



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

September 21, 2023

Model code/Part number:

382D

/

7N0175-7020A

Customer: TRJ

Car Model:

TOYOTA-CAMRY

Document No.:

WI-ENG-PDE-727C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

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PARTS:

1. Assy parts
2. Black tape

3. Black VM tube (Sunprene) $\varnothing 9$ L= 89 \pm 3mm

JIG:

1. Spot taping jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

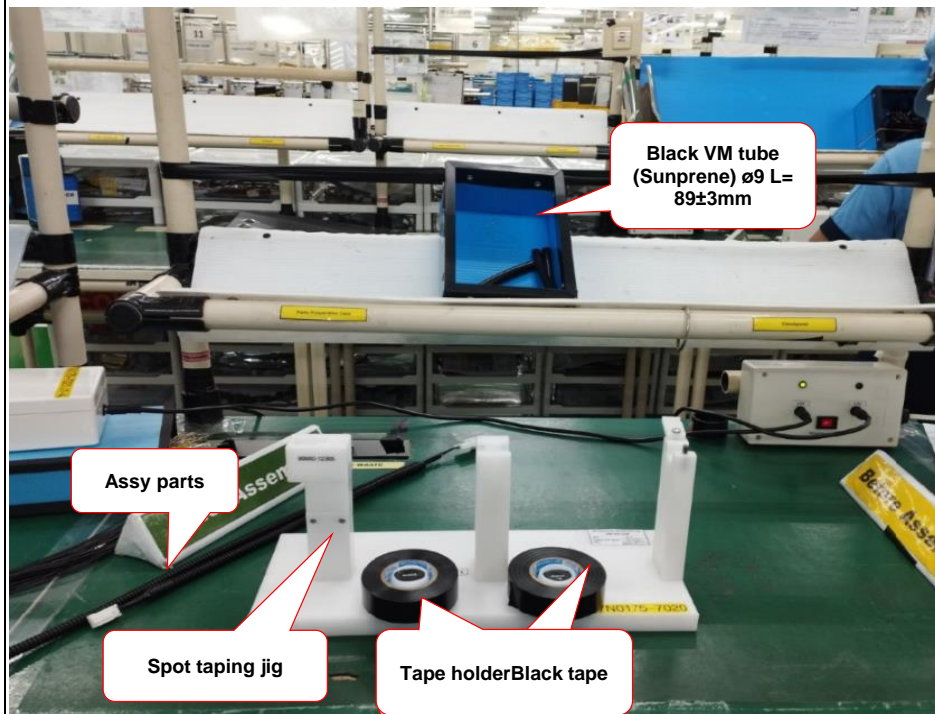
QUALITY POINTERS

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

Revision History

Prepared by

Reviewed by

Approved by

Noted by

09/21/23

0

Initial Issue; Excluded process from **WI-ENG-PDE- 727B** due to new process distribution; Change purpose from pre-launch to mass pro. Update Quality Checkpoint; Remove process of Wire insertion to VM tube (Sunprene) and Taping 1 from Black Corrugated tube to Black VM tube (Sunprene)

M. Mañalac

J. Loterte

C. Villanueva

A. Arañes

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

September 21, 2023

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PARTS:		1. Assy parts 2. Black tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3 Y-taping	<div><div>No gap between tubes</div><div>1. Fix the corrugated tube and vinyl tube. Follow the correct connector orientation.</div><div>2. Start taping at the middle of combined COT & SV tube (Vinyl), then wind the tape going to 2 corrugated tubes (2 windings), width must be same with tape (19mm)</div><div>3. Wind the tape 1/3 shifting until it reach the vinyl tube (must be tape width)</div><div>4. Wind the tape backward 1/2 shifting</div><div>5. Wind the tape 1/2 shifting going to SV tube (Vinyl). Cover the SV tube (Vinyl) & wire 1/3 shifting. Measure SV tube (Vinyl) up to connector 25±3mm then make 3 winds on wire before cutting of tape.</div><div>6. Check the tape condition.</div></div>	<div>MEASURING TAPE</div>	<div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</div> <div>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Used yellow tape to easily visualize the tape shifting but actual should be <u>BLACK TAPE</u></div>

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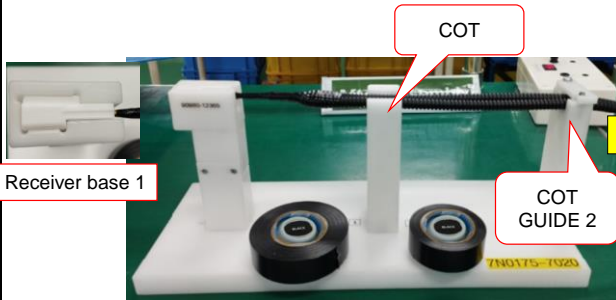
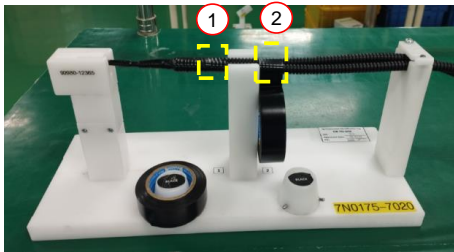
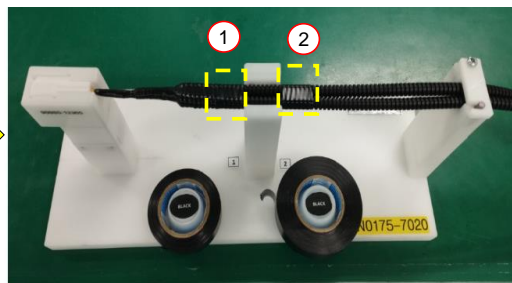
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PARTS:		1. Assy parts 2. Black tape [2pcs]		JIG:	1. Spot taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P3	Spot taping			
		<div><div><p>Receiver base 1</p><p>COT</p><p>COT GUIDE 2</p></div><div><p>1. Get the assy parts and set into spot taping jig using both hands. (See above picture for correct setting). First, set the connector 6098-3802 (W) in Receiver base 1. 2nd, Combine the 2 COT then set to COT guide 1 and COT guide 2 then lock.</p></div><div><p>1 2</p></div><div><p>3. Hold the black tape on location 2 (right side) and start spot taping using both hands. Make 2 windings of tape (Must be Tape width) then cut the tape.</p></div></div> <div><div><p>1 2</p></div><div><p>4. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</p></div></div>		<div><p>2. Fix the 2 Corrugated tube. Get the black tape and start spot taping on location 1 (left side) using right hands. Make 2 windings of tape (Must be Tape width) then cut the tape. Proceed to location 2 then continue the process</p></div> <div><p>1. No peel-off 2. No wrong location 3. No missing tape 4. Check the offset spot tape</p><p>Important reminders/Note/s: 1. Inside spot tape (black) 0-2mm is accepted</p></div>	

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PARTS:

n/a

JIG:

n/a

QUALITY CHECKPOINTS**P3****7N0175-7020A****1****No Missing Tape****on Y-taping and VM tube (Sunprene)****2****No Missing Spot Tape****(Conduct point checking for spot taping)**

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