



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

March 12, 2025

Model code/Part number:

559D / 7N0238-7020B

Customer: TRJ

Car Model: TOYOTA HI-ACE

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-974C

Revision No.:

0

Page No.:

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PARTS:

1. Assy parts; Black SV tube (vinyl) ø5 L= 490±3mm

JIG:

1. Tape holder

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

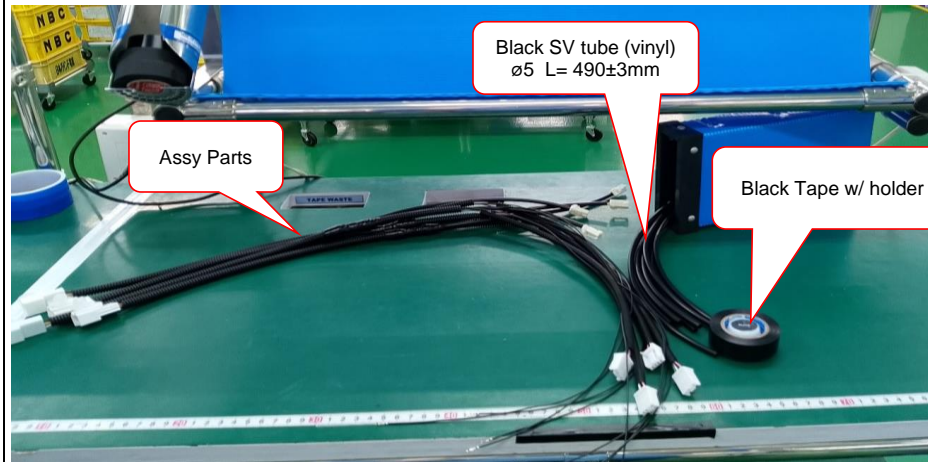
QUALITY POINTERS

1

P3

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.

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

Revision History

Prepared by

Checked by

Reviewed by

Approved by

03/12/25 0 Initial issue.

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J.Loterte

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Eff. Date Rev. No

Details of Change

Revised

Checked

Reviewed

Approved

Est. Date:

March 12, 2025

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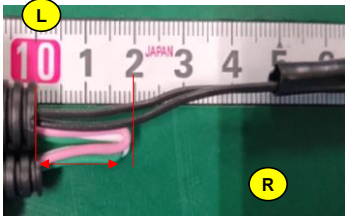
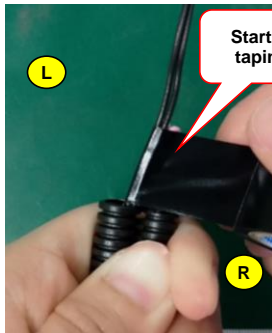
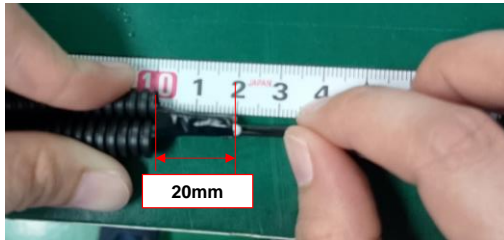

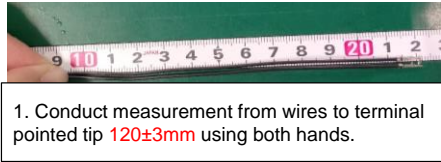
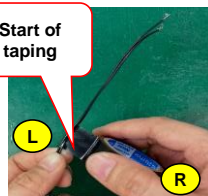
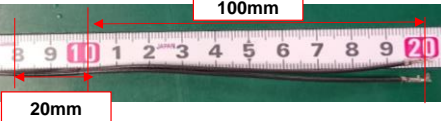

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P3 Spot Tape 1	 <p>1. Combine the assy parts then and then conduct measurement 20mm</p>  <p>Start of taping</p> <p>2. Get the Black tape using right hand then conduct 2 windings of spot taping using both hands.</p>  <p>20mm</p> <p>3. After taping, check the measurement and taping condition.</p>		 <p>MEASURING TAPE</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</p>
3	Spot Tape 2	 <p>1. Conduct measurement from wires to terminal pointed tip 120±3mm using both hands.</p>  <p>Start of taping</p> <p>2. Get the Black tape using right hand then conduct 2 windings of spot taping using both hands.</p>  <p>100mm 20mm</p> <p>3. After taping, check the measurement and taping condition.</p>		 <p>MEASURING TAPE</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</p>

