



WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number: 100B / 7M0594-7021

Customer: TRJ

Car Model: UX LEXUS 2

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

September 07, 2023

Validity Date:

n/a

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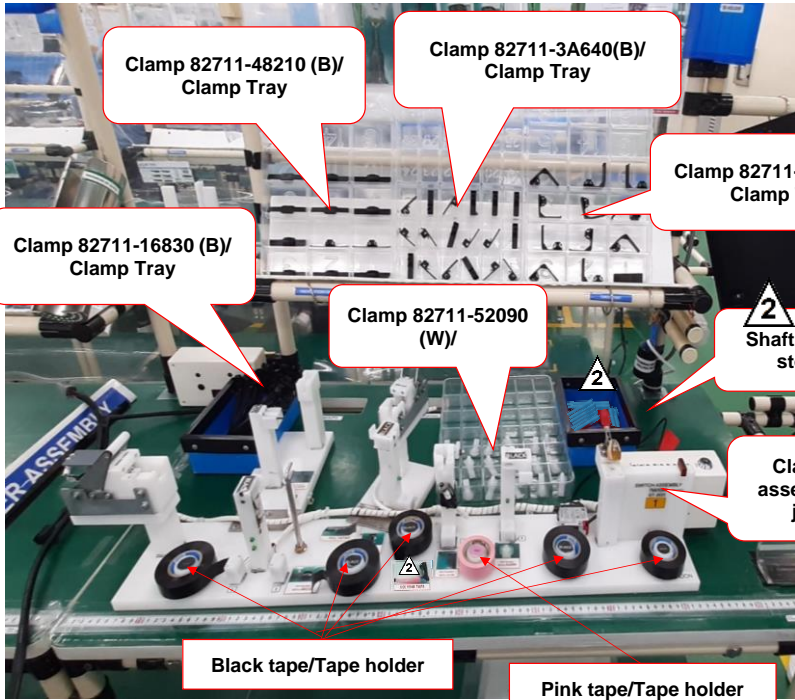

WI-ENG-PDE-425D

Revision No.:

2

Page No.:

1 of 13

PARTS:		1. Assy parts: 2. Clamp 82711-48210 (B); Clamp 82711-3A640(B); Clamp 82711-16830 (B); Clamp 82711-35730 (B); Clamp 82711-52090 (W);		2 3. Blue Shaft webbing stopper 7H0738-0200 4. Black tape [5pcs.]; Pink tape [1pc.]		JIG:		1. Clamp assembly jig	
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1		P4 Clamp setting		<div>TABLE LAYOUT</div> <div></div>		<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div> <div>BANDO GUN</div>		1. No missing parts/tools 2. No excess parts/tools	

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
09/07/23	2	Update template and inclusion of Car model. Change material of Shaft webbing stopper 7H0738-0200. Color from " Red to Blue".	A.Hernandez	J. Loterte	C. Villanueva	A. Arañes	A.Hernandez	J. Loterte	C. Villanueva	A.Arañes
12/22/22	1	Improve quality pointers: Reminders/notes, references and by two's inspection. Inclusion of Quality checkpoints	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
02/24/22	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	February 24, 2022		

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100B / 7M0594-7021

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WI-ENG-PDE-425D

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

2 of 13

PARTS:	1. Clamp 82711-48210 (B) 2. Clamp 82711-3A640 (B) 3. Clamp 82711-35730 (B)	4. Clamp 82711-52090 (W) 5. Black tape [5pcs.] 6. Pink tape [1pc.]	JIG:	1. Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P4 Clamp setting	<div>1. Get 1pc. of clamp 82711-48210 (B) using right hand then set to clamp location 2 and 3 using both hands.</div> <div>2. Get 1pc. of clamp 82711-3A640 (B) using right hand then set to clamp location 4 using both hands.</div> <div>3. Get 1pc. of clamp 82711-35730 (B) using right hand then set to clamp location 5 using both hands.</div> <div>4. Get 1pc. of clamp 82711-52090 (W) using right hand then set to clamp location 6 using both hands.</div> <div>5. Initially attach Black tape on clamp location 2, 3, 4, 5 and 6 using both hands.</div>		<div>STANDARD TAPING FOR CLAMP</div> <div>One side tape under clamp</div> <div>1. No damaged clamp 2. No wrong use of parts 3. No wrong use of tape 4. No wrong insertion of clamp</div> <div>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div>CLAMP ILLUSTRATION</div> <div></div>

