



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model code/Part number:

410D/412D / 7N0235-7020A

Customer: TRJ

Car Model:

LEXUS-ES

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

December 03, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1121C

Revision No.:

0

Page No.:

1 of 6

PARTS:

1. Assy parts; Black VM tube (Sunprene) Ø9 L=101±3mm

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

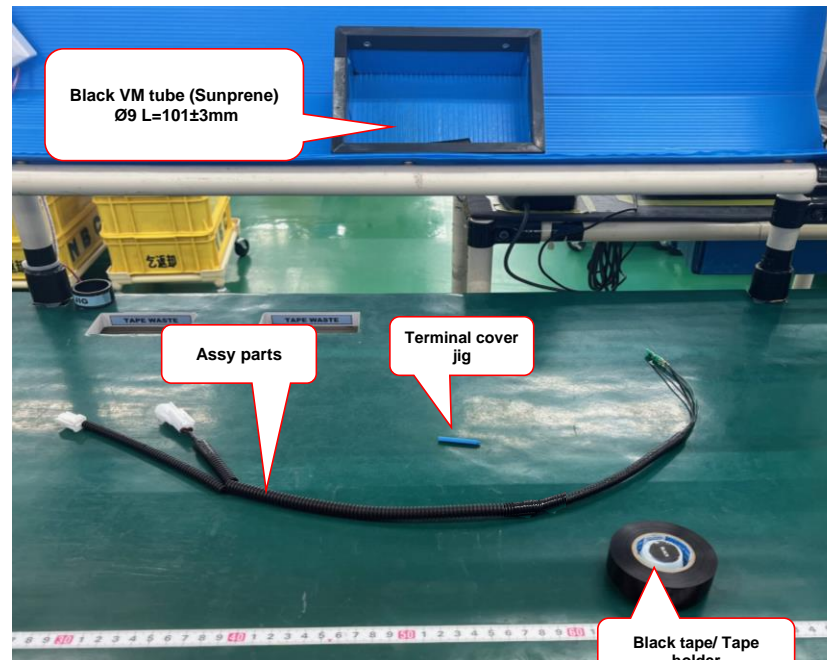
QUALITY POINTERS

1

P3

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 positions of parts/tools


Revision History

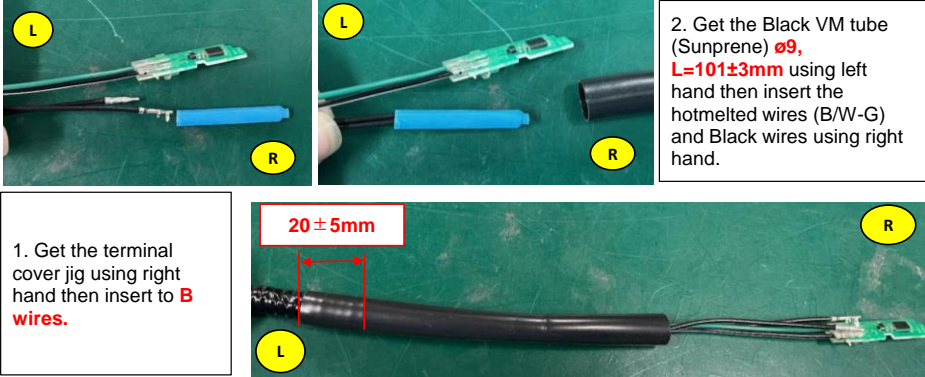

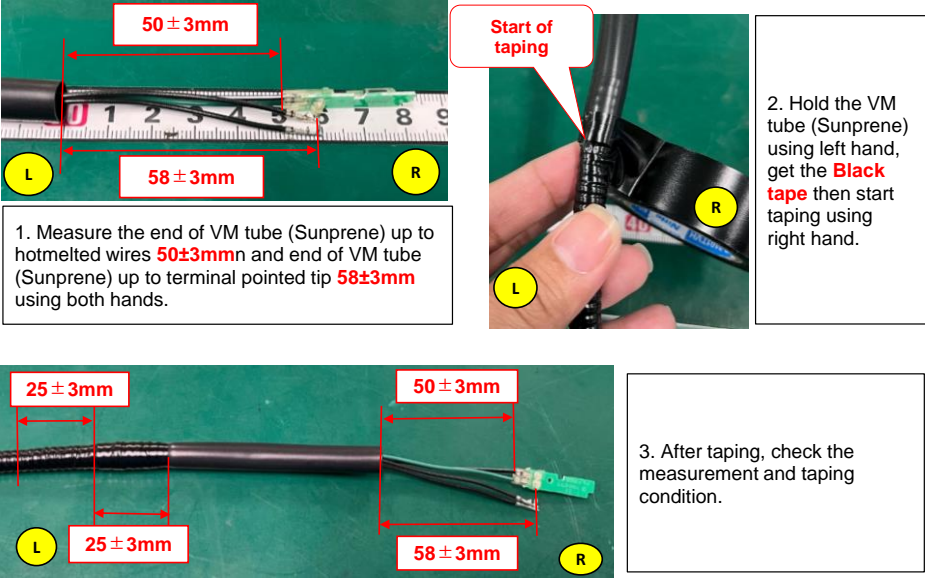

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
12/03/24	0	Initial issue.					D.Castillo	C. Villanueva	A. Arañes	n/a

