



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

November 24, 2023

Process Name/Title:

Model code/Part number:

382D / 7N0185-7020B

Customer: TRJ

Car Model: TOYOTA-CAMRY

Validity Date:

n/a

Document No.:

WI-ENG-PDE-741

Purpose:

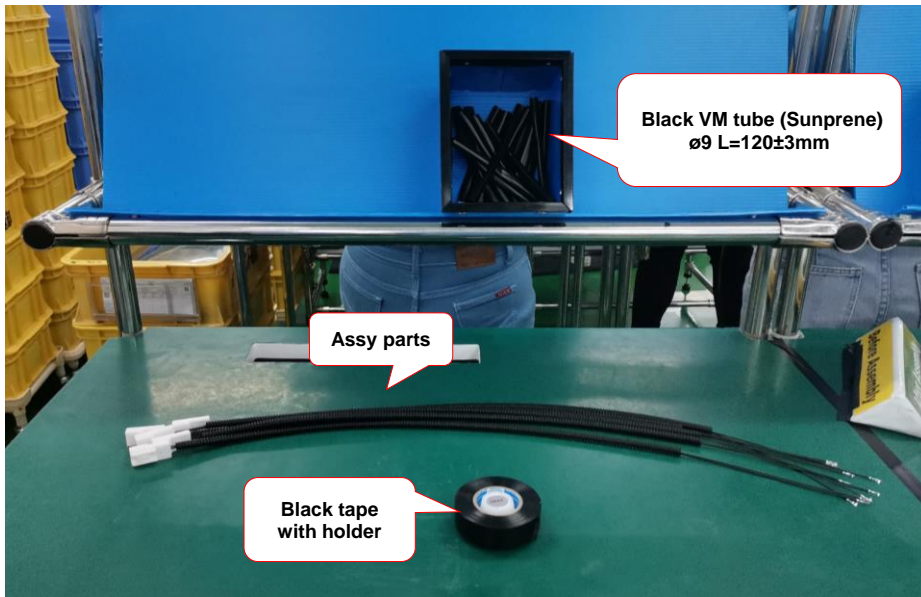
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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1

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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) $\varnothing 9$ L=120 \pm 3mm 3. Black tape				JIG:		n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	P1	<div><div>TABLE LAY-OUT</div><div>Black VM tube (Sunprene) $\varnothing 9$ L=120\pm3mm</div><div>Assy parts</div><div>Black tape with holder</div></div>				<div>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		1. No missing parts/tools 2. No excess parts/tools 3. No wrong position of parts/tools	
Revision History				Prepared by	Reviewed by	Approved by	Noted by		
11/24/23	1	Document purpose from prelaunch to masspro. Additional table layout and quality pointers. Improve work procedure due to improvement. Align quality checkpoints on finished assy parts.				A.Hernandez	C.Villanueva	A. Arañes	n/a
10/24/23	0	Initial issue				A.Hernandez	C.Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted
						Est. Date:	October 24, 2023		

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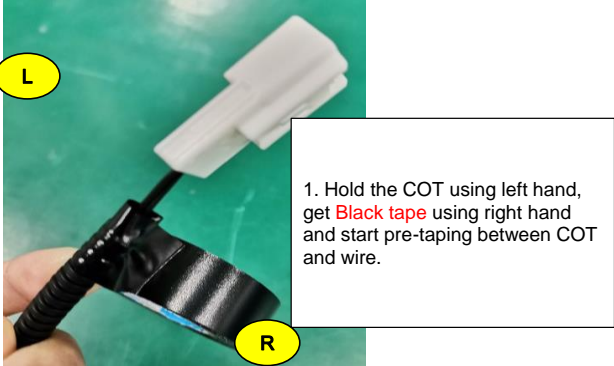
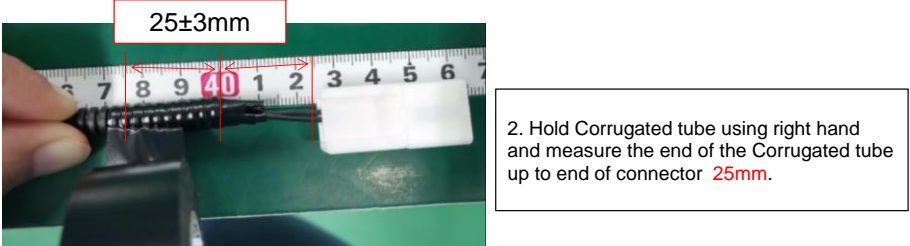
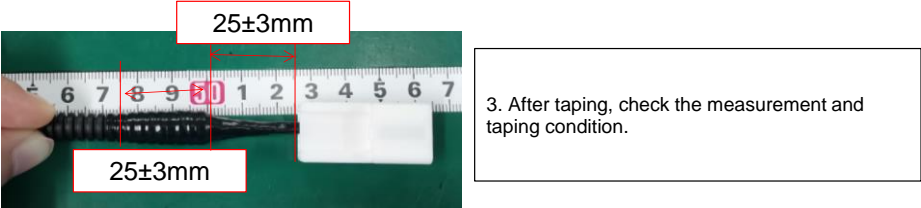

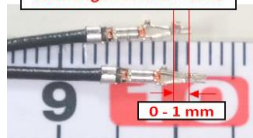
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PARTS:		1. Assy parts 3. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1 Taping 1 Corrugated tube to wire near Connector	<div></div> <div></div> <div></div>		<div>MEASURING TAPE</div> 	<p><i>Note:</i> Please use calibrated/verified measuring tape when getting the measurement.</p> <div>Wire alignment tolerance</div>  <ul style="list-style-type: none">1. No loose tape2. No flip-out tape3. No peel-off tape4. No wrong use of tape5. No wrong dimension