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Document No.:

WI-ENG-PDE-425D

Revision No.:

2

Page No.:

3 of 13

PARTS:		1. Assy parts 2. Clamp 82711-16830 (W) 3. Black tape		JIG:	1. Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P4 Clamp setting	<div></div> <div>1. Put the assy into jig. (<i>See above picture for the correct setting</i>). First, set the connector 6188-0066 (GR) to Checker 1 then pull the checker fixture for continuity checking. Second, set the connector 6098-3802 (W) to Receiver base 1. Third, set the connector 6189-1161 (B) to Checker 2 then pull the checker fixture for continuity checking. Continue to set the harness in jig. Last, set the hotmelted wire and B-B wires together within stopper then press by toggle clamp.</div> <div>2. Check if all LED light for POWER ON, WIRE1, WIRE2 and CLAMP ON was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</div> <div>3. Get 1pc. of clamp 82711-16830 (W) using right hand then set to clamp location 1 using both hands.</div>			<div></div> <div>1. No loose/tight clamp attached 2. No damage clamp 3. No missed tape 4. No missing parts 5. Make sure no clearance between PCB and stopper jig</div> <div><div>BAND CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>NG</div></div><div></div><div>82711-16830 (B)82711-34490 (B)</div></div>

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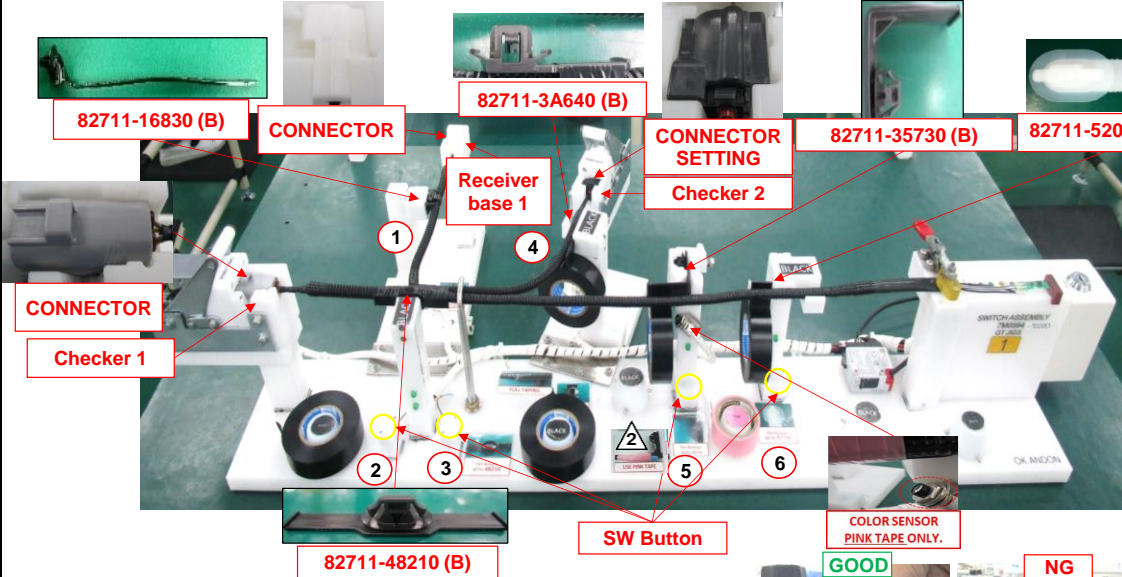
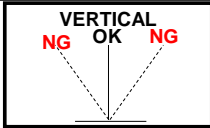


WI-ENG-PDE-425D

Revision No.:

2

Page No.:

4 of 13

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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P4 Clamp setting	<div></div> <div><p>4. Initially tighten the band clamp on clamp location 1 using right hand.</p><p>5. Get the bando gun using right hand then cut the band clamp on location 1. Press the SW button after taping. Continue if the sequence light on clamp location 2 was ON.</p></div> <div><p>BANDO GUN ALIGNMENT</p></div> <div><p>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</p></div>		<div></div> <p>Important reminders/Note/s: 1. Make sure no gap between stopper and PCB</p> <p>1. No loose/tight clamp attached 2. No damage clamp 3. No missed tape 4. No missing parts 5. Make sure no clearance between PCB and stopper jig</p> <div><p>BANDO GUN ILLUSTRATION</p></div>	

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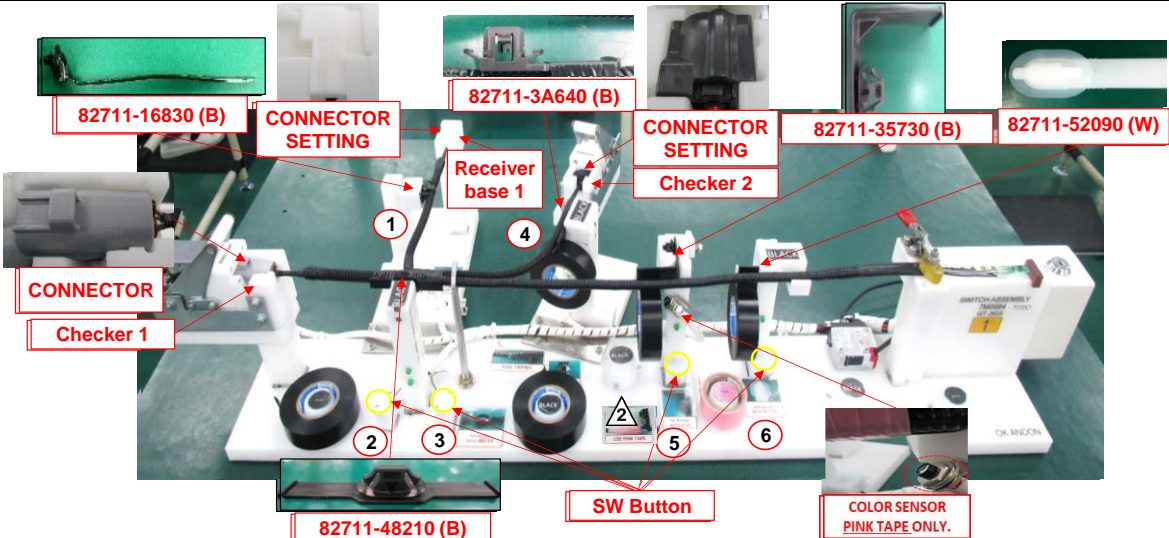
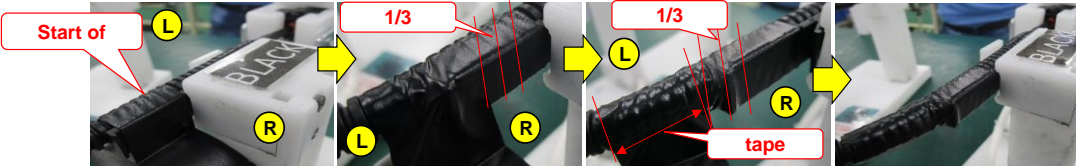

WI-ENG-PDE-425D

Revision No.:

2

Page No.:

5 of 13

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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P4 Clamp Assembly (Continuation)	<div></div> <div><p>6. Hold the Black tape using right hand then start taping using both hands on clamp location 2. Make 3 windings of tape then cut the tape. Press the SW button after taping. Continue if the sequence light on location 3 was ON.</p><p>7. Hold the Black tape using right hand and then start taping using both hands on clamp location 3. Make 3 windings of tape then cut the tape. Press the SW button after taping. Continue if the sequence light on location 4 was ON. Note: Follow below taping procedure for location 4.</p><p>8. Hold the Black tape using right hand and then start taping using both hands on clamp location 4. Make 3 windings of tape then cut the tape. Press the SW button after taping. Continue if the sequence light on location 5 was ON. Note: Follow below taping procedure for location 4.</p></div> <div></div>			<div></div> <p>Important reminders/Note/s: 1. Make sure no gap between stopper and PCB</p> <p>1. No loose/tight clamp attached 2. No damage clamp 3. No missed tape 4. No missing parts 5. Make sure no clearance between PCB and stopper jig</p>

