



## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

May 17, 2024

Process Name/Title:

Model code/Part number:

164B / 7M0547-7020C

Customer: TRJ

Car Model: TOYOTA-AURIS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-046

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

10

Page No.:

1 of 6

## PARTS:

1. Assy parts; Gray tape; Black SV tube (Vinyl) Ø5 L=135±2mm

JIG:

n/a

NO.

PROCESS NAME

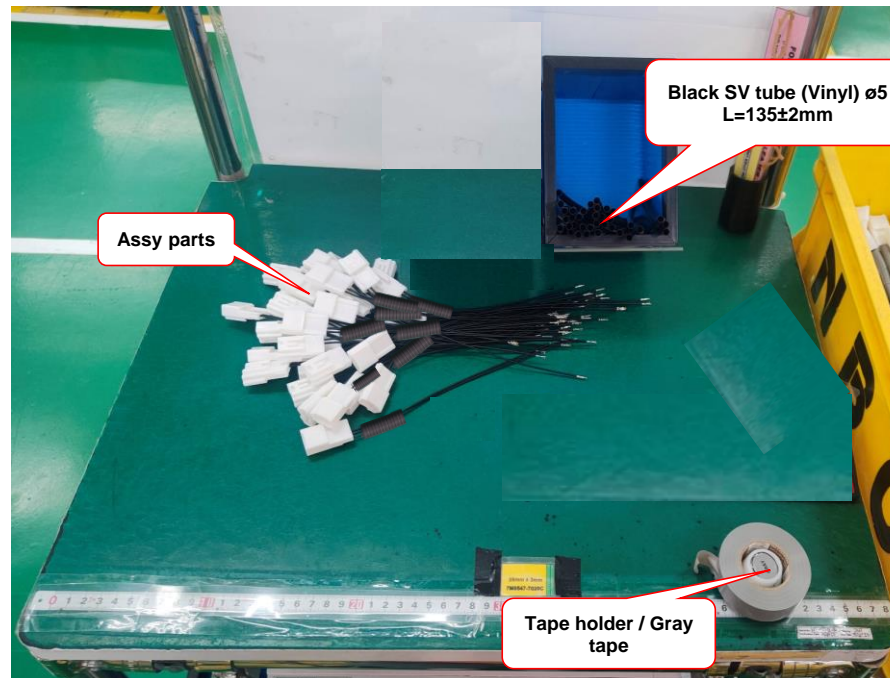
10

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

## 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.

## Document reference/s:

1. Please refer to WI-ENG-PDE-114 for Offline Assembly Process

1. No missing parts/tools
2. No excess parts/tools


## Revision History

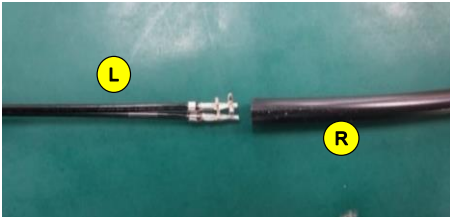


Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/17/24	10	Transfer Wire insertion to corrugated tube(no slit) Ø5 L=39+2mm process to Offline assembly process due to Process improvement. Update table lay-out, Measurement and Visual inspection.	D.Castillo	C. Villanueva	A. Arañes	n/a				
06/30/23	9	Inclusion of table lay-out and quality checkpoints; improve by two's inspection, important reminders/note/s and document references. Standardize term of SV tube (Vinyl); update template, include car model.	J. Loterte	C. Villanueva	A. Arañes	n/a				
07/08/21	8	Revised due to removal of marking.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
							D.Castillo	C. Villanueva	A. Arañes	n/a

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	Model code/Part number: <b>164B / 7M0547-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-AURIS</b>	Document No.:	<b>WI-ENG-PDE-046</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	<b>10</b>	Page No.:	<b>2 of 6</b>

