



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 15, 2025

Model code/Part number:

400D / 7L0162-7020A

Customer:

TRQSS

Car Model:

TOYOTA-bZ4X (BEV)

Document No.:

WI-ENG-PDE-1239

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1. Assy parts

2. Black SV tube (Vinyl) Ø4, L=84±3mm

3. Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

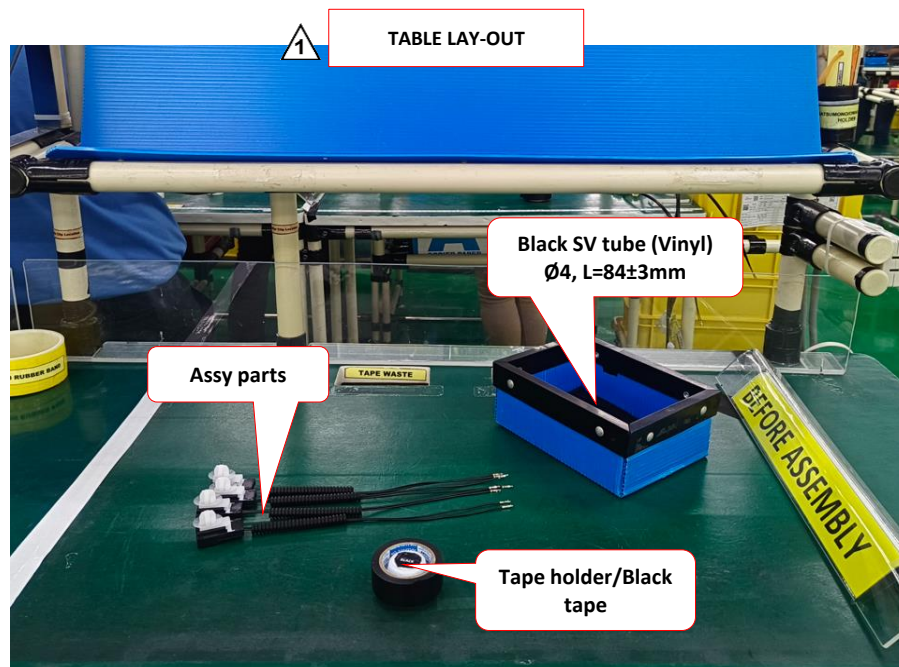
TOOLS/PPE

QUALITY POINTERS

1

P1

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-1268 For OFFLINE ASSEMBLY PROCESS.

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

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved	Prepared by	Checked by	Reviewed by	Approved by
05/15/25	1	Change purpose from pre-launch to Masspro. Transfer process of Wire insertion to connector (WI-ENG-PDE-1268 OFFLINE ASSEMBLY PROCESS) and Spot taping process (WI-ENG-PDE-1269 CLAMP ASSEMBLY PROCESS) due to new distribution of process; Additional table lay-out and Update the Visual inspections/Quality checkpoints	M. Ariola	n/a	C. Villanueva	A. Arañes				
04/28/25	0	Initial issue.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes		n/a		

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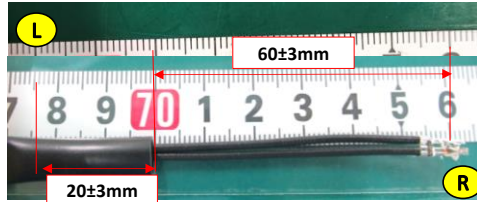
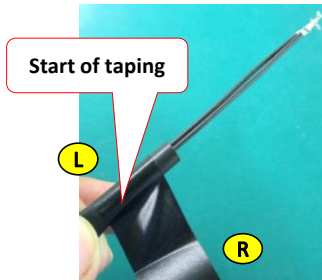
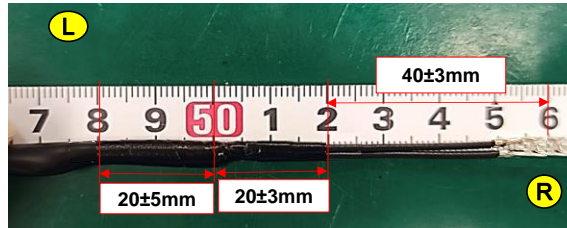

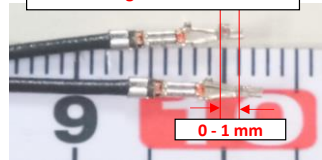
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Revision No.:

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PARTS:		1. Assy parts 2. Black SV tube (Vinyl) Ø4, L=84±3mm		3. Black tape	JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
2		Wire Insertion to Black SV tube (Vinyl) Ø4, L=84±3mm	<div></div> <div>1. Get the Black SV tube (Vinyl) Ø4, L=84±3mm using left hand and insert B-B wires using right hand.</div>			n/a	1. No wrong use of parts 2. No deformed terminal
3	P1	Taping 1 Black SV tube (Vinyl) to wire near terminal	<div><div></div><div>1. Hold the SV tube (Vinyl) using left hand, measure from end of SV tube (Vinyl) up to terminal tip 60±3mm.</div><div></div><div>2. Hold the assy parts using left hand, get the Black tape using right hand then start taping process using both hands.</div><div></div><div>3. After taping, check the measurement, taping condition and wire alignment.</div></div>			<div>MEASURING TAPE</div>  <div>Wire alignment tolerance</div> 	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 7. No insufficient tape Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. 2. Refer to WI-PRO-ASY-0001B for the SV tube (Vinyl) to wire near terminal taping method. Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.