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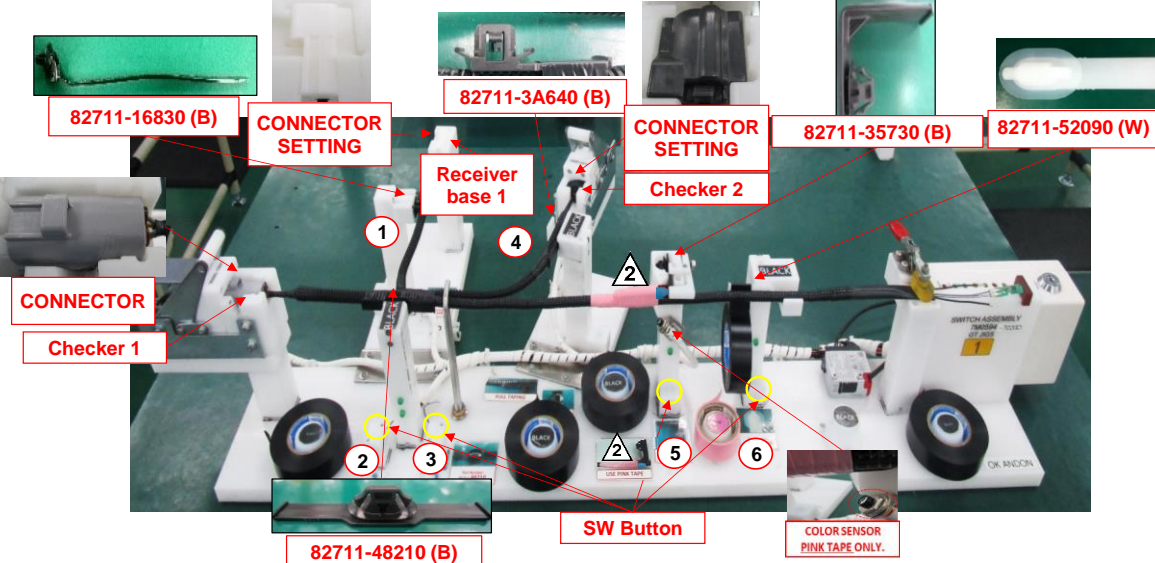
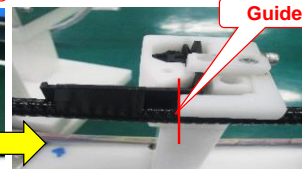

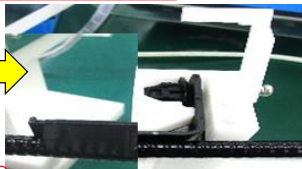
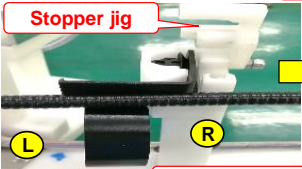

WI-ENG-PDE-425D

Revision No.:

2

Page No.:

6 of 13

PARTS:		1. Assy parts 2. Black tape	JIG:	1. Clamp Assembly Jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P4	Clamp Assembly (Continuation)			
		<div></div> <div></div> <div><p>9. Hold the Black tape using right hand and then start taping using both hands on clamp location 5. Make 3 windings of tape then cut the tape.</p></div> <div><p>10. After spot taping, pull the stopper jig.</p></div>			<div><p>Important reminders/Note/s: 1. Make sure no gap between stopper and PCB</p><ul style="list-style-type: none">1. No loose/tight clamp attached2. No damage clamp3. No missed tape4. No missing parts5. Make sure no clearance between PCB and stopper jig</div>

