



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 17, 2024

Validity Date:

n/a

Model code/Part number:

164B / 7M0545-7020C

Customer:

TRJ

Car Model:

TOYOTA-AURIS

Document No.:

WI-ENG-PDE-080

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

7

Page No.:

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PARTS:

1. Assy parts; (Black SV tube (Vinyl) Ø5 L=52±2mm); Sky Blue tape

JIG:

n/a

NO.

PROCESS NAME

7

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

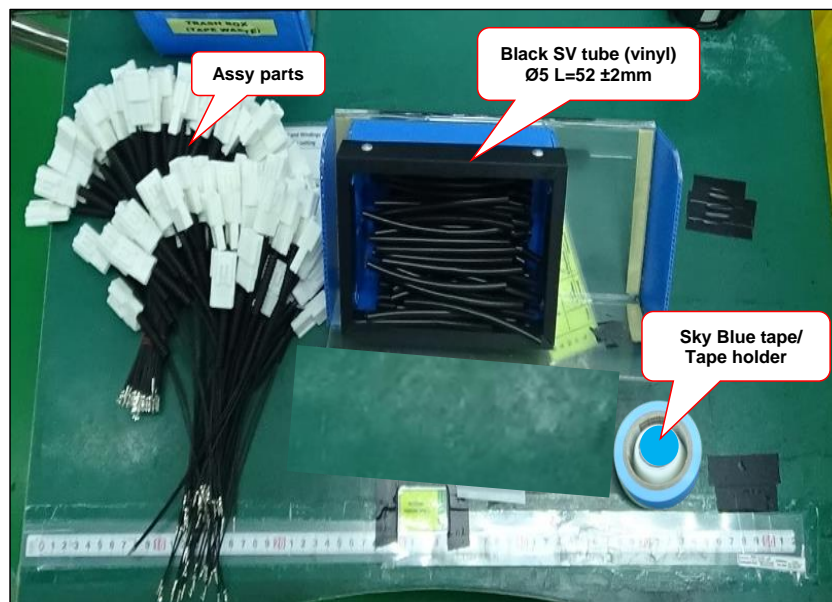
QUALITY POINTERS

1

P1

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.

7

Document references:

1. Refer to WI-ENG-PDE-079 Offline Assembly Process

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

Revision History

Prepared by

Reviewed by

Approved by

Noted by

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	June 6, 2018
05/17/24	7	Transfer to new format. Transfer Wire insertion to COT to Offline assembly process. Inclusion of Table lay-out, Measurement and Visual inspection. Update Work procedure of Connector lock process. Update Quality pointers Important reminders /Note/s. Change term from vinyl tube to SV (Vinyl) tube). Inclusion of car model "TOYOTA-AURIS".	D.Castillo	C.Villanueva	A. Arañes	n/a		
07/07/21	6	Removal of marking.	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes		
02/20/21	5	Remove cycle time; Change connector colours in accordance with color standardization for plastic parts refer to (GL-COM-003); Put assy parts on pg 2; Put measuring tape illustration and instruction on measurement process	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes		

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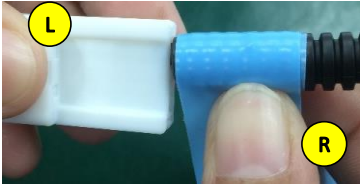

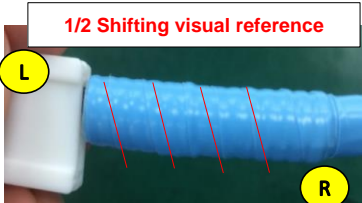

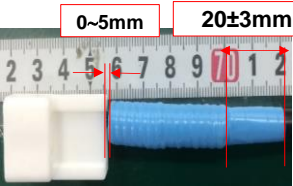

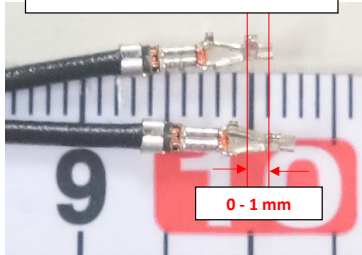
PARTS:		1. Assy parts 2. Black SV tube (Vinyl) Ø5 L=52±2mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1 <div>7</div> Wire insertion to Black SV tube (Vinyl) Ø5 L=52±2mm	<div><div>1. Get the Black SV (Vinyl) tube Ø5 L=52±2mm using left hand then insert the B-B wires (Assy Parts) using right hand.</div></div>		n/a	1. No wrong usage of parts 2. No deformed terminal

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	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 164B / 7M0545-7020C		Customer: TRJ	Car Model: TOYOTA-AURIS	Document No.: WI-ENG-PDE-080		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	7	Page No.:	3 of 5

PARTS:	1. Assy parts 2. Sky Blue tape			JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
3	P1 <div>7 Taping 1 From wire near connector to corrugated tube and from corrugated tube to SV tube (vinyl)</div>	<div><div><p>1. Hold the connector using left hand and tape the wires using right hand. Note: Make 3 times winding.</p></div><div><p>2. Hold the connector using left hand and insert the tape into COT ø5 With Slit using right hand.</p></div><div><p>3. After insertion of tape, Wind the tape 2 times before shifting. Make 1/2 shifting until it covers the COT.</p></div><div><p>1/2 Shifting visual reference</p><p>4. Fix the vinyl tube beside COT. Continue taping until tape width. Wind 3 times, then cut the tape.</p></div><div><p>0~5mm 20±3mm</p><p>35±3mm</p><p>5. After taping, check the condition of tape, measurement and wire alignment.</p></div></div> <div><p>MEASURING TAPE</p></div> <div><div>7 Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. USE SKY BLUE ONLY.</div><div>1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong use of tape 5. No wrong dimension</div><div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div></div>				

