



## WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

October 22, 2024

Model code/Part number:

178D / 7N0128-7021C

Customer:

TRJ

Car Model:

TOYOTA-COROLLA

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-1093B

Revision No.:

1

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## PARTS:

1. Assy parts; Black tape [2pcs]

JIG:

1. Insertion jig
2. Locking jig
3. Terminal cover jig
4. Spot Taping jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

## TOOLS/PPE

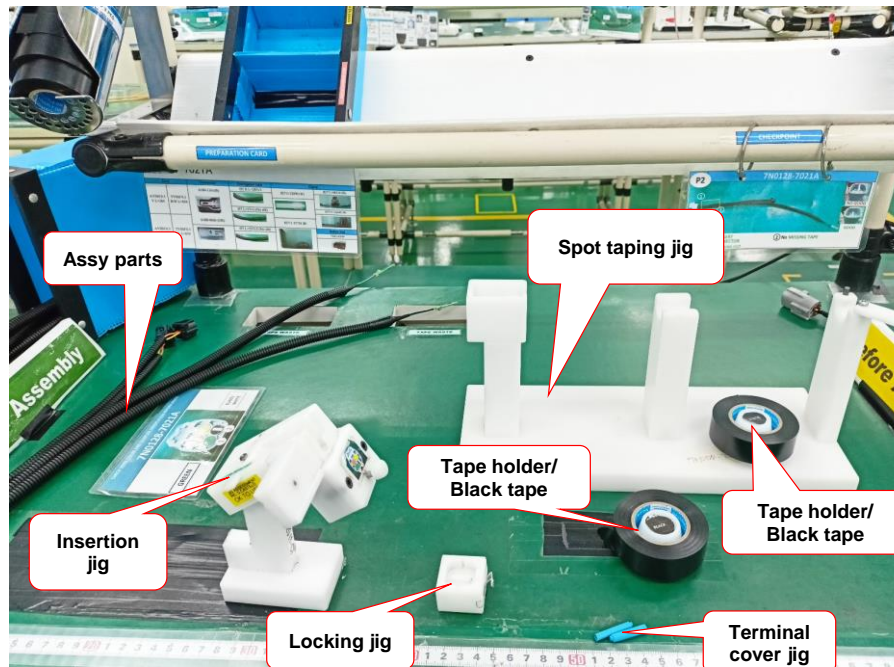
## QUALITY POINTERS

1

P2

Table Lay-out

## TABLE LAY-OUT

**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.

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

## Revision History

Prepared by

Reviewed by

Approved by

Noted by

10/22/24 1 Change purpose from Pre-launch to Masspro.

M.Ariola

C. Villanueva

A. Arañes

n/a

10/17/24 0 Initial issue. Update the illustration of Visual Inspections/Quality Checkpoints

M.Ariola

C. Villanueva

A. Arañes

n/a

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

October 17, 2024

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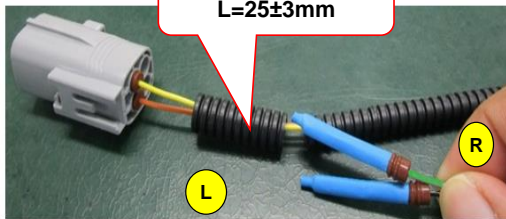
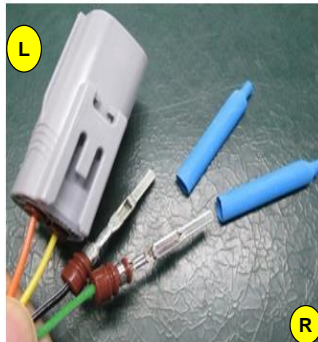

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PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2	Wire insertion to assy parts			
		<div><div><p>1. Get the <b>MRSW CP G-B/W wires L=655±3mm</b> using both hands then insert the terminal cover jig using right hand.</p></div><div><p>2. Get the assy parts then hold the COT (no slit) <b>Ø7 L=25±3mm</b> using left hand then insert the <b>MRSW CP G-B/W wires L=655±3mm</b> using right hand.</p></div><div><p>3. After insertion, remove the cover jig using right hand.</p></div></div> <div><div>TERMINAL COVER JIG</div></div> <div>1. No wrong usage of parts 2. No damaged rubber seal 3. No exposed rubber seal during insertion</div>			

