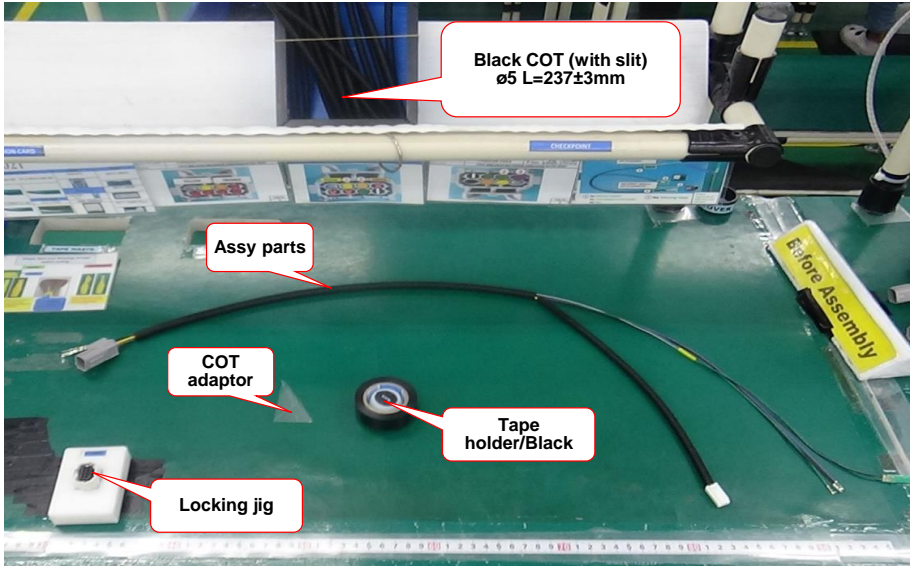




WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	October 22, 2024		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-1091B		
Revision No.:	1	Page No.:	1 of 7

Process Name/Title:	TAPING ASSEMBLY PROCESS		
Model code/Part number:	240B / 7M0516-7021B	Customer:	TRJ
		Car Model:	LEXUS-ES
Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO

PARTS:		1. Assy parts; Black COT (with slit) ø5 L=237±3mm; Black tape		JIG:	1. Locking jig 2. COT adaptor
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P2	<p>TABLE LAY-OUT</p> 		<p>Safety Instruction</p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping</p> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	1. No missing parts/tools 2. No excess parts/tools

Revision History						Prepared by	Reviewed by	Approved by	Noted by
10/22/24	1	Change Purpose from Pre-launch to Masspro. Update the illustration of Visual inspection/Quality Checkpoints	M. Ariola	C. Villanueva	A. Arañes	n/a			
10/17/24	0	Initial issue.	M. Ariola	C. Villanueva	A. Arañes	n/a			
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 17, 2024	

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PROTOTYPE



PRE-LAUNCH



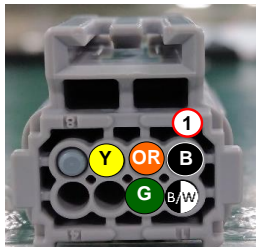
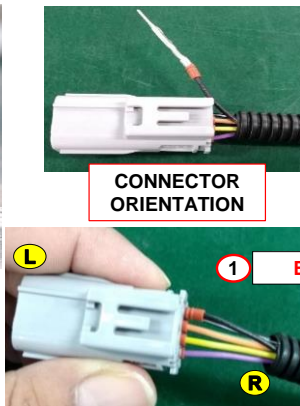


