



WORK INSTRUCTION  
TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number: 241B / 7L0051-7023

Customer: TRQSS

Car Model: LEXUS ES

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

August 13, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-179B

Revision No.:

0

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PARTS: 1. Assy parts, Black vinyl tube Ø5 L=40±3mm; Black Corrugated tube Ø5L=264±3mm(no slit); Black tape, White tape

JIG:

1. Spot taping jig
2. Measuring jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

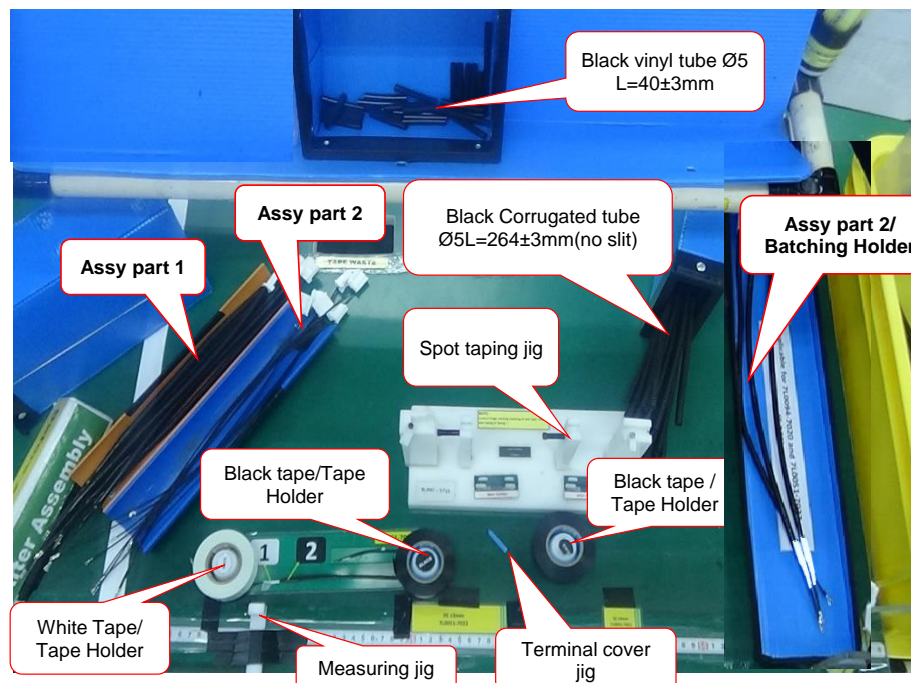
QUALITY POINTERS

1

P2

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**

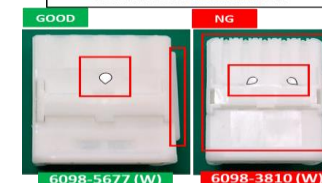
For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

**Document references**

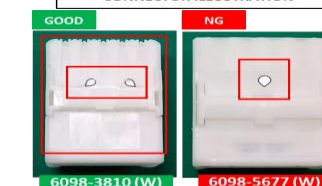
1. Please refer to WI-PRO-CNC-017 for the Wire and Strip Length tolerance.

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

CONNECTOR ILLUSTRATION



CONNECTOR ILLUSTRATION



Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
08/13/24	0	Initial issue. Change process sequence. Inclusion of Measurement and Quality pointers process on page 5 and improve visual inspection on page 6.	A.Hernandez	C. Villanueva	A. Arañes	n/a	A.Hernandez	C. Villanueva	A. Arañes	n/a

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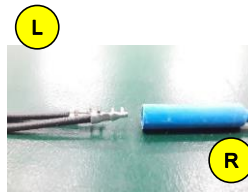
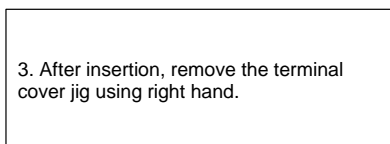


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2.Black Corrugated tube Ø5 L=264±3mm (no slit)		3.Black Vinyl tube ø5 L= 40±3mm	JIG:	1. Terminal cover jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2	Wire insertion to Corrugated tube Ø5 L=264±3mm (no slit)	<div><div></div><div></div><div><div>1. Get the terminal cover jig using right hand and insert the B-B wires using left hand.</div><div></div><div><div>2. Get the corrugated tube Ø5 L=264±3mm (no slit) using right hand and insert to wires.</div><div></div><div><div>3. After insertion, remove the terminal cover jig using right hand.</div></div></div></div><div><div>TERMINAL COVER JIG</div></div></div>		1. No wrong use of parts 2. No deformed terminal	
3		Wire insertion to Vinyl tube Ø5 L=40±3mm	<div><div></div><div><div>1. Get the Vinyl tube ø5 L= 40±3mm using right hand then insert the Black wires.</div></div></div> <div>n/a</div> <td>1. No wrong use of parts 2. No deformed terminal</td>	1. No wrong use of parts 2. No deformed terminal		

