



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 01, 2024

Model code/Part number:

241B / 7L0048-7023A

Customer:

TRQSS

Car Model:

LEXUS-ES

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-1069A

Revision No.:

1

Page No.:

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PARTS:

1. Black Corrugated tube $\varnothing 7$ L=314 \pm 3mm (no slit); Black Corrugated tube $\varnothing 7$ L=61 \pm 3mm (no slit); Connector 6188-0407 (W); AVSSf 0.3 wires B L=551 \pm 3mm; MRSW CP (TVSSf 0.3 wires G-B/W L=571 \pm 3mm with inserted Black VM tube (Sunprene) $\varnothing 5$, L=106 \pm 3mm); Black tape

JIG:

1. Insertion jig
2. Terminal cover jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

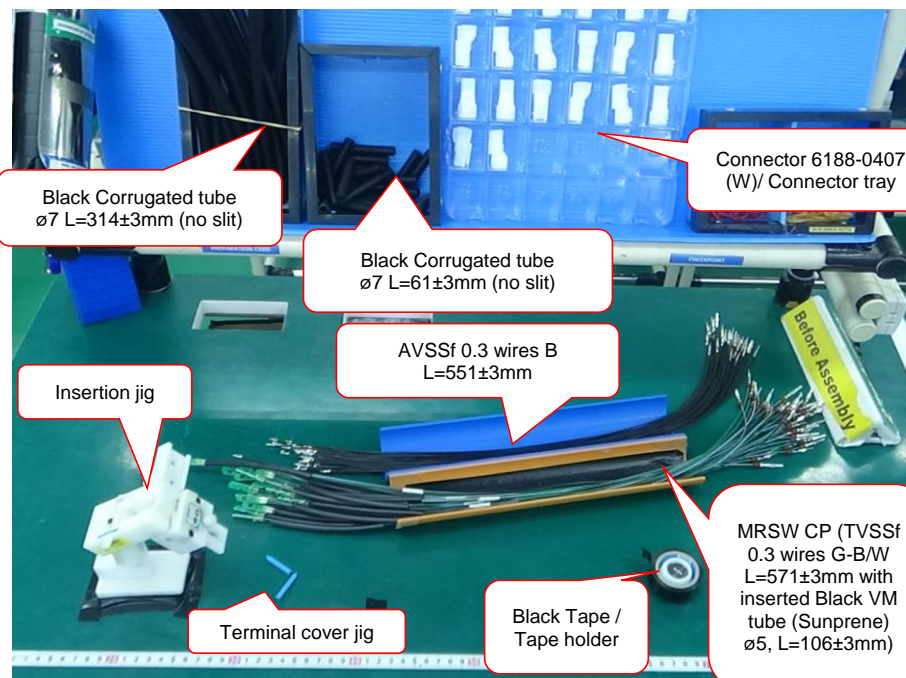
QUALITY POINTERS

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.

Important reminders/Note/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

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
10/01/24	1	Change from pre-launch to masspro. Update work procedure of process 3-4.	D.Castillo	C. Villanueva	A. Arañes	n/a				n/a
09/24/24	0	Initial issue. Transfer process due to process improvement.	D.Castillo	C. Villanueva	A. Arañes	n/a				
Est. Date:							September 24, 2024			

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PRE-LAUNCH



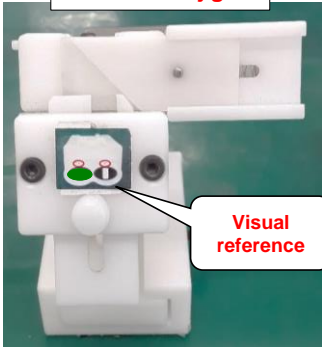
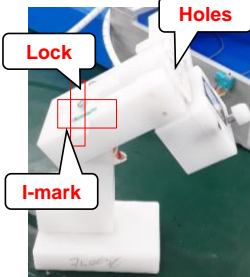


