

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

December 21, 2023

Model code/Part number:

220D / 7R0127 - 7022

Customer:

TRMX

Car Model:

LEXUS-LM

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-596

Revision No.:

3

Page No.:

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PARTS:

1. All parts: Assy parts; Clamp 82711-16830 (B); Red tape [1pc.]

JIG:

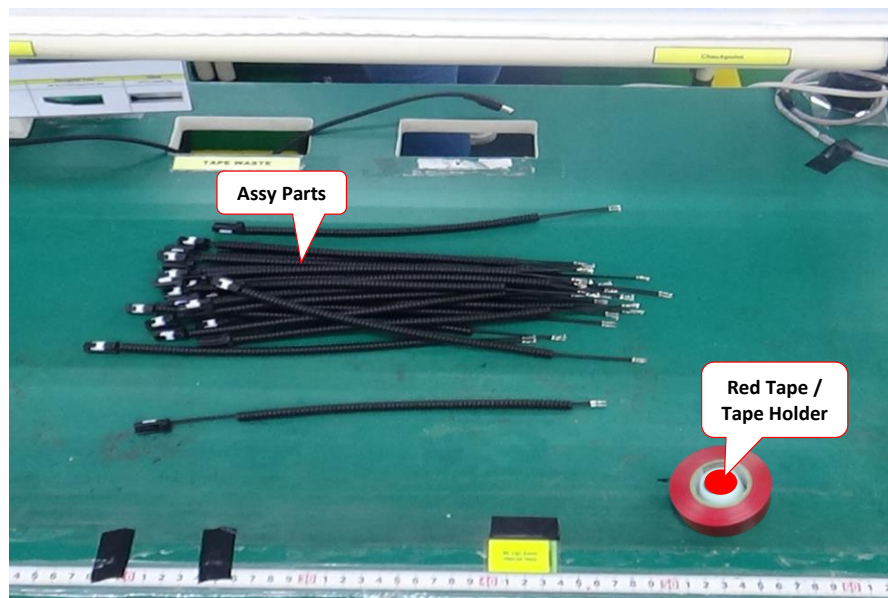
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NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

1

P1

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.

Document reference/s:

1. Refer to WI-ENG-PDE-595 7R0127-7022 - 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
12/21/23	3	Transfer Clamp assembly setting to Measurement process to Clamp Assembly process (WI-ENG-PDE-762) due to process improvement. Update table lay-out and Quality pointers. Inclusion of Car Model "LEXUS-LM"	D.Castillo	C.Villanueva	A. Arañes	n/a				
04/24/23	2	Inclusion of quality checkpoints.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
10/12/23	1	Change document purpose from Pre-launch to Masspro.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 4, 2022		

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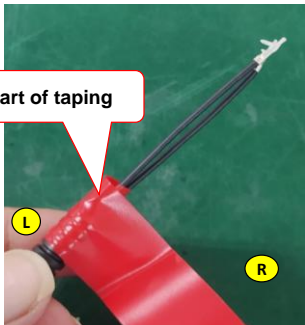