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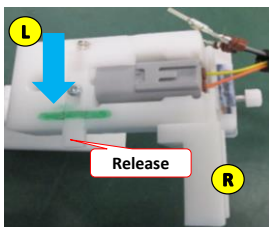
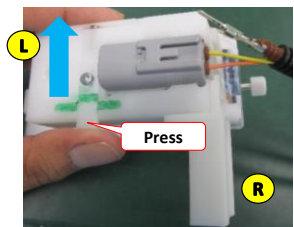
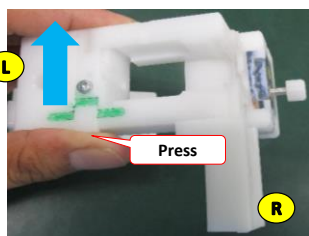
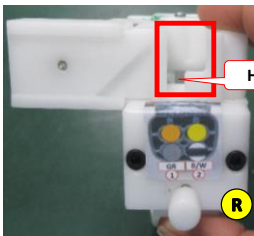
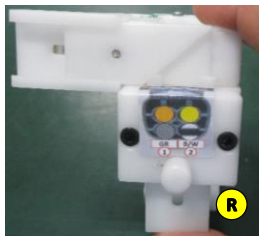

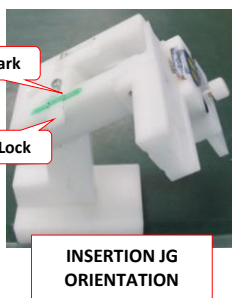
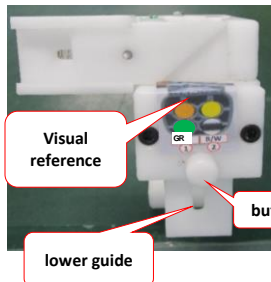
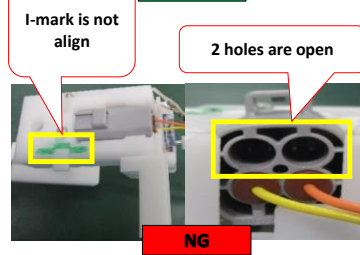
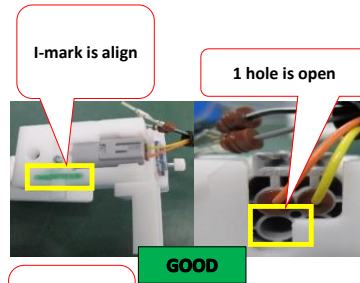
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PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	<div>Connector setting to insertion jig 6188-0066 (GR) (Assy parts)</div> <div><p>1. Push the lower wire guide upward using right thumb. Slot for <b>Green wire</b> will be opened.</p><p>2. Press the lock of insertion jig using left thumb.</p><p>3. Get the connector <b>6188-0066 (GR)</b> using right hand and insert to insertion jig. Release the lock after insertion. <b>Note: Follow the connector orientation.</b></p></div>		n/a	<div><b>CONNECTOR ORIENTATION ILLUSTRATION</b></div> <div><p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p><p><b>Important reminders/Note/s:</b> <b>1. Follow the connector orientation</b></p></div>

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☐ PROTOTYPE

☐ PRE-LAUNCH


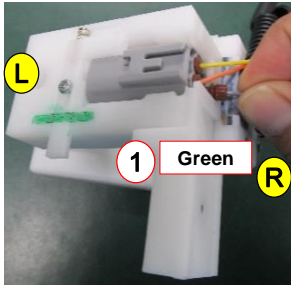

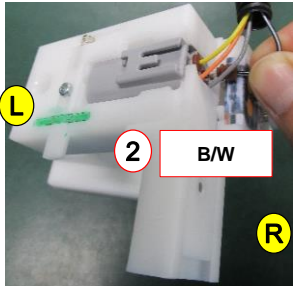
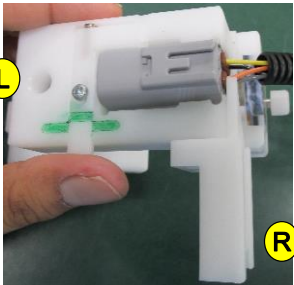
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PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2  Wire insertion to connector 6188-0066 (GR) (Assy parts)	<div><p>TERMINAL FACING</p></div> <div><p>1 Hold the <b>G wire</b> then insert to terminal slot <b>1</b> using right hand.</p></div> <div><p>2. Press the button using right thumb. The slot for <b>B/W wire</b> will be opened.</p></div> <div><p>3. Hold the <b>B/W wire</b> then insert to terminal slot <b>2</b> using right hand.</p></div> <div><p>4. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</p></div>	n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div><b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal.</b> <b>2. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b></div> <div><b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b></div>

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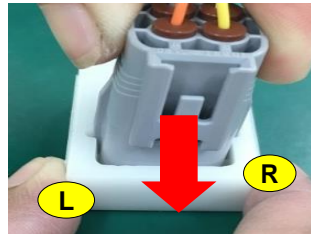
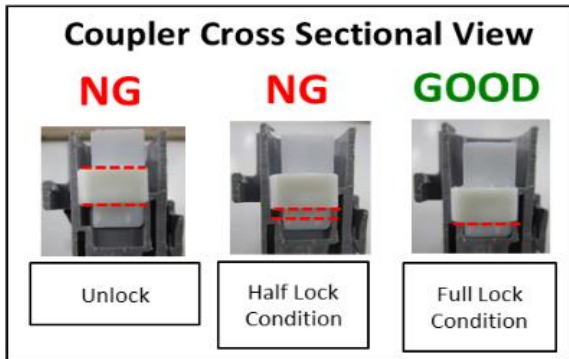



