

**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

June 3, 2024

Validity Date:

n/a

Model code/Part number:

**700B / 7N0039-7020B**

Customer:

**TRJ**

Car Model:

**TOYOTA-LAND CRUISER**

Document No.:

**WI-ENG-PDE-883B**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

1 of 6

**PARTS:** 1. Assy parts; Black corrugated tube (no slit)  $\varnothing 5$  L=496 $\pm$ 4mm; Black tape

JIG:

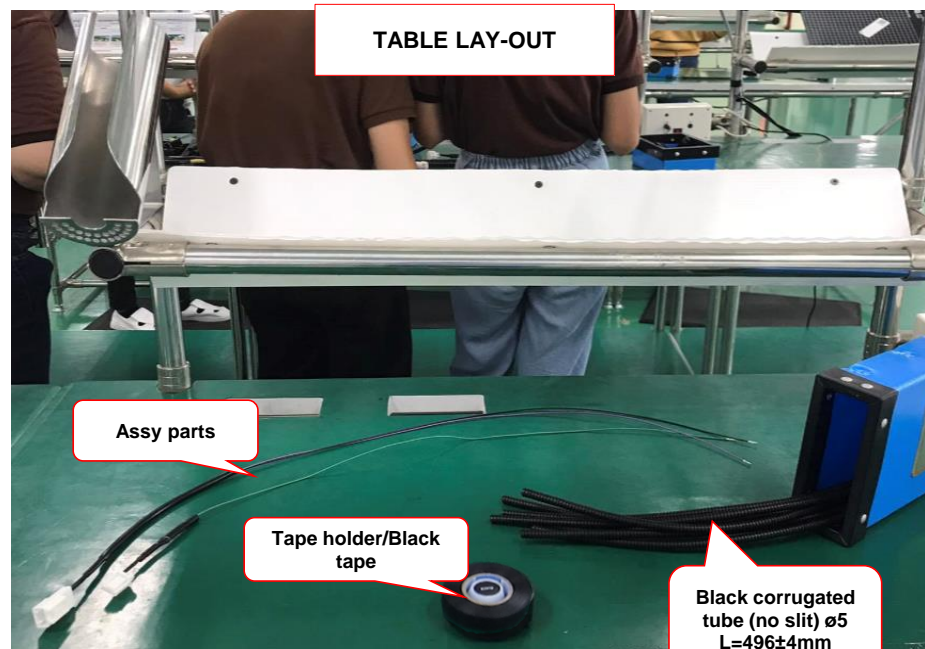
n/a

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

1

P2

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
06/03/24	1	Change pre-launch to mass pro.	A.Hernandez	C. Villanueva	A. Arañes	n/a	A.Hernandez	C. Villanueva	A. Arañes	n/a
05/09/24	0	Initial Issue.	A.Hernandez	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	May 09, 2024		

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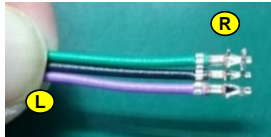
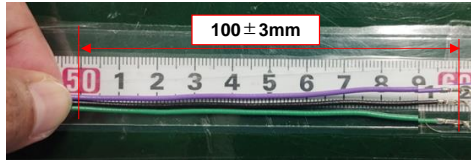
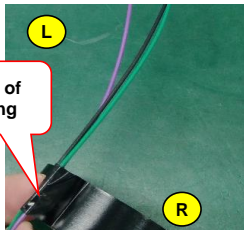
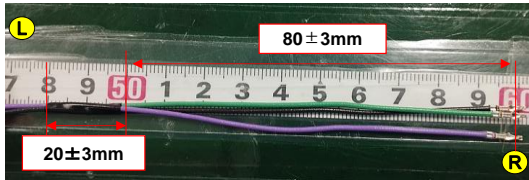