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1. Assy parts

JIG:

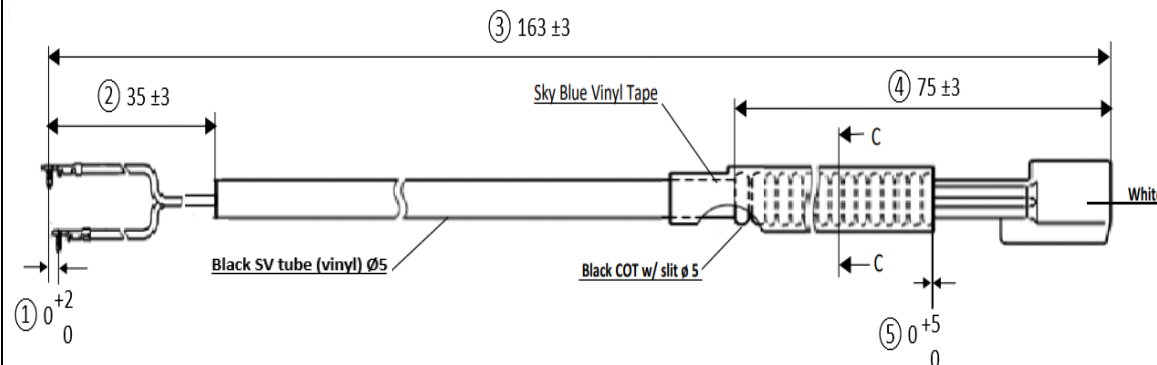
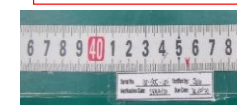
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NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

4

P1

Measurement

**Measuring tape****Important reminders and note/s:**

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

2. For Hatsumono, Nakamono and Owarimono.

Document reference/s:

1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection

1. No wrong dimension

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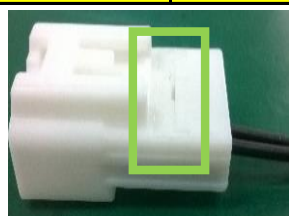
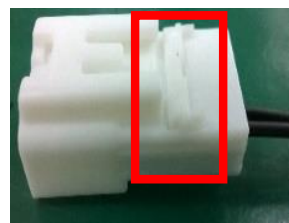
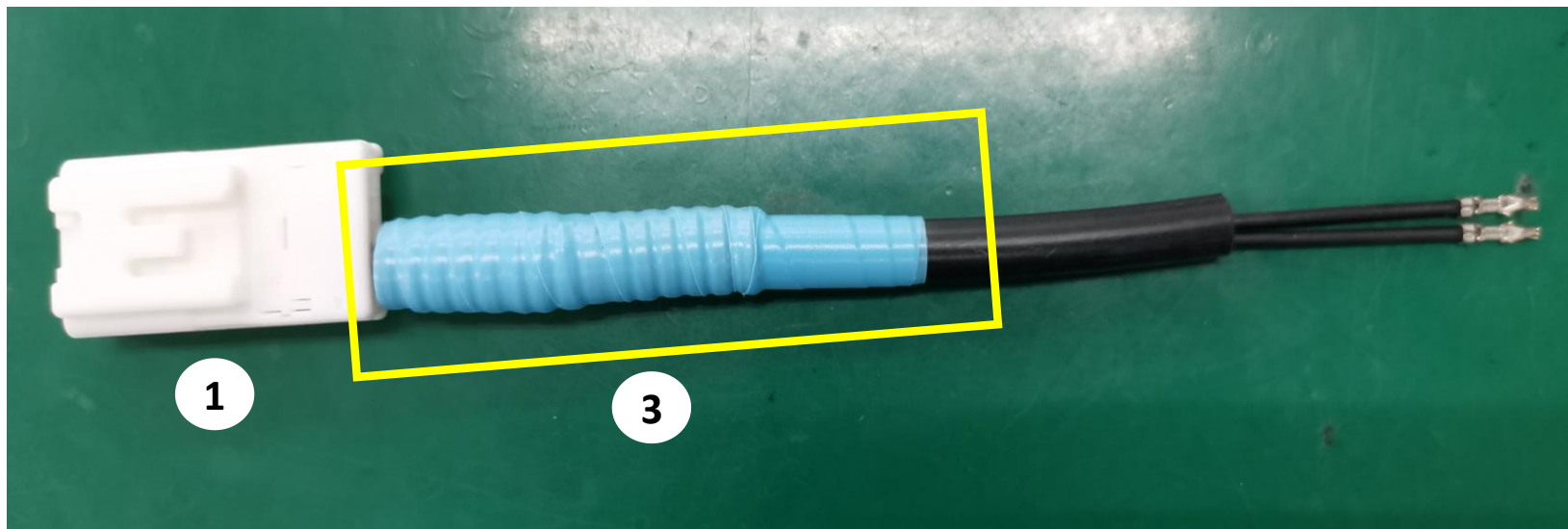
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P1****7M0545-7020C****GOOD****NO GOOD****① No Deformed Terminal****② No Unlocked/Half-locked Connector****③ No Missing Tape and
No Wrong use of tape**

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