



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

December 03, 2024

Model code/Part number:

410D/412D / 7N0235-7020A

Customer: TRJ

Car Model:

LEXUS-ES

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1121B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

1 of 6

PARTS:

1. Assy parts; Black Corrugated tube (w/ slit) Ø5 L=159±3mm; Black tape

JIG:

1. COT adaptor

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

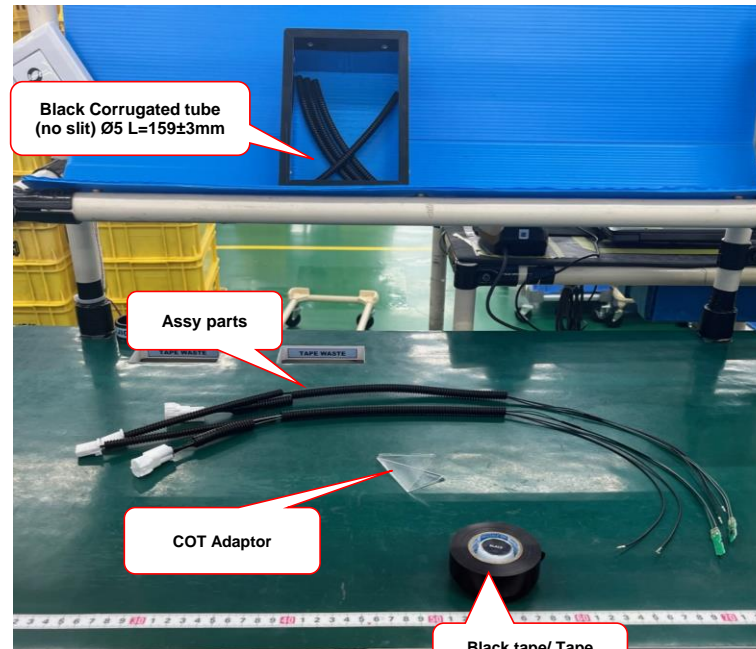
QUALITY POINTERS

1

P2

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 positions of parts/tools


Revision History

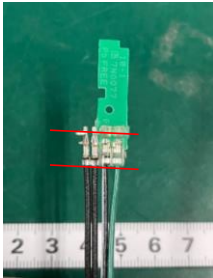
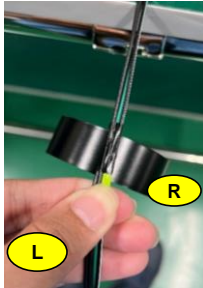
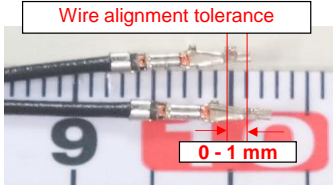
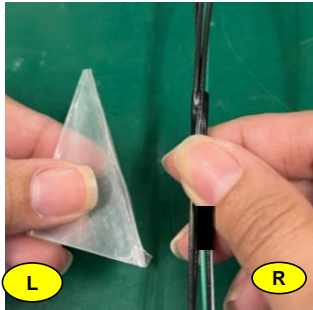
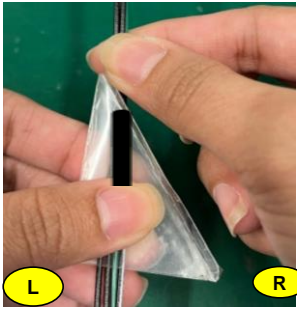

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
12/03/24	0	Initial issue.					D.Castillo	C. Villanueva	A. Arañes	n/a

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	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO		Revision No.:	0	Page No.:


