



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 12, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

780B / 7R0106-7022B

Customer:

TRMX

Car Model:

TOYOTA TUNDR

Document No.:

WI-ENG-PDE-1104

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1. Assy part; Clip type clamp 82711-60270 (L); Black Sunprene tube Ø5 L=125±3mm; Black Corrugated tube Ø5 L=203±3mm (no slit); Black Tape; White Tape

JIG:

1. Measuring jig
2. Terminal cover jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

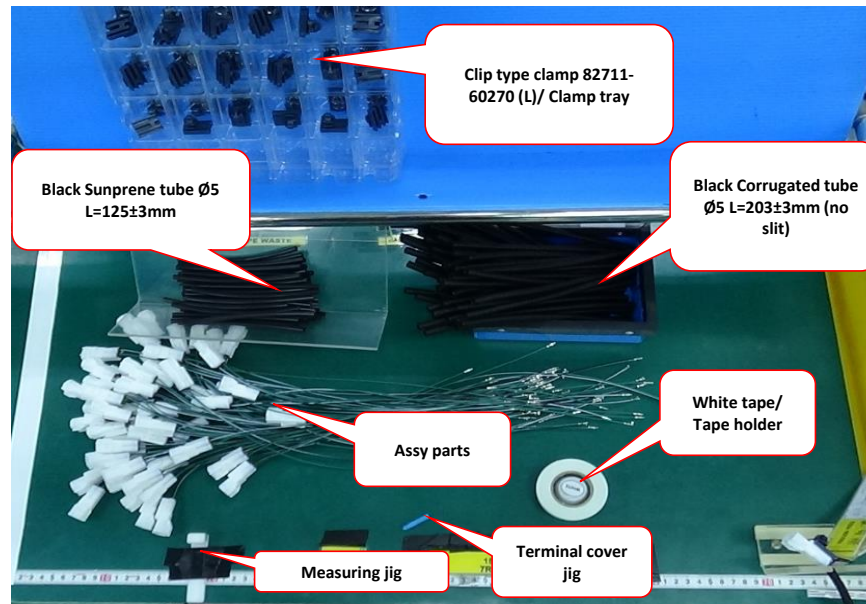
TOOLS/PPE

QUALITY POINTERS

1

P1

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 work place is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

Important reminders/Note/s:

1. Refer to WI-PRO-CNC-017 for wire and Strip Length Tolerance

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

Revision History

Prepared by

Reviewed by

Approved by

Noted by

10/12/24 1 Change pre-launch to mass pro.

A. Hernandez C. Villanueva A. Arañes n/a

10/11/24 0 Initial issue.

A. Hernandez C. Villanueva A. Arañes n/a

Eff. Date Rev. No Details of Change

Revised Reviewed Approved Noted

Est. Date:

October 11, 2024

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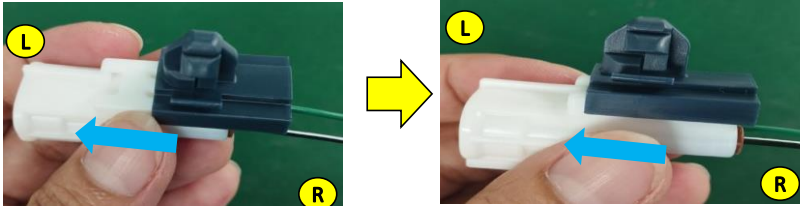
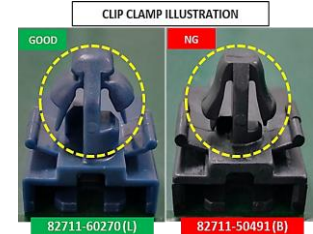
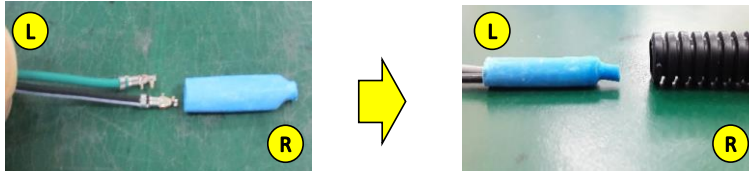


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PARTS:		1. Assy parts 2. Clip type clamp 82711-60270 (L)		3. Corrugated tube Ø5 L=203±3mm (no slit)	JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	Clamp attachment (Clip type Clamp)	 <div>1. Hold the connector using left hand, get the clip type clamp 82711-60270 (L) then insert the clamp using right hand. <i>Note: Sound will be heard if properly inserted.</i></div>			n/a	<div>1. No damaged clamp 2. No wrong use of clamp</div> 
3	P1 Wire insertion to Corrugated tube Ø5 L=203±3mm (no slit)	 <div>1. Get the terminal cover jig using right hand then insert the G and B/W wires.</div> <div>2. Get the Corrugated Ø5 L=203±3mm (no slit) using right hand and insert the G and B/W wires</div> <div>3. After insertion, remove the terminal cover jig using right hand.</div> 			<div>Terminal cover jig</div> 	<div>1. No wrong use of parts 2. No deformed terminal</div>