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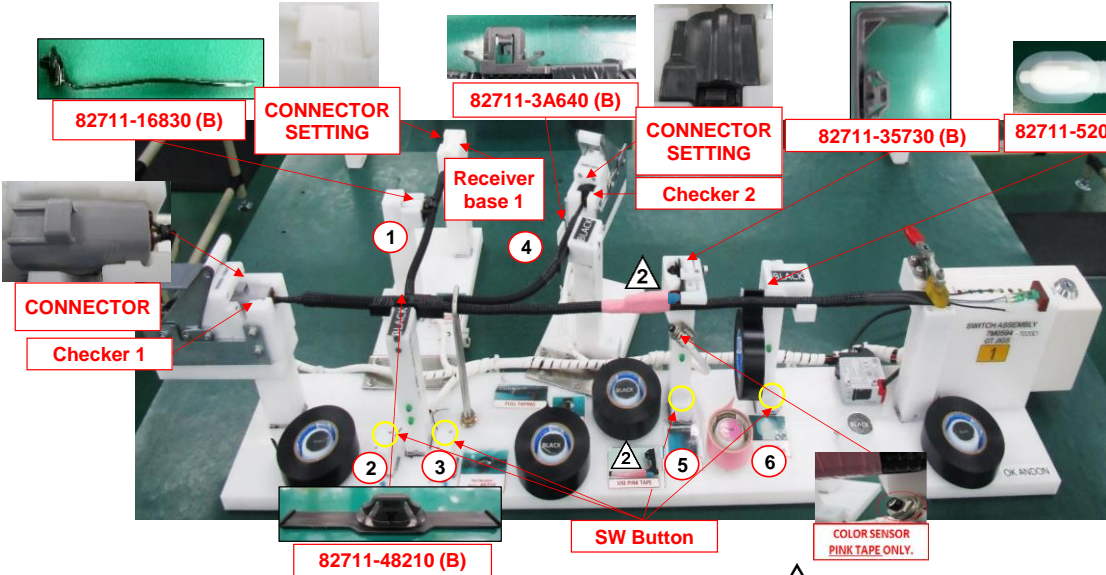
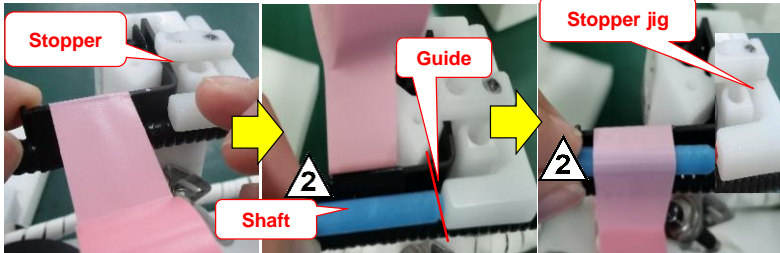


WI-ENG-PDE-425D

Revision No.:

2

Page No.:

7 of 13

PARTS:		1. Assy parts 2. Blue Shaft Webbing stopper 7H0738-0200  3. Black tape		JIG:	1. Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P4 Clamp Assembly (Continuation)	<div></div> <div><div><p>11. Get the PINK tape using right hand then initially attach to clamp using both hands, get the SHAFT (blue color) and fit into guide then make 2 windings of tape before shifting. Note: Color sensor will beep/buzz if sensor detects PINK TAPE and Initial black tape on the clamp must be cover by Pink tape; Follow taping procedure for location 5.</p></div></div>			 <p>Important reminders/Note/s: 1. Make sure no gap between stopper and PCB</p> <ol style="list-style-type: none">1. No loose/tight clamp attached2. No damage clamp3. No missed tape4. No missing parts5. Make sure no clearance between PCB and stopper jig