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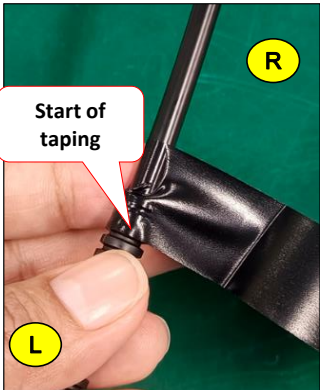


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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 Taping 2 Black Corrugated tube to SV tube (Vinyl)	 <p>1. Measure from COT to terminal pointed tip L=139±3mm using both hands.</p>  <p>2. Fix the corrugated tube and SV tube (Vinyl) using both hands. Hold the COT using left hand. Get the Black tape using right hand and start taping process using both hands.</p>  <p>3. After taping, check the measurement and taping condition.</p>			<p>Document reference/s:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. 2. Refer to WI-PRO-ASY-0001B for Combined COT to SV tube (Vinyl) taping method.</p> <p>Important reminders/Note/s:</p> <p>1. 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 7. No insufficient tape</p>

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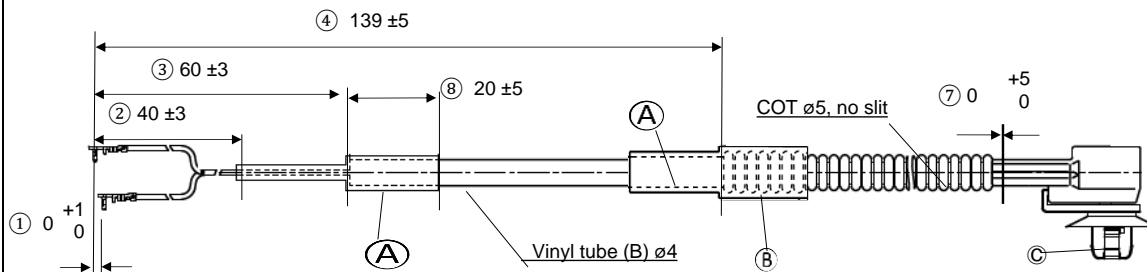

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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1	Measurement	 		<p>1. No wrong dimension.</p> <p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p>

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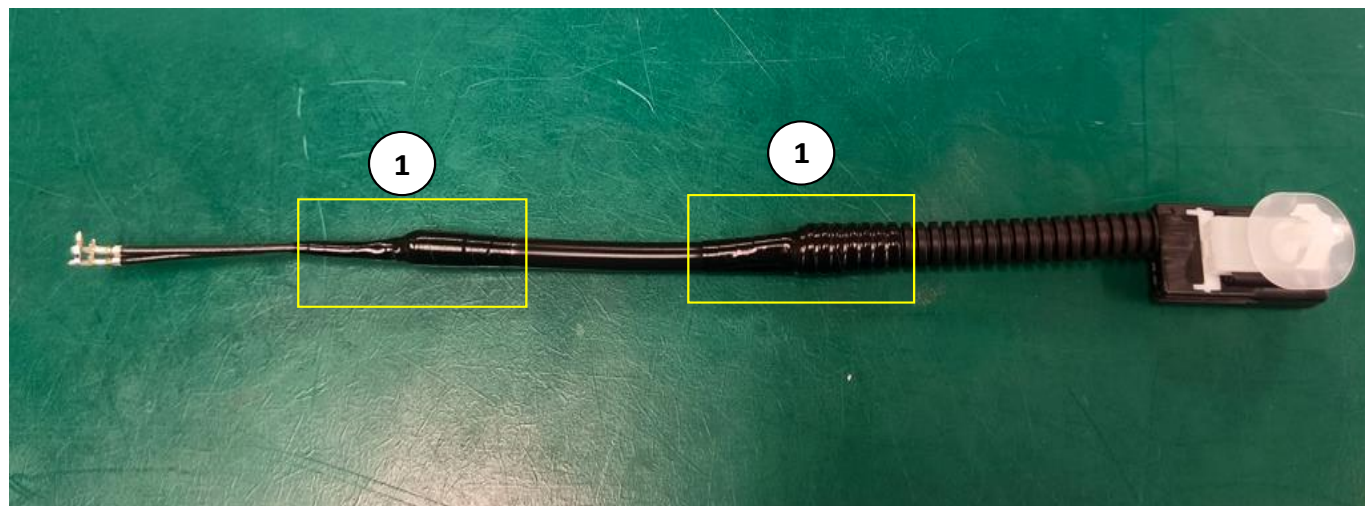
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PARTS:

n/a

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P1****7L0162-7020A****① No Missing tape**

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