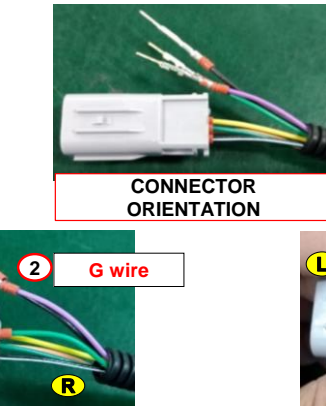

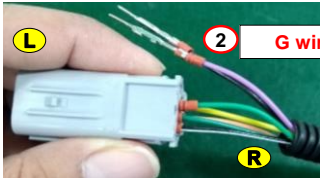
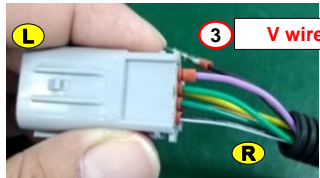
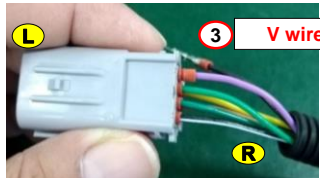
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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Wire Insertion to Connector 6188-0779 (GR)	<div><div><p>VISUAL REFERENCE</p></div><div><p>CONNECTOR ORIENTATION</p></div><div><p>TERMINAL FACING</p></div><div><p>VISUAL REFERENCE</p></div><div><p>CONNECTOR ORIENTATION</p></div><div><p>TERMINAL FACING</p></div><div><p>VISUAL REFERENCE</p></div><div><p>CONNECTOR ORIENTATION</p></div><div><p>TERMINAL FACING</p></div><div>1. Hold the connector 6188-0779 (GR) then hold the B wire and insert beside OR wire using right hand.</div><div>2. Flip the connector 6188-0779 (GR) using left hand, get the G wire then insert beside G wire using right hand.</div><div>3. Hold the connector using left hand, get the V wire then insert beside G wire using right hand.</div></div>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing 6. No wrong orientation of connector</p> <p>Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>

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PROTOTYPE



PRE-LAUNCH



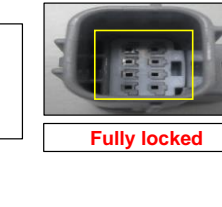
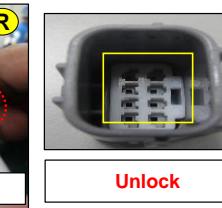
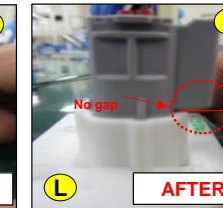
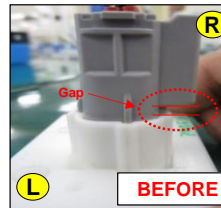
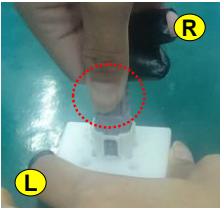
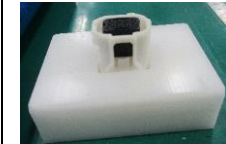
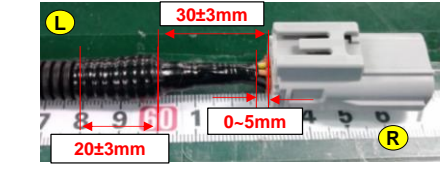
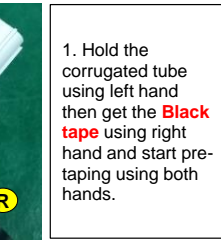
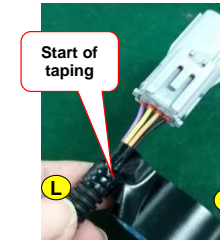

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PARTS:		1. Assy parts 2. Black tape		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Connector Lock	<div><div></div><div>1. Hold the locking jig using left hand put the connector into locking jig using right hand and push 2x. Check the connector lock if properly lock.</div></div>		<div>LOCKING JIG</div> 	<p>Important reminders/Note/s:</p> <p>1. Manual locking may cause damaged connector lock</p> <p>1. Use the provided locking jig per model 2. No unlock/half-lock connector</p>
4	P2 Taping 1 COT to wire near connector	<div><div></div><div>1. Hold the corrugated tube using left hand then get the Black tape using right hand and start pre-taping using both hands.</div><div>2. Hold the corrugated tube using left hand and measure from COT to connector 30±3mm using both hands.</div><div>3. After taping, check the measurement and taping condition.</div></div>		<div>MEASURING</div> 	<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> <p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

