



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

July 31, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

750B / 7M0681-7020A

Customer:

TRJ

Car Model:

TOYOTA HARRIER

Document No.:

WI-ENG-PDE-215B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

Page No.:

1 of 6

PARTS:

1. All parts; Assy parts; Black VM tube (Sunprene) $\varnothing 9$ L=112 \pm 3mm; Black Tape

JIG:

N/A

NO.

PROCESS NAME

3

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

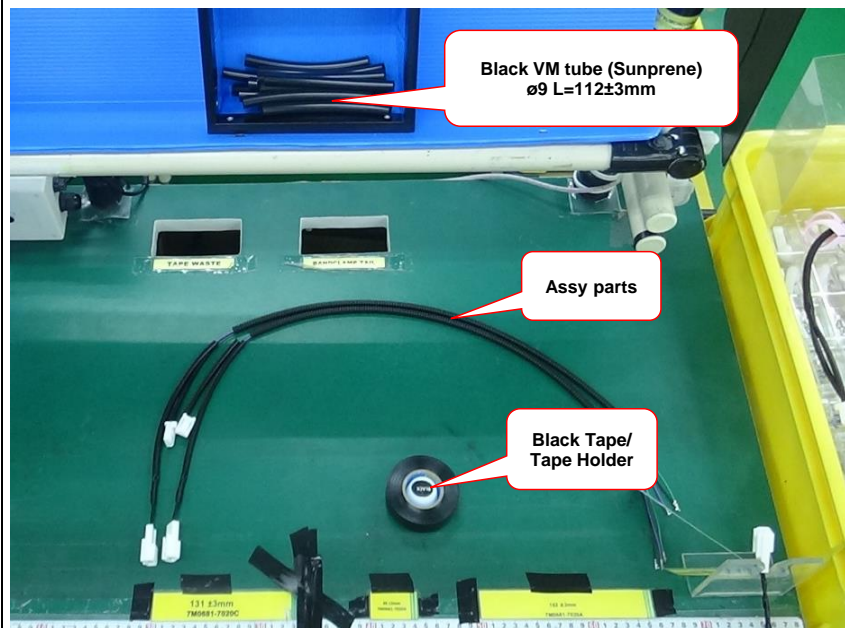
QUALITY POINTERS

1

P2

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.

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

Alert level

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

Revision History

Prepared by

Reviewed by

Approved by

Noted by

07/31/24

3

Separate Clamp setting and Clamp assembly to Clamp assembly process and transfer COT to wire near terminal taping and Y-taping from P1 (WI-ENG-PDE-215A) due to process improvement. Inclusion of Car model "TOYOTA-HARRIER". Change tape width to value (20 \pm 3mm). Update Table lay-out, Measurement and Visual inspection/Quality checkpoints.

D. Castillo

C. Villanueva

A. Arañes

n/a

02/25/23

2

Work instruction improvement: Change MP from 3MP to 2MP. Transfer Y-taping process from P2 to P1 (Page 7). Change term Black vinyl tube to Black SV tube (Vinyl); Inclusion of Table lay-out (Page 1) and Quality checkpoint (Page 8). Update quality pointers.

D. Castillo

J. Loterte

C. Villanueva

A. Arañes

04/26/21

1

Change from Pre-launch to Masspro. Add tape quantity. Change wind to windings.

D. Castillo

J. Loterte

A. shimamura

A. Arañes

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

January 26, 2021

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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	P2 <div>3</div> Y-Taping	<div><div><div>Note: Do not exert excessive force during pulling & winding of tape.</div><div><div>L</div><div>R</div></div></div><div><div><div>20±3mm</div><div>tape shifting 1/2 below</div><div>taping direction</div></div><div><div>20±3mm</div><div>tape shifting 1/3 below</div><div>taping direction</div></div><div><div>20±3mm</div><div>tape shifting 1/2 below</div><div>taping direction</div></div><div><div>20±3mm</div><div>tape shifting 1/2 below</div><div>taping direction</div></div><div><div>20±3mm</div><div>20±3mm</div><div>20±3mm</div><div>20±3mm</div></div></div><div><div>1. Fix the two SV tubes and COT using both hands. See illustration for correct facing of connector.</div><div>3. From SV tube, make 1/3 shifting to COT until 20±3mm. Wind the tape 1 time before shifting.</div><div>4. From COT, wind the tape down to SV tube (1/2 shifting) until 20±3mm.</div><div>5. From SV tube, wind the tape (1/2 shifting) going to side of corrugated tube then cut the tape after 2 windings. After taping, check the condition of tape.</div></div></div>		<div>Measuring tape</div> <div></div>	<div>Important reminders/Note/s:</div> <div>1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.</div> <div>2. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>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</div>

