



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 30, 2024

Model code/Part number:

423B / 7M0468-7020D

Customer:

TRJ

Car Model:

LEXUS RX

Document No.:

WI-ENG-PDE-253A

Purpose:

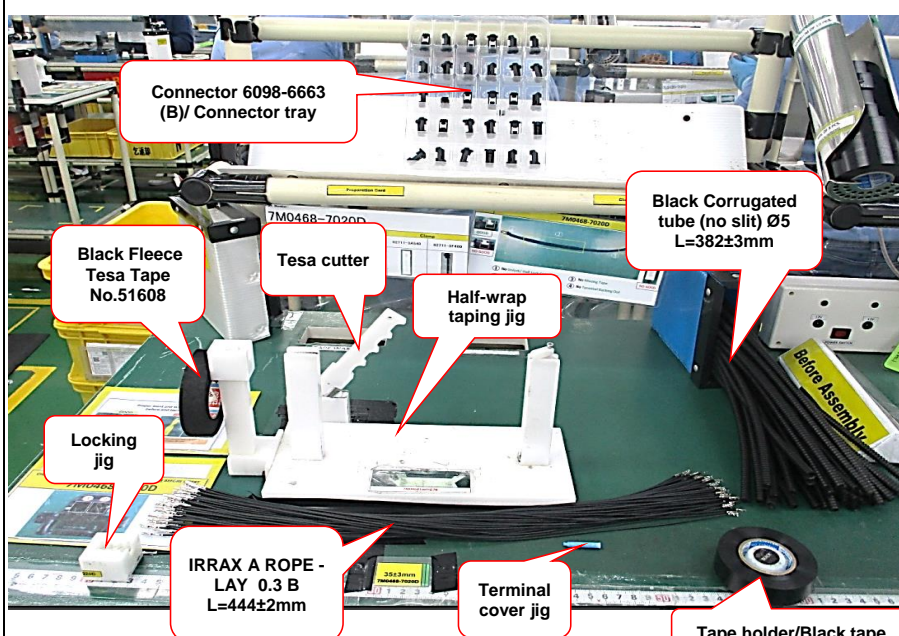
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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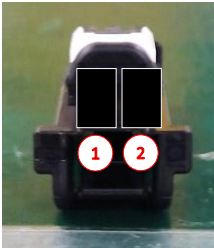

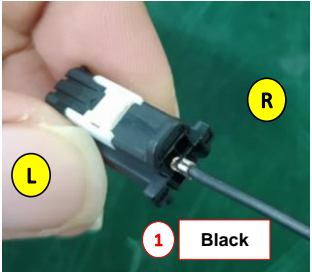
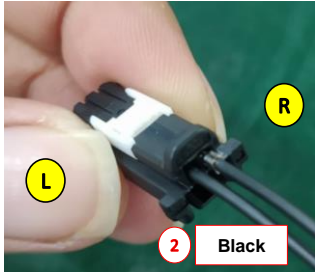
PARTS:				1. Connector 6098-6663 (B); IRRAX A ROPE -LAY 0.3 B L=444±2mm; Black Fleece Tesa Tape No.51608; Black Corrugated tube (no slit) Ø5 L=382±3mm; Black tape				JIG:		1. Locking jig 2. Terminal cover jig 3. Half-wrap taping jig					
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS					
1		P1		Table Lay-out				<div>TABLE LAY-OUT</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>1. No missing parts/ tools. 2. No excess parts/tools.</div> <div>Doument reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</div>			
Revision History								Prepared by		Reviewed by		Approved by		Noted by	
10/30/24		3		Inclusion of Quality checkpoints.				D.Castillo		C. Villanueva		A. Arañes		n/a	
09/14/22		2		Change of tolerance from 35+/-3mm to 35(+3/-1mm) as countermeasure of encountered NG dimension from end of tape to terminal pointed tip. Additional table lay-out. Improve: Work procedure/Illustration on process no.2, 3, 4 and 5; Quality pointers and notes on page no. 1, 2, 3 and 5				M. Ariola		J. Loterte		C. Villanueva		A. Arañes	
3/19/21		1		Transfer process owner from Production (WI-PRO-ASY-113A) to Engineering (WI-ENG-PDE-252A). Change part number due to "removal slit in 25mm" and removal of taping to COT. Apply some improvements.				M. Ariola		J. Loterte		C. Villanueva		A. Arañes	
Eff. Date		Rev. No		Details of Change				Revised		Reviewed		Approved		Noted	
										Est. Date:		November 5, 2018			

