



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

January 27, 2025

Model code/Part number:

700B / 7N0099-7020

Customer: TRJ

Car Model: Toyota-Land Cruiser

Validity Date:

n/a

Document No.:

WI-ENG-PD-716C

Purpose:

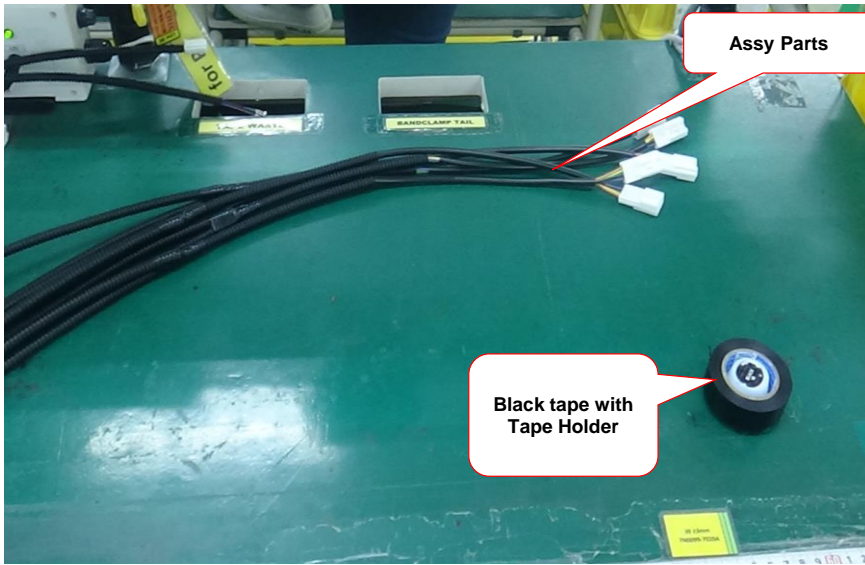
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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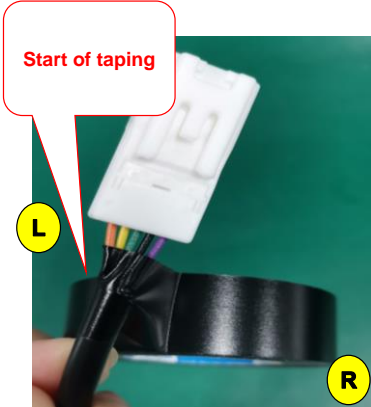
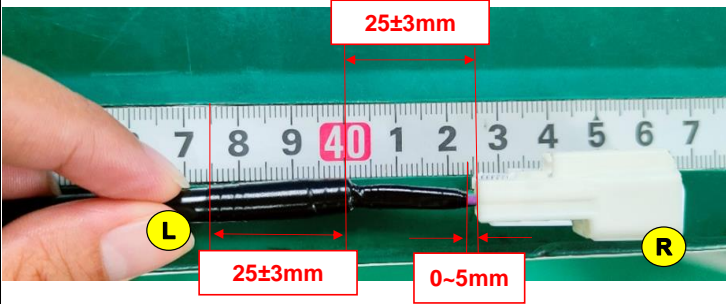

PARTS:		1. Assy Parts 2. Black Corrugated tube (no slit) $\varnothing 5$ L=341 \pm 3mm 3. Black Tape				JIG:		1. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	P3	TABLE LAY-OUT 				Safety Instruction Be sure to wear prescribed personal protective equipment 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
01/27/25	0	Initial issue.				D.Castillo	C.Villanueva	A.Arañes	n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted
						Est. Date:	January 27, 2025		

