



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 16, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

890B / 7L0099-7020

Customer:

TRQSS

Car Model:

TOYOTA C-SUV

Document No.:

WI-ENG-PDE-127

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

6

Page No.:

1 of 5

PARTS:

1. Assy Parts; Black tape

JIG:

n/a

NO.

PROCESS NAME

6

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

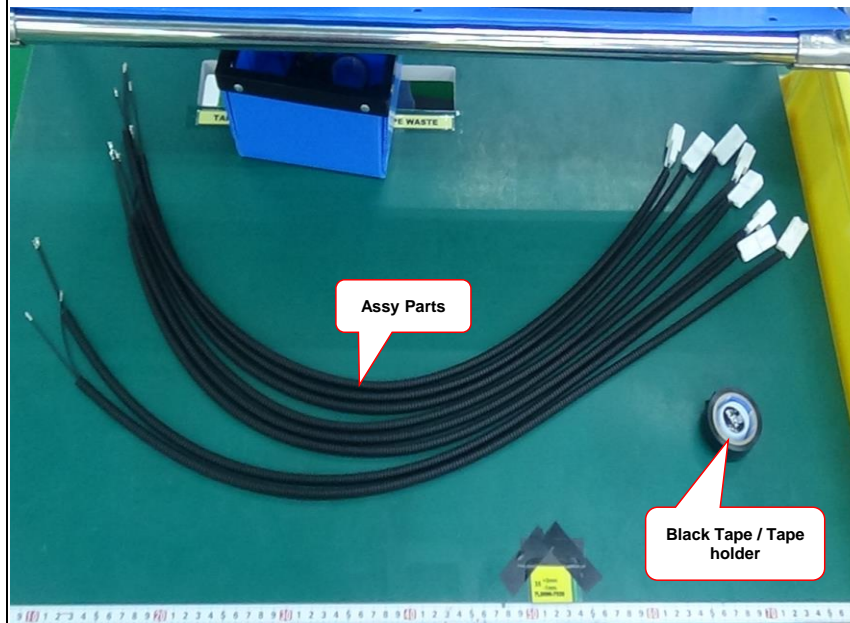
QUALITY POINTERS

1

P1

Table Lay-out

Table Lay-out



Safety Instruction

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

Document reference/s:

1. Refer to WI-ENG-PDE-1006 for Offline assembly process.

1. No missing parts/tools
2. No excess parts/tools

Revision History

Prepared by

Reviewed by

Approved by

Noted by

10/16/24 6 Separate Wire insertion to connector and Wire insertion to Corrugated tube process to Offline assembly process due to process improvement. Inclusion of Important reminders and notes to process 2. Improved Table lay-out, Measurement and Visual inspection/Quality checkpoints.

D.Castillo

C. Villanueva

A. Arañes

n/a

01/23/23 5 Inclusion of Batching quantity: 6pcs. Process identification per table by providing table 1 and table 2. Inclusion of quality checkpoints.

M. Catapang

J. Loterte

C. Villanueva

A. Arañes

10/20/22 4 Merge (WI-ENG-PDE-127B ; Process no.8,9,10 and 11) due to capacity improvement

M. Catapang

J. Loterte

C. Villanueva

A. Arañes

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

August 24, 2020

C. Villanueva

A. Arañes

n/a

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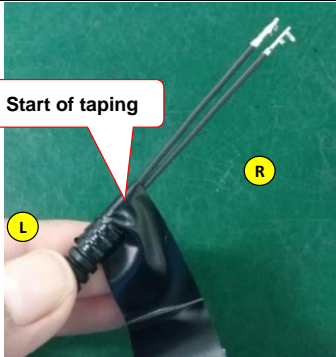
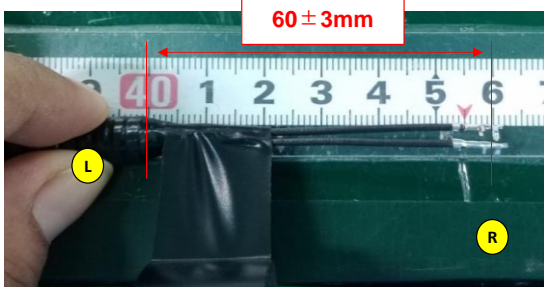

