



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

February 26, 2025

Validity Date:

n/a

Model code/Part number:

559D / 7N0242-7020A

Customer:

TRJ

Car Model:

TOYOTA HI-ACE

Document No.:

WI-ENG-PDE-1182B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

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PARTS:

1. Assy parts; Clamp 82711-1E360 (W); Black SV tube (Vinyl) $\phi 5$ L=535 \pm 2mm ; Sky Blue

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

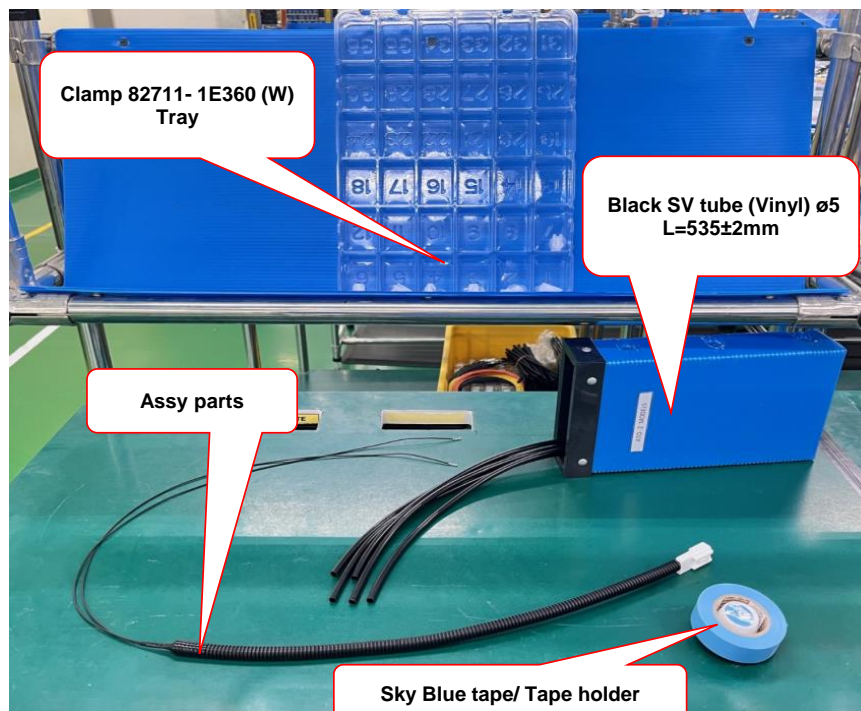
QUALITY POINTERS

1

P2

Table lay-out

TABLE LAY-OUT

**Safety Instruction**

Be sure to wear 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

Revision History

Prepared by

Checked by

Reviewed by

Approved by

02/26/25 0 Initial issue.

D.Castillo

J. Loterte

C.Villanueva

A. Arañes

D. Castillo

J. Loterte

C. Villanueva

A. Arañes

Eff. Date

Rev. No

Details of Change

Revised

Checked

Reviewed

Approved

Est. Date:

February 26, 2025

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PROTOTYPE



PRE-LAUNCH



MASSPRO

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Page No.:

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PARTS:

1. Clamp 82711-1E360 (W)
2. Assy parts

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

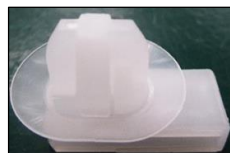
TOOLS/PPE

QUALITY POINTERS

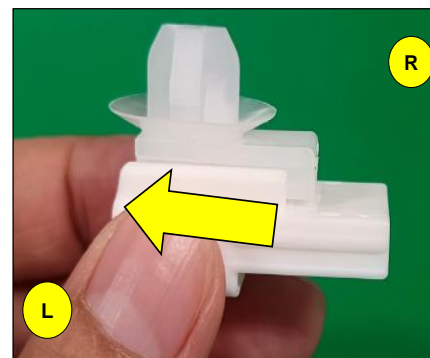
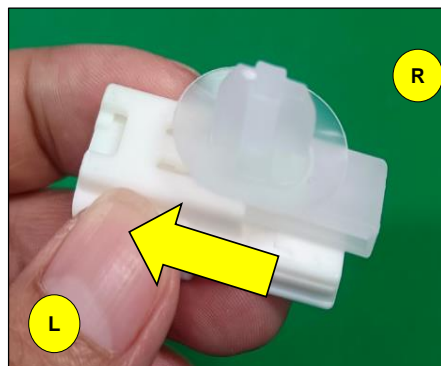
2