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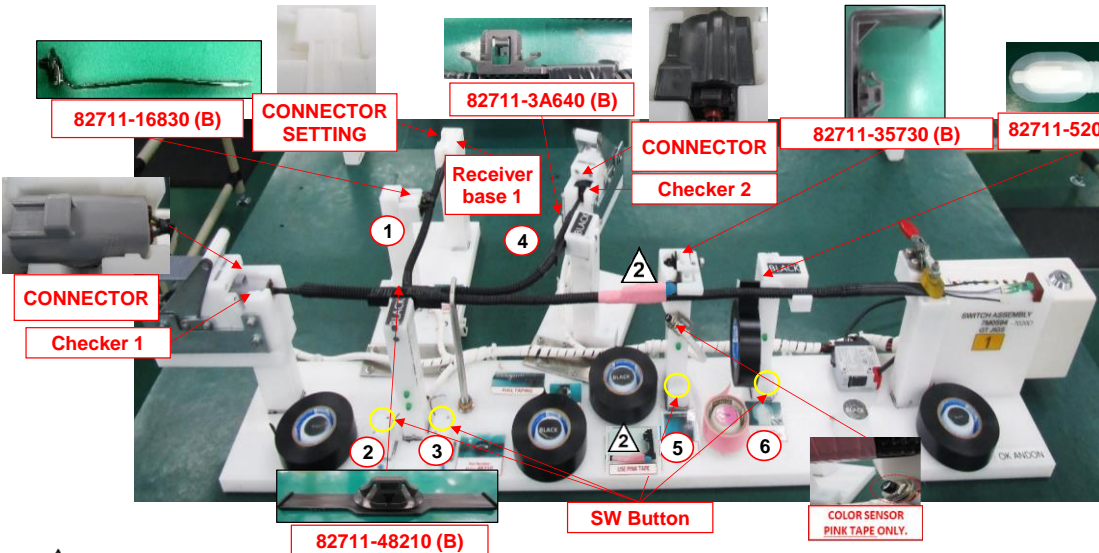
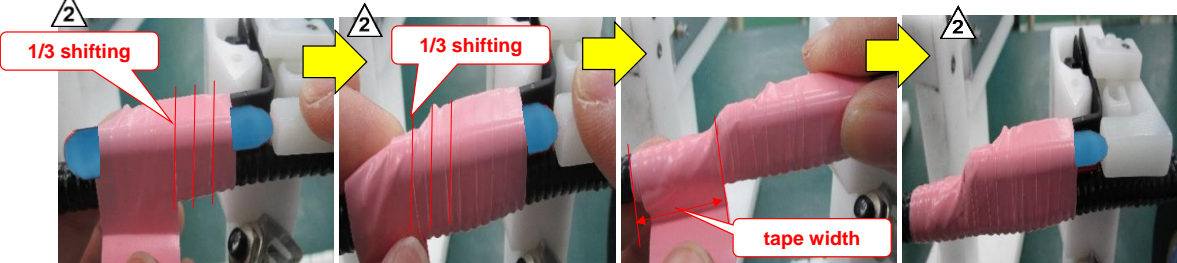

WI-ENG-PDE-425D

Revision No.:

2

Page No.:

8 of 13

PARTS:		1. Assy parts 2. Black tape		JIG:	1. Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P4 Clamp Assembly (Continuation)	<div></div> <div></div> <div>12. Make 1/3 shifting going to corrugated tube until it reach tape width then make 3 windings of tape before cut. Press the SW button after taping. Continue if the sequence light on location 6 was ON.</div>			<div></div> <div>Important reminders/Note/s: 1. Make sure no gap between stopper and PCB</div> <div>1. No loose/tight clamp attached 2. No damage clamp 3. No missed tape 4. No missing parts 5. Make sure no clearance between PCB and stopper jig</div>