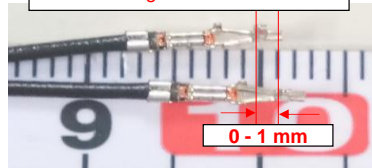




☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

2 of 6

PARTS:		1. Assy parts 2. Black corrugated tube $\phi 5$ L=496 $\pm$ 3mm (No Slit)		3. Black tape		JIG:	1. Terminal cover jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	P2	Spot taping	<div></div> <div>1. Combine the assy parts then align all terminals.</div> <div></div> <div>2. Conduct measurement from wires to terminal pointed tip <b>100<math>\pm</math>3mm</b> using both hands.</div> <div></div> <div>Start of taping</div> <div></div> <div>3. Get the <b>Black tape</b> using right hand then conduct <b>2 windings of spot taping</b> using both hands.</div> <div>4. After taping, check the measurement and taping condition.</div>			<div>MEASURING TAPE</div> 	<div>Wire alignment tolerance</div>  <div><b>Important reminders/Note/s:</b></div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>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</div>
3		Wire insertion to Black corrugated tube (no slit) $\phi 5$ L=496 $\pm$ 4mm	<div></div> <div>1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the <b>B-G-V wires</b> using left hand.</div> <div></div> <div>2. Get the corrugated tube (<b>no slit</b>) <math>\phi 5</math> L=496<math>\pm</math>3mm (<b>no slit</b>) using right hand then insert the <b>B-G-V wires</b> using left hand.</div> <div></div> <div>3. After insertion, remove the terminal cover jig using right hand.</div>			<div>Terminal cover Jig</div> 	<div>1. No wrong insertion 2. No deformed terminal</div>

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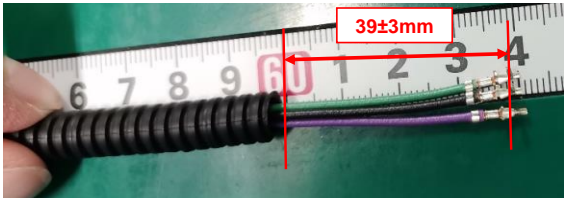


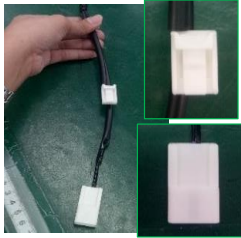



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Revision No.:

1

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
4	P2	Wire insertion to Black corrugated tube (no slit) $\phi 5$ L=496 $\pm$ 4mm (Continuation)	<div></div> <div>4. Conduct measurement between end of COT up to pointed tip <b>39<math>\pm</math>3mm</b>.</div>	<div>MEASURING TAPE</div> 	<div>1. No wrong insertion 2. No deformed terminal</div> <div><b>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></div>
5		Y-Taping	<div><div><div></div><div><b>Note:</b> <b>Do not exert excessive force during pulling &amp; winding of tape.</b></div></div><div></div><div><div></div><div><b>20<math>\pm</math>3mm</b></div><div></div><div>tape shifting 1/2 below</div><div>taping direction</div><div>2. Hold two SV tubes (Vinyl) using left hand and fix to COT. Make 1 winding for pre-tape before shifting then wind the tape down to SV tube (Vinyl) until tape width.</div></div></div>	<div>MEASURING TAPE</div> 	<div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</div> <div><b>Important reminders/Note/s:</b> <b>1. Use YELLOW tape to easy visualization of shifting lines, but actual should be BLACK TAPE.</b> <b>2. Please use calibrated/verified measuring tape when getting the measurement.</b></div>

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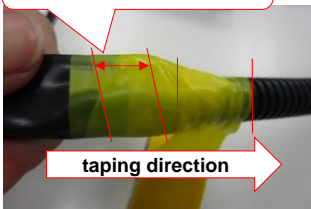



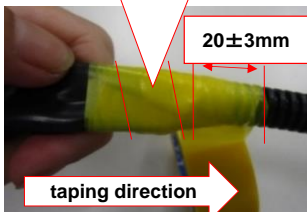
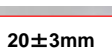
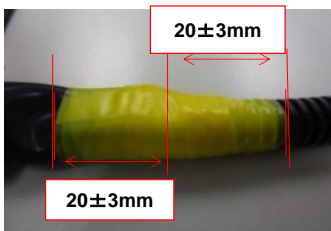
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

4 of 6

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2	Y-taping (Continuation)	<div><div>tape shifting 1/3 below</div><div></div><div>taping direction</div></div> <div><div>3. From SV tube (Vinyl), make 1/3 shifting to COT until tape width. Wind the tape 1 time before shifting.</div></div>	<div>MEASURING TAPE</div> <div></div>	<p><b>Important reminders/Note/s:</b></p> <p>1. Use <b>YELLOW</b> tape to easy visualization of shifting lines, but actual shoould be <b>BLACK TAPE</b>.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</p>
			<div><div>tape shifting 1/2 below</div><div></div><div>taping direction</div></div> <div><div>20±3mm</div><div></div></div> <div><div>4. From COT, wind the tape down to vinyl tube (1/2 shifting) until tape width.</div></div>		
			<div><div>tape shifting 1/2 below</div><div></div><div>taping direction</div></div> <div><div>20±3mm</div><div></div></div> <div><div>20±3mm</div><div></div></div> <div><div>20±3mm</div></div> <div><div>5. From vinyl 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>		