PARTS:	1. Assy part 2. Black tape				3. Black Corrugated tube (w/ slit) Ø5 L=159±3mm				JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS			
2	Spot taping	<div><p>1. Fix the hotmelted wire and terminal pointed tip using both hands.</p></div> <div><p>2. Hold the wires using left hand and get the Black tape and position at the top of wire taping (Black tape) then conduct spot taping using both hands. Make 2 windings of tape. Check the alignment and taping condition.</p></div>				n/a	<div>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No missing tape</div> <div><p>Wire alignment tolerance 0 - 1 mm</p></div>			
3	P2 Wire insertion to Black Corrugated tube (with slit) Ø5 L=159±3mm	<div><p>1. Hold the COT Adaptor using left hand. Insert the wires using right hand.</p></div> <div><p>2. Hold the COT Adaptor with wires using left hand , get the Black Corrugated tube (w/ slit) Ø5 L=159±3mm using right hand then insert to COT adaptor. Hold the COT adaptor and push the COT (same timing) using both hands. Make sure all wires are inserted.</p></div>				<div>COT Adaptor</div> 	<div>1. No wrong use of parts 2. No wires left between the COT slit</div>			

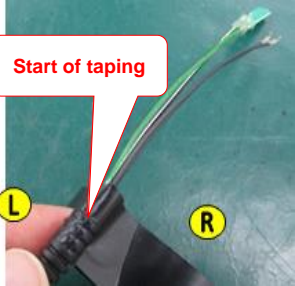
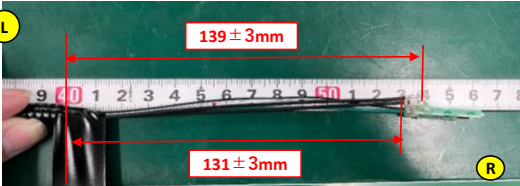
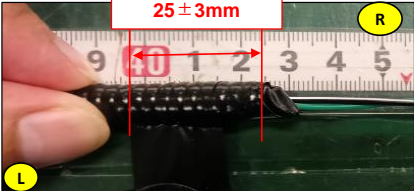
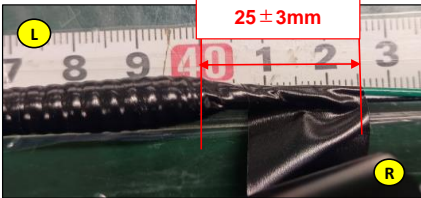
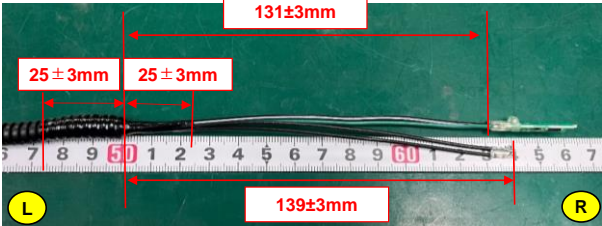

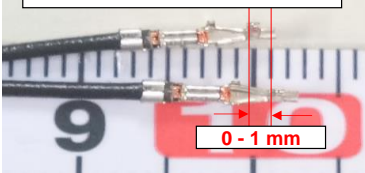
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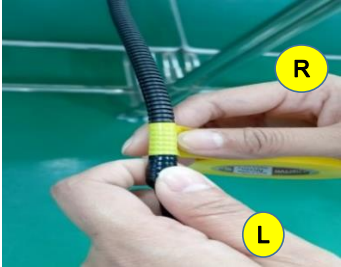
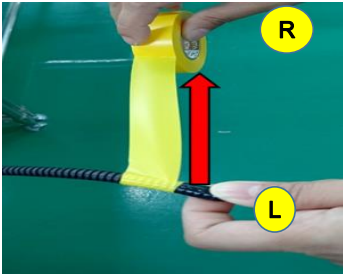
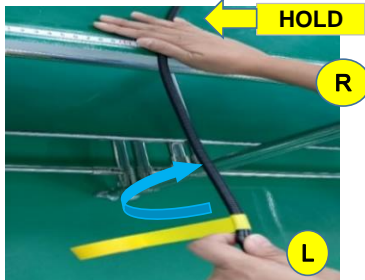
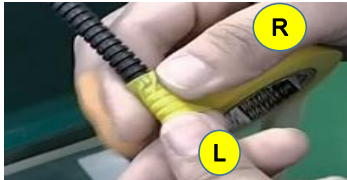