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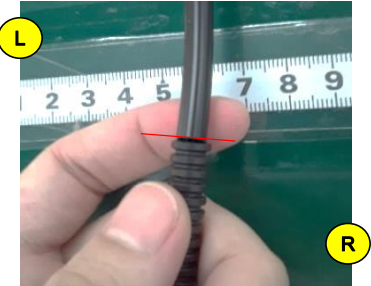
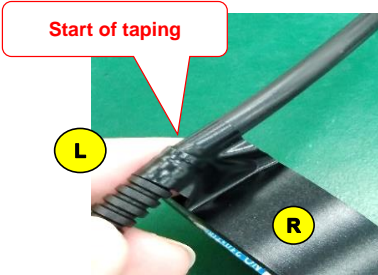
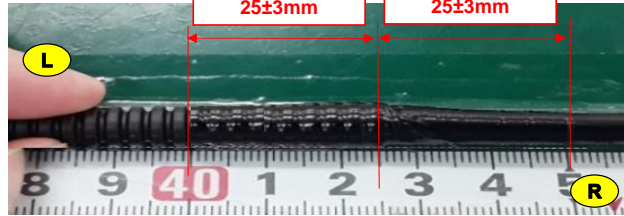



PARTS:		1. Assy parts 2. Black tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
2	P3 Taping 1 SV tube (Vinyl) to wire near connector	<div><p>25±3mm</p><p>1. Measure from end of SV tube (Vinyl) up to end of connector 25±3mm using both hands.</p></div> <div><p>Start of taping</p><p>2. Get the Black tape using right hand then start taping process using both hands. Note: Do not fold the SV tube (Vinyl)</p></div> <div><p>25±3mm</p><p>25±3mm</p><p>0~5mm</p><p>3. After taping, check the measurement and taping condition.</p></div>		<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001B 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 use of tape 6. No wrong dimension</p>	

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PARTS: 1. Assy Parts 2. Black tape [1pc]		JIG:		n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Taping 2 Black corrugated tube to Black SV tube (Vinyl) near connector P3	  <div> <p>1. Fix the corrugated tube and SV tube (Vinyl) using both hands.</p> <p>2. Get the Black tape using right hand then start taping process using both hands.</p> </div>  <div> <p>3. After taping, check the measurement and taping condition.</p> </div>	<div>MEASURING TAPE</div> 	Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. Document reference/s: 1. Refer to WI-PRO-ASY-001B for taping procedure. 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension 7. No insufficient tape
4	Measurement	 <div> <p>1. Measure from end of COT up to terminal pointed tip 39±3mm using both hands.</p> </div>	<div>MEASURING TAPE</div> 	1.No Wrong Dimension

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700B / 7N0099-7020

Customer:

TRJ

Car Model:

Toyota-Land Cruiser

Document No.:

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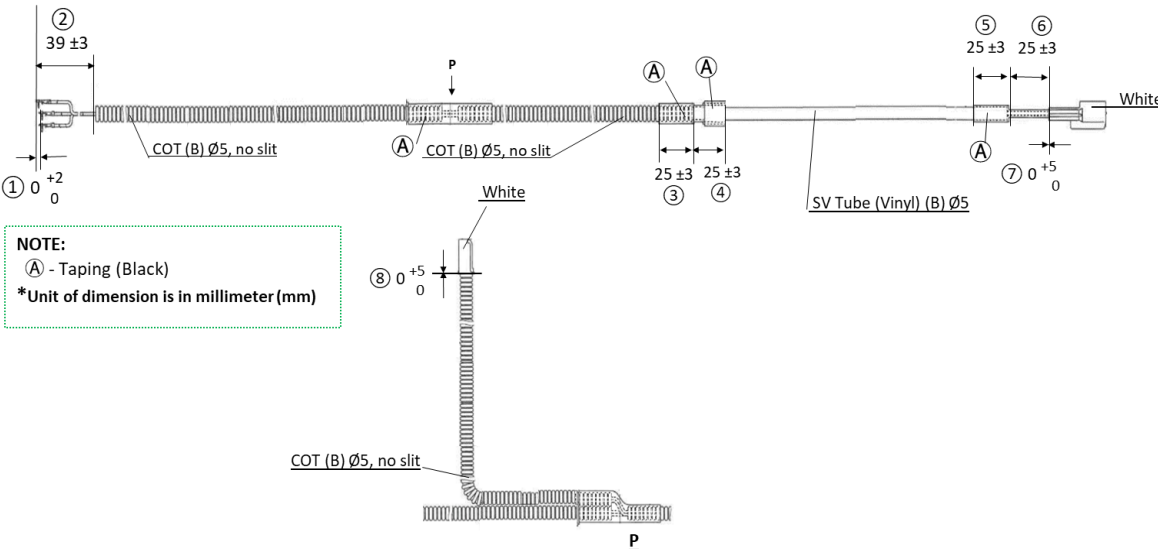
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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P3	Measurement	<div><div>MEASURING TAPE</div></div> 		<div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape 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</div> 1. No wrong dimension

