



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 18, 2024

Model code/Part number:

660B / 7R0111-7021

Customer:

TRMX

Car Model:

TOYOTA-SEQUAIO

Document No.:

WI-ENG-PDE-451A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

4

Page No.:

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PARTS:

1. Assy parts: Black corrugated tube (no slit) $\phi 5$ L=166 \pm 3mm; Black corrugated tube (no slit) $\phi 5$ L=156 \pm 3mm; Yellow tape

JIG:

1. Terminal cover jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

P1

Table Lay-out

Table Lay-out

Black Corrugated tube
 $\phi 5$ L=166 \pm 3mm (no slit)Black Corrugated tube
 $\phi 5$ L=156 \pm 3mm (no slit)

Assy parts

Terminal cover
jig

Yellow tape

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. Refer to WI-ENG-PDE-450 7R0111-7021 - OFFLINE ASSEMBLY PROCESS

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


Revision History





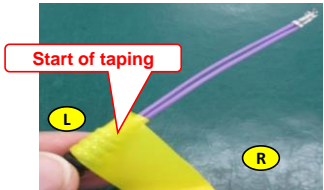
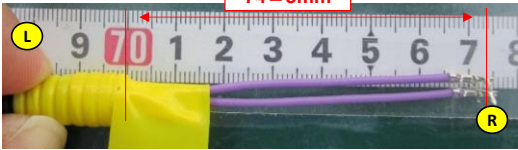
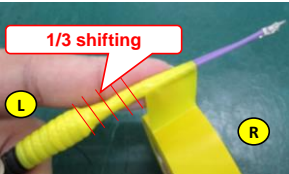
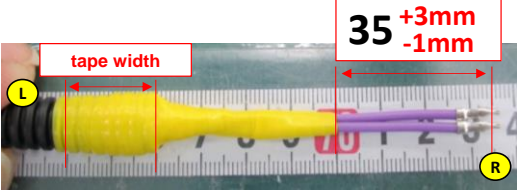

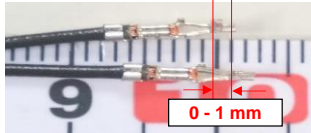
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
06/18/24	4	Transfer Taping 2, Y-taping, Clamp Setting, Clamp assembly and By two's inspection to WI-ENG-PDE-451B due to process improvement. Update table lay-out and Quality checkpoints.	D. Castillo	C. Villanueva	A. Arañes	n/a				
12/09/22	3	Improve: Table lay-out, quality pointers. Transfer of process no.6 to no.10 from P2 to P1 due capacity improvement of 2MP to 1MP. Inclusion of quality checkpoints.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
09/30/22	2	Improve quality pointers: References in process no.1,3 and 5 due to document improvement. Change of tolerance from end of tape up to terminal pointed tip 35+3mm/-3mm to 35+3mm/-1mm as countermeasure due to encountered minimum dimension.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	March 09, 2022		

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	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Process Name/Title:			Document No.:	WI-ENG-PDE-451A		
	Model code/Part number: 660 / 7R0111-7021		Customer: TRMX	Car Model: TOYOTA-SEQUOIA	Revision No.: 4 Page No.: 2 of 4		
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO							

PARTS:	1. Assy parts 2. Black Corrugated tube (no slit) Ø5 L=166±3mm 3. Yellow tape			JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Black Corrugated tube (no slit) Ø5 L=166±3mm	<div><p>1. Get the assy part and combine the V-V wires L=377mm using both hands and get the terminal cover jig using right hand.</p></div> <div><p>2. Get the corrugated tube (no slit) Ø5 L=166±3mm using right hand and insert the wires using left hand.</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div>		<div>TERMINAL COVER JIG</div> 	1. No wrong usage of parts 2. No deformed terminal tip
3	P1 Taping 1 Black corrugated tube to wire near terminal	<div><p>1. Hold the COT using left hand, get the Yellow tape using right hand then start pre-taping using both hands.</p></div> <div><p>2. Measure from end of COT up to terminal pointed tip 74±3mm then continue the taping process using both hands.</p></div> <div><p>3. Make 1/3 shifting on wires until it measures from end tape up to terminal pointed tip 35+3mm/-1mm.</p></div> <div><p>4. After taping, check the measurement, terminal appearance and taping condition.</p></div>		<div>MEASURING TAPE</div> 	<div>Wire alignment tolerance</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> <p>Important reminders/Note/s: 1. USE YELLOW TAPE ONLY 2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document references: 1. Refer to WI-ENG-PDE-588 for Tape and tube end standard tolerance</p>

