



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 3, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

700B / 7N0038-7020B

Customer: TRJ

Car Model: TOYOTA LAND-CRUISER

Document No.:

WI-ENG-PDE-886

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1. Assy parts
2. Black SV tube (vinyl) ø5 L=187±3mm

3. Black Corrugated tube ø5 L=491±4mm
4. Black tape

JIG:

1. Terminal cover jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

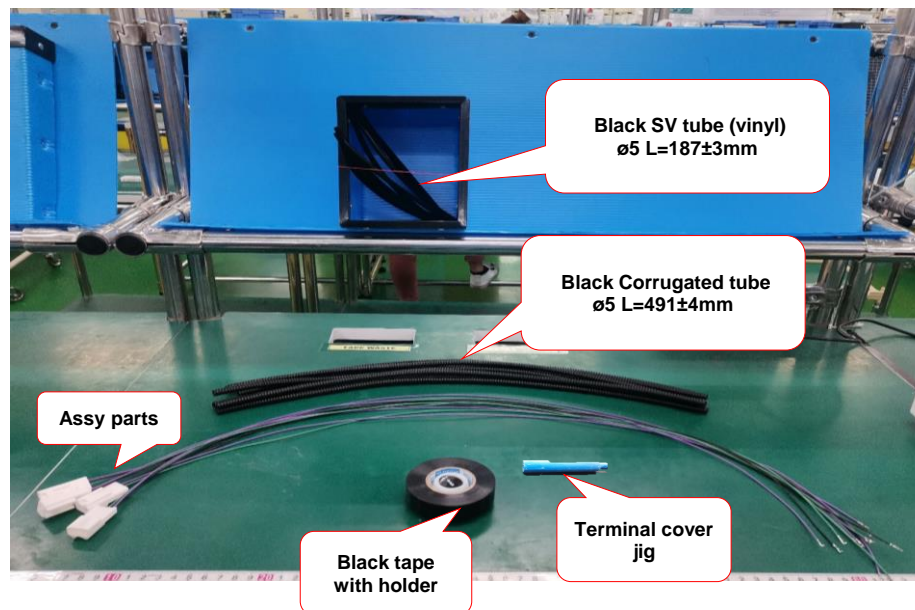
QUALITY POINTERS

1

P1

Table Lay-out

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.

1. No missing parts/tools
2. No excess parts/tools
3. No wrong position of parts/tools

Revision History

Prepared by

Reviewed by

Approved by

Noted by

06/03/24 Change pre-launch to mass pro.

A.Hernandez

C.Villanueva

A. Arañes

n/a

05/09/24 0 Initial issue.

A.Hernandez

C.Villanueva

A. Arañes

n/a

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

May 09, 2024

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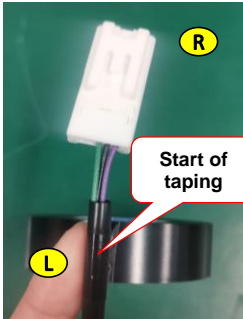
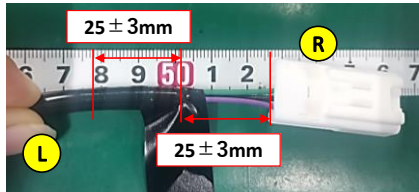
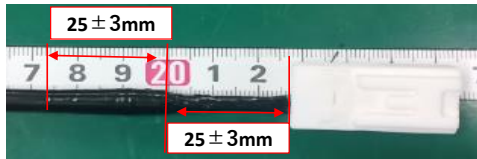

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PARTS:		1. Assy parts 2. Black SV tube (Vinyl) Ø5 L=187±3mm 3. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Black SV tube (Vinyl) Ø5 L=187±3mm	<div><p>1. Get the Black SV tube (Vinyl) Ø5 L=187±3mm using left hand then get the B-V-G L=752±3mm wires and insert using right hand.</p></div> <div></div>		n/a	1. No wrong use of parts. 2. No damaged terminal
3	P1 Taping 1 Black SV tube (Vinyl) to Wire near connector	<div><p>1. Hold the SV tube (Vinyl) using left hand, get the Black tape using right hand then start pre-taping using both hands.</p></div> <div><p>2. Hold the SV tube (Vinyl) using right hand and measure the end of the Corrugated tube up to end of connector 25mm.</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>		<div>MEASURING TAPE</div> <div></div>	1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.