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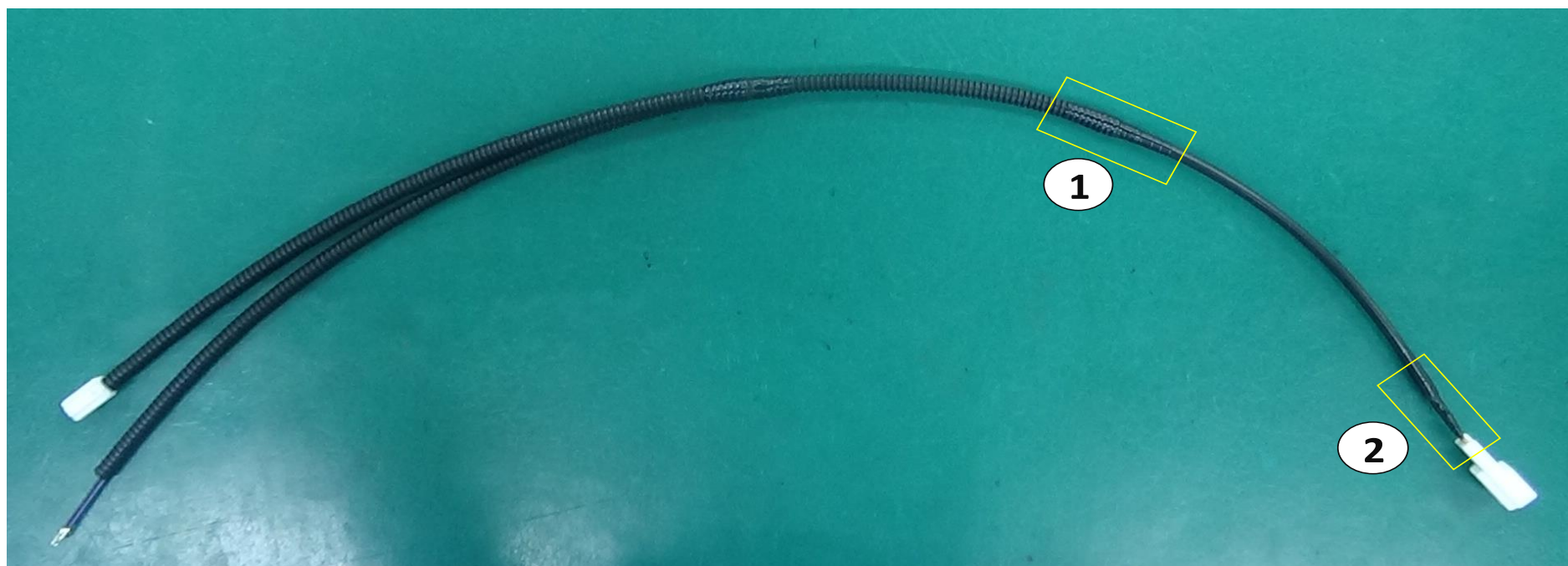
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P3****7N0099-7020**

1

2

No Missing Tape / No wrong use of tape (Black tape)

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