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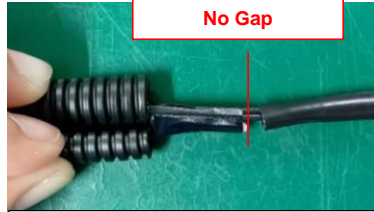
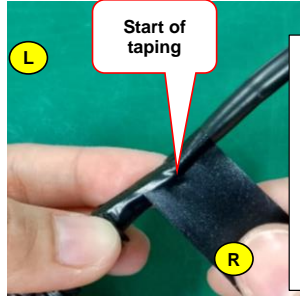
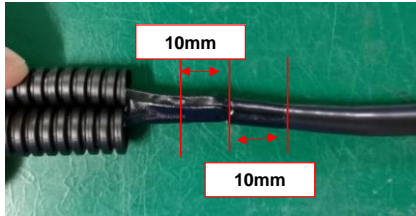
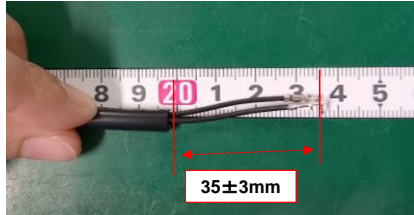
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PARTS:		1. Assy parts 2. Black SV tube (vinyl) $\varnothing 5$ L= 490 \pm 3mm 3. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Wire Insertion to Black SV tube (vinyl) $\varnothing 5$ L= 490 \pm 3mm	 <div>1. Get the B-B wire using right hand then insert the Black SV tube (vinyl) $\varnothing 5$ L=490\pm3mm using right hand.</div>		n/a	1. No wrong use of parts 2. No deformed terminal
5	P3 Spot Tape 3	 <div>1. Combine the assy parts then and Black SV tube (vinyl) $\varnothing 5$ L= 490\pm3mm.</div>  <div>2. Get the Black tape using right hand then conduct 2 windings of spot taping using both hands.</div>   <div>3. After taping, check the measurement and taping condition.</div>		n/a	Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 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

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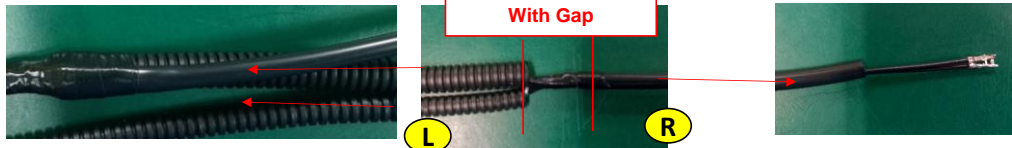
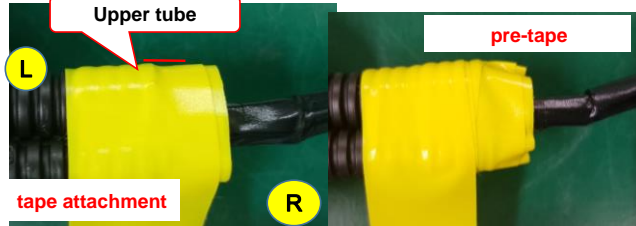
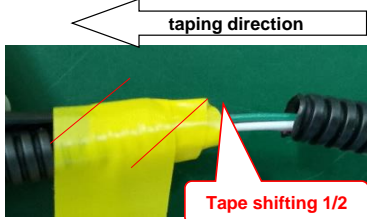
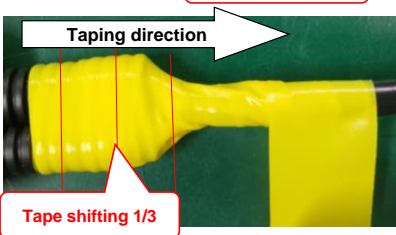
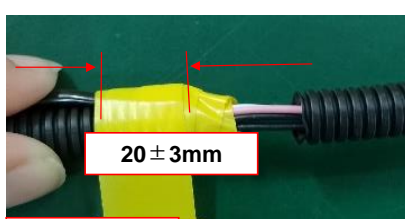
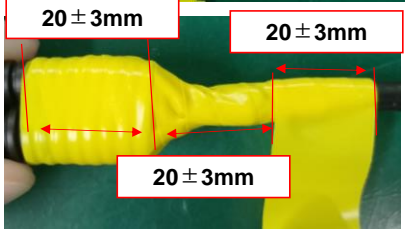
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy Parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P3 Taping 2 Y-Taping	<div><div></div><div><div>1. Fix the 3 corrugated tube. Note: Follow the correct facing. (If need to standard)</div><div><div><div>Upper tube</div><div>pre-tape</div><div>tape attachment</div></div><div><div><div>taping direction</div><div>Tape shifting 1/2</div></div><div><div><div>Taping direction</div><div>Tape shifting 1/3</div></div></div><div><div><div>2. Start taping at the middle of combined tubes, attach the tape on the upper tube. Then make pre-tape 2 windings. Note: Do not exert excessive force during pulling & winding of tape.</div><div><div><div>20 ± 3mm</div></div><div><div><div>20 ± 3mm</div><div>20 ± 3mm</div><div>20 ± 3mm</div></div></div><div><div>3. Winding the tape 1/2 shifting going to the left side.</div><div>4. Make 2 windings, width must be - 20±3mm.</div><div>5. Winding the tape 1/3 shifting going to the right side until reach the other side of tube.</div><div>6. Make 2 windings, width must be 20±3mm.</div></div></div></div></div></div></div></div></div>			<p>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>Important reminders/Note/s: 1. Use <u>yellow 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> <ol 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-out tape6. No exposed wire7. No gap between tubes