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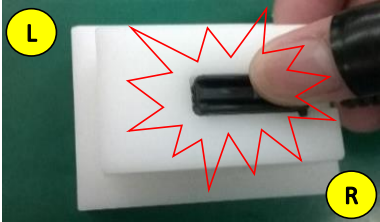


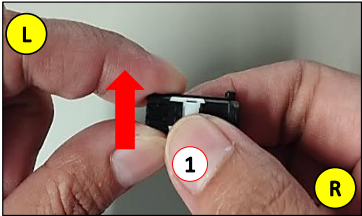
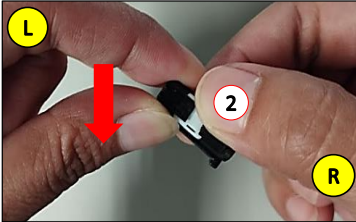
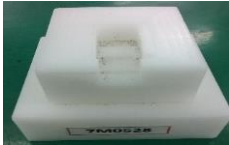
PARTS:	1. Connector 6098-6663 (B) 2. AVSSf 0.3 B L=444mm [2pcs]			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to connector 6098-6663 (B)	<div><p>CONNECTOR ORIENTATION</p></div> <div><p>VISUAL REFERENCE</p></div> <div><p>Wire facing</p></div> <div><p>1. Hold the connector 6098-6663 (B) then get the first Black wire and insert to terminal slot 1 using right hand. Conduct 2x push pull after wire insertion.</p></div> <div><p>2. Hold the connector 6098-6663 (B) then get the second Black wire and insert to terminal slot 2 using right hand. Conduct 2x push pull after wire insertion.</p></div>		n/a	<p>1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing</p> <p>Important reminders/note/s:</p> <p>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>2. Insertion of wire must be from left to right.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</p> <p>2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	3	Page No.:	3 of 7


PARTS:	1. Assy parts			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1	<div><div></div><div>1. Put the connector into locking jig using both hands then press 2x.</div><div></div><div></div><div></div><div></div><div>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</div></div>		<div><div>LOCKING JIG</div></div>	<p>Important reminders/note/s:</p> <p>1. Manual locking may cause damaged connector lock.</p> <p>1. Use provided jig tool per model 2. No unlock/half-locked connector</p>



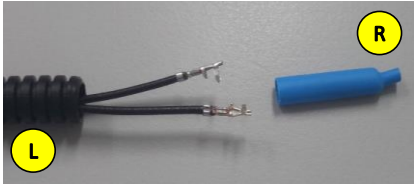

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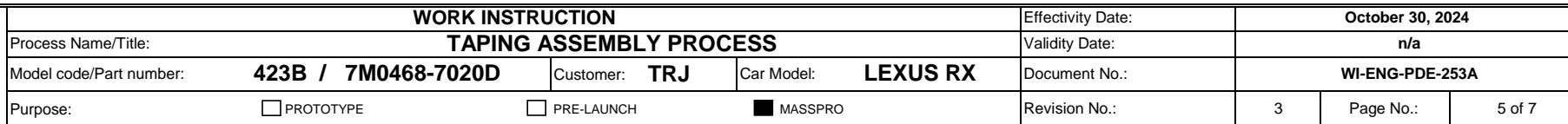
PARTS:	1. Black Corrugated tube (no slit) Ø5 L=382±3mm 2. Assy parts			JIG:	1. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	P1	<div><div><p>1. Get the terminal cover jig using right hand and insert the wires using left hand.</p></div><div><p>2. Get the black corrugated tube (no slit) Ø5 L=382±3mm using right hand and insert the wires using left hand.</p></div><div><p>3. Remove the terminal cover jig after insertion.</p></div></div> <div><div>TERMINAL COVER JIG</div></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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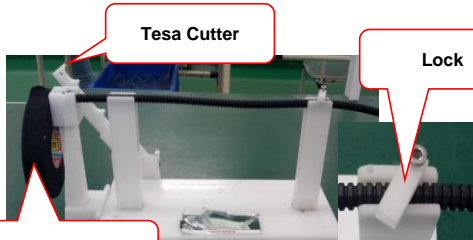