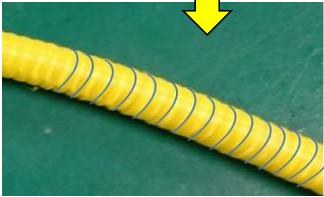
PARTS:		1. Assy part 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
4	P2 Taping 2 Black Corrugated tube to Wire near PCB	<div><p>Start of taping</p></div> <div><p>139 ± 3mm 131 ± 3mm</p></div> <div><p>2. Measure from end of COT up to Hotmelted wires L=131±3mm and COT to terminal pointed tip L=139±3mm then continue the taping process using both hands.</p></div> <div><p>25 ± 3mm</p></div> <div><p>25 ± 3mm</p></div> <div><p>3. Confirm measurement from end of tape up to end of COT 25±3mm then continue the taping process using both hands.</p></div> <div><p>4. Confirm measurement from end of COT up to end of tape 25±3mm then continue the taping process using both hands.</p></div> <div><p>131 ± 3mm 25 ± 3mm 25 ± 3mm 139 ± 3mm</p></div> <div><p>5. After taping, check the measurement, wire alignment and taping condition.</p></div>	<div></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-001A for taping procedure.</p> <ul style="list-style-type: none">1. No peel-off tape2. No flip out tape3. No loose tape4. No wrong use of tape5. No wrong dimension6. No missing tape7. No insufficient tape <div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div>	

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PARTS:		1. Assy part 2. Black tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
5	P2 Half-wrap taping	<div><p>1. Attach the tape, then make 2 windings.</p></div> <div><p>2. Pull the tape around 150mm~200mm.</p></div> <div><p>3. Hold the other side of the harness on the table and apply force to rotate the tape to make halfwrap shifting until cover the COT with slit.s</p></div> <div><p>4. Make 2 windings before cut the tape.</p></div> <div><p>5. After taping, check the condition of tape. THERE MUST BE NO EXPOSED COT BETWEEN HALF WRAP TAPING.</p></div> <div><p>6. Conduct 3x pressing at the end of Taping to prevent peel off and loose tape using left thumb.</p></div> <div><p>internal tolerance 0~14mm</p></div> <div><p>Appearance after Taping</p></div>		<p>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>Important reminders/Note/s: 1. Use Yellow tape for easy visualization of tape shifting, but actual should be BLACK TAPE. 2. Internal tolerance for halfwrap taping shifting should be 0~14mm only.</p> <p>1. No loose/tight tape 2. No flip-out tape 3. No peel-off tape 4. No exposed COT between tape windings</p>		

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PROTOTYPE



PRE-LAUNCH



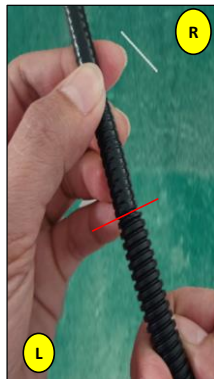

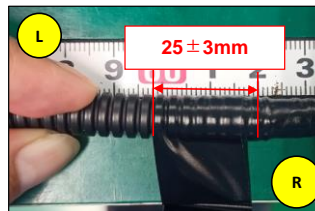
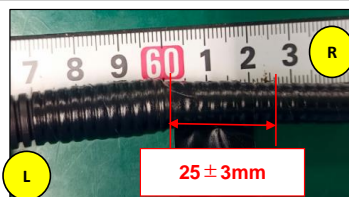
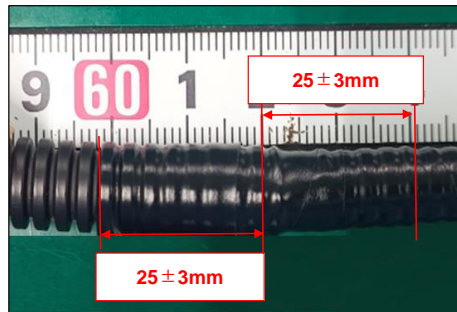