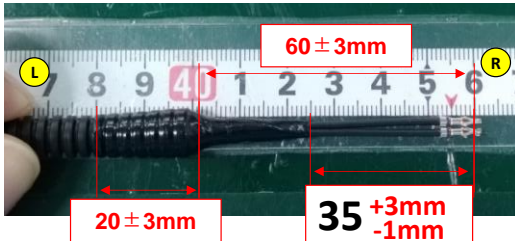

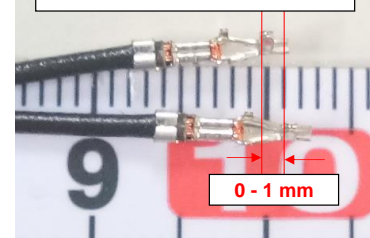
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PARTS:		1. Assy parts 2. Black tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Taping 1 Corrugated tube to wire near terminal	<div><p>Start of taping</p></div> <div><p>60 ± 3mm</p></div> <div><p>1. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.</p><p>2. Measure from end of COT up to terminal pointed tip 60±3mm then continue the taping process using both hands.</p></div> <div><p>35 +3mm -1mm</p><p>3. Confirm measurement of 35+3mm/-1mm from end of tape up to terminal pointed tip then continue the taping process using both hands.</p></div> <div><p>60 ± 3mm</p><p>20 ± 3mm</p><p>35 +3mm -1mm</p><p>4. After taping, check the measurement, taping condition and terminal appearance.</p></div>	<div><p>Measuring tape</p></div>	<p>Important reminders and Note/s:</p> <ol style="list-style-type: none">1. Please use calibrated/verified measuring tape when getting the measurement.2. Do not swap process of Taping 1 (Taping to wire near terminal) to Taping 2 (Taping to wire near connector) <p>Document reference/s:</p> <ol style="list-style-type: none">1. Refer to WI-PRO-ASY-001 for taping procedure.2. Refer to WI-ENG-PDE-588 for TAPE AND TUBE END STANDARD TOLERANCE. <p>1. No peel-off tape 2. No flip-out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape</p> <div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div>

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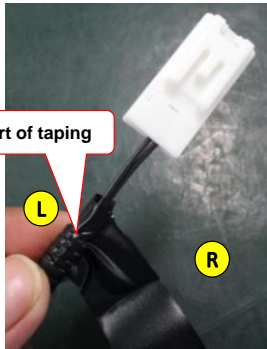
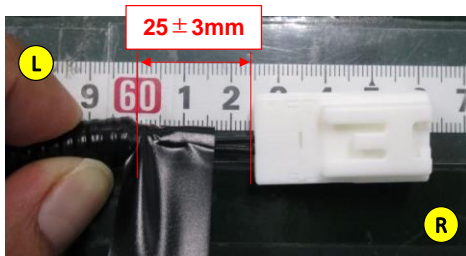
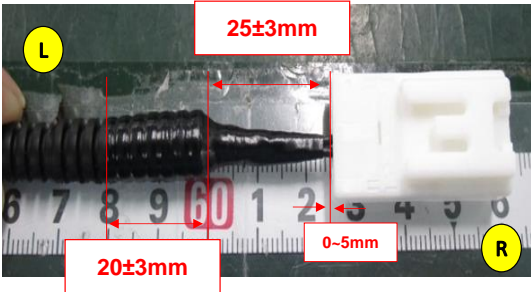

