



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

July 18, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

011B / 7M0368-7020A

Customer:

TRJ

Car Model:

TOYOTA-CAMRY

Document No.:

WI-ENG-PDE-237B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

6

Page No.:

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PARTS:

1. Assy parts; Black VM tube (Sunprene) Ø9 L=120±3mm

JIG:

1. Clamp assembly jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

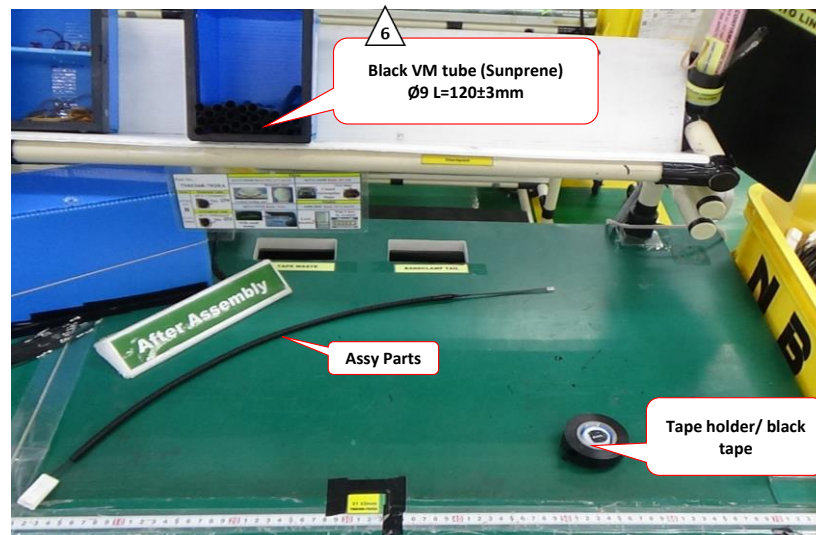
QUALITY POINTERS

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.

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

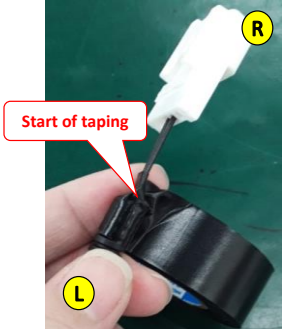
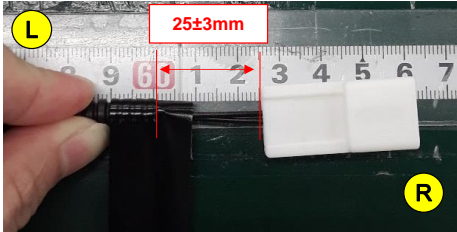
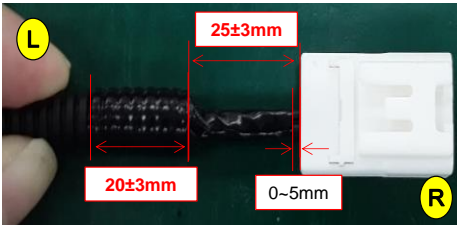

							Prepared by	Reviewed by	Approved by	Noted by
07/18/24	6	Inclusion of car model "TOYOTA-CAMRY". Transfer Wire insertion to VM tube process and Taping 2 from P1 (WI-ENG-PDE-237A). Separate clamp setting and clamp assembly to Clamp assembly process due to Process improvement. Change term to VM tube (Sunprene).	D.Castillo	C. Villanueva	A. Arañes	n/a				
12/09/22	5	Improve Quality pointers; Reminders/notes and references on pages no.1 to 8 due to document improvement. Improve work procedure on process no.5- Visual/By two's inspection due to process improvement. Inclusion of Quality pointers.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
5/26/22	4	Apply some Improvement in Work Procedure/ Illustration. Additional Table Lay-out.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	February 10, 2018		

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	TAPING ASSEMBLY PROCESS			Validity Date:	n/a					
	Process Name/Title:			Customer:	TRJ	Car Model:	TOYOTA-CAMRY			
	Model code/Part number:		011B / 7M0368-7020	Document No.:		WI-ENG-PDE-237B				
Purpose:				<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	6	Page No.:	2 of 5

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 2 Corrugated tube to wire near connector	<div><p>1. Hold the corrugated tube using left hand, get Black tape and start pre-taping using right hand.</p></div> <div><p>2. Hold the corrugated tube using left hand, measure from end of corrugated tube up to the edge of connector 25mm.</p></div> <div><p>3. After taping, check the measurement and tape condition.</p></div>		<div>MEASURING TAPE</div> 	<p>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <ul 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

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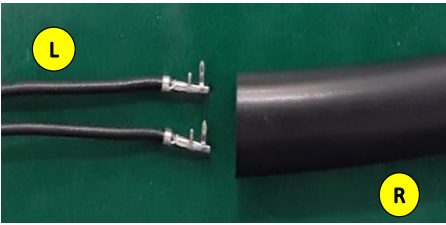