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PRE-LAUNCH



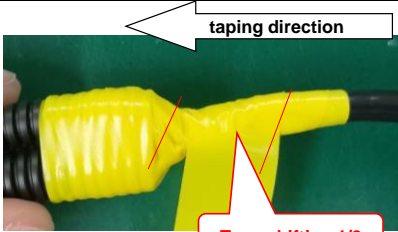
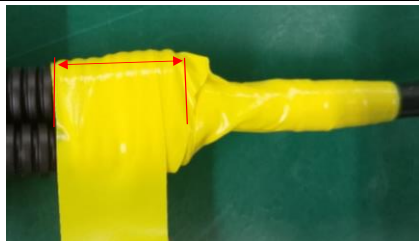

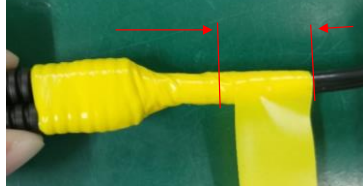
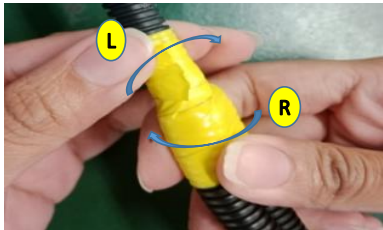
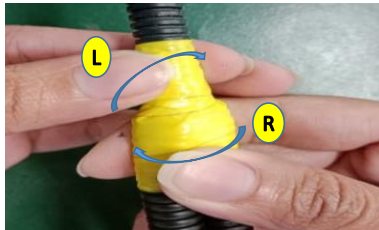
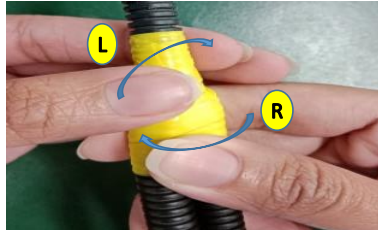
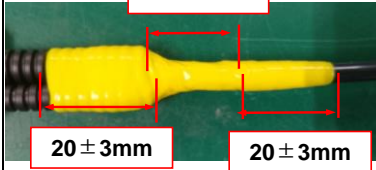
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PARTS:		1. Assy Parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P3	Taping 2 Y-Taping (continuation)			
		<div><div><div></div><div>7. Winding the tape 1/2 shifting going to the left side.</div></div><div><div></div><div>8. Make 2 windings, width must be 20±3mm.</div></div></div> <div><div><div></div><div>9. Winding the tape 1/2 shifting going to the right side until it reach the other side of tube</div></div><div><div></div><div>10. Make 3 winds, width must be 20±3mm. Then cut the tape.</div></div><div><div></div><div>11. conduct proper pressing of end tape using left hand (top part). <i>Note: Reference only.</i></div></div><div><div></div><div>12. conduct proper pressing of end tape using left hand (Middle part).</div></div><div><div></div><div>13. conduct proper pressing of end tape using left hand (bottom part).</div></div></div> <div><div></div><div>14. Check the Measurement and condition of tape.</div></div>			<p>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>Important reminders/Note/s: 1. Use <u>yellow 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> <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-out tape6. No exposed wire7. No gap between tubes