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PARTS:		1. Assy parts 2. Black Corrugated tube (no slit) $\varnothing 5$ L=156 \pm 3mm 3. Black tape		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	<div></div> <div>1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the B-B wires using left hand.</div> <div></div> <div>2. Get the corrugated tube (no slit) $\varnothing 5$ L=156\pm3mm using right hand then insert the B-B wires using left hand.</div> <div></div> <div>3. After insertion, remove the terminal cover jig using right hand.</div>		<div>TERMINAL COVER JIG</div> 	1. No wrong usage of parts 2. No deformed terminal tip

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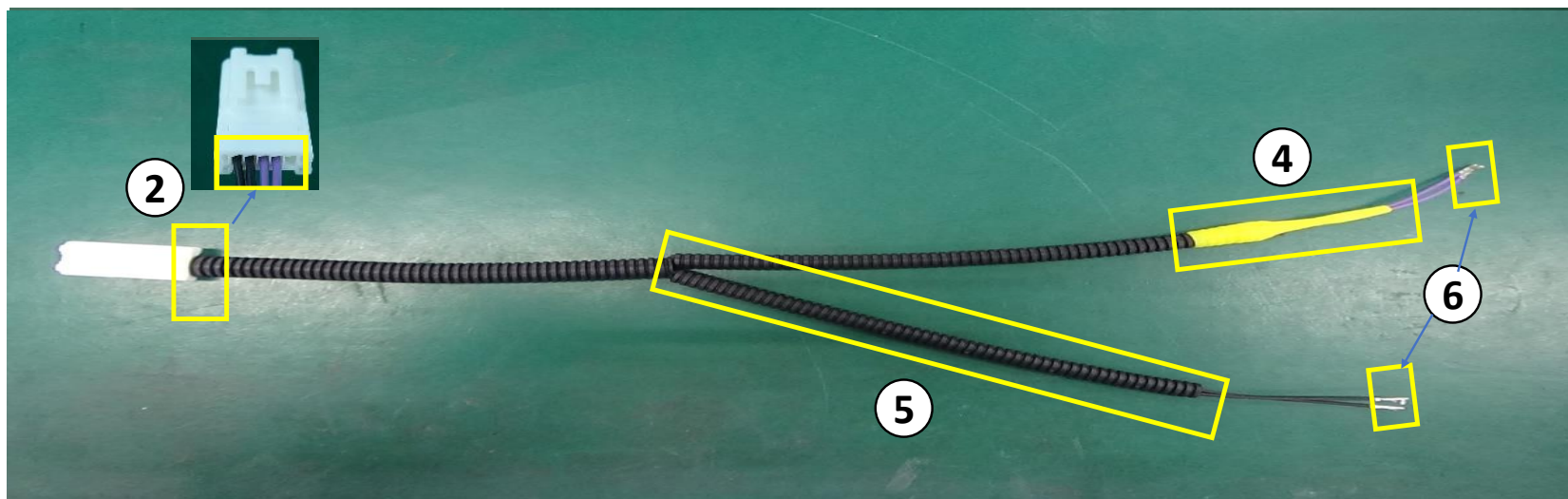
4 fo 4

PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P1****7R0111-7021****GOOD****NO GOOD****① No Unlock/Halflock connector****② No Wrong Insert****③ No Terminal Backing Out****④ No Missing Tape/No Wrong use of tape
(Yellow tape)****⑤ No Missing/Wrong use of COT****⑥ No Deform Terminal**

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