



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

January 26, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

700B

/

7N0037-7020B

Customer: TRJ

Car Model: TOYOTA LAND CRUISER

Document No.:

WI-ENG-PD-758C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1. Assy Parts
2. Black Tape

JIG:

n/a

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

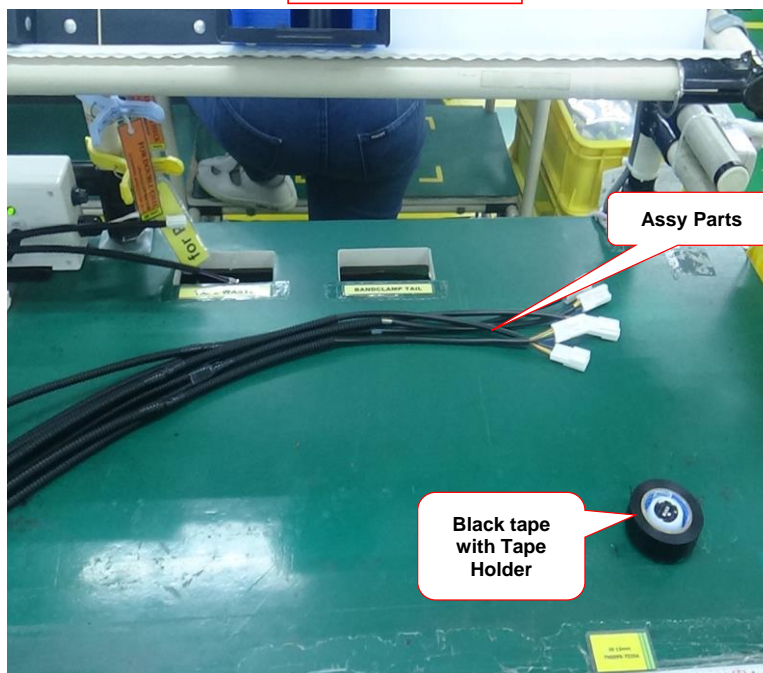
QUALITY POINTERS

1

P3

Tayble 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

Reviewed by

Approved by

Noted by

01/26/24 1 Changed purpose from pre-launch to mass pro. Additional of table lay-out and Quality pointers.

M. Ariola

C. Villanueva

A. Arañes

n/a

12/13/23 0 Initial issue.

M. Ariola

C. Villanueva

A. Arañes

A. Arañes

n/a

Eff. Date Rev. No Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

December 13, 2023

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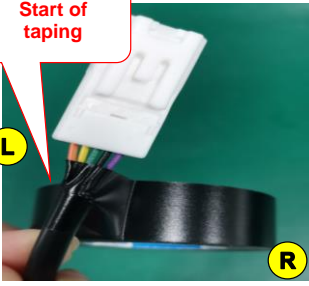
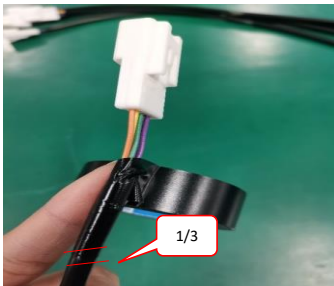
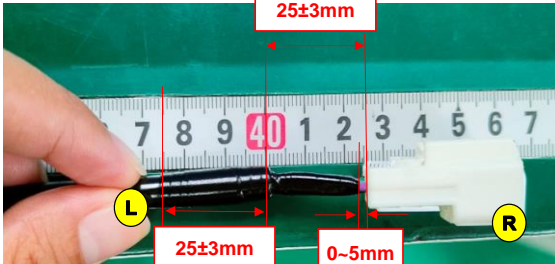

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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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 Taping 1 SV tube (Vinyl) to wire near connector	<div><div>1</div><div>25±3mm</div><div>1. Measure from end of SV tube (Vinyl) up to end of connector 25±3mm using both hands.</div></div> <div><div>Start of taping</div><div>2. Get the Black tape using right hand then start taping process using both hands.</div></div> <div><div>3. Make 1 wind going to SV tube (Vinyl) then make 2 windings (must be tape width). Make 1/3 shifting from SV tube (vinyl) to wire. Make 3 winds then cut the tape. Note: No need to fold the SV tube .</div></div> <div><div>25±3mm</div><div>4. After taping, check the measurement and taping condition.</div></div>		<div>MEASURING TAPE</div>  <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</div>	<div>Important reminders/Note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div>

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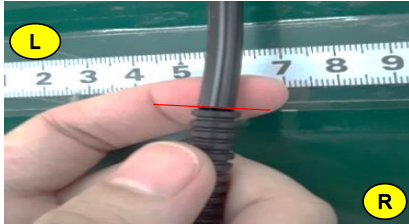