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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2	Connector Lock	<div><p>1. Put the connector into locking jig using right hand then press <b>2x</b>. Touch the connector lock to confirm if properly locked.</p></div> <div></div>	<div><p>Before pressing</p></div> <div><p>After pressing</p></div> <div><p>LOCKING JIG</p></div>	<p><b>Important reminders /Note/s:</b></p> <p><b>1. MANUAL LOCKING MAY CAUSED DAMAGED LOCK</b></p> <p>1. Use the provided locking jig per model 2. No unlock/half-locked connector</p>

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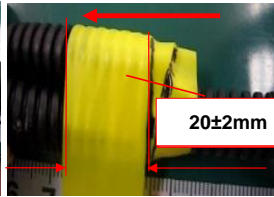
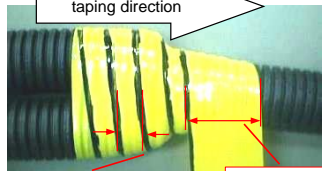
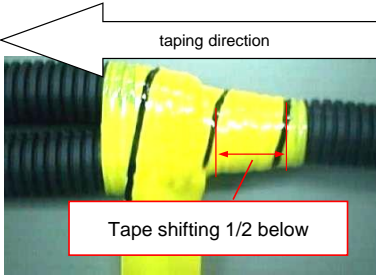


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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P2	Y-taping	<div><div>NO GAP BETWEEN CORRUGATED TUBES</div><div></div><div>1. Fix the corrugated tube .</div><div></div><div></div><div>20±2mm</div><div>2. Start taping at the middle of combined Corrugated tubes, then winding the tape to left side width must be same with (20±2mm)</div><div></div><div>taping direction</div><div>Tape shifting 1/3 below</div><div>20±2mm</div><div>3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be same with 20±2mm)</div><div></div><div>taping direction</div><div>Tape shifting 1/2 below</div><div>4. Wind the tape backward 1/2 shifting.</div></div>	<div>MEASURING TAPE</div> <div></div>	<p><b>Important reminders and Note/s:</b></p> <p>1. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines, but actual should be <b>BLACK TAPE</b>.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <p>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</p> <p><b>Y-TAPING ORIENTATION</b></p> <div></div>

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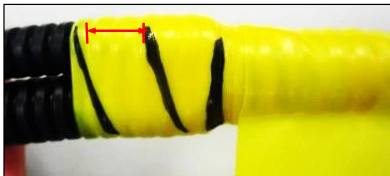
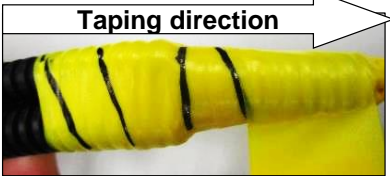

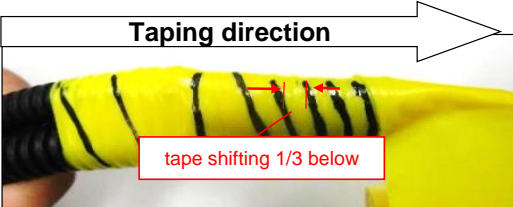
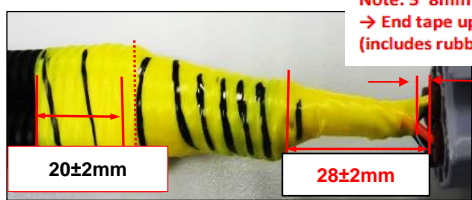
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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P2	Y-taping (Continuation)	<div></div> <div>5. Wind the tape 1/2 shifting going to other side of corrugated tube.</div> <div></div> <div>Taping direction</div> <div>6. Make the half of tape outside the COT then wind it 2-3 times as Pre-Taping.</div>	<div>MEASURING TAPE</div> <div></div>	<p><b>Important reminders and Note/s:</b></p> <p>1. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines, but actual should be <b>BLACK TAPE</b>.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <p>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</p>
			<div></div> <div>Taping direction</div> <div>tape shifting 1/3 below</div> <div></div> <div>Note: 5~8mm → End tape up to connector (includes rubber seal)</div> <div>20±2mm</div> <div>28±2mm</div> <div>8. After taping, check the measurement and taping condition.</div>		