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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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	P1 Taping 2 Black corrugated tube to wire near connector	<div><div><p>Start of taping</p><p>L</p><p>R</p></div><div><p>25 ± 3mm</p><p>L</p><p>R</p></div><div><p>1. Hold the corrugated tube using left hand, get Black tape and start pre-taping using right hand.</p></div><div><p>2. Measure from end of corrugated tube up to the edge of connector 25±3mm then continue the taping process using both hands. Note: Do not pull the wire if not met the target dimension.</p></div><div><p>25±3mm</p><p>20±3mm</p><p>0~5mm</p><p>L</p><p>R</p></div><div><p>3. After taping, check the measurement and taping condition.</p></div></div> <div><div>Measuring tape</div></div> <div><p>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Do not pull the wire if not met the target dimension.</p><p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p><ul style="list-style-type: none">1. No peel-off tape2. No flip-out tape3. No loose tape4. No wrong use of tape5. No wrong dimension6. No missing tape</div>			

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		6	Page No.: 4 of 5

PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	<div>6</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
4	P1	<div>Measurement</div> <div></div> <div>NOTE: A - Taping (B)</div>	<div>MEASURING TAPE</div> <div></div>	<div>Important reminders and note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension</div>	

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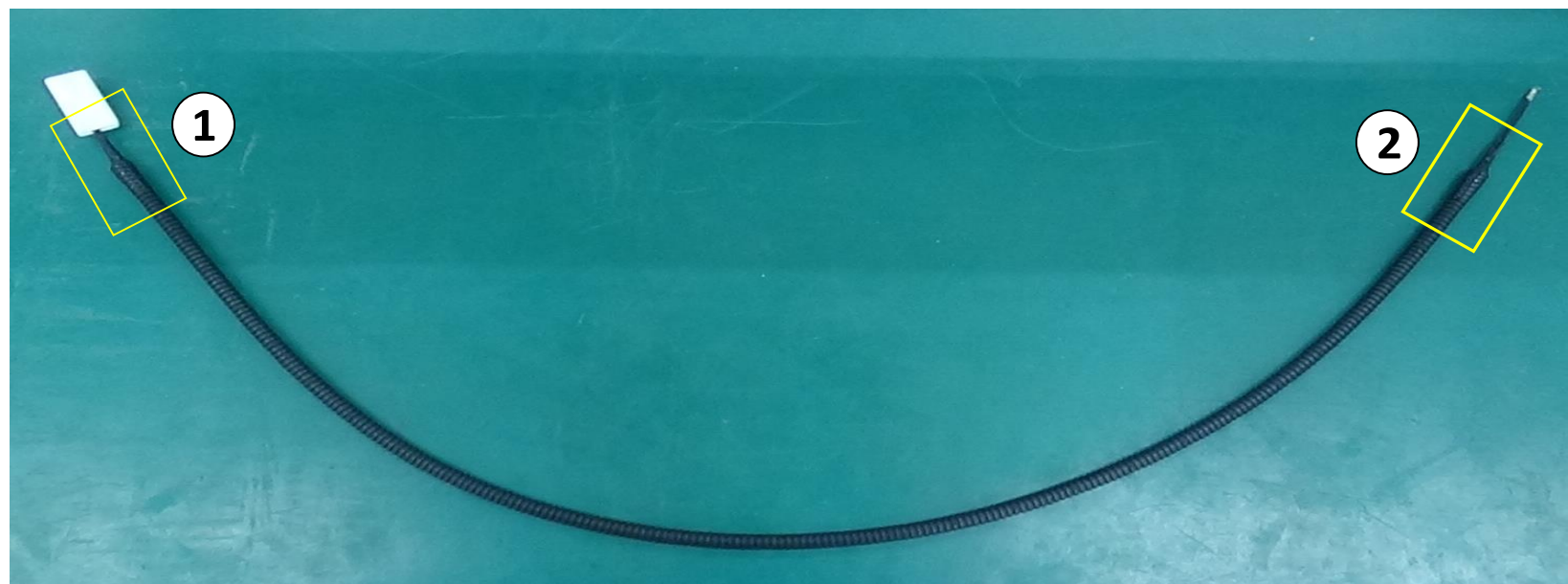
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5 of 5**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING-P1****7L0099-7020****① ② No Missing tape (Black tape)**

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