

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**

Effectivity Date:

**June 8, 2021**Product Name/Code: **096D / 7L0119-7020**Customer: **TRQSS**

Validity Date:

**n/a**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

**WI-ENG-PDE-242B**

Revision No.:

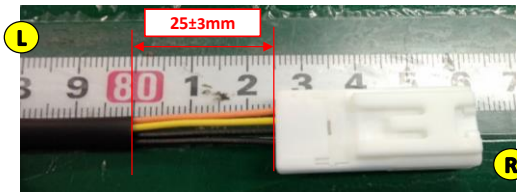
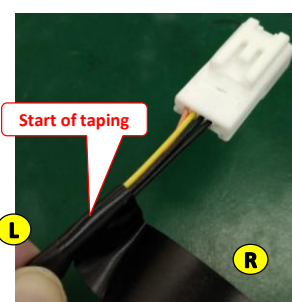
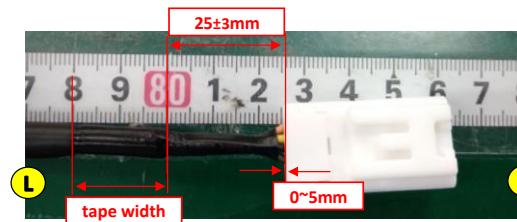

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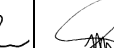
**1 of 5****PARTS:**  
1. Assy parts  
2. Black tape

JIG:

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 Taping 1 Black vinyl tube to wire near connector	 <p>1. Measure from end of vinyl tube up to end of connector <b>25±3mm</b> using both hands.</p>  <p>2. Get the <b>Black tape</b> using right hand then start taping process using both hands. <b>Note: Please refer to WI-PRO-ASY-001 for taping procedure.</b></p>  <p>3. After taping, check the measurement and taping condition.</p>	<p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> <p><b>MEASURING TAPE</b></p> 	<ol style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong use of tape</li><li>6. No wrong dimension</li></ol> <p><b>Note:</b> Please use calibrated/verified measuring tape when getting the measurement.</p>

## Revision History

Eff. Date	Rev. No	Details of Change	Prepared	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
06/08/21	1	Change purpose from Pre-launch to Mass pro	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes				
02/27/21	0	Initial issue	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes

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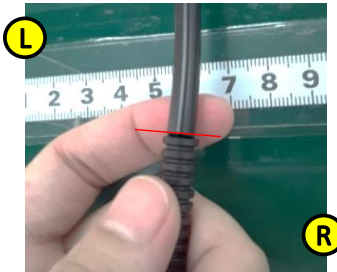
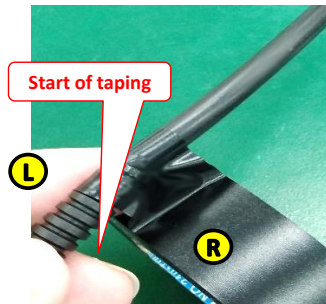
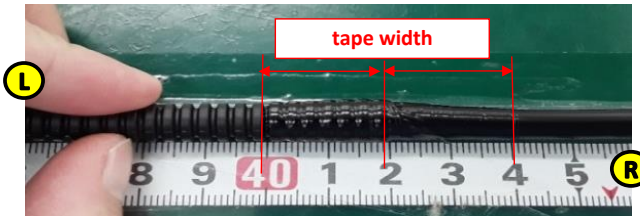

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 2 Black corrugated tube to Black sunprene tube near connector	<div><p>1. Fix the corrugated tube and vinyl tube using both hands.</p></div> <div><p>2. Get the <b>black tape</b> and start taping process using both hands. <i>Note: Please refer to WI-PRO-ASY-001 for taping procedure.</i></p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>	<div><b>MEASURING TAPE</b></div> 	<ol style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong use of tape</li><li>6. No wrong dimension</li></ol> <div><b>Note:</b> Please use calibrated/verified measuring tape when getting the measurement.</div>

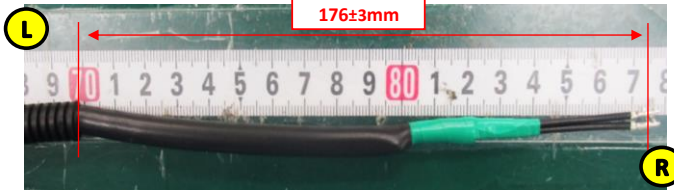
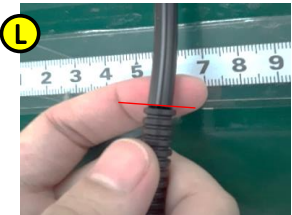
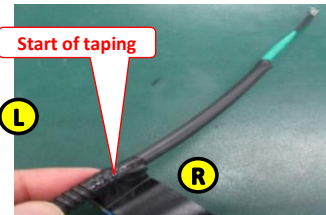


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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	1	Page No.:

<b>PARTS:</b>	1. Assy parts 2. Black tape			<b>JIG</b>	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
3	P1  Taping 3 Black Corrugated tube to Black sunprene tube near terminal	<div style="text-align: center;">  <p>1. Measure from end of corrugated tube up to end of terminal pointed tip <b>176±3mm</b> using both hands.</p> </div> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  <p>2. Fix the corrugated tube and vinyl tube using both hands.</p> </div> <div style="text-align: center;">  <p>3. Get the <b>black tape</b> and start taping process using both hands. <i>Note: Please refer to WI-PRO-ASY-001 for taping procedure.</i></p> </div> </div> <div style="text-align: center;">  <p>4. After taping, check the measurement and taping condition.</p> </div>	<div style="border: 1px solid red; padding: 5px; text-align: center; color: red;"> <b>MEASURING TAPE</b> </div> 	<p><b>Note:</b> Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none"> <li>1. No flip-out tape</li> <li>2. No peel-off tape</li> <li>3. No loose tape</li> <li>4. No missing tape</li> <li>5. No wrong use of tape</li> <li>6. No wrong dimension</li> </ol>	

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☒ MASSPRO

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### PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

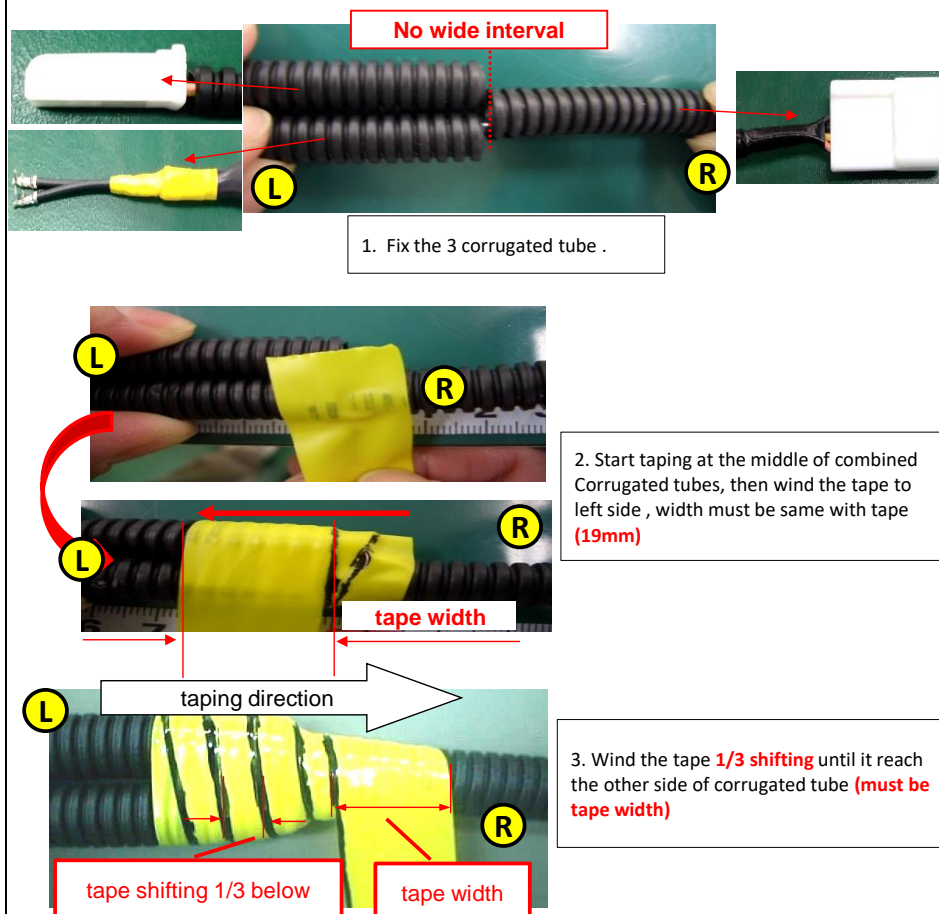
TOOLS/PPE

QUALITY POINTERS

4

P2

Y-Taping



n/a

**NOTE:**  
USE YELLOW TAPE FOR EASY  
VISUALIZATION OF SHIFTING  
LINES, BUT ACTUAL SHOULD  
BE BLACK TAPE.

1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong use of tape
6. No wrong dimension

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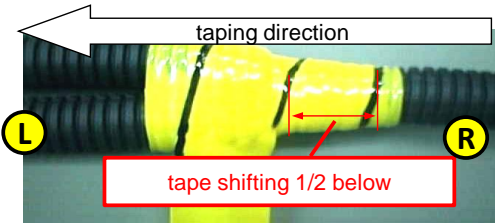
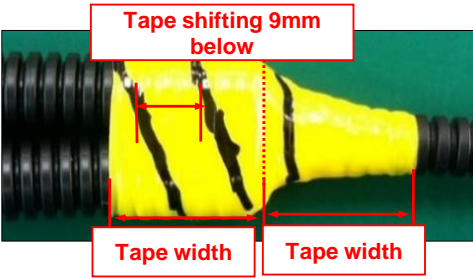

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PARTS:		1. Assy parts 2. Black tape			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	P2 Y-Taping (Continuation)	  <p>4. Wind the tape backward <b>1/2 shifting</b></p> <p>5. Wind the tape <b>1/2 shifting</b> going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.</p>				<p><b>NOTE:</b> <b>USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.</b></p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p> <p><b>Note:</b> Please use calibrated/verified measuring tape when getting the measurement.</p>

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