


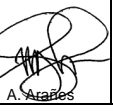
	<b>WORK INSTRUCTION</b> <b>TAPING ASSEMBLY PROCESS</b>				Effectivity Date:	May 17, 2024		
	Process Name/Title:				Validity Date:	n/a		
	Model code/Part number: <b>164B / 7M0611-7020B</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-AURIS</b>	Document No.:	<b>WI-ENG-PDE-082</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	8	Page No.:	1 of 6


<b>PARTS:</b>		1. Assy parts; Black SV tube (Vinyl) ø5 L=42±2mm; Pink tape		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
1	P1	<p><b>TABLE LAY-OUT</b></p> 	<p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p><b>Document reference/s:</b> 1. Refer to <b>WI-ENG-PDE-081</b> for Offline assembly process.</p> <p>1. No missing parts/tools 2. No excessparts/tools</p>	




  

Revision History						Prepared by	Reviewed by	Approved by	Noted by		
05/17/24	8	Transfer wire insertion to COT (with slit) process to Offline assembly process due to Process improvement. Inclusion of Measurement and improved Visual inspection.	D.Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes		
07/14/23	7	Inclusion of table lay-out and quality pointers; improve work procedureillustration, important reminders/note/s and document references; standardize term of SV tube (Vinyl); update template, inclusion of car model	J. Loterte	C. Villanueva	A. Arañes	n/a					
06/16/21	6	Revise due to removal of marking.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes					
02/26/21	5	Apply some improvements. Update pictures from process 1 to 6. Remove cycle time in every process.	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes					
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	February 01, 2018

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<b>PARTS:</b>		1. Assy parts 2.Black SV tube (Vinyl) ø5 L=42±2mm		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	P1  Wire insertion to Black SV tube (Vinyl) ø5 L=42±2mm	<div><div>1. Get the SV tube (Vinyl) ø5 L=42±2mm using right hand then insert the B-B wires using left hand.</div></div>		n/a	1. No wrong usage of parts 2. No deformed terminal

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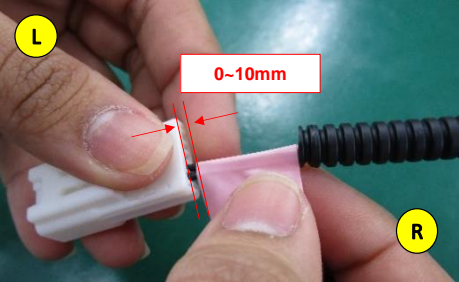


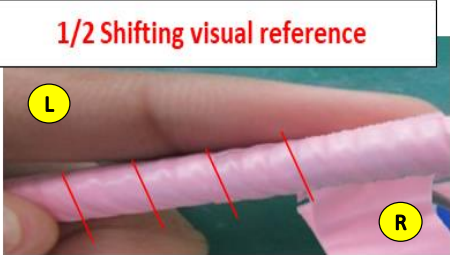
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PARTS:	1. Assy parts 2. Pink tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1  Taping 1 From wire near connector to corrugated tube (with slit) and from corrugated tube (with slit) to SV tube (vinyl)	<div><p>1. Hold the connector using left hand and attach the <b>pink tape</b> on wires using right hand (<i>see picture for illustration</i>) then make <b>3 winds</b>, do not cut the tape. <b>Note: Attachment of tape to wire must be from 0~10mm.</b></p></div> <div><p>2. After taping, insert the COT (with slit) into <b>Pink tape</b> using right hand.</p></div> <div><p>3. After insertion, conduct <b>2x winding</b> of tape then make <b>1/2 shifting</b> going to right side until it covers the COT (with slit).</p></div> <div><p><b>1/2 Shifting visual reference</b></p></div>	n/a	<b>Important reminders/note/s:</b> <b>1. USE PINK TAPE ONLY.</b>  <b>2. Please use calibrated/verified measuring tape when getting the measurement.</b>  1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong use of tape 5. No wrong dimension

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## TAPING ASSEMBLY PROCESS

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164B / 7M0611-7020B

Customer:

TRJ

Car Model:

TOYOTA-AURIS

Purpose:

☐ PROTOTYPE

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### PARTS:

1. Assy parts
2. Pink tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

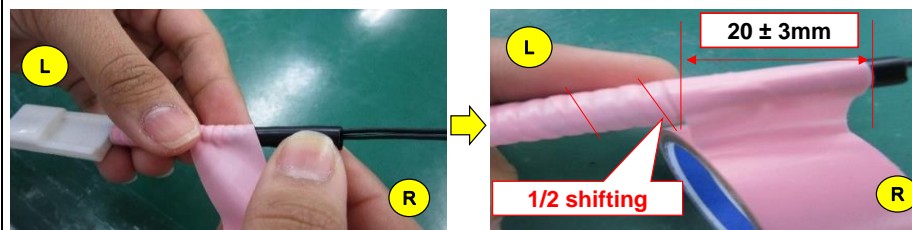
TOOLS/PPE

QUALITY POINTERS

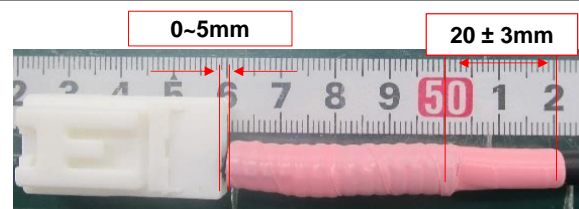
3

P1

Taping 1  
From wire near  
connector to corrugated  
tube (with slit) and from  
corrugated tube (with  
slit) to SV tube (vinyl)  
(continuation)

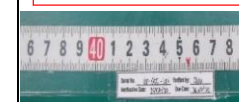


4. Fix the SV tube (Vinyl) to COT (with slit) and continue the taping process using both hands. Make **3 winds** then cut the tape.



5. After taping, check measurement, taping condition and wire alignment.

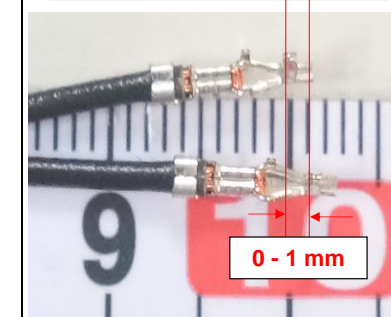
Measuring tape



**Important reminders and note/s:**  
1. Please use calibrated/verified measuring tape when getting the measurement.

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

Wire alignment tolerance



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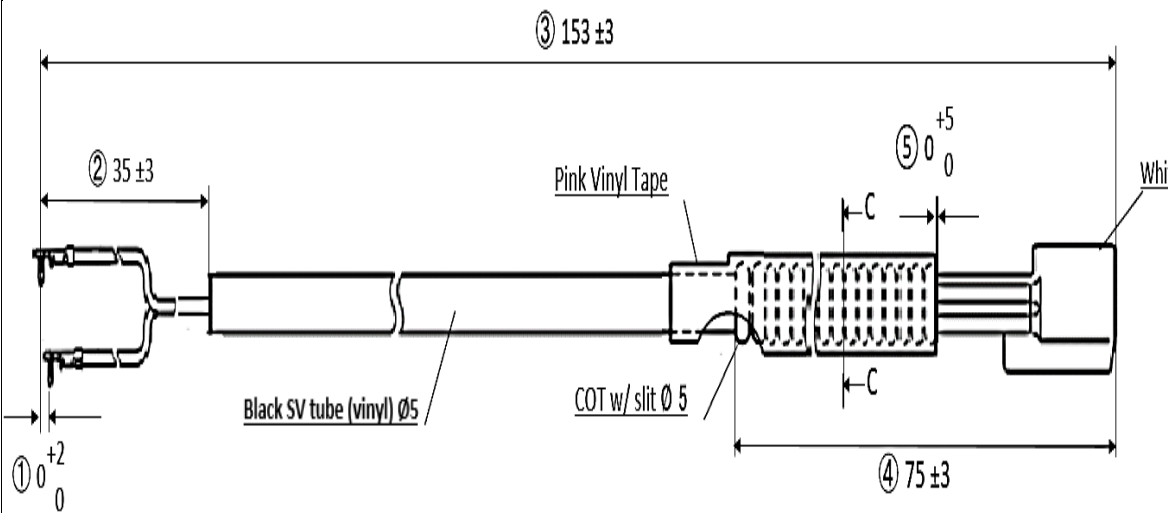
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1	Measurement	<div>Measuring tape</div>  <p>Technical drawing of a cable assembly. The drawing shows a central tube with various components and dimensions. Key dimensions include: ① 0<sup>+2</sup><sub>0</sub>, ② 35 ±3, ③ 153 ±3, ④ 75 ±3, and ⑤ 0<sup>+5</sup><sub>0</sub>. Labels include: Black SV tube (vinyl) Ø5, Pink Vinyl Tape, COT w/ slit Ø 5, and White.</p>	<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection.</p> <p>1. No wrong dimension</p>