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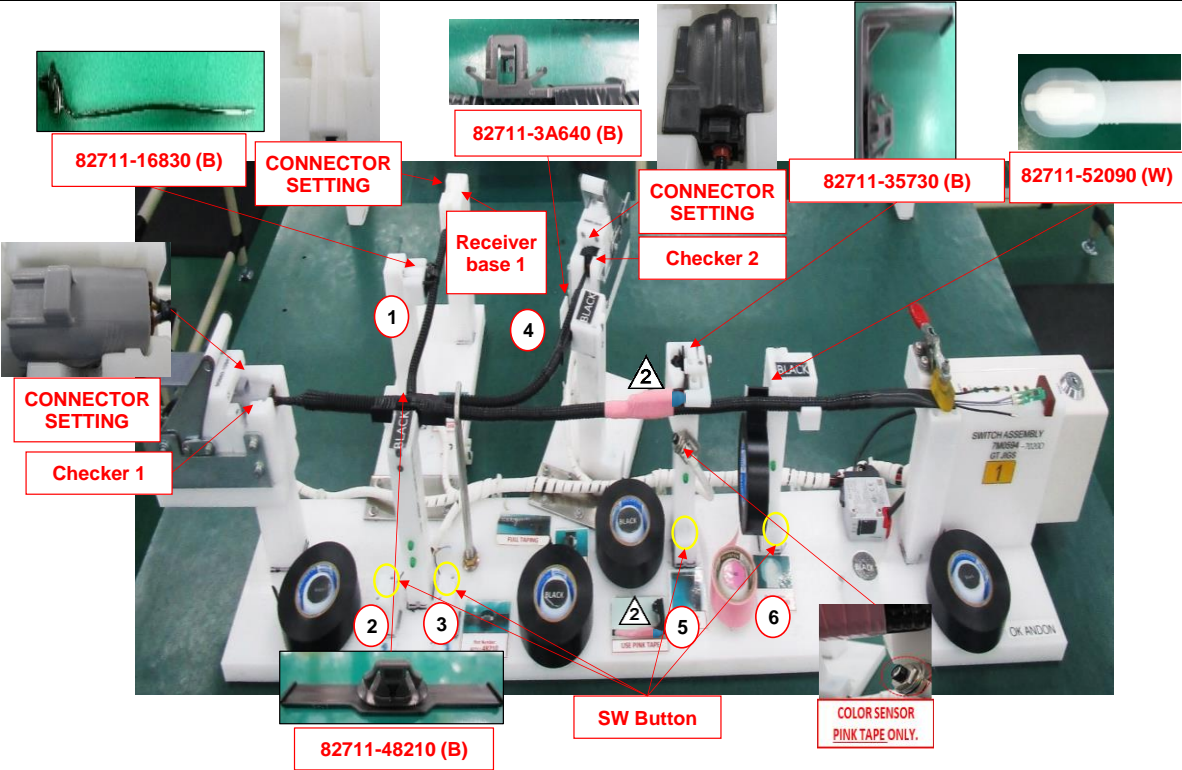

WI-ENG-PDE-425D

Revision No.:

2

Page No.:

9 of 13

PARTS:		1. Assy parts 2. Black tape		JIG:	1. Clamp Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P4 Clamp Assembly (Continuation)	<div></div> <div>13. Hold the Black tape using right hand and then start taping using both hands on clamp location 6. Make 3 windings of tape then cut the tape. Press the SW button after taping. GO sound will be heard.</div> <div>14. After taping, CONDUCT POINT CHECKING before removing from jig.</div>			<div></div> <div>Important reminders/Note/s: 1. Make sure no gap between stopper and PCB</div> <div>1. No loose/tight clamp attached 2. No damage clamp 3. No missed tape 4. No missing parts 5. Make sure no clearance between PCB and stopper jig</div>

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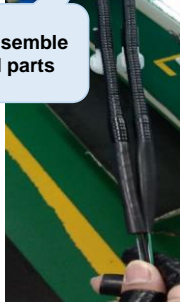






WI-ENG-PDE-425D

Revision No.:

2

Page No.:

10 of 13

PARTS:		n/a		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P4	Visual/By Two's Inspection			
		<div><div><p>ACTUAL PRODUCT</p></div><div><p>Master sample</p><p>2</p><p>Assembled parts</p></div><div><p>2. Check the connector lock, terminal, insertion and taping condition.</p></div><div><p>1. Conduct alignment of harness (Master sample vs. assembled parts) using both hands.</p></div><div><p>3. Check the presence of clamp tube and taping condition.</p></div><div><p>4. Check the presence of all clamp attachment and band clamp cut condition.</p></div></div> <td><div><div><p>MASTER SAMPLE</p></div><div><p>1. No skip checking during inspection</p><p>0 ~ 2mm</p></div><div><p>Important reminders/Note/s:</p><p>1. Using a steel rule, check if the band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value.</p></div></div></td>		<div><div><p>MASTER SAMPLE</p></div><div><p>1. No skip checking during inspection</p><p>0 ~ 2mm</p></div><div><p>Important reminders/Note/s:</p><p>1. Using a steel rule, check if the band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value.</p></div></div>	

