

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

July 21, 2023

Validity Date:

n/a

Model code/Part number:

100B / 7M0595-7021

Customer:

TRJ

Car Model:

LEXUS (TOYOTA) UX

Document No.:

WI-ENG-PDE-430C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

1 of 9

PARTS:1. Assy parts; Black VM tube (Sunprene) $\varnothing 9$ L=93 \pm 3mm

JIG:

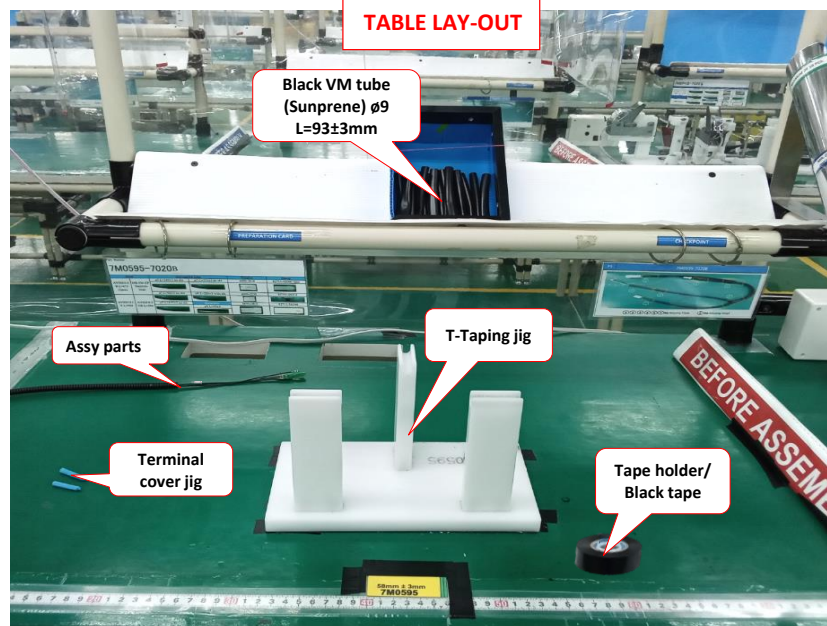
1. T-Taping jig
2. Terminal cover jig

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

1

P3

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

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
07/21/23	2	Updated template; Inclusion of CAR MODEL "LEXUS (TOYOTA) UX" .	M.Ariola	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
03/07/23	1	Standardized tube description: VM tube (Sunprene); Inclusion of Quality Checkpoint on page no. 10	M.Ariola	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
03/01/22	0	Initial Issue	M.Ariola	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes

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PARTS:

1. Assy parts

JIG

1. Terminal cover jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

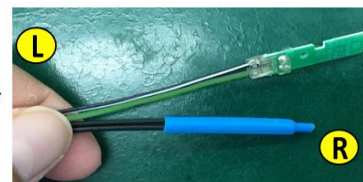
TOOLS/PPE

QUALITY POINTERS

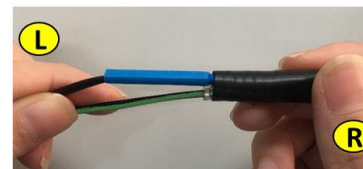
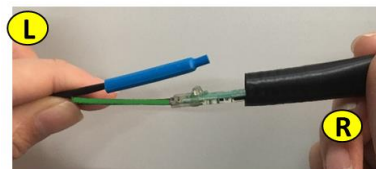
2

P3

Wire insertion to
Black VM Tube
(Sunprene)
ø9 L=93±3mm

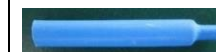


1. Get the terminal cover jig using right hand then insert the terminal **B-B wires** using left hand.

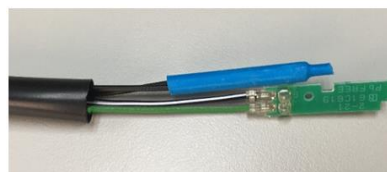


2. Hold the Black VM Tube (Sunprene) **ø9 L=93±3mm** using right hand then Insert first the **hotmelted wires** and then next the **B-B wires** with cover jig using left hand.

