

**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**October 14, 2024**

Model code/Part number:

**220D / 7L0134-7020B**

Customer:

**TRQSS**

Car Model:

**LEXUS-LM**

Document No.:

**WI-ENG-PDE-1099B**

Purpose:

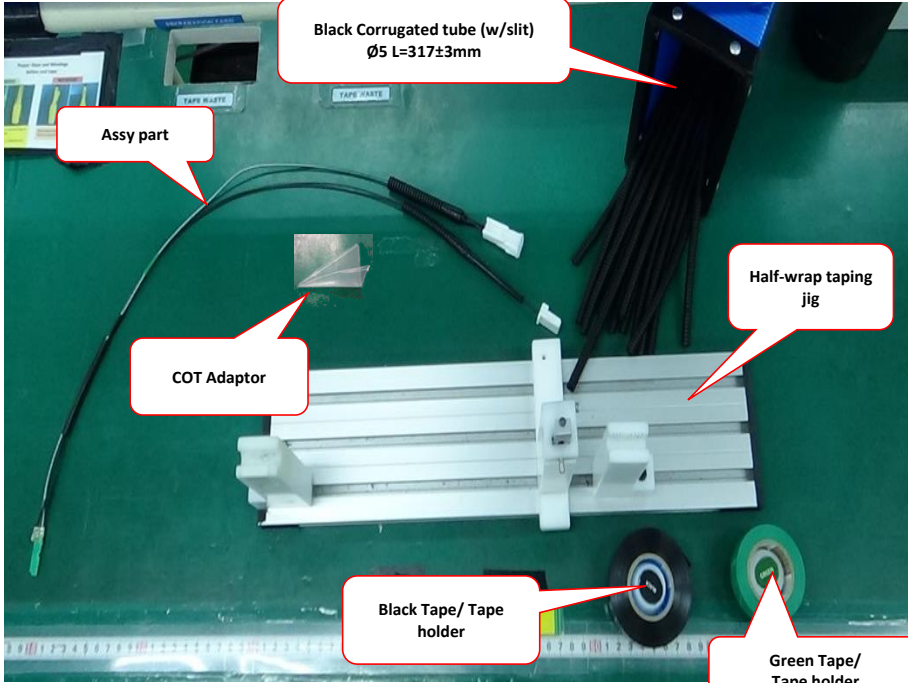
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

**1**

Page No.:


**1 of 5**

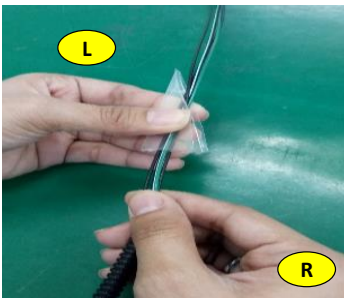
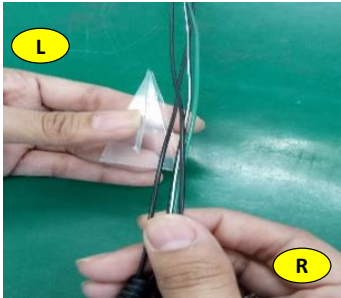
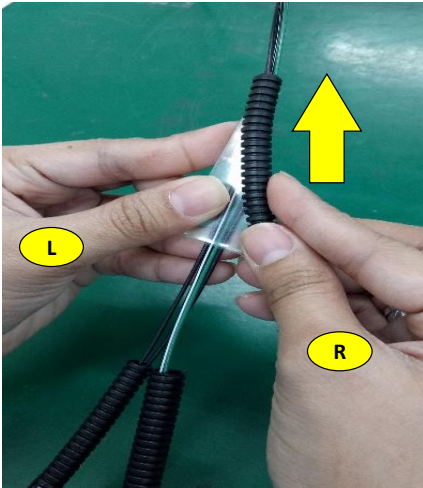

