



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

July 10, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

100B / 7M0594-7021

Customer: TRJ

Car Model:

LEXUS UX

Document No.:

WI-ENG-PDE-425B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

Page No.:

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PARTS:

1. Assy parts: Black COT (with slit) Ø5 L=410±3mm; Black tape [1pc.]

JIG:

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

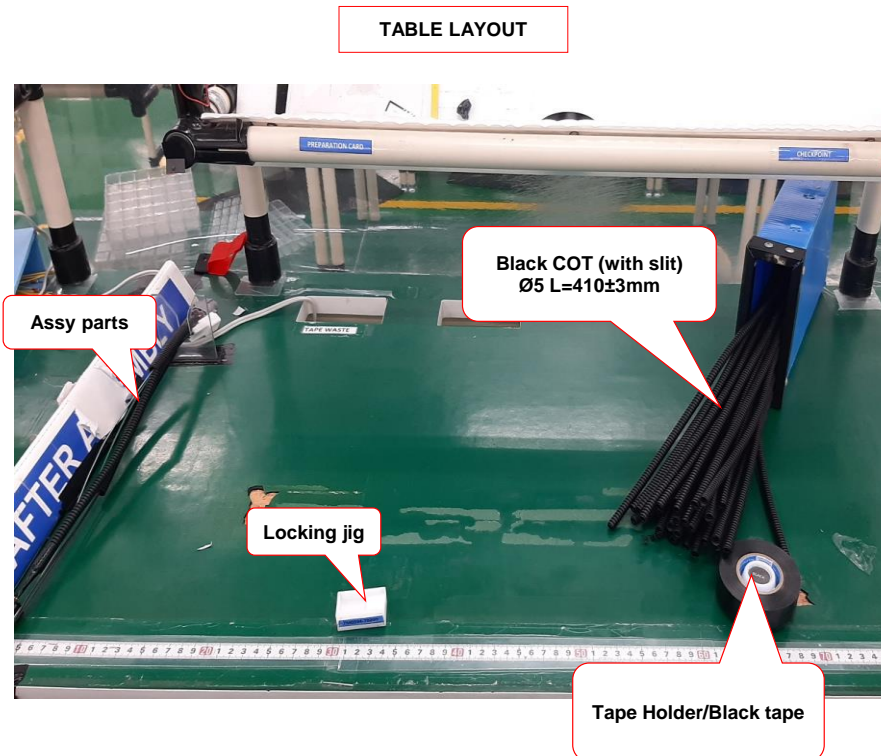
TOOLS/PPE

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

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
07/10/24	3	Additional Important reminders/Note/s in Process 5 (Page 6) due to customer claim countermeasure. Change tape width to value (20±3mm).	D.Castillo	C.Villanueva	A. Arañes	N/A				
09/07/22	2	Update template and inclusion of Car model	A.Hernandez	J. Loterte	C. Villanueva	A. Arañes				
12/17/22	1	Improve quality pointers: Reminders/notes and references. Work procedure/illustration of connector locking process. Inclusion of Quality checkpoints	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	February 24, 2022		

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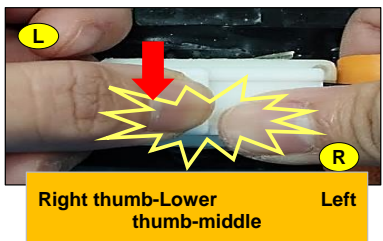


