

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**

Effectivity Date:

November 24, 2023Model code/Part number: **382D / 7N0186-7020B**Customer: **TRJ**Car Model: **TOYOTA-CAMRY**

Validity Date:

n/a

Document No.:

WI-ENG-PDE-742

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

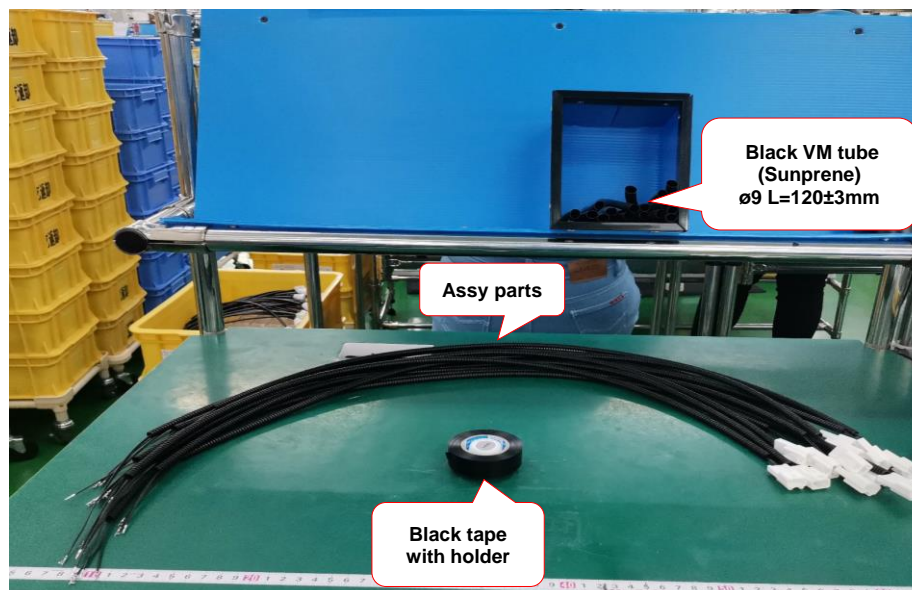
1

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1 of 4**PARTS:**

1. Assy parts
2. Black VM tube (Sunprene) $\varnothing 9$ L=120 \pm 3mm
3. Black tape [1 pc.]

JIG:

n/a**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****1****P1****TABLE LAY-OUT****TABLE LAY-OUT****Safety Instruction**

Be sure to wear required 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
3. No wrong position of parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
11/24/23	1	Document purpose from prelaunch to masspro. Additional table layout and quality pointers. Improve work procedure due to improvement. Align quality checkpoints on finished assy parts.					A. Hernandez	C. Villanueva	A. Arañes	n/a
10/24/23	0	Initial issue.	A. Hernandez	C. Villanueva	A. Arañes	n/a				

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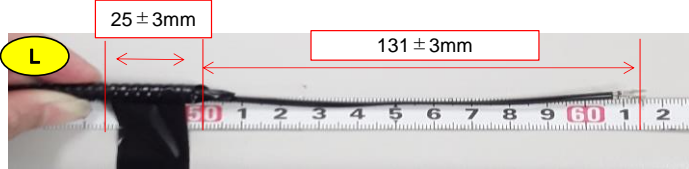
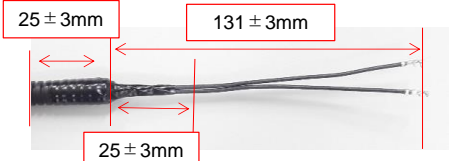

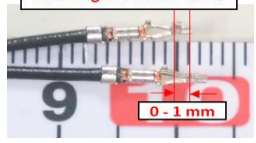
☒ MASSPRO

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PARTS:		1. Assy parts 3. Black tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Taping 1 Corrugated tube to wire near terminal	<div><p>1. Hold the COT using left hand, get Black tape using right hand and start pre-taping between COT and wire.</p></div> <div><p>2. Hold the corrugated tube using left hand and measure from end of COT to terminal pointed tip 131mm and proceed to taping process. <i>Please refer to WI-PRO-ASY-001 for taping procedure.</i></p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>	<div>MEASURING TAPE</div> 	<p><i>Note:</i> Please use calibrated/verified measuring tape when getting the measurement.</p> <div>Wire alignment tolerance</div>  <ul style="list-style-type: none">1. No loose tape2. No flip-out tape3. No peel-off tape4. No wrong use of tape5. No wrong dimension