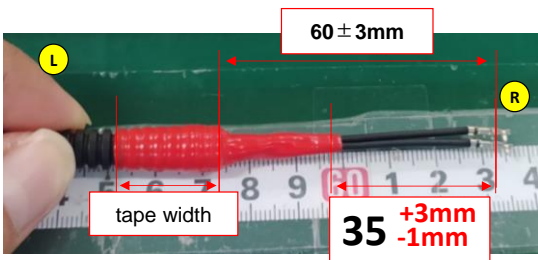

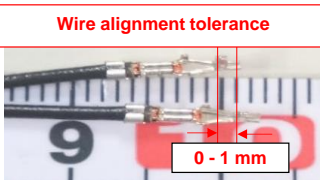
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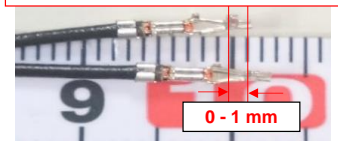
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PARTS:		1. Assy parts 2. Red tape [1pc]		JIG:	n/a	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	Taping 1 COT to wire near terminal	<div><div></div><div><p>1. Hold the COT using left hand, get the Red tape using right hand then start pre-taping using both hands.</p></div><div></div><div><p>2. Measure from end of COT up to terminal pointed tip 60±3mm then continue the taping process using both hands.</p></div><div></div><div><p>3. After taping, check the measurement, taping condition and terminal appearance.</p></div></div> <div><div>MEASURING TAPE</div></div>		<div><div>Wire alignment tolerance</div></div> <div><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></div> <div><p>Important reminders/Note/s:</p><p>1. USE RED TAPE ONLY 2. Please use calibrated/verified measuring tape when getting the measurement.</p></div> <div><p>Document reference/s:</p><p>1. Refer to WI-ENG-PDE-588 for Tape and tube end standard tolerance.</p></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

Important reminders/Note/s:

1. **USE RED TAPE ONLY**
2. Please use calibrated/verified measuring tape when getting the measurement.

Document reference/s:

1. Refer to WI-ENG-PDE-588 for Tape and tube end standard tolerance.

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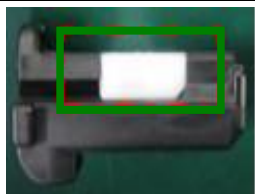
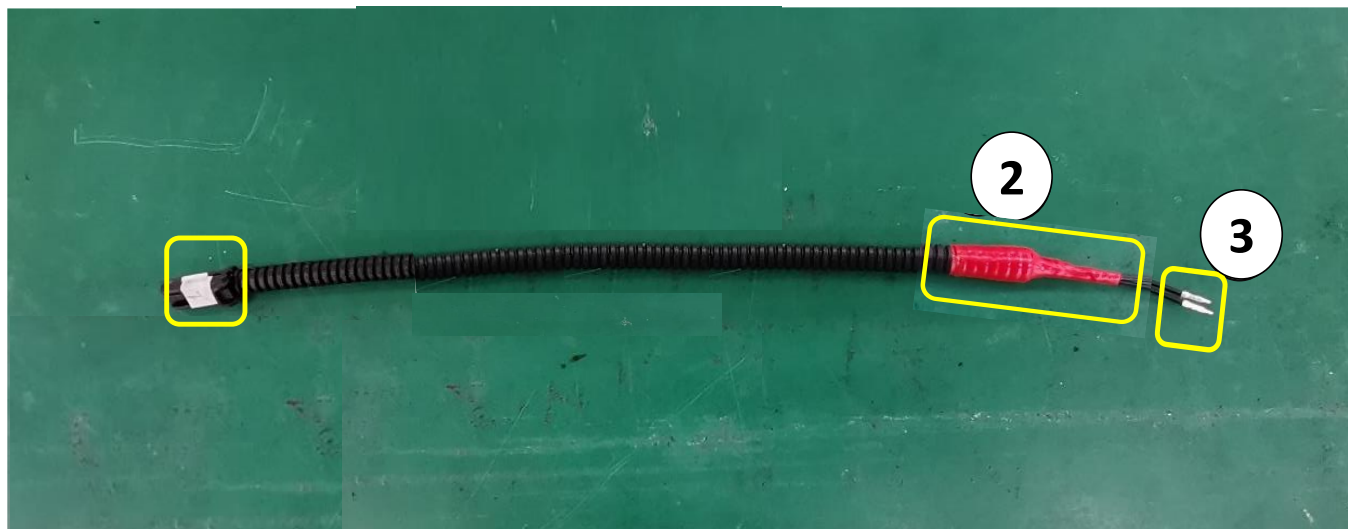
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PARTS:

Assy parts

JIG:

n/a

**QUALITY CHECKPOINTS****P1****7R0127-7022****GOOD****NO GOOD****GOOD****NO GOOD****1** No **Unlock/**
Halflock Connector**2** No **Missing Tape****3** No **Deformed**
Terminal**4** No **Terminal Backing**
Out

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