



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

December 21, 2023

Model code/Part number:

220D / 7R0128-7021

Customer:

TRMX

Car Model:

LEXUS-LM

Document No.:

WI-ENG-PDE-594

Purpose:

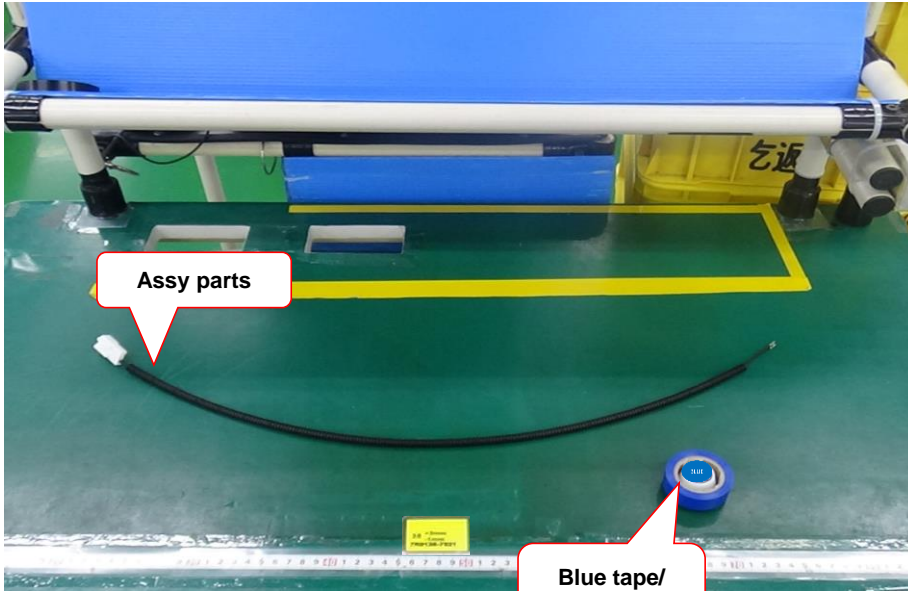
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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PARTS:		1.All parts: Assy parts; Blue tape [1pc]				JIG:		n/a					
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS				
1	P1	Table Lay-out	<div>Table Lay-out</div>  <div>Assy parts</div> <div>Blue tape/ Tape holder</div>				<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		<div>Document references: 1. Refer to WI-ENG-PDE-593 for Offline Assembly Process.</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>				
Revision History						Prepared by		Reviewed by		Approved by		Noted by	
12/21/2023	3	Transfer Clamp assembly setting to Measurement process to Clamp Assembly process (WI-ENG-PDE-763) due to process improvement. Update table lay-out and Quality pointers. Inclusion of Car Model "LEXUS-LM"				D.Castillo	C.Villanueva	A. Arañes	n/a				
04/24/2023	2	Inclusion of quality checkpoints				M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
10/26/2022	1	Change document purpose from Pre-launch to masspro.				M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	October 3, 2022		

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☐ PRE-LAUNCH

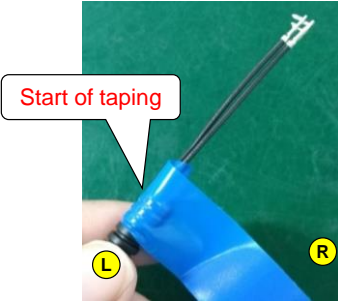

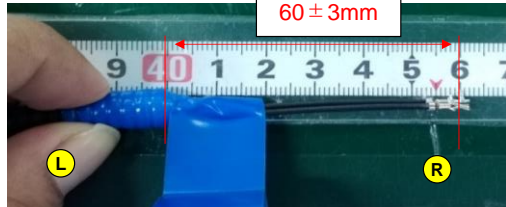
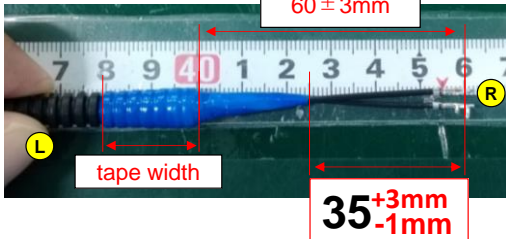

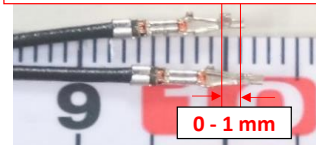
☒ MASSPRO

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PARTS:		1. Assy parts 2. Blue tape [1pc]	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Taping 1 COT to wire near terminal	<div><p>Start of taping</p></div> <div><p>1. Hold the COT using left hand, get the Blue tape using right hand then start pre-taping using both hands.</p></div> <div><p>60 ± 3mm</p><p>2. Measure from end of COT up to terminal pointed tip 60±3mm then continue the taping process using both hands.</p></div> <div><p>60 ± 3mm</p><p>tape width</p><p>35+3mm/-1mm</p><p>3. After taping, check the measurement, taping condition and terminal appearance.</p></div>	<div>MEASURING TAPE</div> 	<div>Wire alignment tolerance</div>  <p>0 - 1 mm</p> <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape <p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. USE BLUE TAPE ONLY2. Please use calibrated/verified measuring tape when getting the measurement. <p>Document references:</p> <ol style="list-style-type: none">1. Refer to WI-ENG-PDE-588 for Tape and tube end standard tolerance

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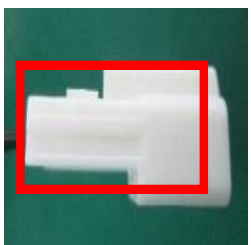
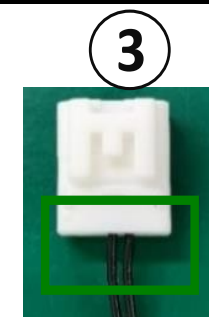
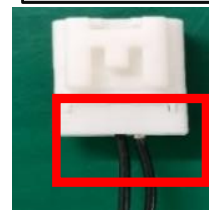
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PARTS:

1. Assy parts

JIG:

n/a

**QUALITY CHECKPOINTS****P1****7R0128-7020****GOOD****NO GOOD****GOOD****NO GOOD****① No Unlock/Halflocked Connector****③ No Terminal Backing Out****② No Wrong Insert****④ No Missing/Wrong Color of tape****⑤ No Deform Terminal**

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