TERMINAL COVER JIG



1. No wrong use of parts
2. No deformed terminal
3. No wires left during insertion



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Page No.:

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

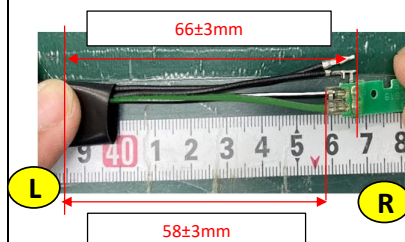
TOOLS/PPE

QUALITY POINTERS

3

P3

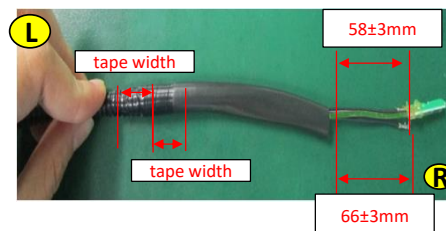
Taping 1
Black Corrugated tube
to
Black VM Tube (Sunprene)



1. Measure the end of the Black VM Tube (Sunprene) up to the edge of hotmelt **58±3mm** and Black VM Tube (Sunprene) up to terminal pointed tip **66±3mm**.



2. Hold the Black VM Tube (Sunprene) using left hand then start taping using right hand.



3. After taping, check the dimension, terminal appearance and taping condition.

MEASURING TAPE



1. No peel-off tape
2. No flip out tape
3. No loose tape
4. No wrong use of tape
5. No wrong dimension

Important reminders/Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.

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☐ PRE-LAUNCH

☒ MASSPRO

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4 or 9

PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

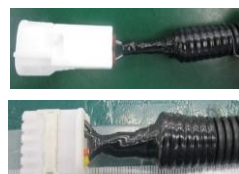
TOOLS/PPE

QUALITY POINTERS

4

P3

Y-Taping 1

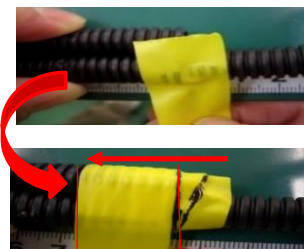


NO GAP BETWEEN CORRUGATED

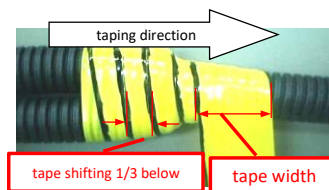
L

R

1. Fix the corrugated tube . Follow the correct orientation of connectors.



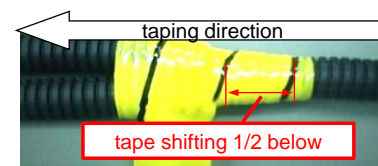
2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side , width must be same with tape (19mm)



tape shifting 1/3 below

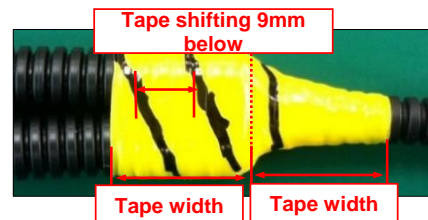
tape width

3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape



tape shifting 1/2 below

4. Wind the tape backward **1/2 shifting**



Tape shifting 9mm below

Tape width

Tape width

5. Wind the tape **1/2 shifting** going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.

MEASURING TAPE



Important reminders/Note/s:

1. Used **Yellow** tape to easily visualize the tape shifting. But actual should be **Black**.
2. Please use calibrated/verified measuring tape when getting the measurement.
3. Do not exert extra force during pulling & windings of tape.

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PARTS:

1. Assy parts
2. Black tape

JIG

1. T-Taping jig

NO.