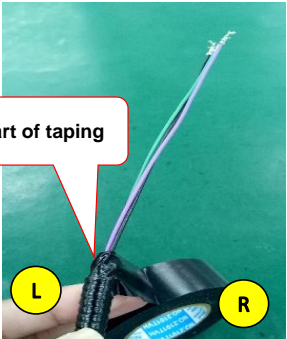
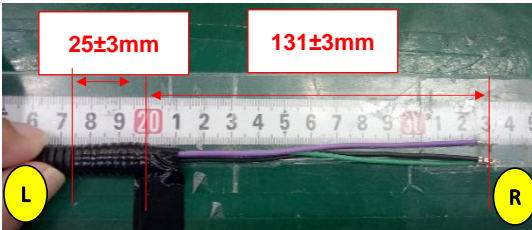


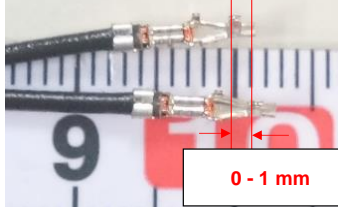
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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	3	Page No.:	3 of 6

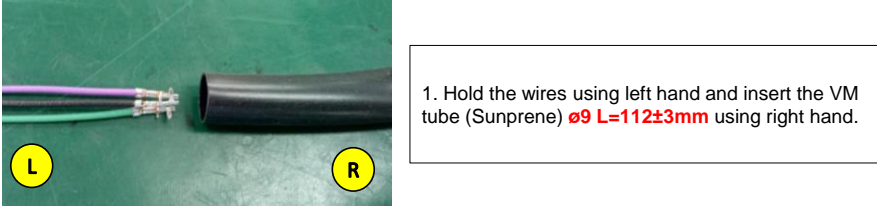
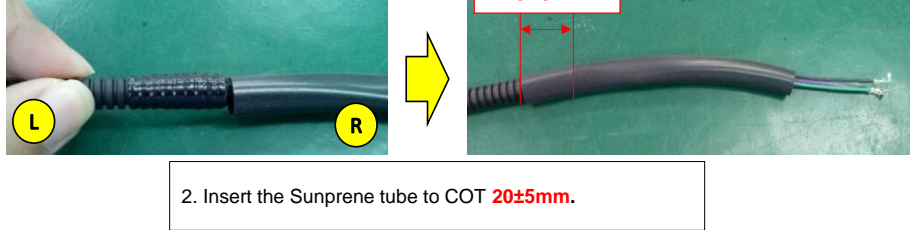
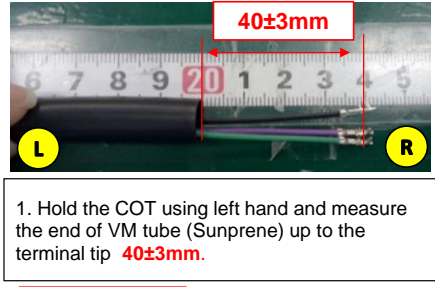