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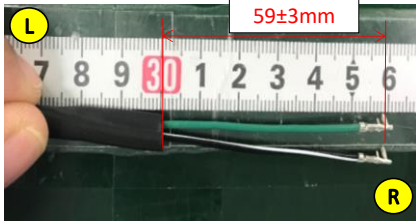
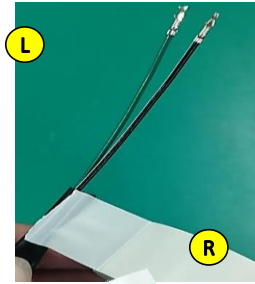
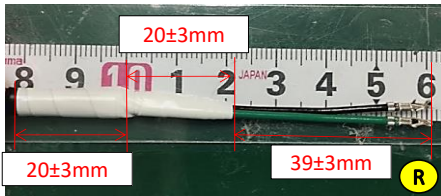

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PARTS:		1. Assy parts 2. Black Sunprene tube Ø5 L=125±3mm 3. White Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	Wire insertion to Sunprene tube Ø5 L=125±3mm	 <div>1. Get the Black Sunprene tube Ø5 L=125±3mm using right hand and insert the G and B/W wires</div>	n/a	1. No wrong use of parts 2. No deformed terminal
5		Taping 1 Sunprene to wire near terminal	 <div>1. Hold the Sunprene tube using left hand. Measure from end of Sunprene up to the terminal pointed tip 59±3mm.</div>  <div>2. Hold the Sunprene tube using left hand. Get White tape using right hand and start taping using both</div>  <div>3. After taping, check the measurement, wire alignment and taping condition.</div>	<div>Measuring tape</div> 	1. No wrong use of parts 2. No deformed terminal

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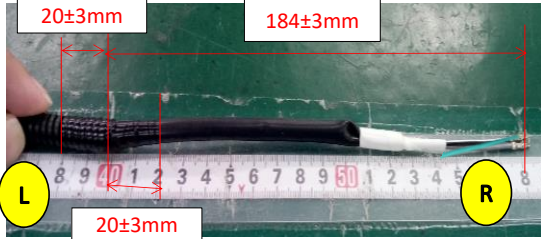
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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1 Taping 1 COT to Sunprene tube near terminal	<div><p>1. Get the assy parts. Hold the COT using left hand. Measure from end of COT up to the terminal pointed tip 184±3mm.</p></div> <div><p>2. Hold the COT using left hand. Get Black tape using right hand and start taping using both hands. Make sure no gap between COT and Sunprene tube.</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>		n/a	<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> <p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p>

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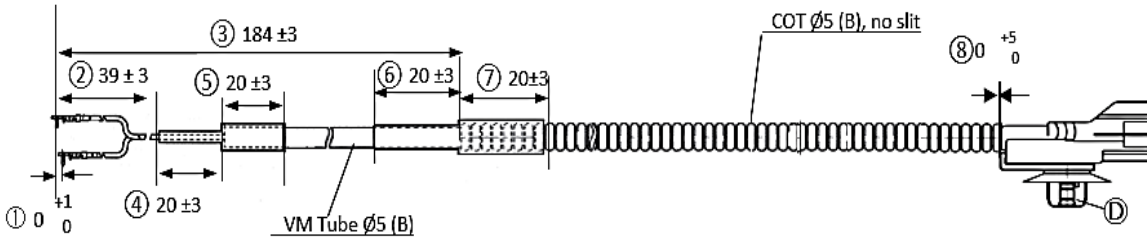
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1 Measurement			<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection.</p> <p>1. No wrong dimension</p>

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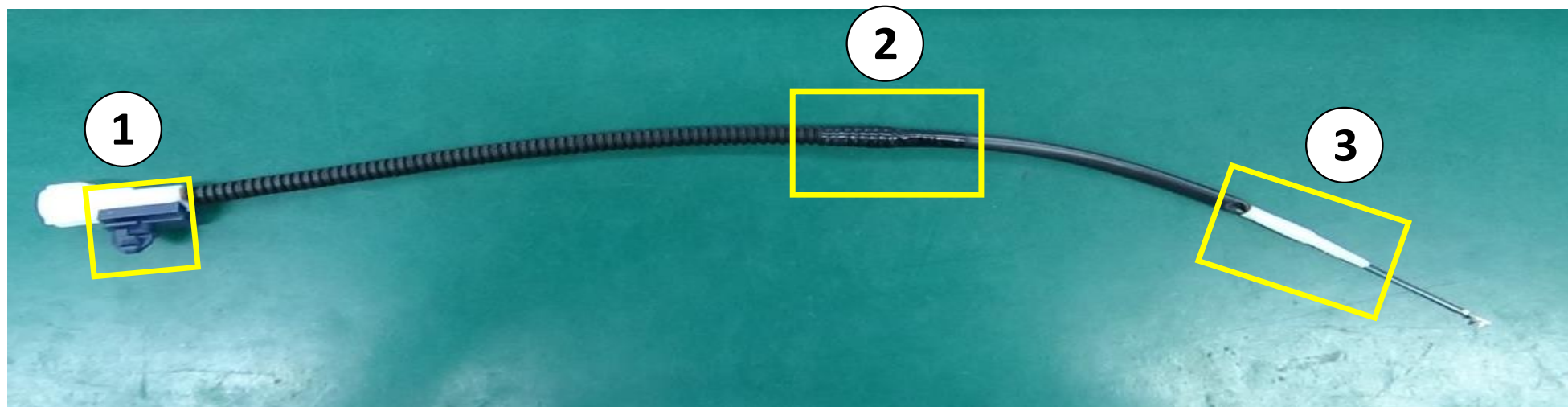
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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P1****7R0106-7022B**

1 No Missing
Clip Clamp

2 No Missing tape/
Wrong use of tape
(BLACK Tape)

3 No Missing tape/
Wrong use of tape
(WHITE Tape)

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