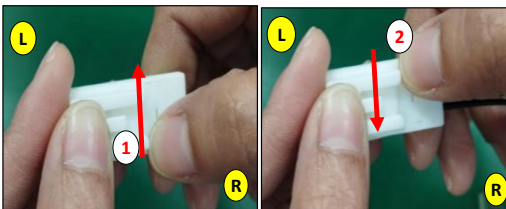

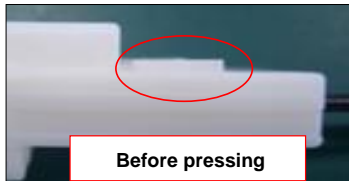



☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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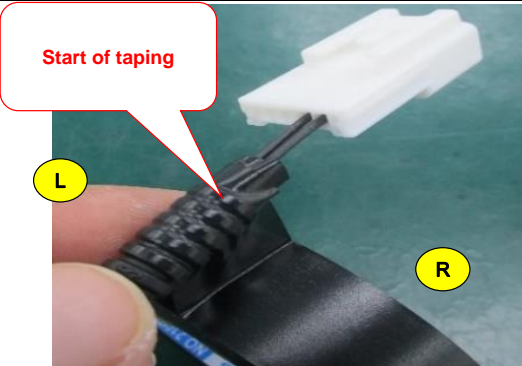
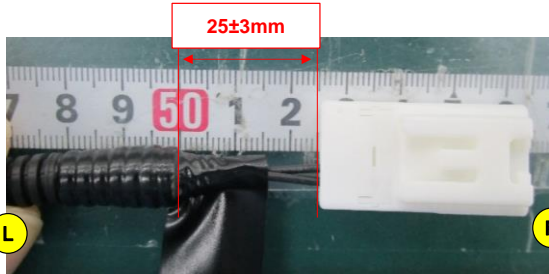
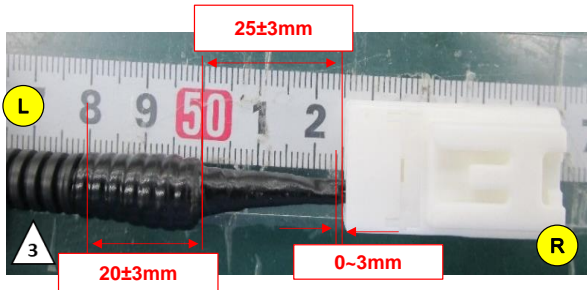

PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Connector Lock	<div><div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div><div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div><div><p>Right thumb-Lower thumb-middle Left</p></div><div><p>Right thumb-upper Left thumb-middle</p></div><div><p>Right thumb-middle Left thumb-middle</p></div><div><p>6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div></div>		<div></div>	<div><p>Before pressing</p></div> <div><p>After pressing</p></div> <div><div><p>GOOD</p><p>Full Lock</p></div><div><p>NG</p><p>Half Lock</p></div></div> <p>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <p>1. Use the provided jig tool to lock the connector. 2. No unlock/half-locked connector</p>

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	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	3	Page No.:




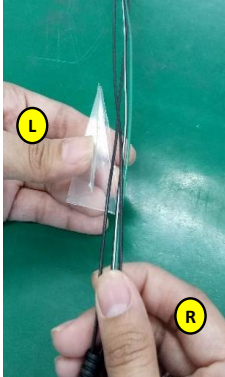
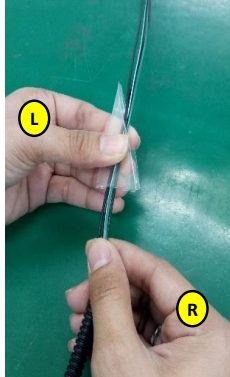
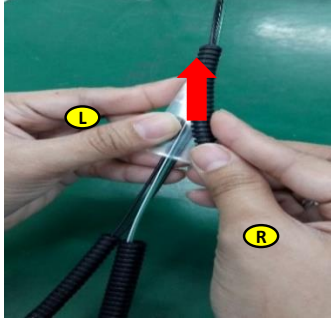

PARTS:	1. Assy parts 2. Black tape			JIG:	n/a			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
3	P2 Taping 3 Black corrugated tube to wire near connector	<div><p>Start of taping</p><p>L R</p></div> <div><p>25±3mm</p><p>L R</p></div> <div><p>25±3mm</p><p>20±3mm</p><p>0~3mm</p><p>L R</p></div> <div><p>1. Hold the corrugated tube using left hand, get the balck tape then start taping process using both hands.</p><p>2. Measure from end of the corrugated tube up to connector 25±3mm then continue the taping process using both hands.</p><p>3. After taping, check the measurement and tape condition.</p></div>			<div><p>MEASURING TAPE</p></div>	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</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>		


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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		3	Page No.:

PARTS:		1. Assy parts 2. Black tape		JIG:		n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
4	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, get the Black tape using right hand then make 2 windings of tape using both hands. Note: Position of spot taping must be right beside Green tape.</p> </div> 		N/A	<p>Important reminders/Note/s:</p> <p>1. 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 use of tape</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p>		
5	P2 Wire insertion to Black Corrugated tube (w/slit) ø5 L=410±3mm	<div>   <p>1. Hold the COT adaptor using left hand then 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=410±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>  <p>COT Adaptor</p> </div>	<p>1. No wrong use of parts 2. No wires left between COT with slit</p>		

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PARTS:

1. Assy parts
2. Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

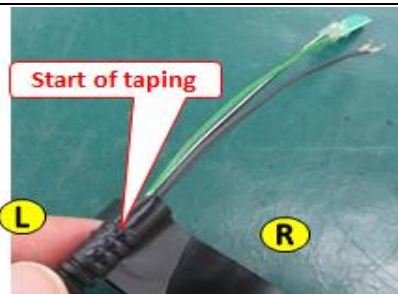
TOOLS/PPE

QUALITY POINTERS

6

P2

Taping 4
Black Corrugated tube
(w/slit) to wire near PCB
and terminal tip

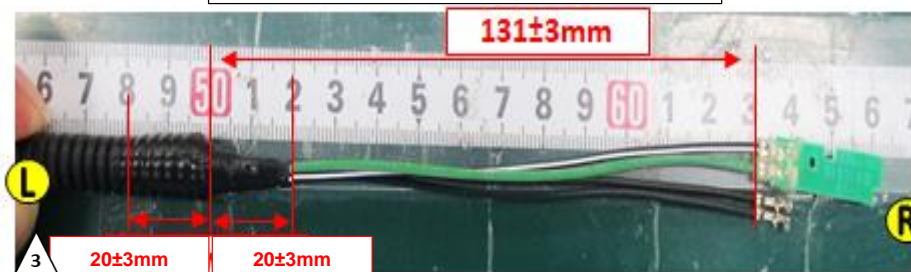


Start of taping

1. Hold the corrugated tube using left hand then start taping using right hand.



2. Measure from end of the corrugated tube up to hotmelted wires **131±3mm** then continue the taping process using both hands.



3. After taping, check the measurement and taping condition.

MEASURING TAPE



Important reminders/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.



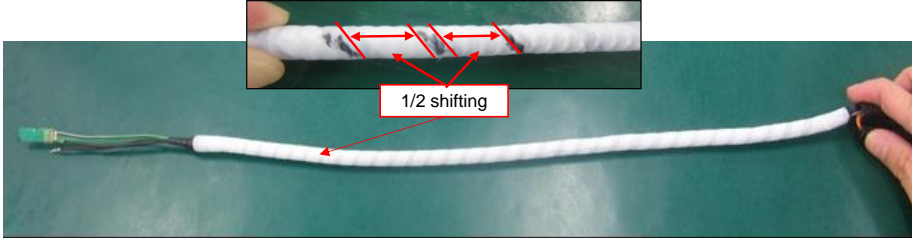

1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong dimension
6. No wrong use of tape

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
7	P2 Half-wrap taping	<div><div>Start of taping</div><div>1. Hold the corrugated tube using left hand and begin taping using right hand.</div></div> <div><div>1/2 shifting</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><div>1/2 shifting</div><div>3. Check the taping condition.</div></div>		<div>MEASURING TAPE</div> 	<div>Important reminders/Note/s 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Used <u>WHITE TAPE</u> to easily visualize the tape shifting, but actual should be <u>BLACK TAPE</u>. 3. Internal tolerance for halfwrap taping shifting should be 0~14mm only.</div> <div>3</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>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</div>	

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PARTS:

1. Assy parts

JIG:

n/a

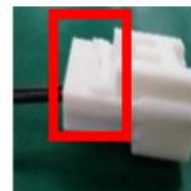
VISUAL INSPECTION/ QUALITY CHECKPOINTS

P2

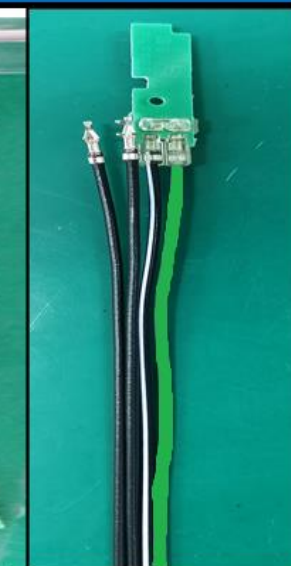
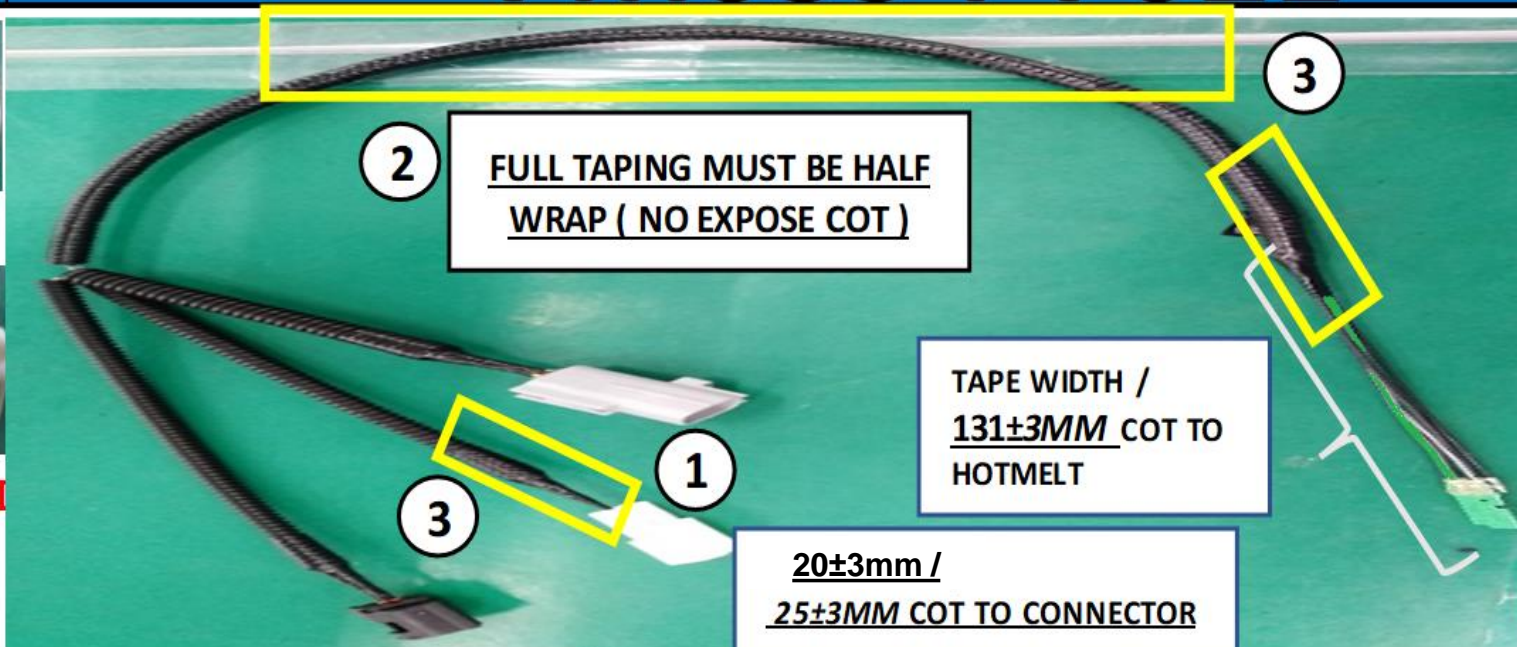
7M0594-7021



GOOD



NO GOOD



Proper alignment of B-B wires and hotmelt

1

No UNLOCKED/HALFLOCKED CONNECTOR

2

No MISSING COT

3

No Missing Tape

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