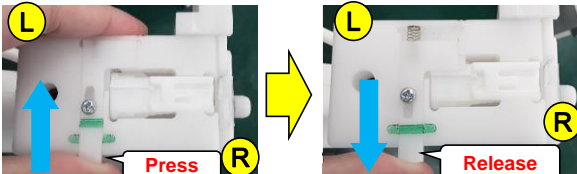
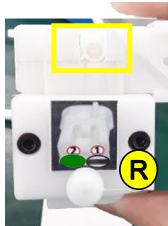


MASSPRO

Revision No.:

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PARTS:	1. Connector 6188-0407 W)			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<div><div><div>Insertion jig</div><div>Visual reference</div></div><div><div>Lock</div><div>Holes</div><div>I-mark</div></div><div><div>Connector orientation</div></div></div> <div><div><div>L</div><div>Press</div><div>1. Press the lock of insertion jig using left thumb.</div></div><div><div><div>L</div><div>R</div><div>Press</div><div>Release</div><div>2. Insert the connector 6188-0407 (W) into jig using right hand and release the lock. Note: Refer to above illustration for correct setting.</div></div><div><div><div>L</div><div>R</div><div>R</div><div>3. Press the lower wire guide using right thumb. Terminal slot for B/W wire will be opened.</div></div></div></div><div>n/a</div><div><div>Connector Orientation Illustration</div><div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div></div><div><div>I-mark is not align</div><div>1 hole is open</div><div>NG</div></div></div></div>			

n/a

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PARTS:

1. MRSW CP (TVSSf 0.3 wires G L=571±3mm; B/W L=571±3mm with inserted Black VM tube (Sunprene) ø5, L=106±3mm
2. AVSSf 0.3 wires B L=551±3mm [2pcs]
3. Black tape

JIG:

n/a

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

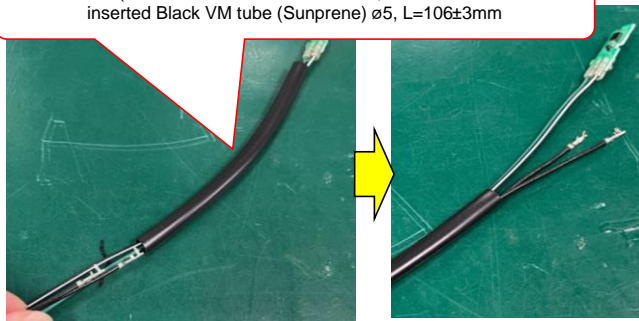
TOOLS/PPE

QUALITY POINTERS

3

Wire insertion to
Black VM tube (Sunprene)
ø5, L=106±3mm

MRSW CP (TVSSf 0.3 wires G L=571±3mm; B/W L=571±3mm with
inserted Black VM tube (Sunprene) ø5, L=106±3mm



1. Get the hotmelted wire with VM tube (Sunprene) ø5, L=106±3mm using right hand. Get the 2 Black wires L=51mm and insert to VM tube (Sunprene) ø5, L=106±3mm using left hand.

n/a

1. No wrong use of parts
2. No deformed terminal

4

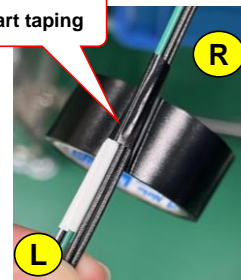
P1

Spot Taping



1. Align Hotmelted and 2 Black wires. Terminal pointed tip must be align to the edge of hotmelt.

Start taping



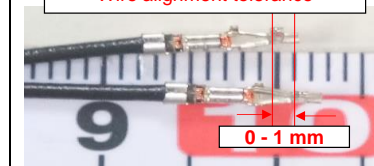
2. Hold the assy parts using left hand, get **Black tape** and position the tape near wire tape then start taping using both hand. Make **2 windings** then cut the tape.