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PRE-LAUNCH



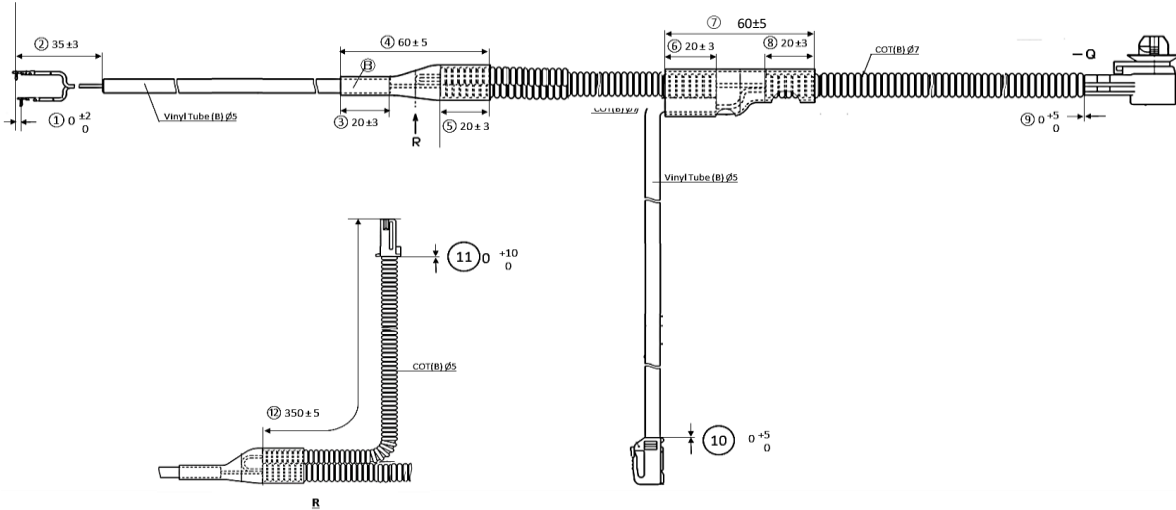

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PARTS:	1. Assy Parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P3 Measurement	<div></div>	<div>MEASURING TAPE</div> <div></div>	<div>1. No wrong dimension</div> <div>Important reminders and note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div>

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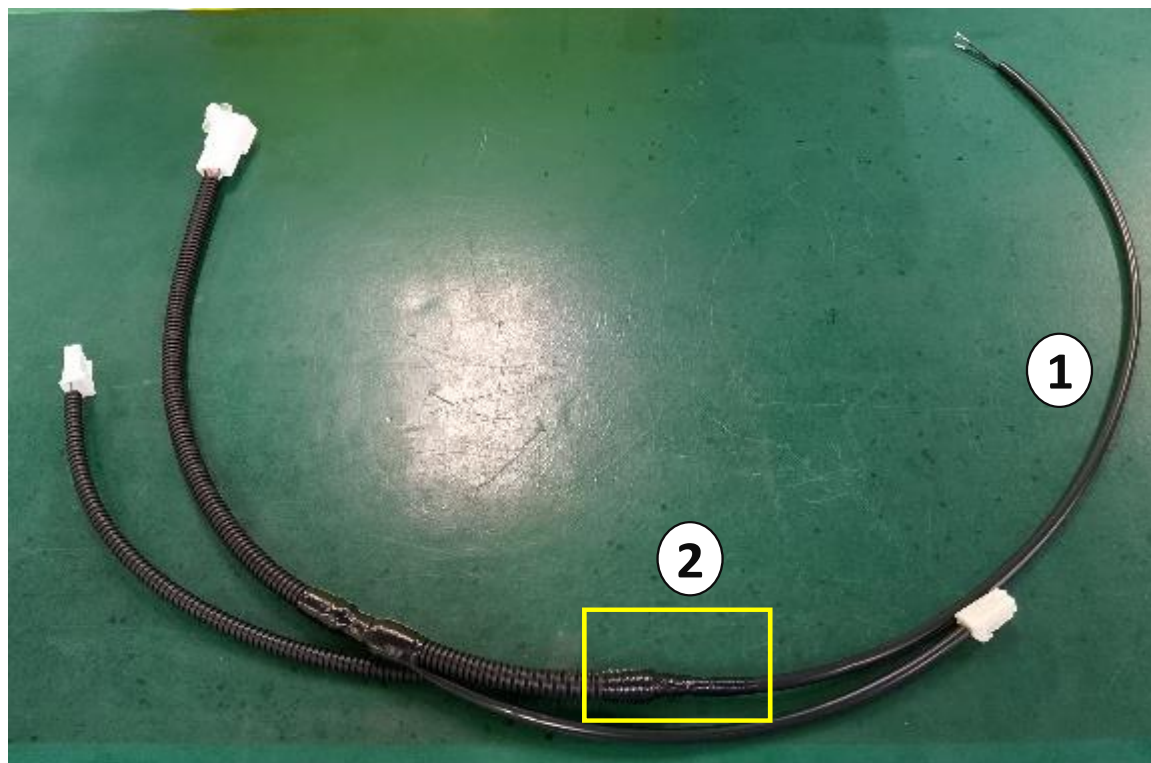
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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P3****7N0238-7020B****① No Missing SV tube (vinyl)****② No Wrong Facing of Y-Taping**

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