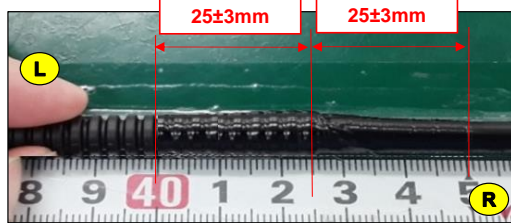



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NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	P3 Taping 2 Black corrugated tube to Black SV tube (Vinyl) near connector	<div><p>1. Fix the corrugated tube and SV tube (Vinyl) using both hands.</p></div> <div><p>2. Get the Black tape using right hand then start taping process using both hands.</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div> <div><p>4. Measure from end of COT up to terminal pointed tip 39±3mm using both hands.</p></div>	<div>MEASURING TAPE</div>  <div>MEASURING TEMPLATE</div> 	<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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WORK INSTRUCTION

CLAMP ASSEMBLY PROCESS

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☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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PARTS:		1. Assy parts 2. Master sample		JIG:	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
4	P3	<div>Visual/By Two's Inspection</div> <div><div>Assembled parts</div><div>Master sample</div><div>1. Conduct alignment of harness (Master sample vs. Assembled parts) using both hands.</div><div>2. Check the connector lock condition, insertion, terminal condition.</div><div>3. Check the presence tape & taping condition.</div><div>4. Check the terminal. Must no deformed terminal.</div></div>		<div>1. No skip checking during inspection.</div> <div>MASTER SAMPLE</div> <div>CONNECTOR ILLUSTRATION</div> <div><div>GOOD</div><div>6098-3802 (W)</div><div>NG</div><div>6098-5668 (W)</div></div>	

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PARTS:

n/a

JIG:

n/a



QUALITY CHECKPOINTS

P3

7N0037-7020B



GOOD



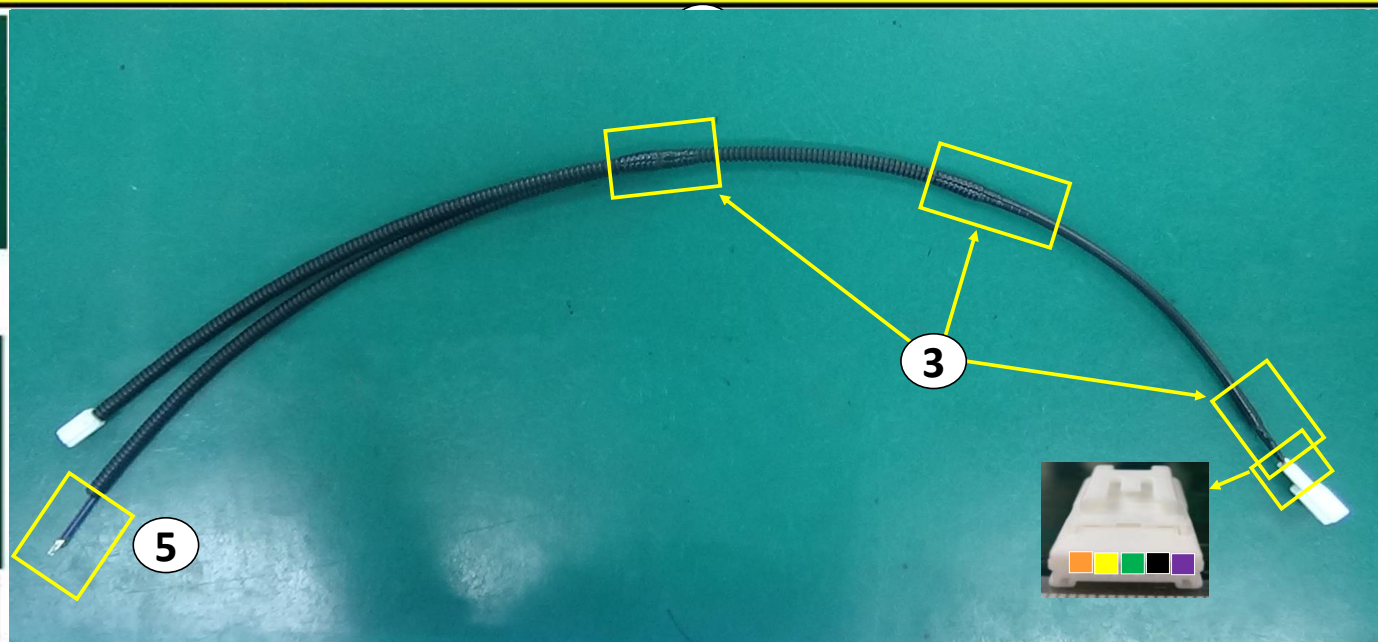
GOOD



NO GOOD



NO GOOD



1

No Unlock/half-locked
Connector (2)

2

Wrong Insertion
(2)

3

No Missing Tape

4

No Wrong facing of
Y-Taping

5

No Deformed
terminal

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