3. After taping, check the taping condition.

n/a

1. No flip-out tape.
2. No peel-off tape.
3. No loose tape.
4. No missing tape.
5. No wrong use of tape.

Wire alignment tolerance



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PROTOTYPE



PRE-LAUNCH








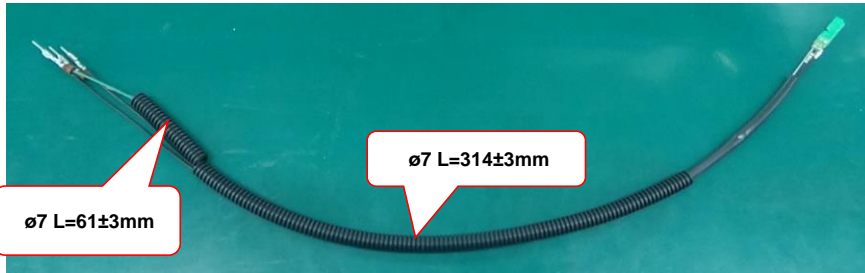

MASSPRO

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PARTS:		1. Assy parts		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1	Wire insertion to Black Corrugated tube ø7 L=314±3mm (no slit) (Assy parts)	  1. Get the terminal cover jig using right hand then insert to both terminals of G-B/W wires . 2. Get the corrugated tube ø7 L=314±3mm using right hand then insert the G-B/W wires using left hand.	<div>Terminal cover jig</div> 	1. No damaged rubber seal 2. No deformed terminal 3. No wrong use of parts
6		Wire insertion to Black Corrugated tube ø7 L=61±3mm (no slit) (Assy parts)	  1. Get the corrugated tube ø7 L=61±3mm using right hand then insert the G-B/W wires using left hand. 2. After insertion, remove the cover jig using right hand. 	<div>Terminal cover jig</div> 	1. No damaged rubber seal 2. No deformed terminal 3. No wrong use of parts

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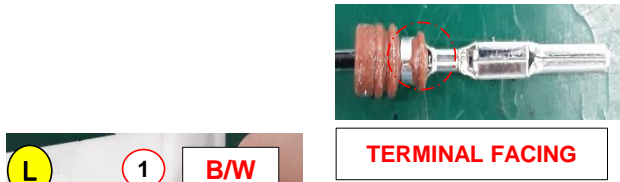
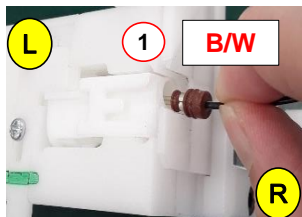
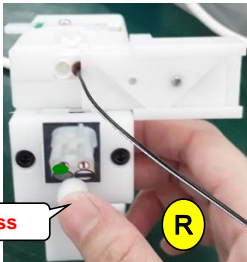
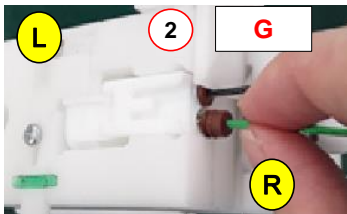
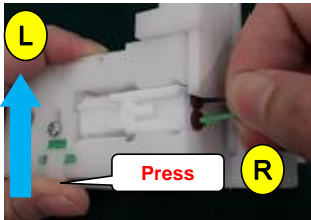
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TAPING ASSEMBLY PROCESS

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Car Model:	LEXUS-ES		
Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO

PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1 Wire Insertion to connector 6188-0407 (W)	<div></div> <div></div> <div></div> <div></div> <div></div> <div><p>1. Hold the insertion jig using left hand. Get the B/W wire and insert to connector using right hand.</p><p>2. Press the button using right thumb. slot for Green wire will be opened.</p><p>3. Get the Green wire and insert to connector using right hand.</p><p>4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p>Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p>

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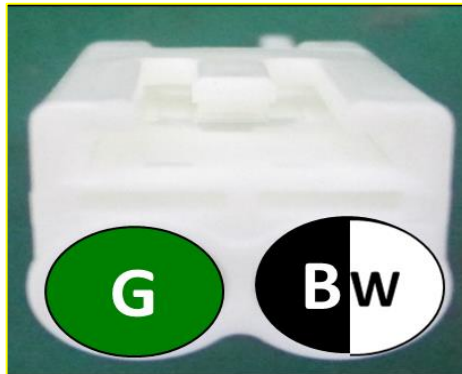
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P1****7L0048-7023A****1** No **Wrong Insert****3** No **Missing parts****2** No **Deformed terminal****4** No **Terminal backing out**

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