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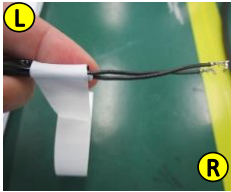
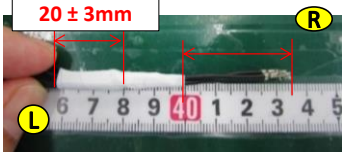

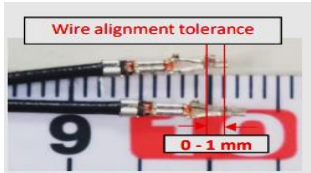


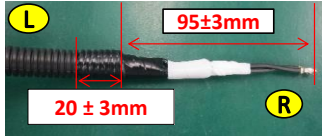
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PARTS:		1. Assy parts 2. White Tape	3. Black Tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Taping (1) SV tube (vinyl) to wire near terminal ( White tape)	<div><p>55 ± 3mm</p><p>1. Measure the end of the vinyl tube up to the end of the terminal pointed tip 55±3mm using both hands.</p></div> <div><p>2. Hold the vinyl tube using left hand, start taping process using right hand.</p></div> <div><p>20 ± 3mm</p><p>3. After taping, check the measurement, terminal appearance and taping condition.</p></div>		<div><p>Measuring tape</p></div>	<p><b>Important reminders/Note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. Use <u>WHITE TAPE</u> only</p> <p>1. No peel-off tape 2. No flip-out tape 3. No loose tape 4. No wrong use of tape</p> <div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div>
5	Taping (2) Corrugated tube to SV tube (vinyl) ( Black tape)	<div><p>95±3mm</p><p>1. Measure from end of COT up to terminal pointed tip 95±3mm then continue the taping process using both</p></div> <div><p>2. Hold the COT using left hand and start taping process using right hand.</p></div> <div><p>95±3mm</p><p>20 ± 3mm</p><p>3. After taping, check the measurement, terminal appearance and taping</p></div>			<p><b>Important reminders/Note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. Use <u>BLACK TAPE</u> only</p> <p>1. No peel-off tape 2. No flip-out tape 3. No loose tape 4. No wrong use of tape</p>

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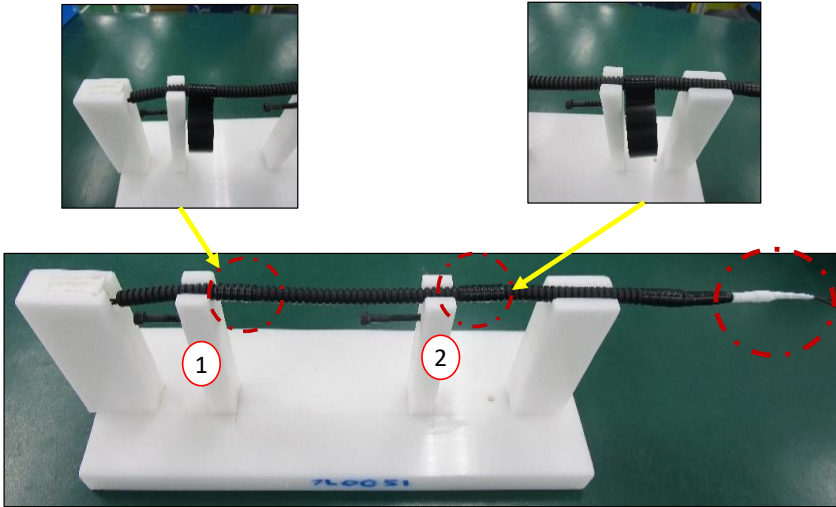
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PARTS:	1. Assy parts 2. Black Tape			JIG:	1. Spot Taping jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
6	P2	Spot Taping	<div></div> <div>1. Get the assy parts (1) using both hands and set to taping jig.</div> <div>2. Get the <b>black tape</b> and begin spot taping on location 1 using both hands. Make 2 winds.</div> <div>3. Get the black tape and begin spot taping on location 2 using both hands.</div> <div>4. Remove from jig using both hands and transfer to next process together with assy parts 2 (<b>Connector 6098-3810</b> with inserted 2 Black wires)</div>			n/a	1. No missing tape 2. No wrong position of tape.

