



## WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

October 14, 2024

Model code/Part number:

380D / 7L0139-7020B

Customer:

TRQSS

Car Model:

TOYOTA CAMRY

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-1115

Revision No.:

1

Page No.:

1 of 6

PARTS: 1. Assy parts; Black VM tube (Sunprene) Ø5 L=125±3mm; Black tape

JIG:

1. Measuring jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

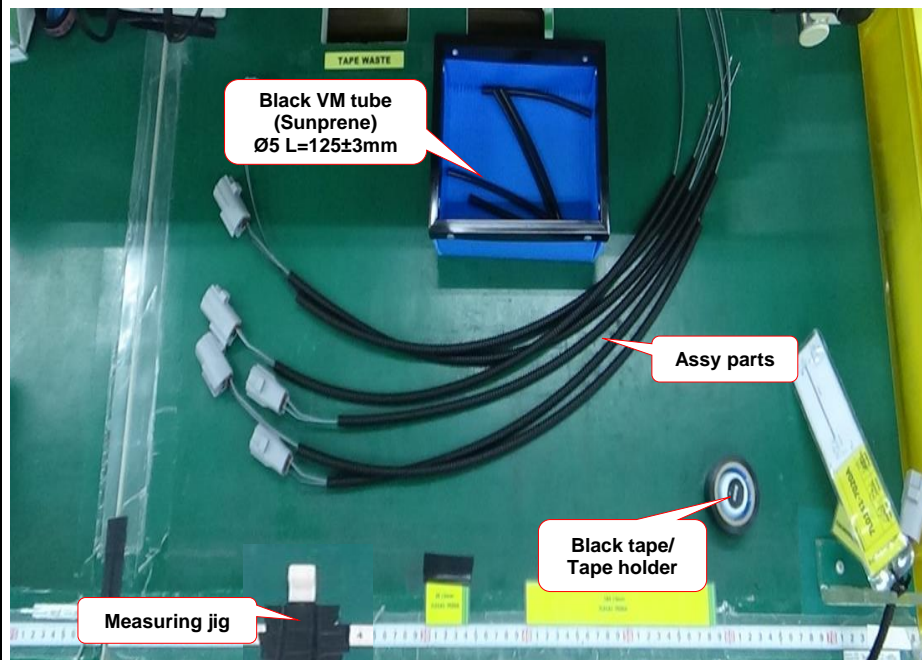
QUALITY POINTERS

1

P1

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.

## Document reference/s:

1. Refer to **WI-PRO-CNC-017** for Wire and Strip Length Tolerance.
2. Refer to **WI-ENG-PDE-968** for Offline assembly process

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

## Revision History

Prepared by

Reviewed by

Approved by

Noted by

10/14/24 1 Change purpose from Pre-launch to Masspro.

M. Ariola

C. Villanueva

A. Arañes

N/A

10/11/24 0 Initial issue. Update the Visual Inspection/Quality checkpoints

M. Ariola

C. Villanueva

A. Arañes

N/A

Eff. Date Rev. No Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

October 11, 2024

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Page No.:

2 of 6

<b>PARTS:</b>		1. Assy parts 2. Black VM tube (Sunprene) Ø5 L=125±3mm		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>Wire insertion to Black VM tube (Sunprene) Ø5 L=125±3mm</div> <div></div> <div>1. Get the VM tube (Sunprene) Ø5 L=125±3mm using right hand then insert the GR-B/W wires using left hand.</div>		N/A	1. No wrong use of parts 2. No deformed terminal

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Page No.:

3 of 6

PARTS:		1. Assy parts 2. Black tape		JIG:	1. Measuring jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Taping 1 Black VM tube (Sunprene) to wire near terminal	<p>2. Hold the tube using left hand, get the <b>Black tape</b> using right hand then start taping process using both hands.</p> <p>3. After taping, check the taping condition, measurement and wire alignment.</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 6. No wrong dimension</p> <p><b>Wire alignment tolerance</b></p> <p><b>Important reminders and Note/s:</b> 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p><b>Document reference/s:</b> 1. Refer to WI-PRO-ASY-001 for taping procedure.</p>

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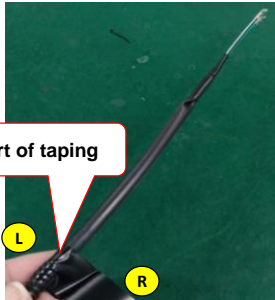


WI-ENG-PDE-1115

Revision No.:

1

Page No.:

4 of 6

PARTS:		1. Assy parts 2. Black tape		JIG:	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 Taping 2 Black COT to Black VM tube (Sunprene)	 <p>1. Measure from end of corrugated tube up to terminal pointed tip <b>184±3mm</b> using both hands.</p>  <p>2. Hold the corrugated tube and VM tube (Sunprene) using left hand, get the <b>Black tape</b> then start taping process using both hands.</p>  <p>3. After taping, check the taping condition, measurement and wire alignment.</p>			<p><b>Important reminders and Note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p><b>Document reference/s:</b></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 use of tape 6. No wrong dimension</p>

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Page No.:

5 of 6

### PARTS:

1. Assy parts

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

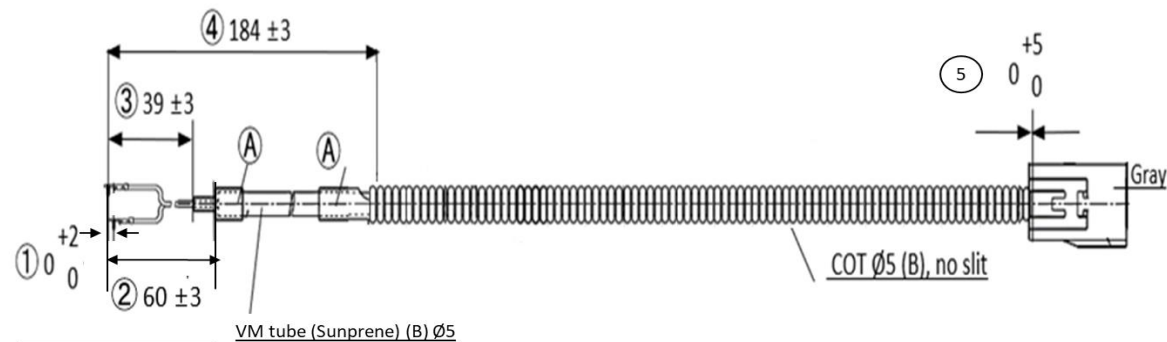
TOOLS/PPE

QUALITY POINTERS

4

P1

Measurement



MEASURING  
TAPE



**Important reminders and note/s:**  
1. Please use calibrated/verified measuring tape when getting the measurement.

2. For Hatsumono, Nakamono 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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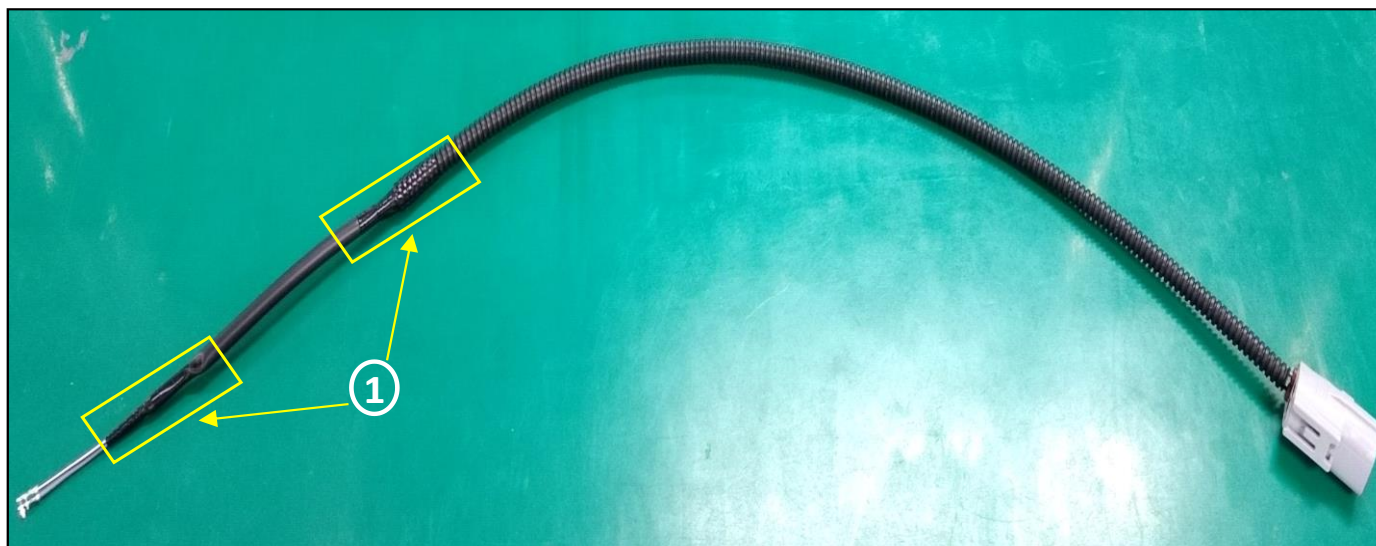
Page No.:

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

1. Assy parts

JIG:

N/A

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P1****7L0139-7020B****① No Missing Tape**

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