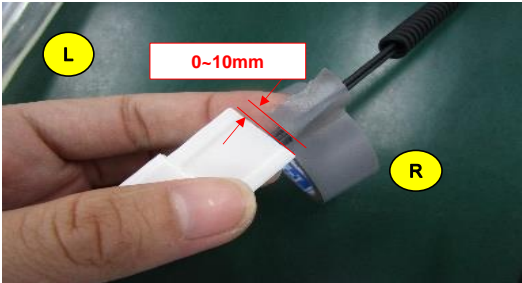
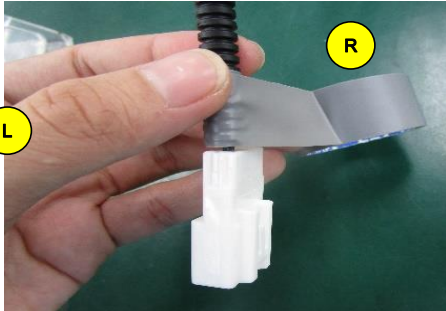
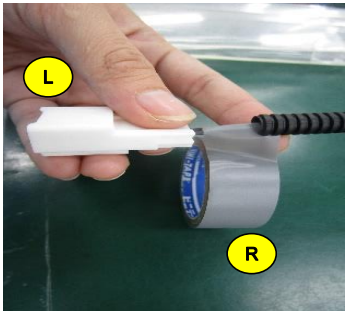
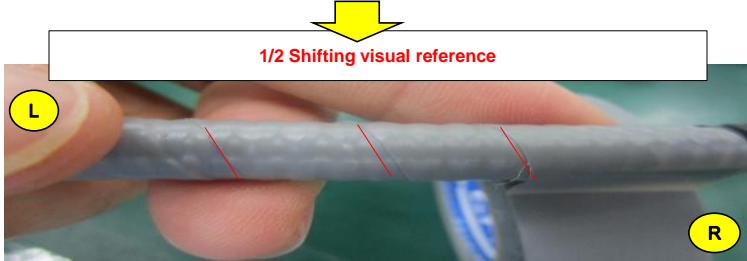
<b>PARTS:</b>		1. Assy parts 2. Black SV tube (Vinyl) ø5 L=135±2mm		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	P1	<div><div>1. Get the Black SV tube (Vinyl) <b>ø5 L=135±2mm</b> using right hand then insert the <b>B-B wires (Assy Parts)</b> using left hand.</div></div>		n/a	1. No wrong usage of parts 2. No deformed terminal

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	<b>10</b>	Page No.:	<b>3 of 6</b>

<b>PARTS:</b>		1. Assy parts 2. Gray tape		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
3	P1  Taping 1 From wire near connector to corrugated tube up to vinyl tube	<div><div>1. Hold the connector using left hand and attach the <b>GRAY TAPE</b> on wires using right hand (see picture for illustration) then make <b>3 windings</b>, do not cut the tape.  <b>Note: Attachment of tape to wire must be from 0~10mm.</b></div></div> <div><div>2. After taping, insert the <b>GRAY TAPE</b> into the <b>COT w/slit</b> using right hand.  3. After insertion, conduct <b>2x winding</b> of <b>GRAY TAPE</b> then make <b>1/2 shifting</b> going to right side until it covers the COT with slit.</div></div> <div><div>1/2 Shifting visual reference</div></div>		n/a	<b>Important reminders and Note/s:</b> <b>1. Use GRAY TAPE only</b>  1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension

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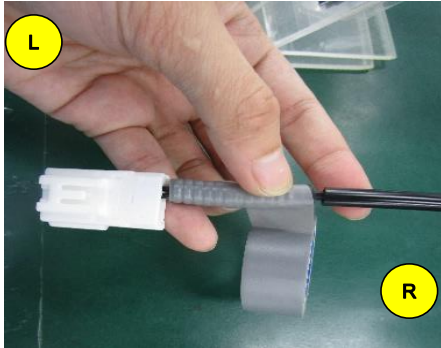
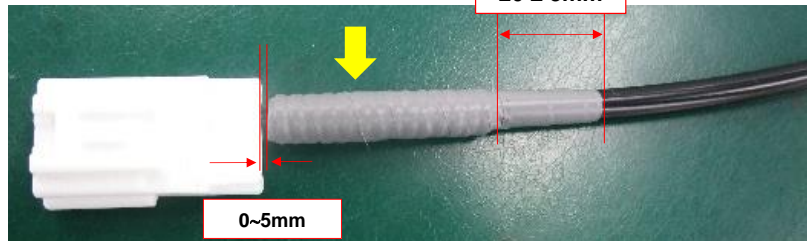

