



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 18, 2024

Process Name/Title:

Model code/Part number: 900B.910B / 7N0104-7020A

Customer: TRJ

Car Model:

LEXUS-NX/RX

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-410B

Revision No.:

5

Page No.:

1 of 5

PARTS:

1. Assy parts; Black corrugated tube L=363±mm; COT adopter; Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

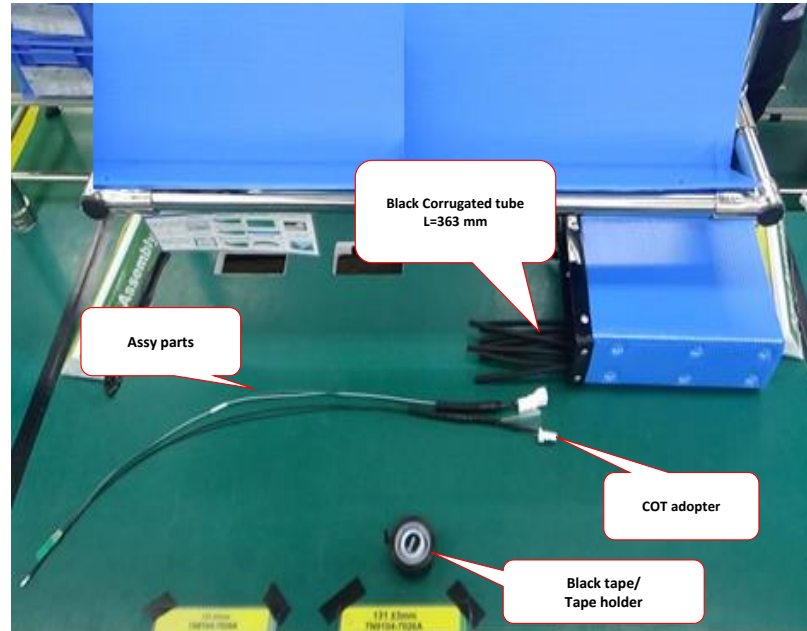
QUALITY POINTERS

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

06/18/24

5

Transfer process 2,3,4 and 5 from WI-ENG-PDE-410A. Distributed process to WI-ENG-PDE-410C due to process improvement. Update table lay-out and Quality checkpoints. Additional Important reminders/Note/s in Process 5 (Page 4) due to customer claim countermeasure.

D.Castillo

C.Villanueva

A. Arañes

n/a

03/18/24

4

Work instruction improvement. Change MP from 3MP to 2MP. Transfer process from P3. Change term Vinyl tube to SV tube (Vinyl); Sunprene tube to VM tube (Sunprene). Update Table lay-out and Quality checkpoints (Page 12).

D.Castillo

C.Villanueva

A. Arañes

n/a

01/19/23

3

Correction of work procedure on process 3 no.2 Change "Measure from end of the corrugated tube up to hotmelted wire 131±3mm" to Measure from end of the corrugated tube up to terminal pointed tip 131±3mm".

M.Ariola

J. Loterte

C.Villanueva

A. Arañes

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted


Est. Date:




April 12, 2022

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	Model code/Part number: 900B.910B / 7N0104-7020A		Customer: TRJ	Car Model: LEXUS-NX/RX	Revision No.: 5 Page No.: 2 of 5		
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO							





PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
2	P2 Taping 1 Spot taping	<div></div> <div></div> <div></div>	n/a	<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>	

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


PARTS:		1. Assy parts 2. Black tape		JIG:		1. COT Adaptor	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
3	P2 <div>5</div> Wire insertion to Black Corrugated tube (w/slit) ø5 L=363±3mm	<div></div> <div>1. Hold the COT adaptor using left hand. Combined the 2 assy parts and put inside the COT adaptor using right hand</div> <div>2. Hold the COT adaptor with wires using left hand, get the Black Corrugated tube (w/slit) ø5 L=363±3mm using right hand and insert to COT adaptor. Pull the adaptor and push the COT (same timing) using both hands. Make sure all wires are inserted.</div>		<div>COT Adaptor</div> 		1. No wrong use of parts 2. No wires left in between the COT with slit	

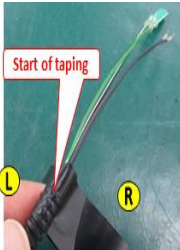
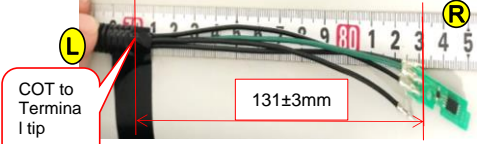