PROCESS NAME

WORK PROCEDURE/ILLUSTRATION

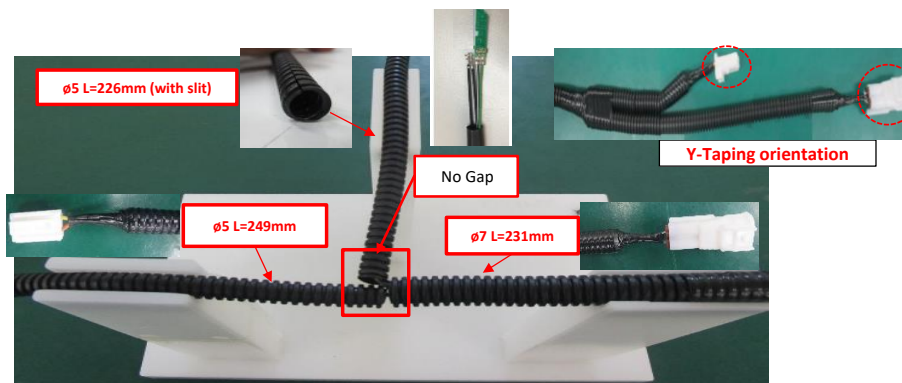
TOOLS/PPE

QUALITY POINTERS

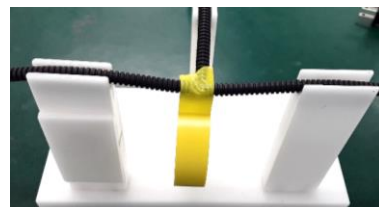
5

P3

T-taping



1. Arrange the 3 corrugated tube to form **inverted T** into jig using left and right hand.



2. Start taping at the middle to fix the **3 corrugated** tubes using both hands. The tape must attached to all corrugated tubes.



3. Wind the tape from front to back at the right side.

T-TAPING JIG



1. No peel-off tape
2. No flip out tape
3. No loose tape
4. No wrong use of tape
5. No wrong dimension

Important reminders/Note/s:

1. Used **Yellow** tape to easily visualize the tape shifting. But actual should be **Black**.
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3. Do not exert extra force during pulling & windings of tape.

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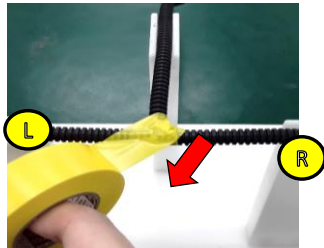
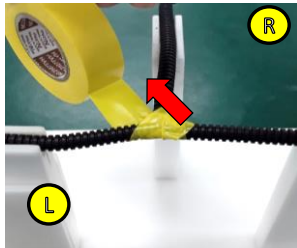

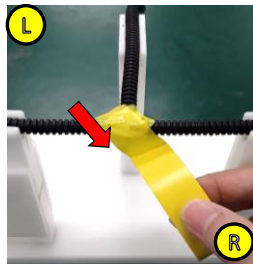
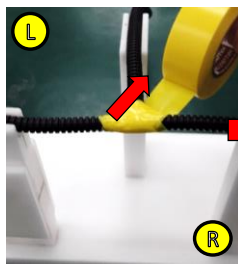
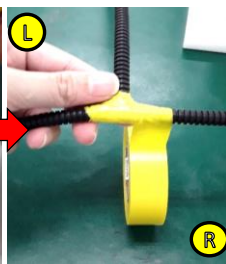
☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape		JIG	1. T-Taping jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P3	T-taping (Continuation)	<div><div><p>4. Wind the tape from back to front (cross pattern).</p></div><div><p>5. Wind the tape from front to back at the left side.</p></div></div>		<div><div>T-TAPING JIG</div></div>	<div>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension</div> <div>Important reminders/Note/s:</div> <div>1. Used <u>Yellow</u> tape to easily visualize the tape shifting. But actual should be <u>Black</u>. 2. Please use calibrated/verified measuring tape when getting the measurement. 3. Do not exert extra force during pulling & windings of tape.</div>
			<div><div><p>6. Wind the tape from back to front (cross pattern).</p></div><div><p>7. Repeat the process from ③~⑥ 3 times.</p></div><div><p>8. Remove the harness for T-taping jig then tape the right side corrugated tube (3 windings), width must be same as tape (19mm).</p></div></div>			

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

5

P3

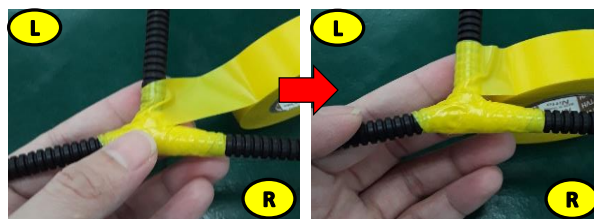
T-taping
(Continuation)



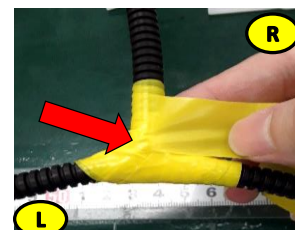
9. From the right side, wind the tape **2/3 shifting** going to center.