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October 22, 2024

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Model code/Part number:

240B / 7M0516-7021B

Customer: TRJ

Car Model:

LEXUS-ES

Document No.:

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Purpose:



PROTOTYPE



PRE-LAUNCH



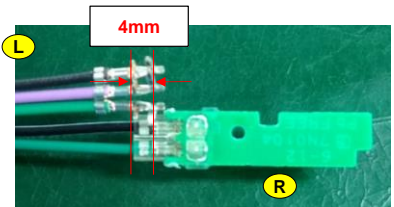



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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2 Taping 2 Spot taping	<div><p>4mm</p><p>1. Align the edge of hotmelted wire to terminal stabilizer (4mm gap) using both hands.</p></div> <div><p>Start of taping</p><p>2. Hold the wires using left hand, get the Black tape then conduct spot taping beside Yellow tape using both hands. Make 2 windings of tape then cut.</p></div> <div><p>3. Check the wire alignment and taping condition.</p></div>		<div>MEASURING TAPE</div> 	<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> <p>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p>

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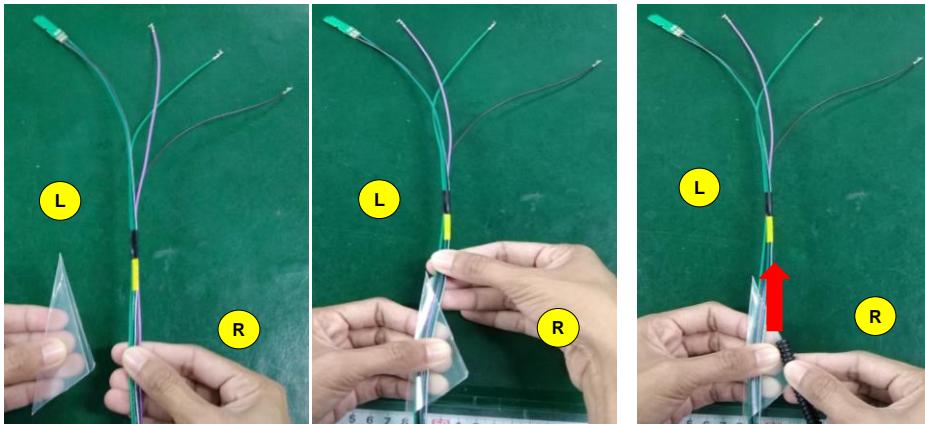

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PARTS:		1. Assy parts 2. Black COT (with slit) $\phi 5$ L=237 \pm 3mm		JIG:	1. COT Adaptor
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P2	Wire insertion to COT (with slit) $\phi 5$ L=237 \pm 3mm	<div></div> <div>1. Hold the COT adaptor using left hand. Combined the 2 assy parts and put inside the COT adaptor using right hand</div> <div>2. Hold the COT adaptor with wires using left hand, get the Black Corrugated tube (w/slit) $\phi 5$ L=237\pm3mm using right hand and insert to COT adaptor. Pull the adaptor and push the COT (same timing) using both hands. Make sure all wires are inserted.</div>	<div>COT Adaptor</div> 	1. No wrong use of parts 2. No wires left in between the COT slit

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PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Assy parts
2. Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

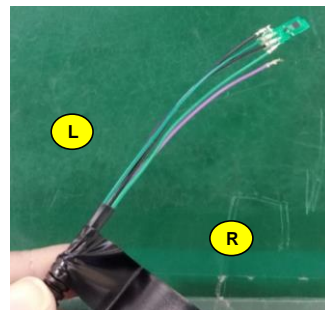
TOOLS/PPE

QUALITY POINTERS

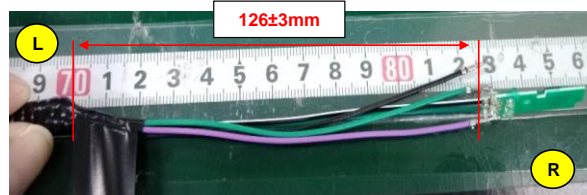
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P2