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☐ PRE-LAUNCH


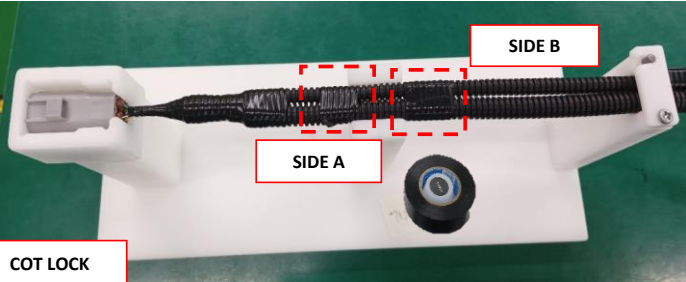
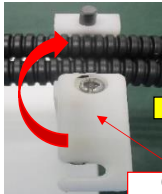
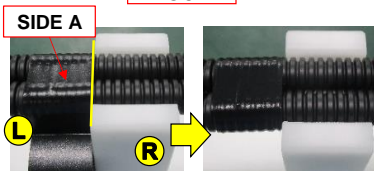
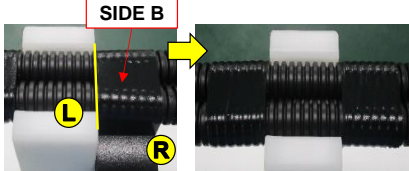

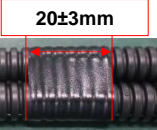

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PARTS:		1. Assy parts 2. Black tape		JIG:	1. Spot taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P2  Spot taping	<div><div><p>CONNECTOR SETTING</p></div><div><p>COT LOCK</p></div><div><div><p>COT LOCK</p></div><div><p>SIDE A</p></div><div><p>SIDE B</p></div><div><p>1. Get the assy parts then set into jig using both hands. <i>(See above picture for correct setting).</i> First, set the connector <b>6188-0066 (GR)</b> to <b>Receiver base</b>. Continue to set the <b>2 COT</b> in the <b>COT guide</b> then lock.</p></div><div><p>2. Hold the assy parts using left hand, get the <b>Black tape</b> then conduct <b>2 windings</b> of tape on <b>SIDE A</b> then cut using both hands.</p></div><div><p>3. Hold the assy parts using left hand, get the <b>Black tape</b> then conduct <b>2 windings</b> of tape on <b>SIDE B</b> then cut using both hands.</p></div><div><div><p>20±3mm</p></div><div><p>20±3mm</p></div><div><p>4. Check the measurement and taping condition.</p></div></div></div><div><p>MEASURING TAPE</p></div></div>		<p><b>Important reminders and Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></p> <p>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</p>	

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P2	Measurement	<div><p>MEASURING TAPE</p></div>		<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>

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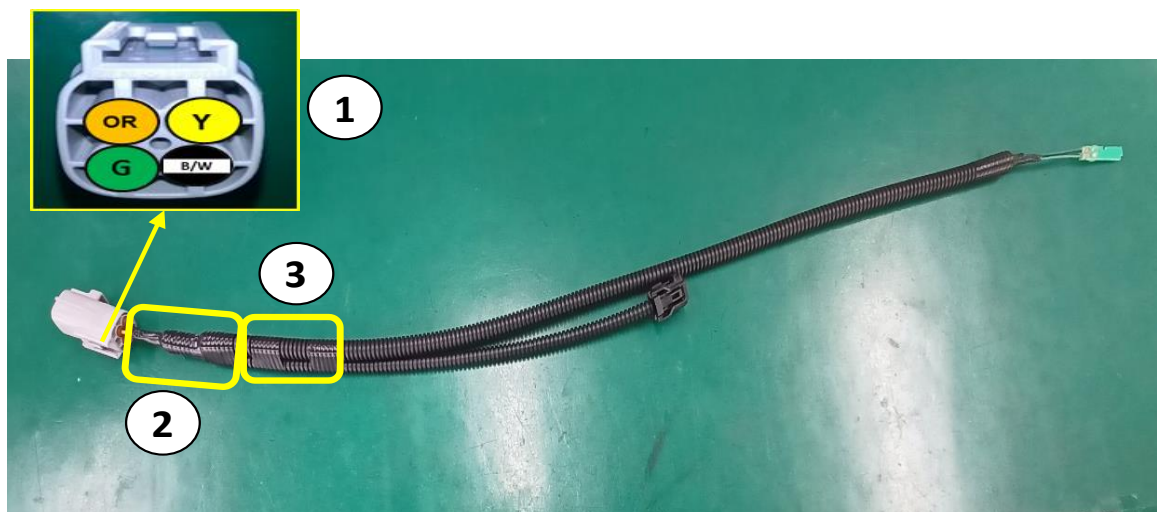
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P2****7N0128-7021C**

- ① No Wrong insert
- ② No Missing tape
- ③ No Missing spot tape
- ④ No Wrong Facing of Connector (Y-taping)

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