P2

Clip attachment
(Clip type clamp)



CLAMP
ORIENTATION



1. Hold the Connector using left hand, get the clip type clamp **82711-1E360 (W)** then insert the clamp using right hand.

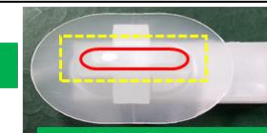
Note: Follow the illustration. Sound will be heard if properly inserted.

n/a

1. No wrong used of clamp
2. No damaged clamp
3. No missing clamp

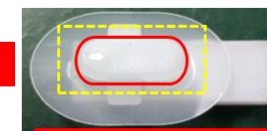
CLIP CLAMP ILLUSTRATION

GOOD



82711-1E360 (W)

NG



82711-12B10 (W)

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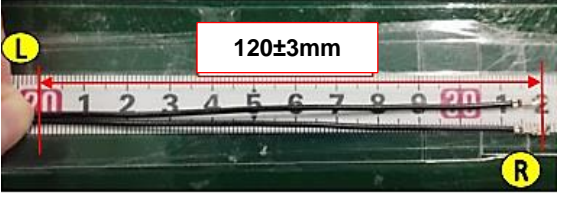
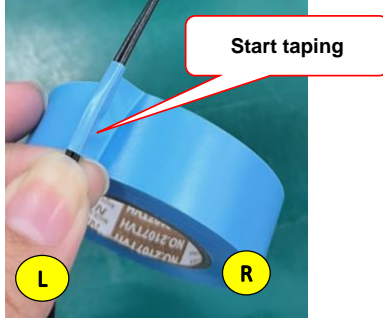
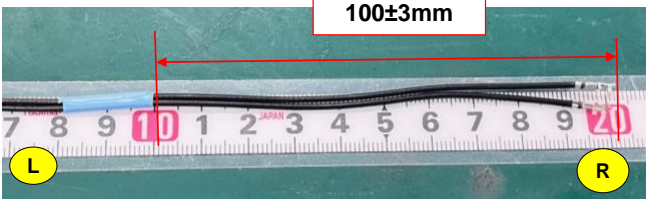

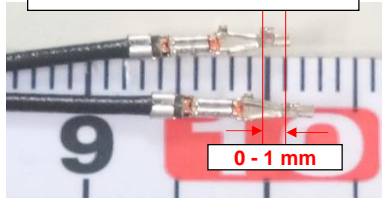

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PARTS:	1. Assy part 2. Sky Blue 3. Black SV tube (Vinyl) ø5 L=535±2mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Spot taping P2	<div><p>120±3mm</p></div> <div><p>1. Hold the wires using left hand and measure from wire up to terminal pointed tip 120±3mm</p></div> <div><p>Start taping</p></div> <div><p>2. Get the Sky Blue tape and start taping on the Black wires. Conduct 2 windings of tape before cut the tape using both hands.</p></div> <div><p>100±3mm</p></div> <div><p>3. After taping, check the measurement, tape condition and terminal appearance.</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>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape 7. No insufficient tape</p> <div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div>
4	Wire Insertion to Black Black SV tube (Vinyl) ø5 L=535±2mm	<div></div> <div><p>1. Hold the assy part using left hand and get Black SV tube (Vinyl) ø5 L=535±2mm using right hand then insert.</p></div>	n/a	<p>1. No wrong usage of parts 2. No deformed terminal</p>

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PARTS:

1. Assy part
2. Sky Blue

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

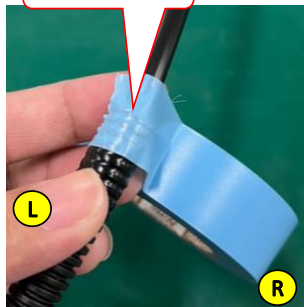
QUALITY POINTERS

5

P2

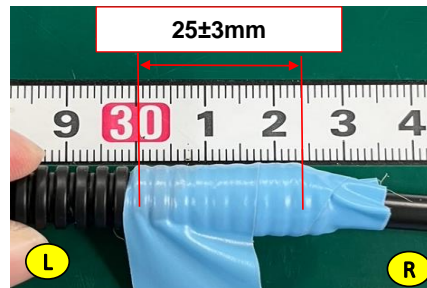
Taping 2
Black corrugated tube to
Black SV tube (Vinyl)

Start taping



1. Get the **Sky blue tape** using right hand then start taping process using both hands.

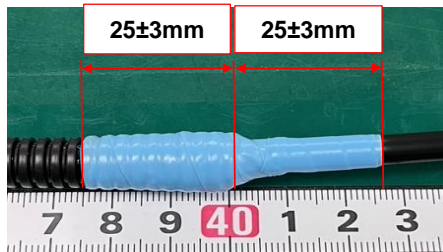
25±3mm



2. Hold the assy part using left hand and measure from end of tape up to end of COT **25±3mm**. Then continue taping using both hands.

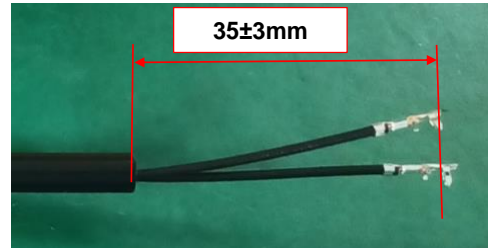
25±3mm

25±3mm

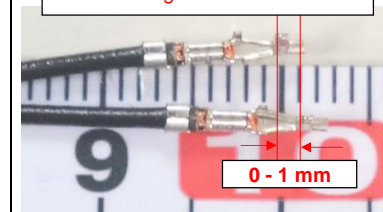


3. After taping, check the measurement, taping condition and terminal appearance.

35±3mm

MEASURING
TAPE

Wire alignment tolerance



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PARTS:

1. Assy parts

JIG:

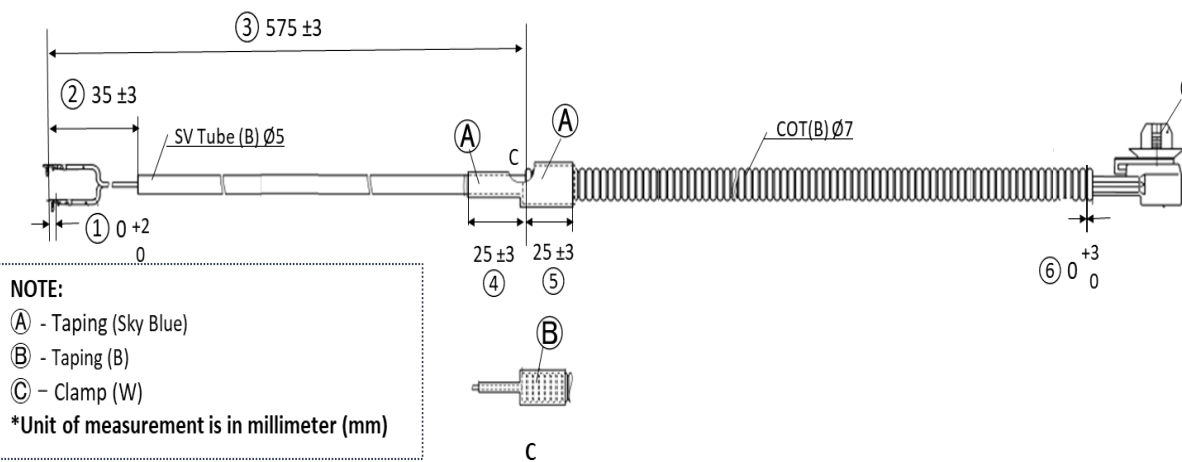
n/a

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

6

P2

Measurement

**MEASURING
TAPE****Important reminders and note/s:**
1. Please use calibrated/verified measuring tape when getting the measurement.**2. For Hatsumono and Owarimono.****Document reference/s:****1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection****1. No wrong dimension**