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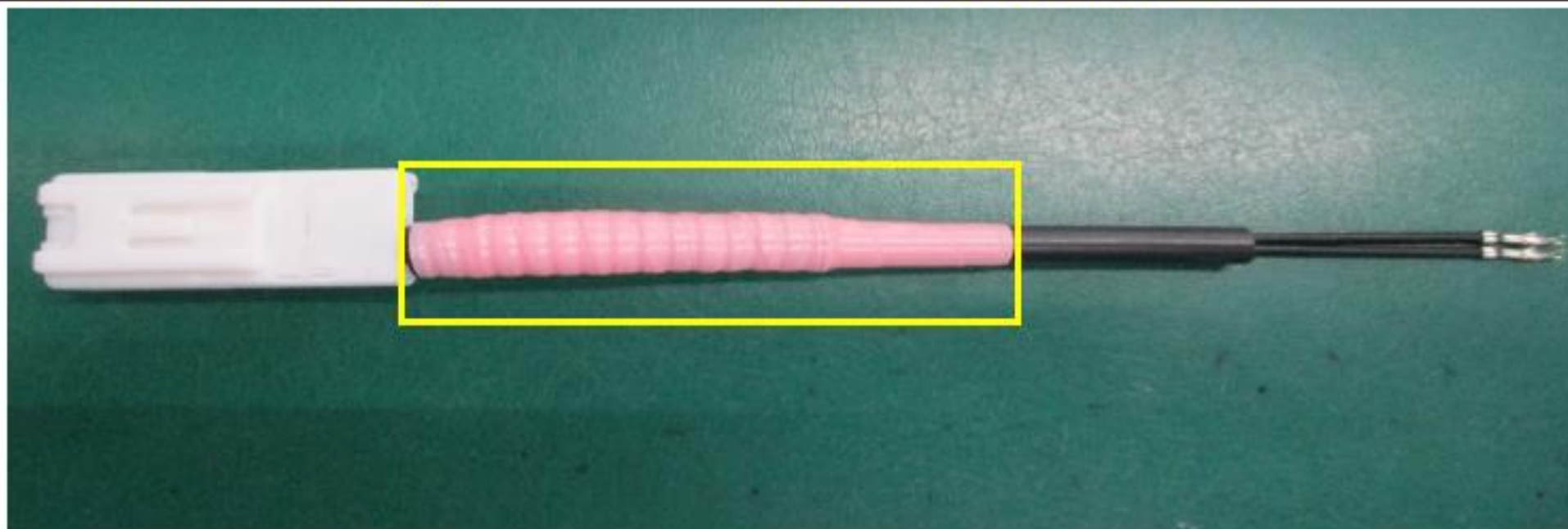
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**PARTS:**

1.Assy Parts

JIG:

n/a

**VISUAL INSPECTION****TAPING - P1****7M0611-7020B****① No Missing Tape (Pink tape)****② No Wrong use of tape**

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