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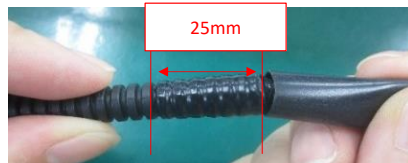



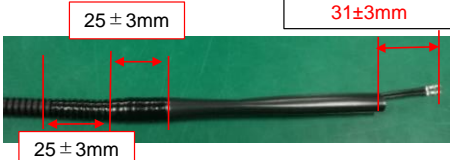


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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) $\varnothing 9$ L=120 \pm 3mm 3. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to Black VM tube (Sunprene) $\varnothing 9$ L=120 \pm 3mm	<div><div></div><div><div>1. Hold the 2 Black wires using left hand and insert the Black VM tube (Sunprene $\varnothing 9$ L=120\pm3mm using right hand.</div><div></div><div>2. Insert the Sunprene tube to COT 25mm</div></div><div></div></div>		<div>MEASURING TAPE</div> 	<p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p> 1. No wrong use of parts
4	P1 Taping 2 COT to VM tube (Sunprene)	<div><div></div><div><div>1. Hold the corrugated tube $\varnothing 5$ L=739\pm7mm (no slit) using left hand and measure the sunprene tube up to terminal tip 31mm.</div><div></div><div>25 \pm 3mm</div><div>31 \pm 3mm</div><div>25 \pm 3mm</div></div><div><div></div><div><div>2. Hold the COT using left hand and begin taping using right hand.</div><div>Note: Refer to WI-PRO-ASY-001 for taping procedure.</div></div><div><div>3. After taping, check the dimension, terminal appearance and taping condition.</div></div></div></div>		<div>MEASURING TAPE</div> 	<div>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension</div> <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p>

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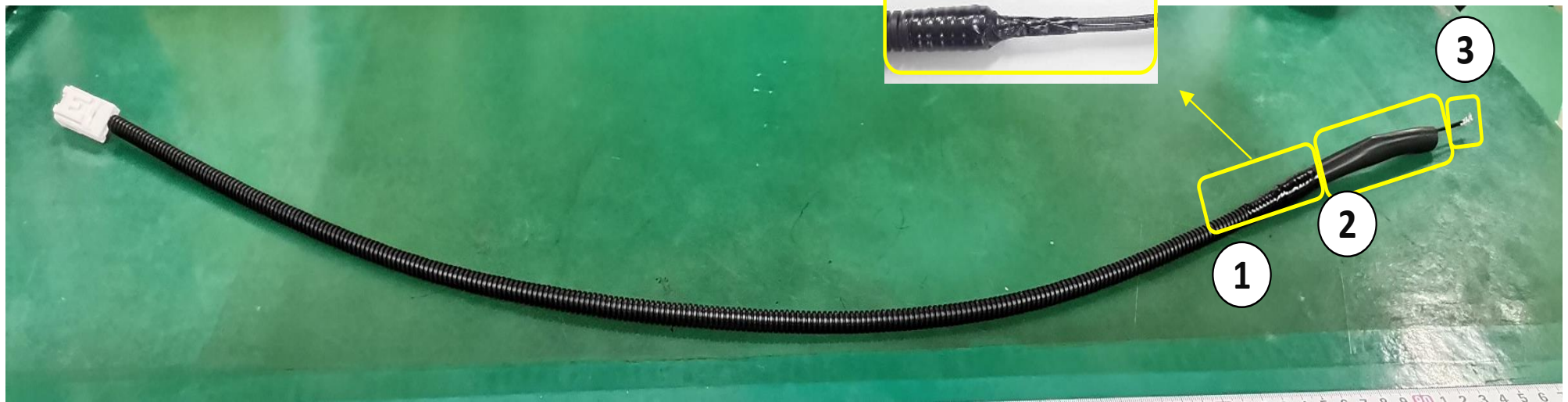
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PARTS:

n/a

JIG:

n/a

QUALITY CHECKPOINTS**P1****7N0186-7020B****1****No Missing Tape**

(on COT to wire and taping COT to sunprene tube)

2**No Missing VM tube (Sunprene)****3****No Deformed Terminal**

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