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	Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Document No.:	WI-ENG-PDE-1121C	
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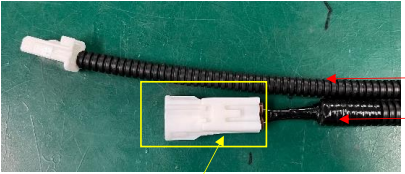
PARTS:	1. Assy part 2. Black tape 3. Black VM tube (Sunprene) ø9, L=101±3mm			JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Black VM tube (Sunprene) ø9, L=101±3mm	 <p>2. Get the Black VM tube (Sunprene) ø9, L=101±3mm using left hand then insert the hotmelted wires (B/W-G) and Black wires using right hand.</p> <p>1. Get the terminal cover jig using right hand then insert to B wires.</p>		 <p>Terminal cover jig</p>	1. No wrong usage of parts 2. No deformed terminal
3	P3 Taping 4 Black Corrugated tube to VM tube (Sunprene)	 <p>2. Hold the VM tube (Sunprene) using left hand, get the Black tape then start taping using right hand.</p> <p>1. Measure the end of VM tube (Sunprene) up to hotmelted wires 50±3mm and end of VM tube (Sunprene) up to terminal pointed tip 58±3mm using both hands.</p> <p>3. After taping, check the measurement and taping condition.</p>		 <p>MEASURING TAPE</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 7. No insufficient taping Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. Document reference/s: 1. Refer to WI-PRO-ASY-001A for taping procedure.

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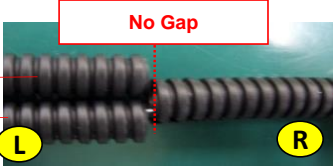
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PARTS:		1. Assy part 2. Black tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
4	P3	Y-taping				



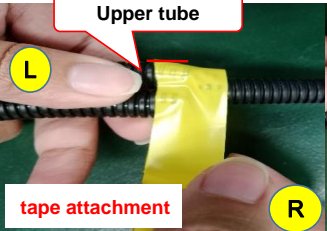
CONNECTOR ORRECT FACING




No Gap



1. Fix the 3 corrugated tube.
Note: Follow the connector correct facing.




Upper tube



pre-tape

2. Start taping at the middle of combined tubes, attach the tape on the upper tube. Then make pre-tape **2 windings**.
Note: Do not exert excessive force during pulling & winding of tape.

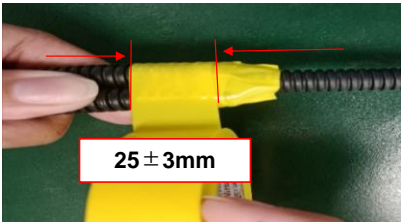


tape attachment

taping direction

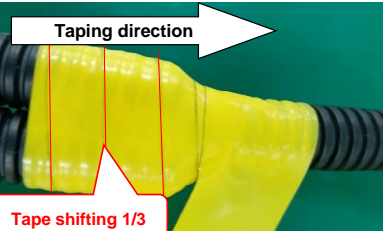
Tape shifting 1/2

3. Winding the tape **1/2 shifting** going to the left side.



25 ± 3mm

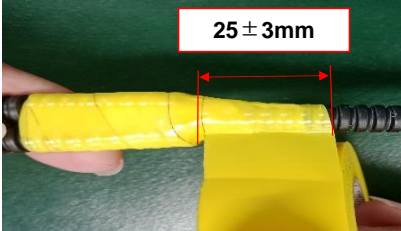
4. Make **2 windings**, width must be **25±3mm**.



Taping direction

Tape shifting 1/3

5. Winding the tape **1/3 shifting** going to the right side until reach the other side of tube.



25 ± 3mm

6. Make **2 windings**, width must be **25±3mm**.


Document reference/s:
1. Refer to WI-PRO-ASY-001C for taping procedure (special).