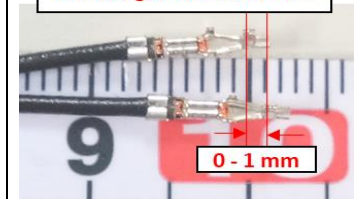
WI-ENG-PDE-046

Revision No.:

10

Page No.:

4 of 6

PARTS:	1. Assy parts 2. Gray tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1  Taping 1 From wire near connector to corrugated tube up to vinyl tube (Continuation)	<div><div><div><div>L</div><div>R</div></div><div>4. Fix the vinyl tube to COT and continue the taping process using both hands. Make 3 windings then cut the tape.</div><div>5. After taping, check the measurement, wire alignment and taping condition.</div><div><div>20 ± 3mm</div><div>0~5mm</div><div>35 ± 3mm</div><div>0~5mm</div><div>20 ± 3mm</div></div></div></div>	<div>Measuring tape</div> 	<div>Important reminders and Note/s; 1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</div> <div>Wire alignment tolerance</div>  <div>0 - 1 mm</div>

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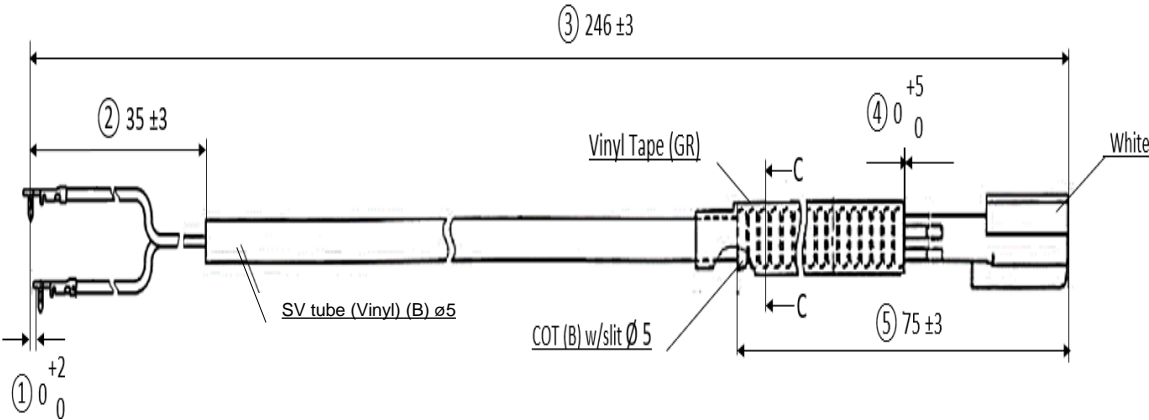
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

**10**

Page No.:

**5 of 6**

PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	<div><div>10</div>WORK PROCEDURE/ ILLUSTRATION</div>	TOOLS/PPE	QUALITY POINTERS
4	P1	Measurement	<div><div>Measuring tape</div></div>  <p>Technical drawing of a cable assembly with the following dimensions and labels:</p> <ul style="list-style-type: none"><li>① 0<sup>+2</sup><sub>0</sub></li><li>② 35 ±3</li><li>③ 246 ±3</li><li>④ 0<sup>+5</sup><sub>0</sub></li><li>⑤ 75 ±3</li><li>Labels: SV tube (Vinyl) (B) ø5, Vinyl Tape (GR), COT (B) w/slit Ø 5, C, White</li></ul>	<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>

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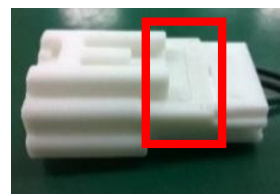
Page No.:

**6 of 6****PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ VISUAL INSPECTION****TAPING-P1****7M0547-7020C****GOOD****NO GOOD****①****No Deformed Terminal****②****No Unlocked/Half-locked Connector****③****No Missing Tape and  
No Wrong use of tape**

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