10. Wind the tape from front to back side (**cross pattern**).



11. Tape the top side corrugated tube (**3 windings**), width must be same as tape (**19mm**).



12. From the top side, wind the tape **2/3 shifting** going to center.

n/a

1. No peel-off tape
2. No flip out tape
3. No loose tape
4. No wrong use of tape
5. No wrong dimension

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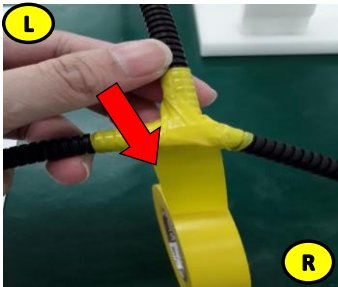
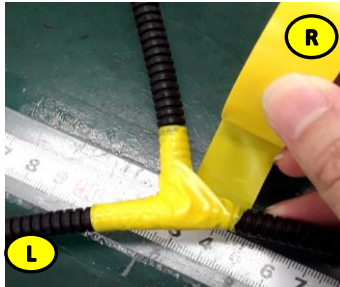
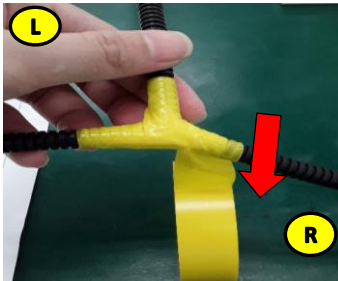
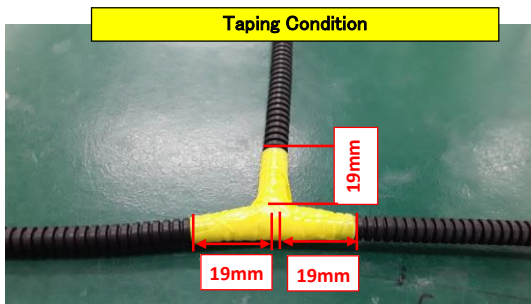
☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
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n/a

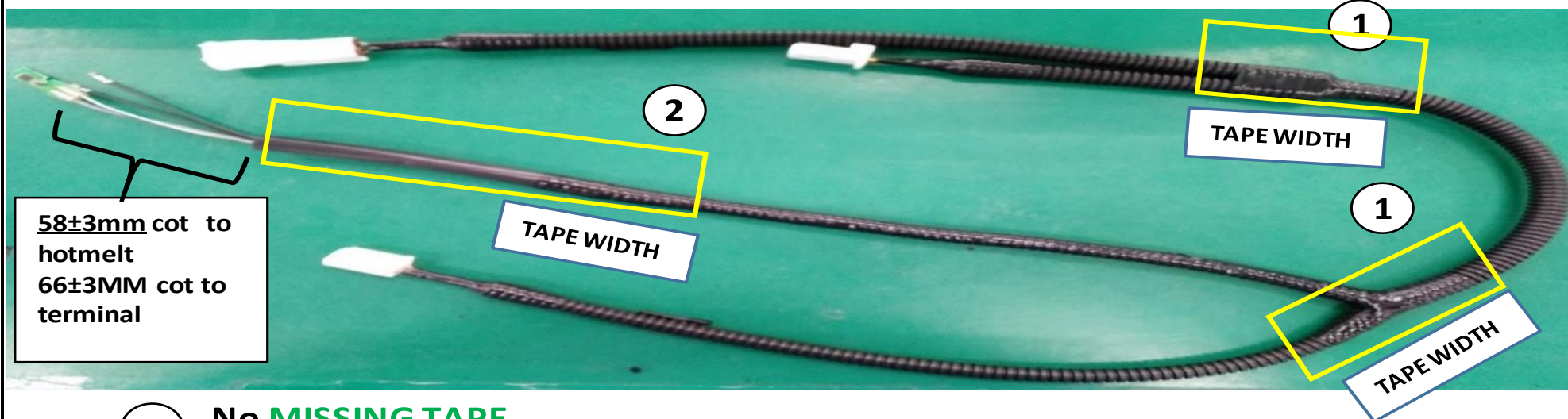
JIG

n/a

QUALITY CHECKPOINTS

P3

7M0595-7021



1

No MISSING TAPE
CORRECT FACING OF T-TAPING
& Y-Taping

2

No Missing SV tube (Vinyl)

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