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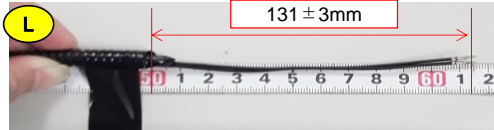
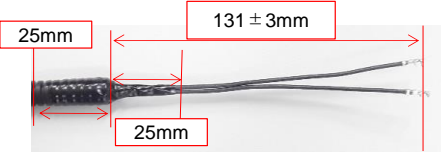




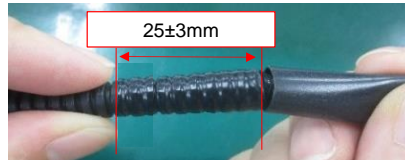



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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) $\varnothing 9$ L=120 \pm 3mm 3. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Taping 2 Corrugated tube to wire near terminal	   <p>1. Hold the COT using left hand, get Black tape using right hand and start pre-taping between COT and wire.</p> <p>2. Hold the corrugated tube using left hand and measure from end of COT to terminal pointed tip 131\pm3mm and proceed to taping process. <i>Please refer to WI-PRO-ASY-001 for taping procedure.</i></p> <p>3. After taping, check the measurement and taping condition.</p>		 	<p>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension</p> <p><i>Note:</i> <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p> 
4	Wire insertion to Black VM tube (Sunprene) $\varnothing 9$ L=120 \pm 3mm	   <p>1. Hold the 2 Black wires using left hand and insert the Black VM tube (Sunprene) $\varnothing 9$ L=120\pm3mm using right hand.</p> <p>2. Insert the Sunprene tube to COT 25\pm3mm</p>		 	<p><i>Note:</i> <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p> <p>1. No wrong use of parts</p>

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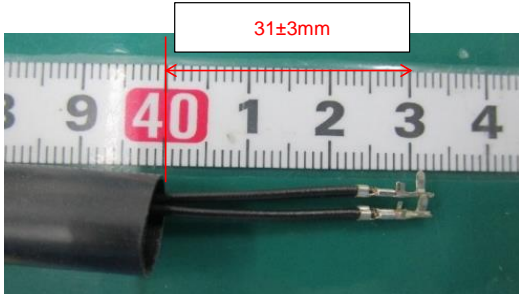



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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1 Taping 3 COT to VM tube (Sunprene)	<div><p>31±3mm</p><p>40</p><p>1. Hold the corrugated tube $\phi 5$ L=474±4mm (no slit) using left hand and measure the sunprene tube up to terminal tip 31mm.</p></div> <div><p>Start of taping</p><p>L</p><p>R</p><p>2. Hold the COT using left hand and begin taping using right hand. <i>Note: Refer to WI-PRO-ASY-001 for taping procedure.</i></p></div> <div><p>25±3mm</p><p>31±3mm</p><p>25±3mm</p><p>3. After taping, check the dimension, terminal appearance and taping condition.</p></div>		<p>MEASURING TAPE</p> 	<p>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension-out tape</p> <p>Note: Please use calibrated/verified measuring tape when getting the measurement.</p>

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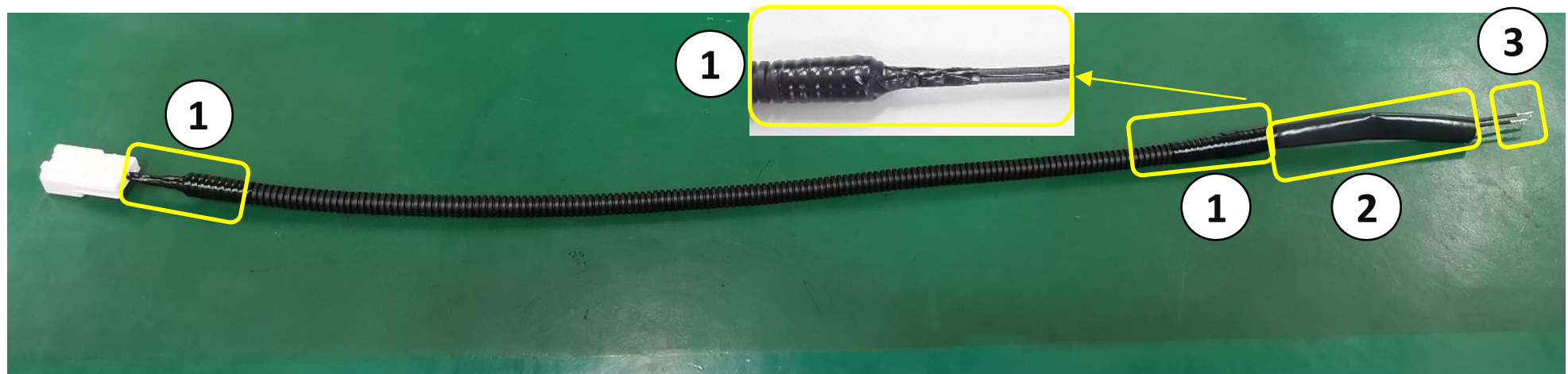
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PARTS:

n/a

JIG:

n/a

QUALITY CHECKPOINTS**P1****7N0185-7020B**

1 No Missing Tape
(on COT to wire and taping
to sunprene tube)

2 No Missing VM tube (Sunprene)

**3 No Deformed
Terminal**

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