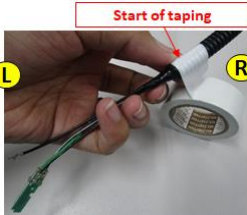

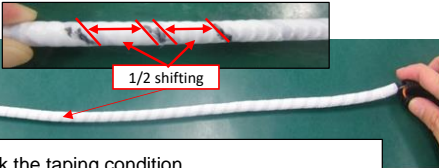

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PARTS:	1. Assy parts 2. Black tape			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
4	<div>5</div> <div>Taping 2 Black Corrugated tube (w/slit) to wire near PCB and terminal tip</div> <div>P2</div>	<div><div>L R</div></div> <div>1. Hold the corrugated tube using left hand then start taping using right hand.</div> <div><div>L R</div><div>131±3mm</div></div> <div>2. Measure from end of the corrugated tube up to hotmelted wires 131±3mm then continue the taping process using both hands.</div> <div><div>25±3mm</div><div>25±3mm</div></div> <div>3. After taping, check the measurement and taping condition.</div>	<div>Measuring tape</div> 	<div>1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape</div> <div>Important reminders/Note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement</div> <div>2. Refer to WI-PRO-ASY-001 for taping procedure</div>	
5	<div>5</div> <div>Half-wrap taping</div>	<div><div>L R</div></div> <div>1. Hold the corrugated tube using left hand and begin taping using right hand.</div> <div><div>L R</div><div>1/2 shifting</div></div> <div>2. Make 1/2 shifting. Repeat the process until the end of corrugated tube. Make 3 winds and then cut the tape.</div> <div><div>1/2 shifting</div></div> <div>3. Check the taping condition.</div>	<div>Measuring tape</div> 	<div>1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape</div> <div>Important reminders/Note/s</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>2. Used WHITE TAPE to easily visualize the tape shifting, but actual should be BLACK TAPE.</div> <div>3. Internal tolerance for halfwrap taping shifting should be 0~14mm only.</div> <div>5</div>	

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PARTS:

n/a

JIG:

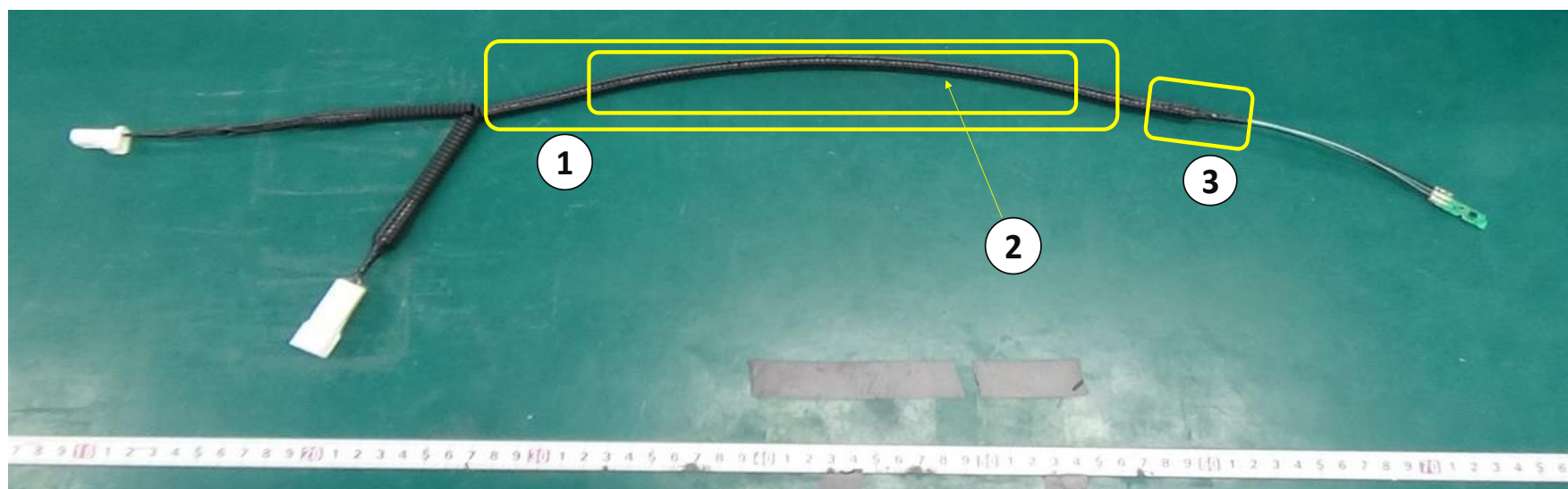
n/a



VISUAL INSPECTION/ QUALITY CHECKPOINTS

P2

7N0104-7020A



① No Missing COT

② No Missing half wrap taping

③ No Missing tape in COT to Wire near PCB

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