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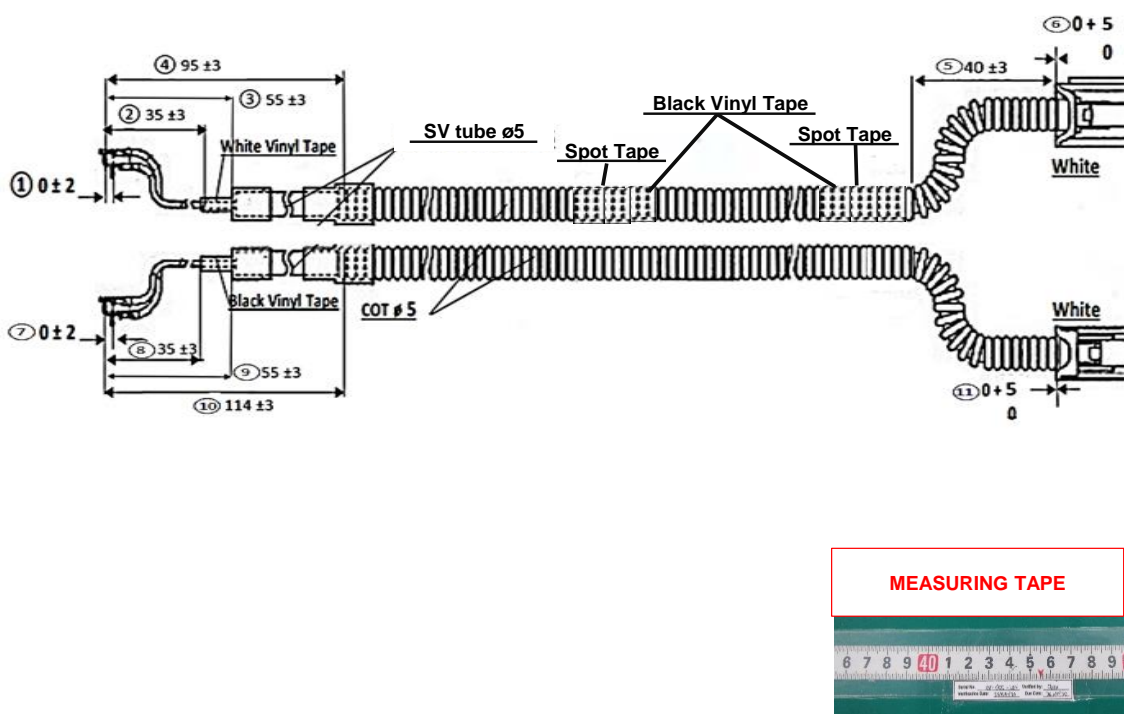
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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P2  Measurement	<div></div>			<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated /verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection.</p> <p>1. No wrong dimension</p>

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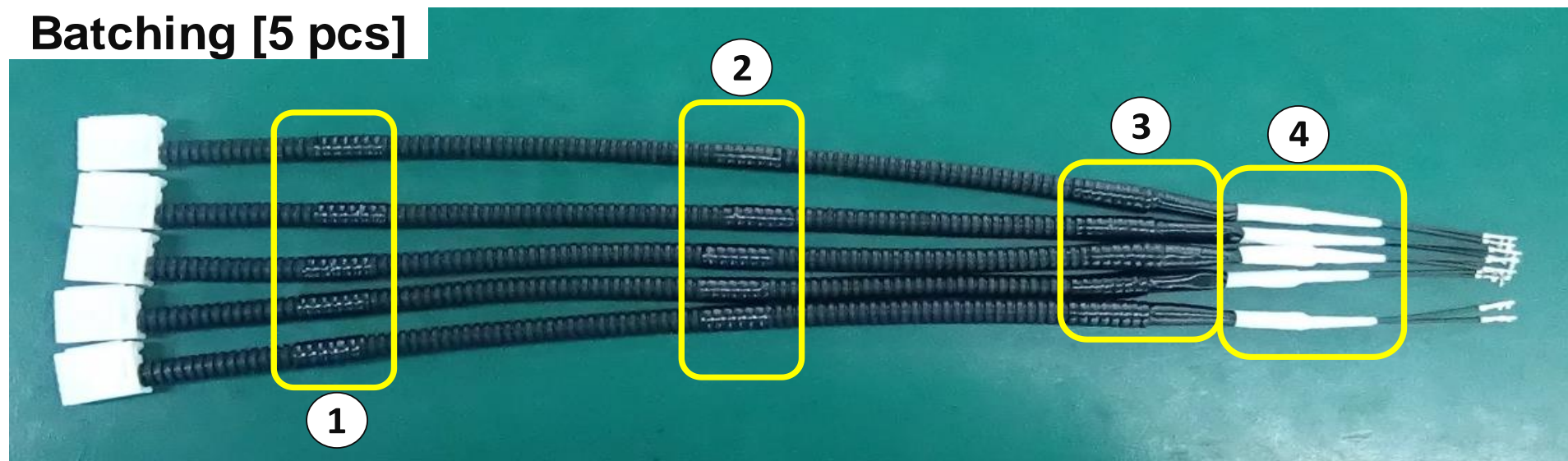
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**6 of 6****PARTS:****n/a****JIG:****n/a****VISUAL INSPECTION/QUALITY CHECKPOINTS****P2****7L0051-7023****Batching [5 pcs]****① ② No Missing Spot Tape****③ ④ No Missing Tape/ Wrong Use of Tape**

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