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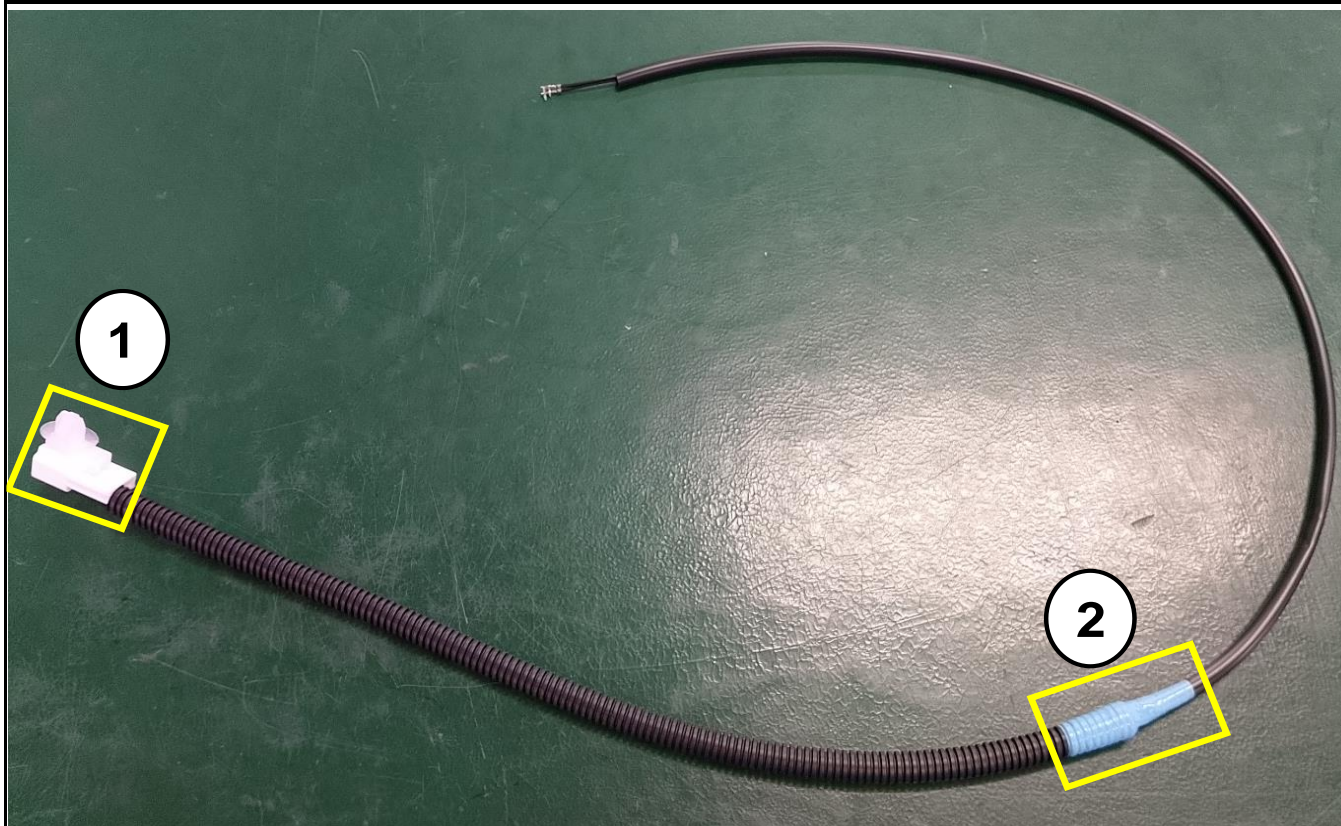
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P2****7N0242-7020A**

① No Missing Clip
Clamp

② No Missing tape

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