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☒ MASSPRO

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Page No.:

5 of 6

PARTS:

n/a

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

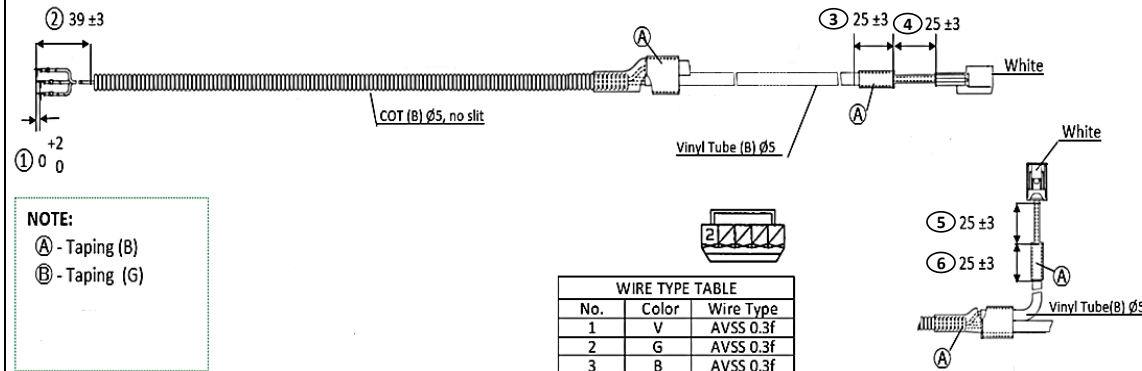
TOOLS/PPE

QUALITY POINTERS

6

P2

Measurement



**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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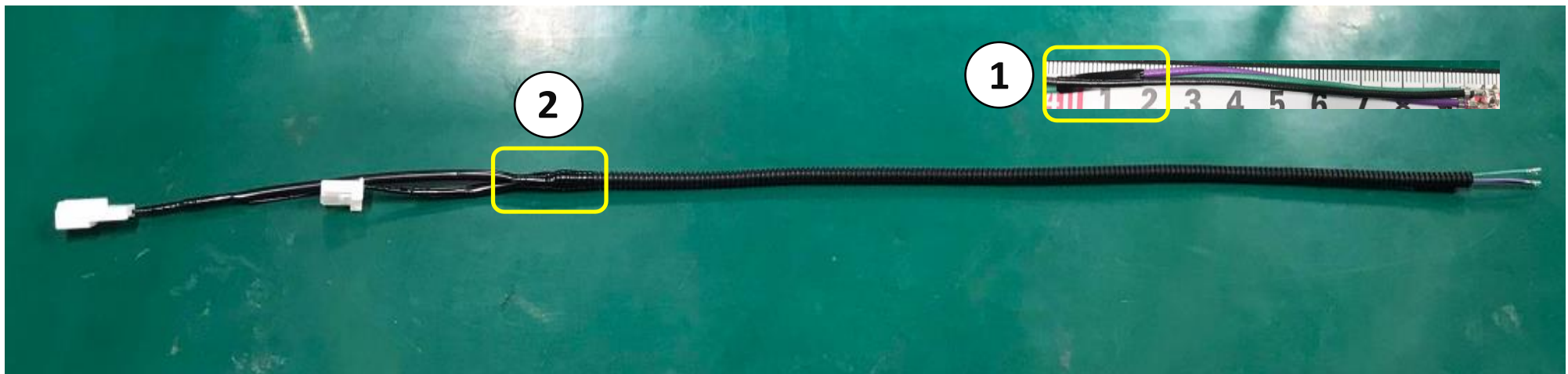
Page No.:

**6 of 6****PARTS:**

n/a

JIG:

n/a

**VISUAL INSPECTION/QUALITY CHECKPOINTS****P2****7N0039-7020B**

**1** No **Missing spot tape)**  
(on wire taping)

**2** No **Missing Tape**  
(on Y-taping)

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