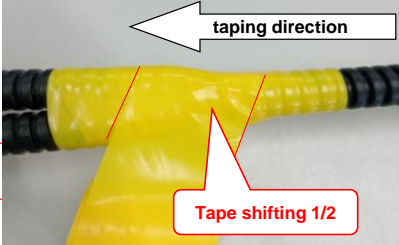
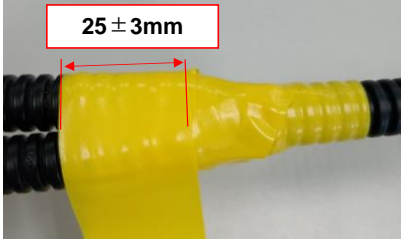
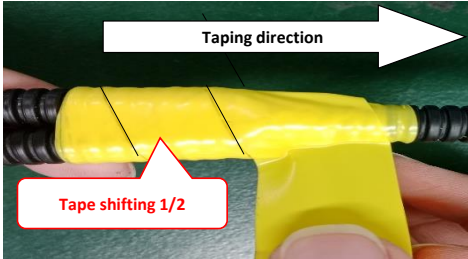
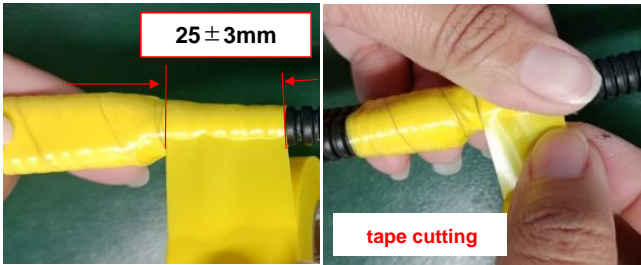

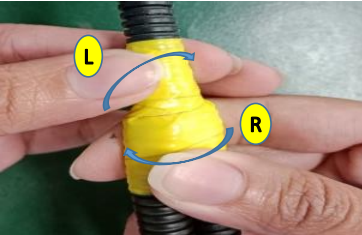
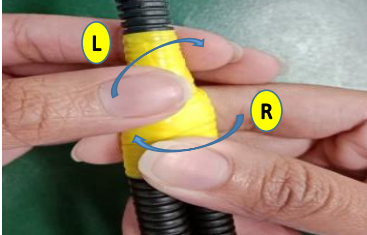
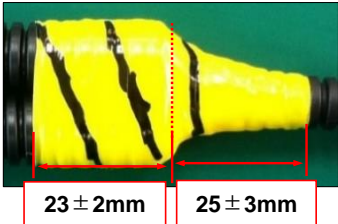
Important reminders/Note/s:
1. Use **yellow tape** for easy visualization of tape shifting, but actual should be **BLACK TAPE**.
2. Please use calibrated/verified measuring tape when getting the measurement.

1. No loose tape
2. No flip-out tape
3. No peel-off tape
4. No wrong use of tape
5. No wrong dimension-out tape
6. No exposed wire
7. No gap between tubes

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PARTS:		1. Assy part 2. Black tape			JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
4	P3 Y-taping (Continuation)	<div><p>7. Winding the tape 1/2 shifting going to the left side.</p></div> <div><p>8. Make 2 windings, width must be 25±3mm.</p></div> <div><p>9. Winding the tape 1/2 shifting going to the right side until it reach the other side of tube</p></div> <div><p>10. Make 3 winds, width must be 25±3mm. Then cut the tape.</p></div> <div><p>11. conduct proper pressing of end tape using left hand (top part). <i>Note: Reference only.</i></p></div> <div><p>12. conduct proper pressing of end tape using left hand (Middle part). <i>Note: Reference only.</i></p></div> <div><p>13. conduct proper pressing of end tape using left hand (bottom part). <i>Note: Reference only.</i></p></div> <div><p>14. Check the Measurement and condition of tape.</p></div>			<p>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>Important reminders/Note/s: 1. Use yellow tape for easy visualization of tape shifting, but actual should be <u>BLACK TAPE</u>. 2. Please use calibrated/verified measuring tape when getting the measurement.</p> <ul style="list-style-type: none">1. No loose tape2. No flip-out tape3. No peel-off tape4. No wrong use of tape5. No wrong dimension-out tape6. No exposed wire7. No gap between tubes		

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PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

0

Page No.:

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PARTS:

1. Assy parts

JIG:

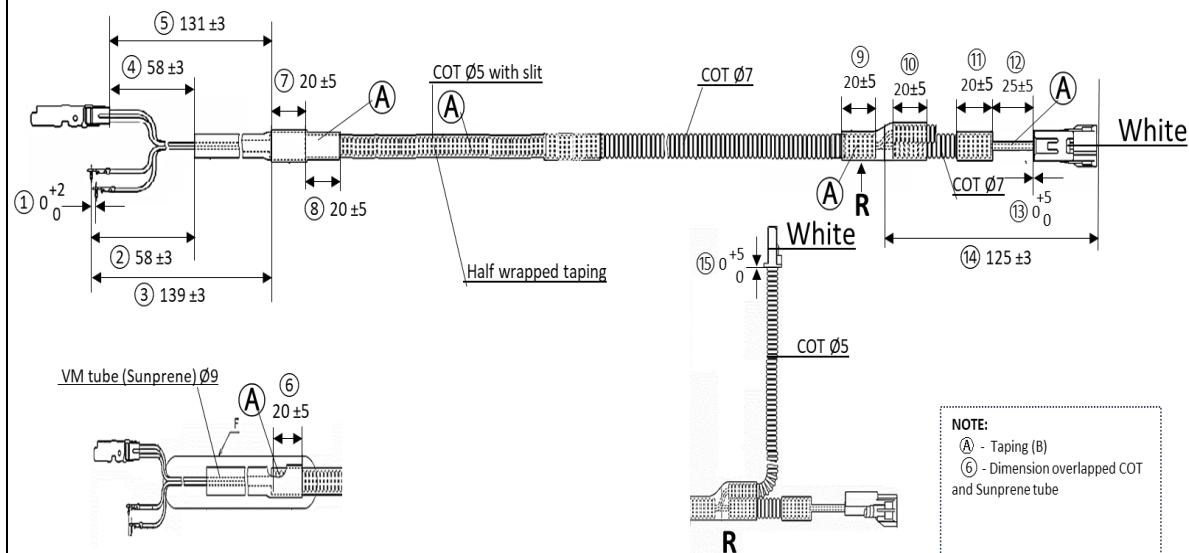
n/a

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

5

P3

Measurement

**MEASURING
TAPE****Important reminders and note/s:**
1. Please use calibrated/verified measuring tape when getting the measurement.**2. For Hatsumono and Owarimono.****Document reference/s:****1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection**

1. No wrong dimension

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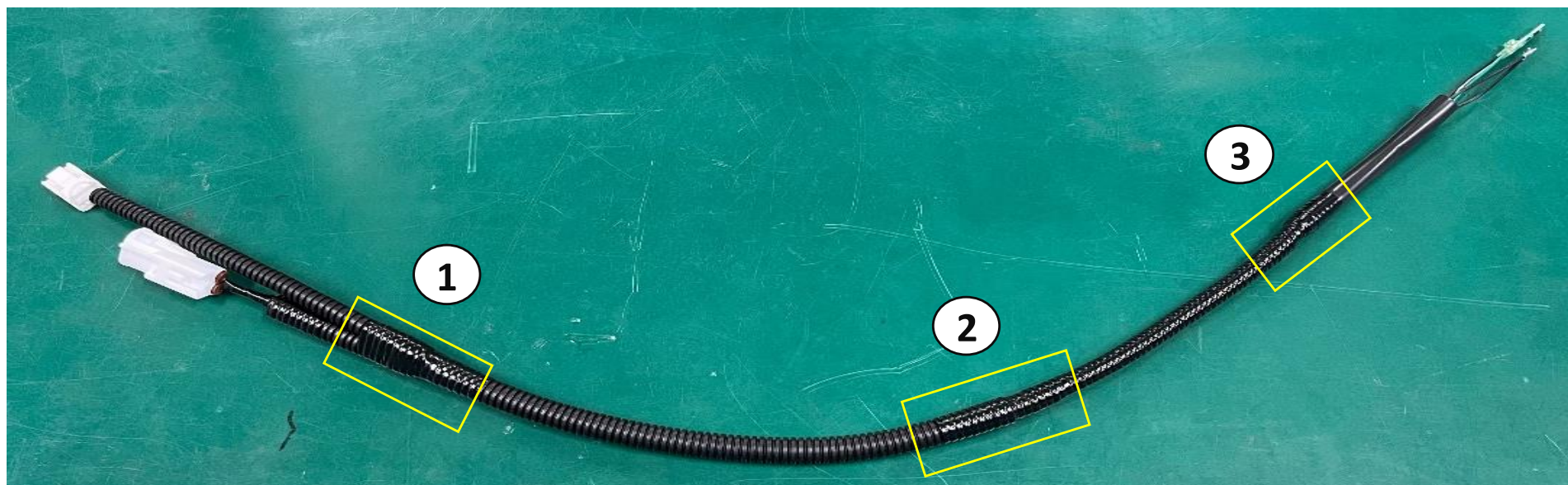
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P3****7N0235-7020A****1****2****3****No Missing Tape**

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