MASSPRO

Revision No.:

0

Page No.:

5 of 6

PARTS:		1. Assy part 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P2	<div><div><p>1. Fix the Corrugated tube (No slit) and the Corrugated tube (w/slit) using both hands.</p></div><div><p>2. Get the black tape and start taping process using both hands.</p></div><div><p>3. Measure from end of tape up to end of Corrugated tube (No slit) 25±3mm.</p></div><div><p>4. Measure from end of Corrugated tube (No slit) to end of tape 25±3mm.</p></div><div><p>65 After taping, check the measurement and taping condition.</p></div></div> <div><p>MEASURING TAPE</p></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-001A for taping procedure.</p> <ol style="list-style-type: none">1. No peel-off tape2. No flip out tape3. No loose tape4. No wrong use of tape5. No wrong dimension6. No missing tape7. No insufficient taping	

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PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

0

Page No.:

6 of 6

PARTS:

1. Assy parts

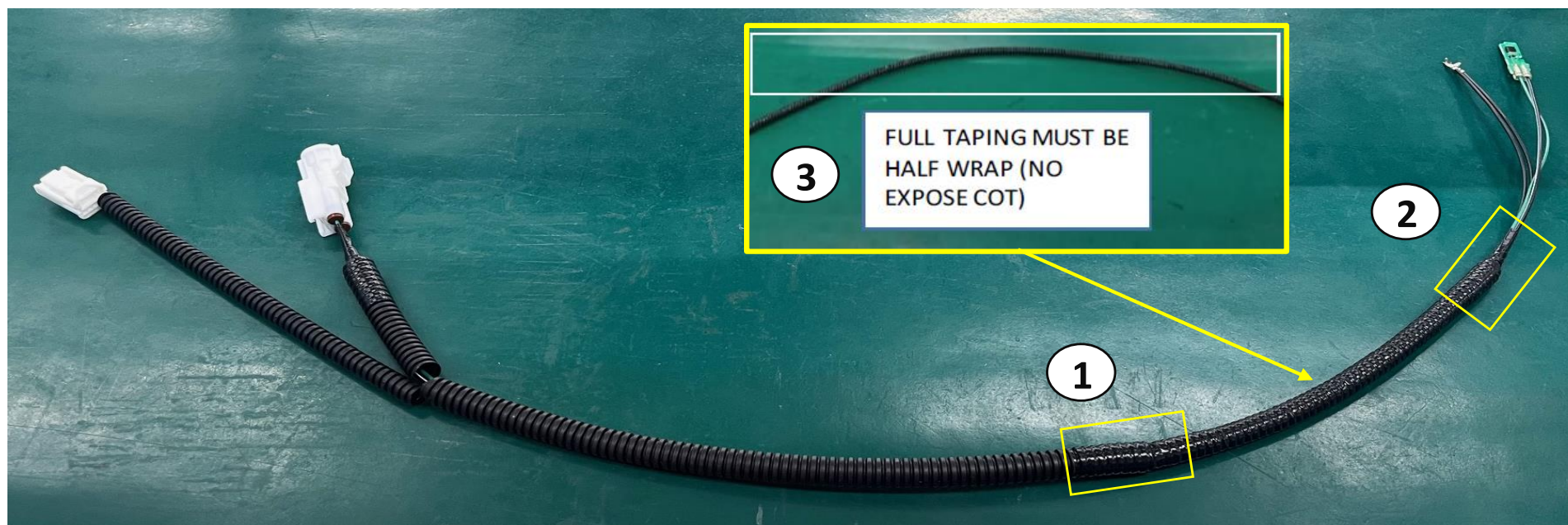
JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING - P2

7N0235-7020A



1 2 No Missing Tape

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