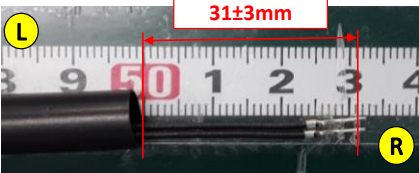



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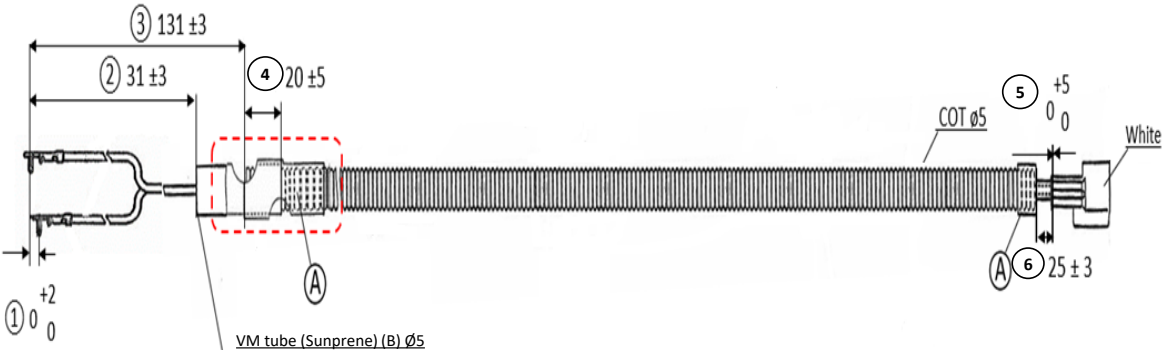

PARTS:	1. Assy parts 2. Black tape 3. VM tube (Sunprene) Ø9 L=120±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	 Wire insertion to VM tube (Sunprene) Ø9 L=120±3mm	 1. Get and hold Black wires (Assy Parts) using right hand then get and insert VM tube (Sunprene) Ø9 L=120±3mm using left hand.	n/a	1. No wrong use of parts 2. No deformed terminal
4	 P2 Taping 3 Corrugated tube to VM tube (Sunprene) near terminal	 1. Measure from end of VM tube (Sunprene) up to the terminal pointed tip 31±3mm .  2. Hold the VM tube (Sunprene) using left hand, get the Black tape then start taping using right hand.  3. After taping, check the taping condition and measurement.		Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure. 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

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		6	Page No.: 4 of 5

PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	<div>6</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
5	P2	Measurement <div></div>	<div>MEASURING TAPE</div> <div></div>	<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension.</p>	

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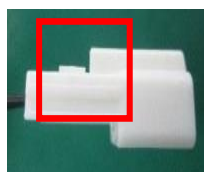
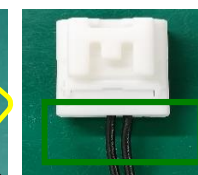
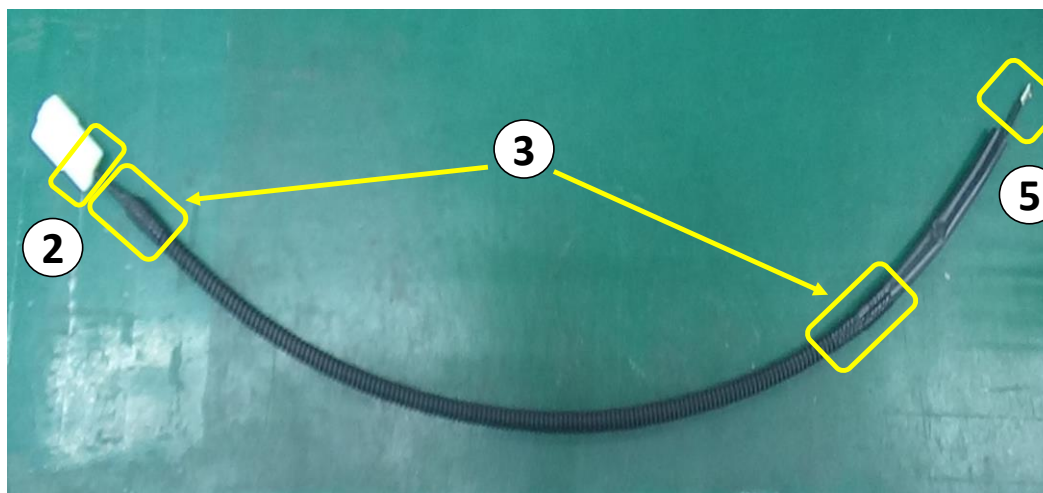
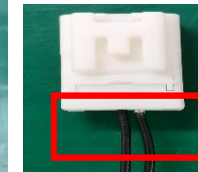
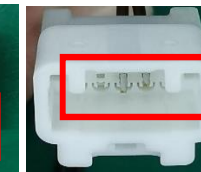
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P2****7M0368-7020A****GOOD****GOOD****NO GOOD****NO GOOD****GOOD****GOOD****NO GOOD****NO GOOD**

① **No Unlock / Halflock Connector**

② **No Wrong Insert**

③ **No Missing Tape (Taping on COT-wire and taping on sunprene tube)**

④ **No Terminal Backing Out**

⑤ **No Deformed Terminal**

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