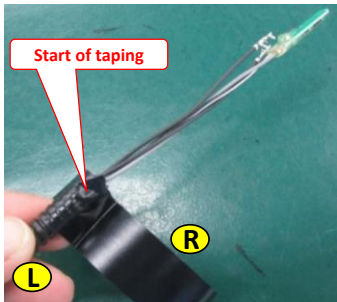

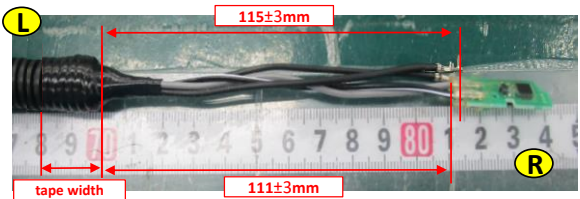

	<b>WORK INSTRUCTION</b> <b>TAPING ASSEMBLY PROCESS</b>				Effectivity Date:		<b>May 04, 2021</b>	
	Process Name/Title:				Validity Date:		n/a	
	Product Name/Code: <b>011B / 7M0512-7020D</b>		Customer: <b>TRJ</b>		Document No.:		<b>WI-ENG-PDE-134B</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		3	Page No.: 1 of 4

<b>PARTS:</b>		1. Assy parts 2. Black tape		JIG:		n/a	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>		<b>QUALITY POINTERS</b>	
1	P2 Taping of COT w/slit to wire near terminal/PCB	<div style="display: flex; justify-content: space-around;"> <div>  <p><b>Start of taping</b></p> <p>1. Hold the corrugated tube using left hand and start taping using right hand.</p> </div> <div>  <p>2. Measure the end of the corrugated tube to hotmelted wire <math>111\pm 3\text{mm}</math> &amp; corrugated tube up to the terminal tip <math>115\pm 3\text{mm}</math> then continue the taping process.  <i>Note: Refer to WI-PRO-ASY-001 for taping procedure.</i> </p> </div> <div>  <p>3. After taping, check measurement and taping condition.</p> </div> </div>		<div style="border: 1px dashed red; padding: 5px;"> <p><b>Safety Instruction</b></p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px dashed red; padding: 5px;"> <p><b>Housekeeping</b></p> <p>1. Maintain and always practice 5's.            2. Personal things on the workplace is prohibited. Keep it in your locker.</p> </div> <div style="border: 1px dashed red; padding: 5px;"> <p><b>Alert level</b></p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div> <div style="border: 1px solid red; padding: 5px;"> <p><b>MEASURING TAPE</b></p>  </div>		<div style="border: 1px solid red; padding: 5px;"> <p><b>Note:</b></p> <p>Please use calibrated/verified measuring tape when getting the measurement.</p> </div> <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>	

Revision History				Prepared by				Reviewed by		Approved by		Noted by	
05/04/21	3	Removal of validity date. Apply some improvements.		M. Catapang	C. Villanueva	A. Shimamura	A. Arañes						
10/22/20	2	Change effectivity and validity date. Remove cycle time.		M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes						
03/06/18	n/a	Previously established as Engineering Instruction (EI-ENG-PDE-021). Initial issue.		S. Manalo	R. Alcantara	A. Arañes	n/a						
Eff. Date	Rev. No	Details of Change		Revised	Checked	Approved	Noted	Est. Date:		July 16, 2018			

