



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

September 8, 2023

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

700B

/ 7N0039-7020A

Customer:

TRJ

Car Model: TOYOTA-LAND CRUISER

Document No.:

WI-ENG-PDE-715B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS: 1. Assy parts; Black corrugated tube (no slit) $\phi 5$ L=496 \pm 4mm; Black tape

JIG:

n/a

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

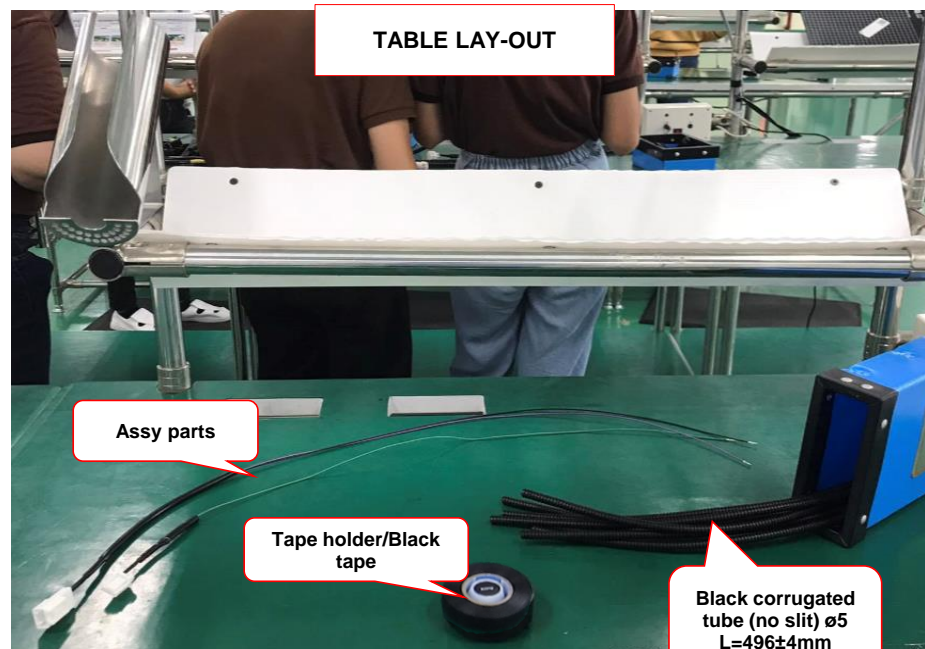
TOOLS/PPE

QUALITY POINTERS

1

P2

Table lay-out

**Safety Instruction**

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

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

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.

Revision History

Prepared by

Reviewed by

Approved by

Noted by

09/08/23 1 Change purpose from pre-launch to Masspro. Additional table lay-out; Update Quality checkpoints

M. Ariola

J. Loterte

C. Villanueva

A. Arañes

08/08/23 0 Initial Issue.

M. Ariola

J. Loterte

C. Villanueva

A. Arañes

Eff. Date Rev. No Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

August 08, 2023

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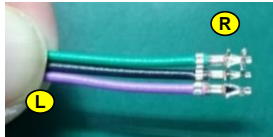
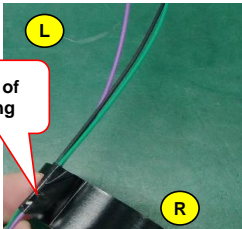
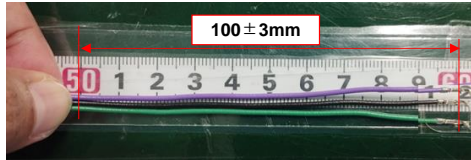
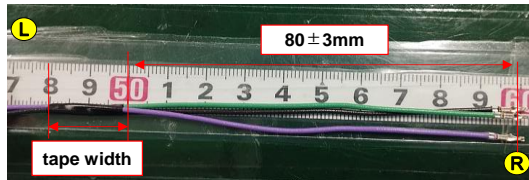

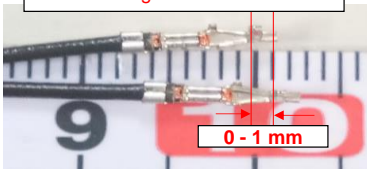




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PARTS:		1. Assy parts 2. Black corrugated tube $\phi 5$ L=496 \pm 3mm (No Slit) 3. Black tape		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Spot taping	<div><div></div><div>1. Combine the assy parts then align all terminals.</div><div></div><div>Start of taping</div><div>3. Get the Black tape using right hand then conduct 2 windings of spot taping using both hands.</div></div> <div><div></div><div>100 \pm 3mm</div><div>2. Conduct measurement from wires to terminal pointed tip 100\pm3mm using both hands.</div><div></div><div>80 \pm 3mm</div><div>tape width</div><div>4. After taping, check the measurement and taping condition.</div></div> <div>MEASURING TAPE</div> <div></div>		<div></div> <div>Wire alignment tolerance</div> <div>0 - 1 mm</div> <div>Important reminders/Note/s:</div> <div>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>	
3	Wire insertion to Black corrugated tube (no slit) $\phi 5$ L=496 \pm 4mm	<div><div></div><div>1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the B-G-V wires using left hand.</div><div></div><div>2. Get the corrugated tube (no slit) $\phi 5$ L=496\pm3mm (no slit) using right hand then insert the B-G-V wires using left hand.</div><div></div><div>3. After insertion, remove the terminal cover jig using right hand.</div></div>		Terminal cover Jig	<div></div> <div>1. No wrong insertion 2. No deformed terminal</div>