Taping 3
COT w/slit to wire near
terminal and PCB

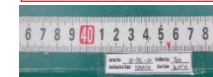


1. Hold the corrugated tube using left hand, get **Black tape** and start pre-taping using right hand.



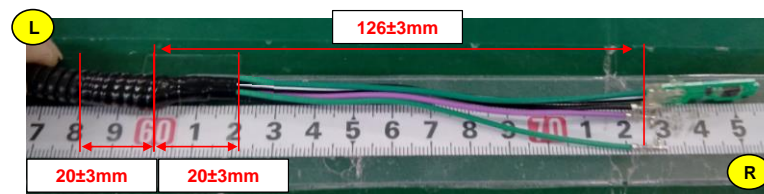
2. Measure from COT up to the hotmelted wire **126±3mm**. Continue the taping process using both hands.

MEASURING TAPE



Important reminders/Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.

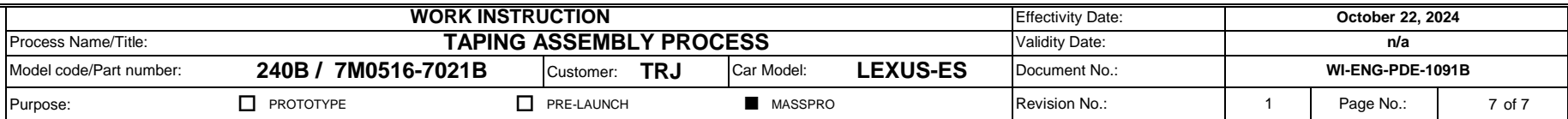


3. After taping, check the measurement and taping condition.

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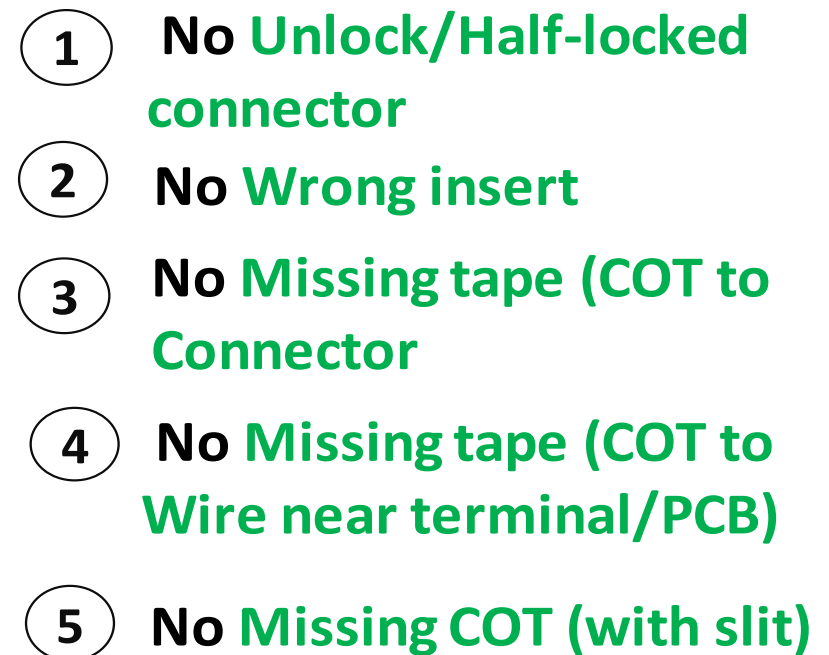
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1 VISUAL INSPECTION/ QUALITY CHECKPOINTS

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