



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

February 07, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number: 930B / 7N0205-7020A Customer: TRJ Car Model: TOYOTA-4RUNNER

Document No.:

WI-ENG-PDE-782D

Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

1 of 4

PARTS:
1. Assy parts
2. Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

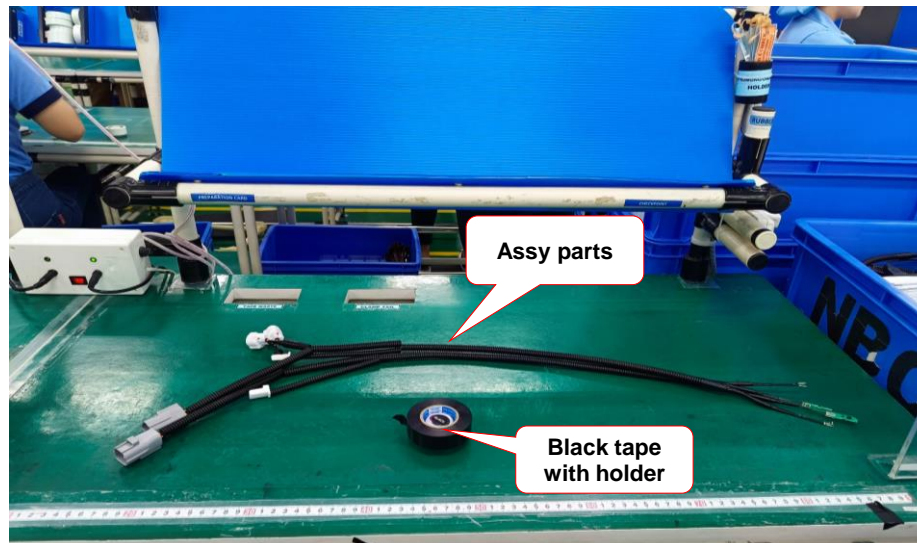
QUALITY POINTERS

1

P4

TABLE-LAY-OUT

TABLE LAY-OUT

**Safety Instruction**

Be sure to wear required 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.

1. No missing parts/tools
2. No excess parts/tools
3. No wrong position of parts/tools

Revision History

Prepared by

Reviewed by

Approved by

Noted by

02/07/24 1 Change pre-launch to mass pro. Inclusion of table lay-out. Separate Insertion and Clamp assembly process.

M. Ariola

C. Villanueva

A. Arañes

n/a

01/15/24 0 Initial issue

M. Ariola

C. Villanueva

A. Arañes

n/a

Eff. Date Rev. No Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

January 15, 2023

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7N0205-7020A

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☐ PROTOTYPE

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QUALITY POINTERS

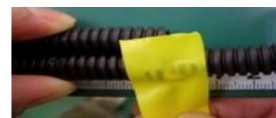
2

P4

Y-taping 1

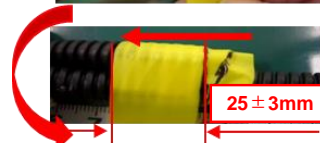


No Gap between tubes



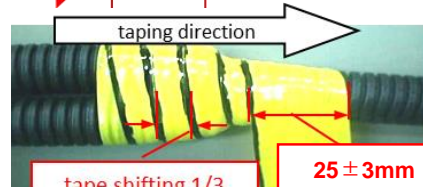
Note: Do not exert excessive force during pulling & winding of tape

1. Fix the corrugated tube .



25 ± 3mm

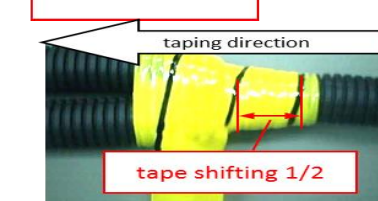
2. Start taping at the middle of combined Corrugated tubes, then winding the tape going to 2 corrugated tubes, width must be **Tape width**.