PARTS:		1. Assy parts; Black Corrugated tube (with slit) Ø5 L=317±3mm; Black tape; Green tape				JIG:		1. COT Adaptor 2. Half-wrap taping jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	P2	<div><b>TABLE LAY-OUT</b></div>  <div><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>						1. No missing parts in assy parts 2. No excess tape/tape holder	
Revision History						Prepared by	Reviewed by	Approved by	Noted by
10/14/24	1	Change from Pre-launch to Masspro.				D.Castillo	C.Villanueva	A. Arañes	n/a
10/09/24	0	Initial issue. Transfer Y-taping to P3.				D.Castillo	C.Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted
						Est. Date:	October 09, 2024		

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	Model code/Part number: <b>220D / 7L0134-7020B</b>		Customer: <b>TRQSS</b>	Car Model: <b>LEXUS-LM</b>	Document No.:	<b>WI-ENG-PDE-1099B</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		1	Page No.:	2 of 5	


<b>PARTS:</b>	1. Black Corrugated tube (with slit) Ø5 L=317±3mm			JIG:	1. COT Adaptor			
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
2	P2  Wire insertion to Black Corrugated tube (w/slit) ø5 L=317±3mm	<div><p>1. Hold the COT adaptor using left hand. Combined the 2 <b>assy parts</b> and put inside the COT adaptor using right hand</p><p>2. Hold the COT adaptor with wires using left hand, get the <b>Black Corrugated tube (w/slit) ø5 L=317±3mm</b> using right hand and insert to COT adaptor. Pull the adaptor and push the COT (<b>same timing</b>) using both hands. Make sure all wires are inserted.</p></div>			<div><div>COT Adaptor</div></div>	1. No wrong use of parts 2. No wires left in between the COT with slit		

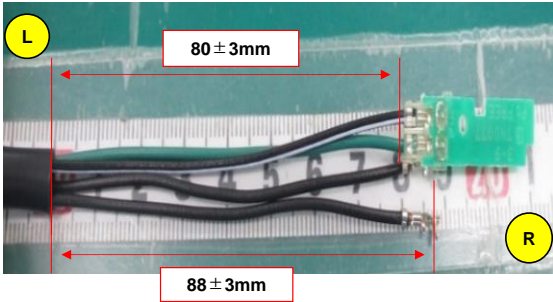
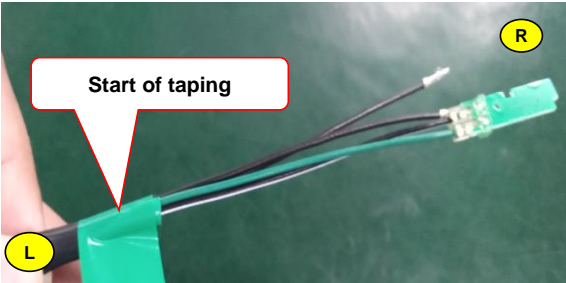
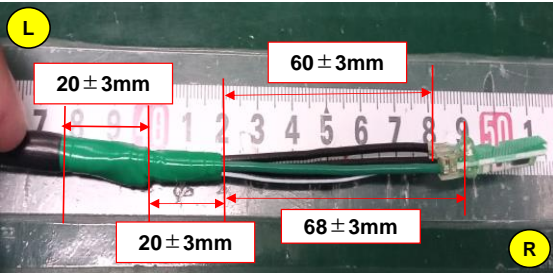

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	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:		1	Page No.:	3 of 5		