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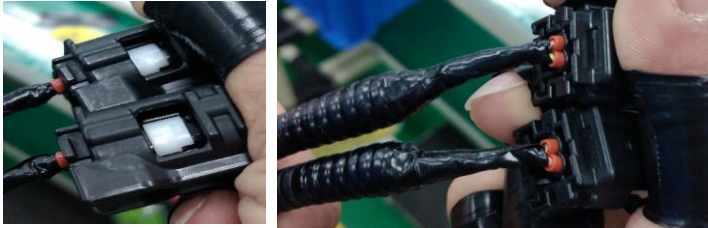
WI-ENG-PDE-425D

Revision No.:

2

Page No.:

11 of 13

PARTS:		n/a		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P4 Visual/By Two's Inspection (Continuation)	 5. Check the connector lock, terminal, insertion and taping condition.		 6. Check the presence of clamp attachment and taping condition.	<div>MASTER SAMPLE</div>  1. No skip checking during inspection
		 7. Check the connector lock, terminal, insertion and taping condition.		 8. Check the presence of clamp attachment and taping condition and presence of shaft.	
		 9. Conduct bending of COT and tube then check the taping condition.		 10. Check the terminal and PDB appearance. Must be no deformed terminal.	

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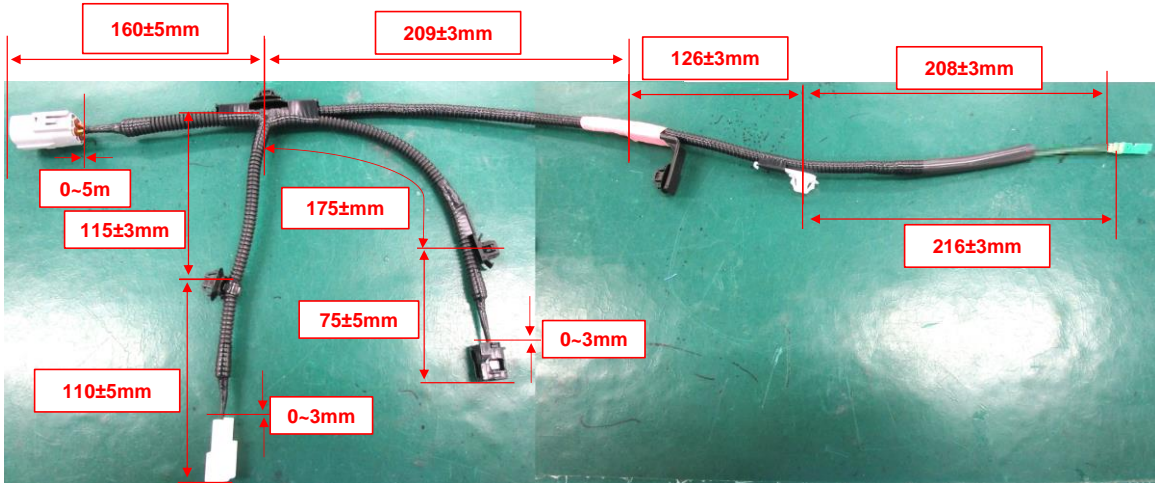
WI-ENG-PDE-425D

Revision No.:

2

Page No.:

12 of 13

PARTS:		n/a		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P4	Measurement	<div><div>MEASURING TAPE</div><p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p></div>		<p>Important reminders/Note/s: 1. FOR HATSUMONO AND OWARIMONO</p> <p>1. No wrong dimension</p>

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WI-ENG-PDE-425D

Revision No.:

2

Page No.:

13 of 13

PARTS:

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JIG:

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QUALITY CHECKPOINTS

P4

7M0594-7021



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