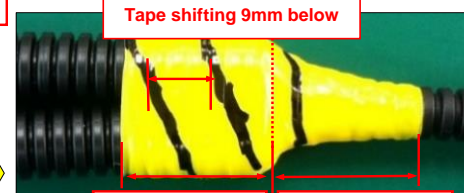
25 ± 3mm

3. Winding the tape 1/3 shifting until it reach the other side of corrugated tube, width must be **25mm**.

tape shifting 1/3 below



tape shifting 1/2



25 ± 3mm

25 ± 3mm

5. Winding the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.

4.Winding the tape backward 1/2 shifting.

MEASURING TAPE



Important reminders/Note/s:

1. Use **YELLOW TAPE** for easy visualization of shifting lines, but actual should be **BLACK TAPE**.

2. Please use calibrated/verified measuring tape when getting the measurement.

Document references:

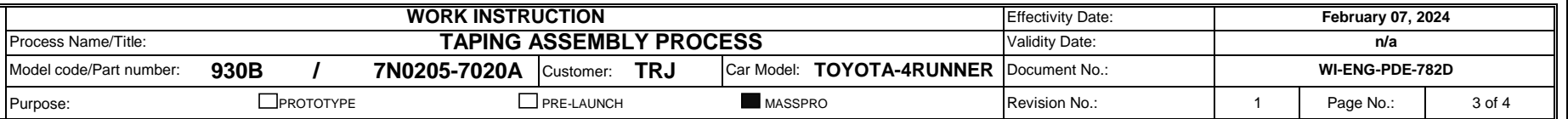
1. Refer to WI-PRO-ASY-001 for Taping process

1. No wrong usage of parts.
2. No deformed terminal

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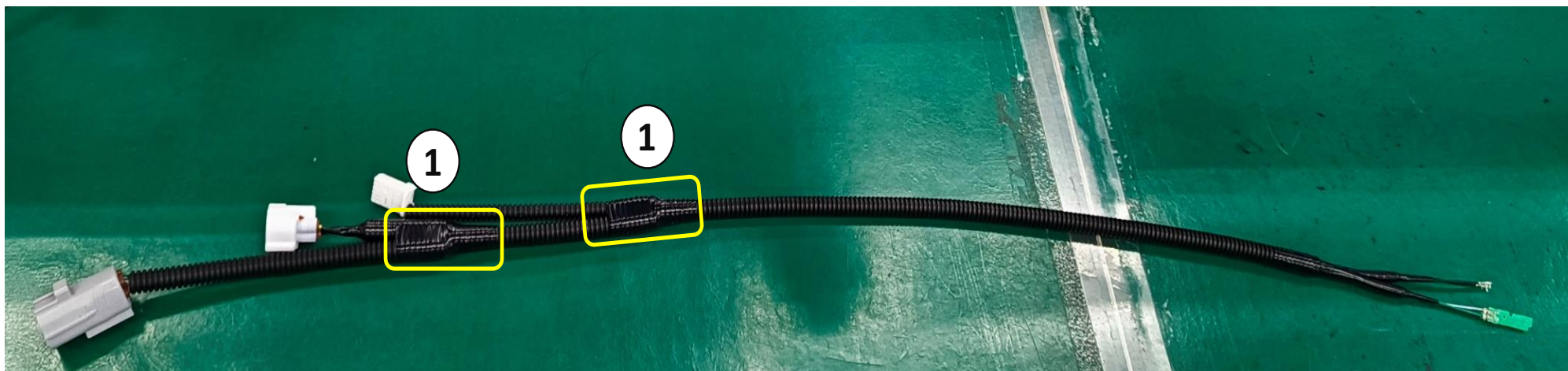
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PARTS:

n/a

JIG:

n/a

QUALITY CHECKPOINTS**P4****7N0205-7020A****1****No Missing Tape
(Y-TAPING)****2****No Wrong Facing
(Y-TAPING)**

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