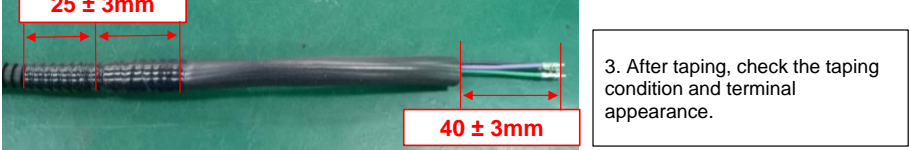

PARTS:	1. Assy parts 2. Black tape			JIG:	N/A		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
3	P2 Taping 2 Corrugated tube to wire near terminal	<div><p>Start of taping</p></div> <div><p>25±3mm 131±3mm</p></div> <div><p>131±3mm 25±3mm 25±3mm</p></div> <div><p>1. Get Black tape, hold corrugated tube using left hand then start pre-taping.</p><p>2. Measure the end of the corrugated tube up to the terminal tip 131±3mm. Then continue taping using right hand.</p><p>3. After taping, check the dimension, taping condition and wire alignment.</p></div> <div><p>Measuring tape</p></div>	<div><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></div> <div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div> <div><p>Important reminders/Note/s:</p><p>1. Please use calibrated/verified measuring tape when getting the measurement.</p><p>Document references:</p><p>1. Please refer to WI-PRO-ASY-001 for taping procedure.</p></div>				


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PARTS:		1. Black VM tube (Sunprene) $\varnothing 9$ L=112 \pm 3mm 2. Black tape		JIG:		N/A	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
4	Wire insertion to Black VM tube (Sunprene) $\varnothing 9$ L=112 \pm 3mm P2	<div>   </div>		N/A		1. No wrong use of parts	
5	Taping 3 Corrugated tube to VM tube (Sunprene)	<div>    </div>		<div>  </div>		<div> <p>1. No loose tape</p> <p>2. No peel-off tape</p> <p>3. No flip-out tape</p> <p>4. No wrong dimension</p> <p>5. No wrong use of tape</p> <p>6. No missing tape</p> <p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document references:</p> <p>1. Please refer to WI-PRO-ASY-001 for taping procedure.</p> </div>	

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PARTS:

1. Assy parts

JIG:

n/a

NO.

PROCESS NAME

3

WORK PROCEDURE/ ILLUSTRATION

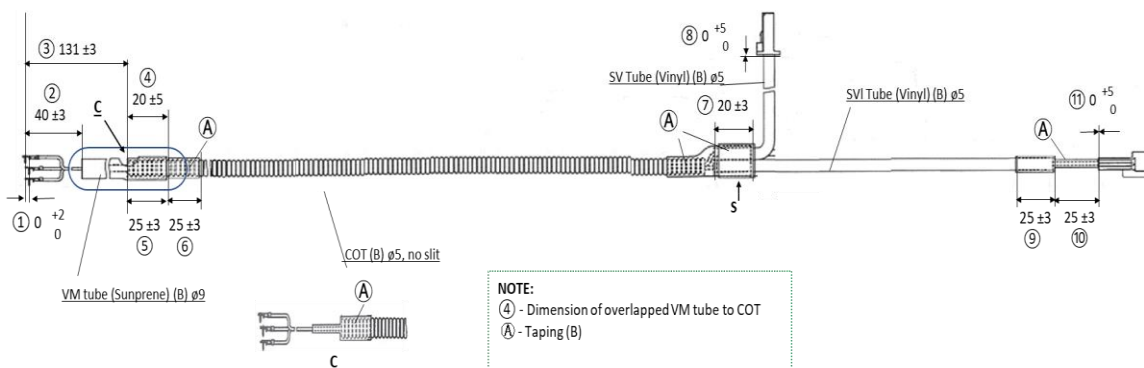
TOOLS/PPE

QUALITY POINTERS

6

Clamp
Assy

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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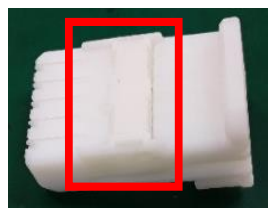
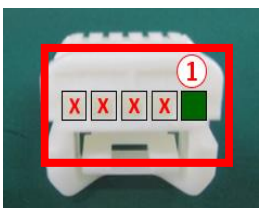
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PARTS:

1. Assy parts

JIG:

N/A

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P2****7M0681-7020A****GOOD****GOOD****NO GOOD****NO GOOD****GOOD****GOOD****NO GOOD****NO GOOD**

1 No **Unlock/**
Halflocked Connector
(on 2 connector)

2 No **Wrong Insert**
(on 2 connector)

3 No **Missing Tape**

5 No **Deformed Terminal**

4 No **Terminal**
Backing Out

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