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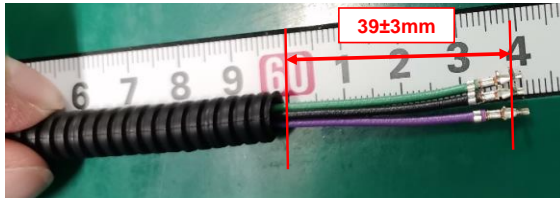


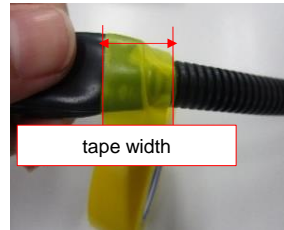

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Wire insertion to Black corrugated tube (no slit) $\phi 5$ L=496 \pm 4mm (Continuation)	 <p>4. Conduct measurement between end of COT up to pointed tip 39\pm3mm.</p>		1. No wrong insertion 2. No deformed terminal Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.
5		Y-Taping	 <p>Note: Do not exert excessive force during pulling & winding of tape.</p>  <p>tape width</p> <p>tape shifting 1/2 below</p> <p>taping direction</p> <p>1. Fix the two SV tubes (Vinyl) and COT using both hands. <i>See illustration for correct facing of connector.</i></p> <p>2. Hold two SV tubes (Vinyl) using left hand and fix to COT. Make 1 winding for pre-tape before shifting then wind the tape down to SV tube (Vinyl) until tape width.</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 Important reminders/Note/s: 1. Use YELLOW tape to easy visualization of shifting lines, but actual should be BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement.

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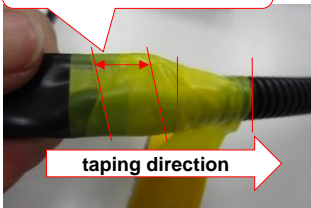
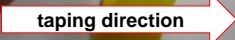




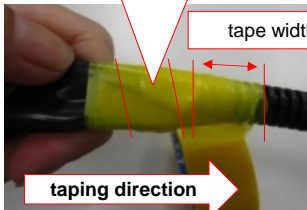
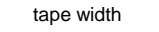

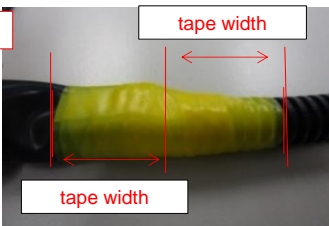


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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
5	P2	Y-taping (Continuation)	<div><div><div>tape shifting 1/3 below</div></div><div><div>taping direction</div></div></div> <div><div>3. From SV tube (Vinyl), make 1/3 shifting to COT until tape width. Wind the tape 1 time before shifting.</div></div>	<div><div>MEASURING TAPE</div></div>	<div><div>Important reminders/Note/s:</div><div><div>1. Use YELLOW tape to easy visualization of shifting lines, but actual shoould be BLACK TAPE.</div><div>2. Please use calibrated/verified measuring tape when getting the measurement.</div></div><div><div>1. No flip-out tape</div><div>2. No peel-off tape</div><div>3. No loose tape</div><div>4. No missing tape</div><div>5. No wrong dimension</div><div>6. No wrong use of tape</div></div></div>	
			<div><div><div>tape shifting 1/2 below</div></div><div><div>tape width</div></div><div><div>taping direction</div></div></div> <div><div>4. From COT, wind the tape down to vinyl tube (1/2 shifting) until tape width.</div></div>			
			<div><div><div>tape shifting 1/2 below</div></div><div><div>tape width</div></div><div><div>taping direction</div></div></div> <div><div><div>tape width</div></div><div><div>tape width</div></div><div><div>tape width</div></div></div> <div><div>5. From vinyl tube, wind the tape (1/2 shifting) going to side of corrugated tube then cut the tape after 2 windings. After taping, check the condition of tape.</div></div>			

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PARTS:

n/a

JIG:

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**QUALITY CHECKPOINTS****P2****7N0039-7020A**

1 No **Missing spot tape)**
(on wire taping)

2 No **Missing Tape**
(on Y-taping)

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