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## WORK INSTRUCTION

### TAPING ASSEMBLY PROCESS

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n/a

Product Name/Code: 011B / 7M0512-7020D

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WI-ENG-PDE-134B

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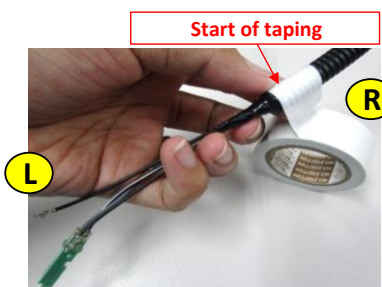
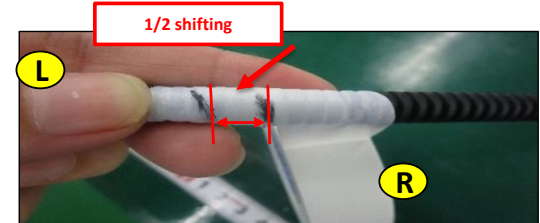
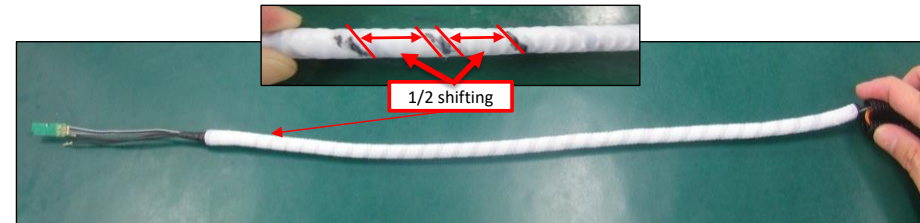
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PARTS:		1. Assy parts 2. Black tape		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2	Half-wrap taping	<div><p>1. Hold the corrugated tube using left hand and begin taping using right hand.</p></div> <div><p>2. Make <b>1/2 shifting</b>. Repeat the process until the end of corrugated tube. Make <b>3 winds</b> and then cut the tape.</p></div> <div><p>3. Check the taping condition.</p></div>	n/a	<div><p><b>NOTE: USE WHITE TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.</b></p></div> <div><p>1. No peel-off tape 2. No flip out of tape 3. No wide interval between the COT 4. No exposed wire 5. No wrong use of tape</p></div>

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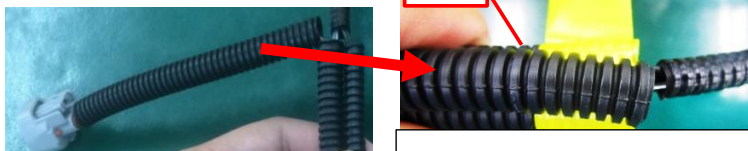
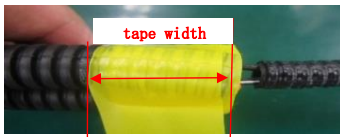
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PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2	Tri-type Taping   <b>CORRECT FACING</b>   <b>2. Tape the 2 combined COT (5 &amp; 7mm) 1x winding</b>   <b>3. Combine the other COT 7mm.</b>   <b>4. Tape the 3 COT 2x winding</b>	n/a	<div>3</div> <div><b>NOTE: USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.</b></div> <div>1. No peel-off tape 2. No flip out of tape 3. No wide interval between the COT 4. No exposed wire 5. No wrong use of tape</div>

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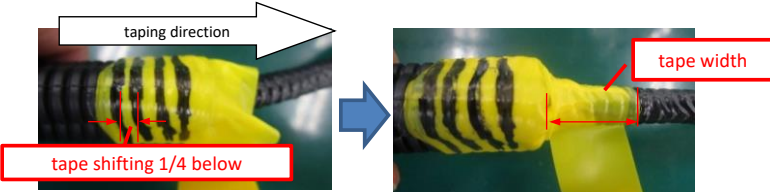
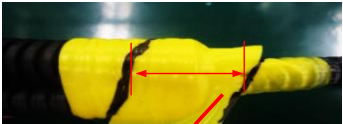
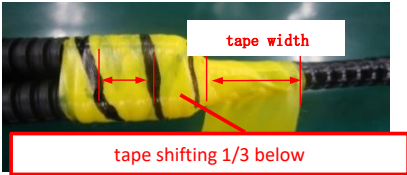
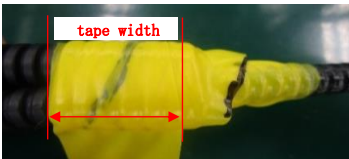
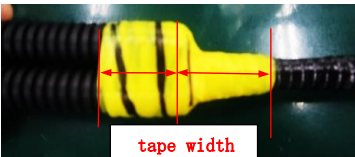
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 Tri-type Taping (Continuation)	<div><p>taping direction</p><p>tape shifting 1/4 below</p><p>tape width</p></div> <p>5. Wind the tape 1/4 shifting until it reach the other side of corrugated tube (must be tape width)</p> <div><p>tape shifting 1/2 below</p></div> <p>6. Wind the tape backward 1/2 shifting</p> <div><p>tape shifting 1/3 below</p><p>tape width</p></div> <p>8. Wind the tape 1/3 shifting going to other side of corrugated tube (must be tape width). Wind the tape 3x before cutting the tape.</p> <div><p>tape width</p></div> <p>7. Wind the tape 2x.</p> <div><p>tape width</p></div> <p>9. After taping, check the condition of tape.</p>	n/a	<p>3</p> <p><b>NOTE: USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.</b></p> <p>1. No peel-off tape 2. No flip out of tape 3. No wide interval between the COT 4. No exposed wire 5. No wrong use of tape</p>

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