<b>PARTS:</b>		1. Assy parts 2. Green tape		JIG:	n/a	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
3	P2 Taping 3 VM tube (Sunprene) to wire near terminal and hotmelt	<div><div>1. Hold VM tube (Sunprene) using left hand. Measure from VM tube (Sunprene) to end of hotmelted wire <b>80±3mm</b> and VM tube (Sunprene) to terminal tip <b>88±3mm</b>.</div></div> <div><div>2. Get <b>Green tape</b> using right hand, hold the VM tube (Sunprene) using left hand. Fold the VM tube (Sunprene) and start taping using right hand.</div></div> <div><div>3. After taping check the measurement, wire alignment and taping condition.</div></div>		<div><b>Measuring tape</b></div> 	<p><b>Important reminders/note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p><b>Document references:</b></p> <p>1. Please refer to <b>WI-PRO-ASY-001</b> 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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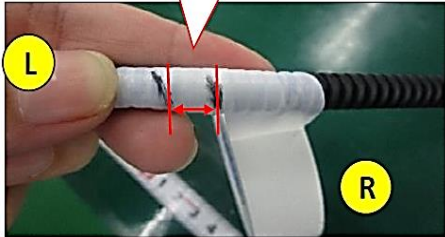
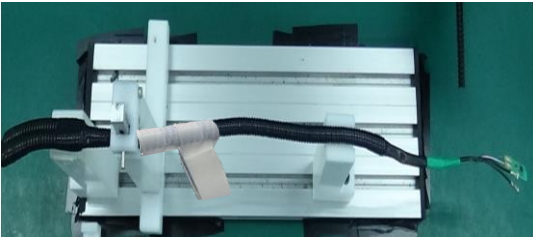
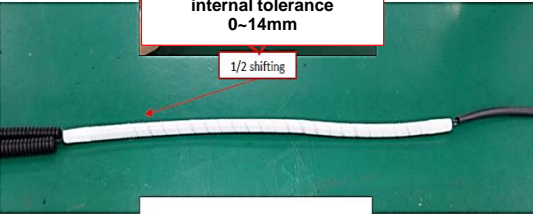

☒ MASSPRO

Revision No.:

1

Page No.:

4 of 5

PARTS:		1. Assy parts 2. Black tape		JIG:	1. Half-wrap taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Half-wrap taping	<div><div>Start of taping</div><div>1. Hold the assy parts using left hand and position the tape on COT then start taping using both hands. Make <b>2 windings</b>.</div></div> <div><div>1/2 shifting</div><div>2. Making halfwrap shifting until cover the COT with slit.</div></div> <div><div>3. After making <b>1/2 shifting</b>. Set harness to jig,repeat the process until the end of corrugated tube. Make <b>3 windings</b> and then cut the tape.</div></div> <div><div>internal tolerance 0~14mm</div><div>1/2 shifting</div><div>4. Check the taping condition.</div></div>	<div>Measuring tape</div> 	<p><b>Important reminders/note/s:</b></p> <p>1. Use <u>White tape</u> for easy visualization of tape shifting, but actual should be <u>BLACK TAPE</u>. 2. 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 missing tape 5. No wrong use of tape 6. No wrong dimension</p>

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Revision No.:

1

Page No.:

5 of 5

PARTS:

1. Assy parts

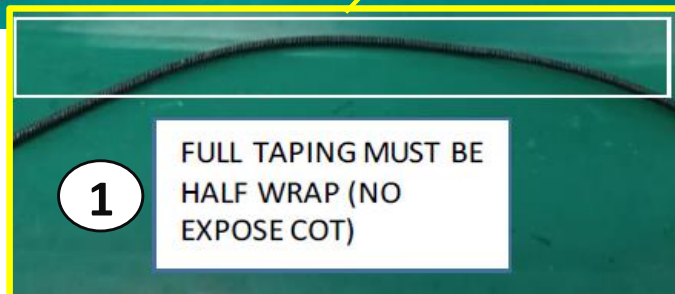
JIG:

n/a

### VISUAL INSPECTION/ QUALITY CHECKPOINTS

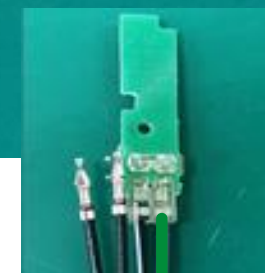
## TAPING - P2

## 7L0134-7020B



2

**No Missing Tape**  
**No wrong use tape**  
**(Green tape)**



Proper alignment of  
B-B wires and hotmelt

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