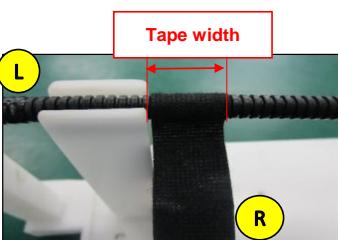




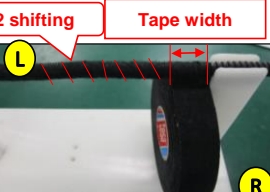




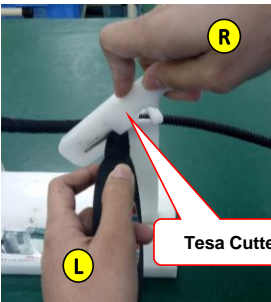

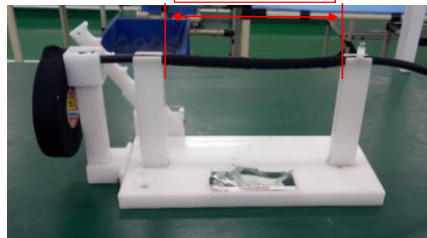


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PARTS:		1. Black Fleece Tesa Tape No.51608 2. Assy parts		JIG:	Half wrap taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1 Half wrap taping (Tesa tape)	<div><div><div></div><div></div><div><p>1. Get the assy parts (see above picture for correct setting) and then put it on jig using both hands. Set the connector to receiver base up to cot guide and lock.</p><p>2. Get the Tesa tape and start taping using right hand. Make 2 windings before shifting.</p></div><div></div><div></div><div><p>3. Make 1/2 shifting until COT are fully covered then make 2 windings.</p><p>4. Get the tesa cutter using right hand then cut the tape.</p></div><div></div></div></div>		<div></div>	<div><div><h3>TESA TAPE CONDITION</h3><p>Whitish appearance of Tesa Tape due to thickness variation Judgement: GOOD</p></div><div><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</p></div></div>

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423B / 7M0468-7020DCustomer: **TRJ**

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LEXUS RX

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1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P1****7M0468-7020D**

1



1

No Unlock/Halflock Connector

2

No Missing tape (Half wrap TESA tape)

2

3

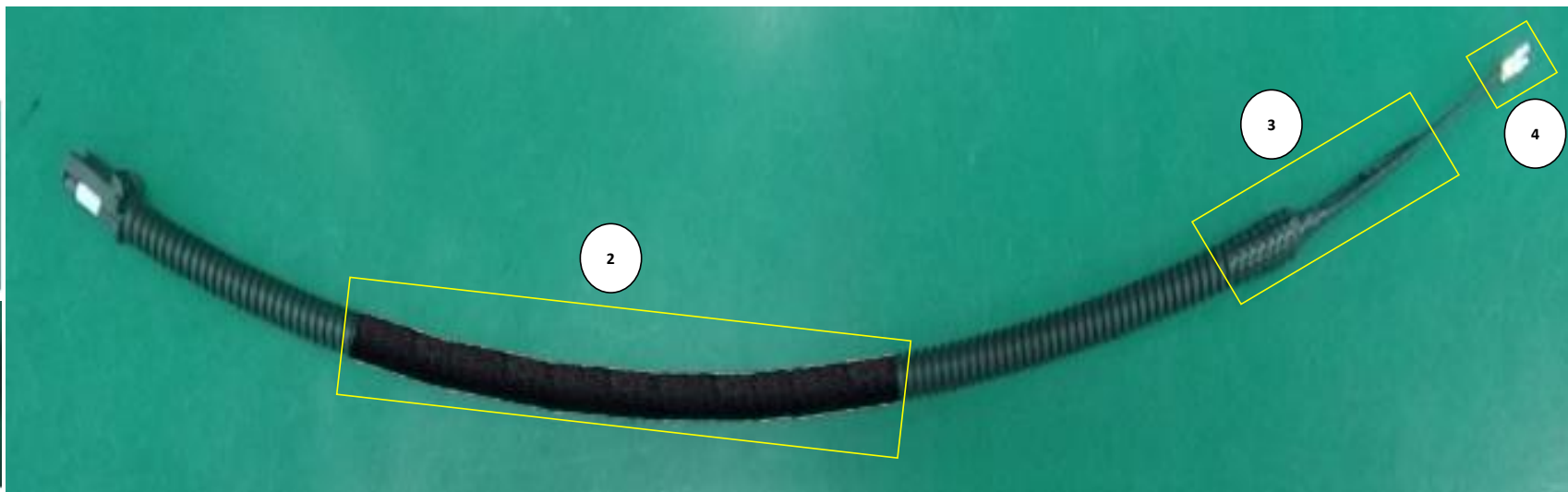
No Missing tape (COT to wire near terminal)

4

No Deformed terminal

3

4



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