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☐ PROTOTYPE

☐ PRE-LAUNCH

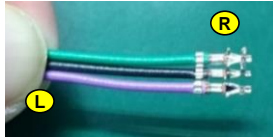
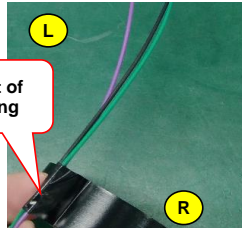
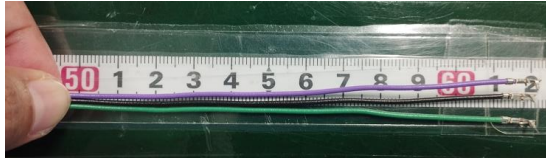
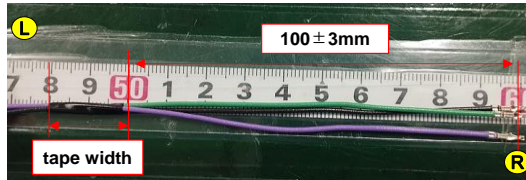

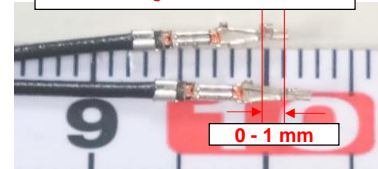




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PARTS:		1. Assy parts 2. Black corrugated tube $\phi 5$ L=491 \pm 4mm (No Slit)		3. Black tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	P1 Spot taping	<div><p>1. Combine the assy parts then align all terminals.</p></div> <div><p>3. Get the Black tape using right hand then conduct 2 windings of spot taping using both hands.</p></div> <div><p>2. Conduct measurement from wires to terminal pointed tip 120\pm3mm using both hands.</p></div> <div><p>4. After taping, check the measurement and taping condition.</p></div> <div><p>MEASURING TAPE</p></div> <div><p>Wire alignment tolerance</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></div>				
5	Wire insertion to Black corrugated tube	<div><p>1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the B-G-V wires using left hand.</p></div> <div><p>2. Get the corrugated tube (no slit) $\phi 5$ L=491\pm4mm (no slit) using right hand then insert the B-G-V wires using left hand.</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div> <div><p>Terminal cover Jig</p><p>1. No wrong insertion 2. No deformed terminal</p></div>				

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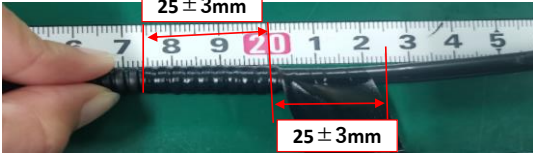
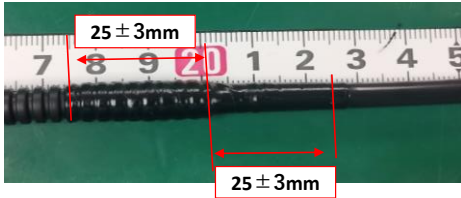

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1 Taping 2 Black Corrugated tube (no slit) to Black SV tube (Vinyl)	<div><div>Start of taping</div></div> <div><div>25 ± 3mm</div></div> <div><div>25 ± 3mm</div></div> <div>1. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.</div> <div>2. Hold the COT using right hand and measure the COT up to the SV tube (vinyl) 25mm. Note: Refer to WI-PRO-ASY-001 for taping procedure.</div> <div>3. After taping, check the measurement and taping condition.</div>		<div>MEASURING TAPE</div> 	Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension-out tape

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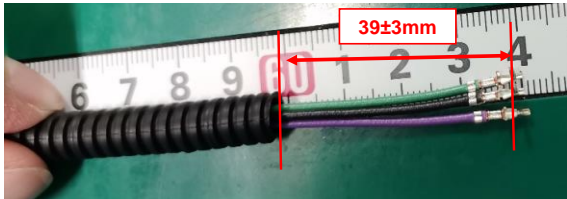

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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	Wire insertion to Black corrugated tube (no slit) $\phi 5$ L=491 \pm 4mm (Continuation)	 <p>4. Conduct measurement between end of COT up to pointed tip 39\pm3mm.</p>			<p>1. No wrong insertion 2. No deformed terminal</p> <p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p>
	P1				

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CLAMP ASSEMBLY PROCESS

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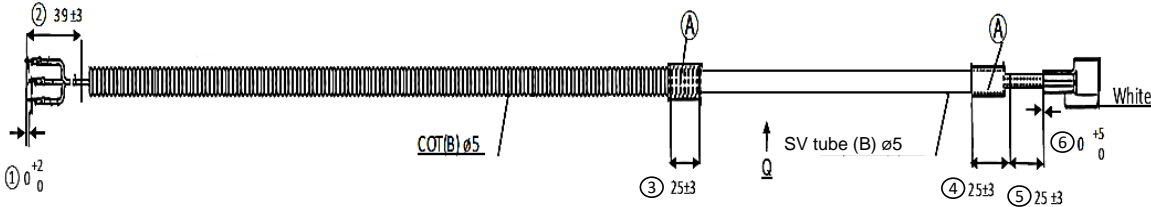

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		n/a		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1	Measurement		<div>Measuring tape</div> 	<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> <p>1. No wrong dimension</p>

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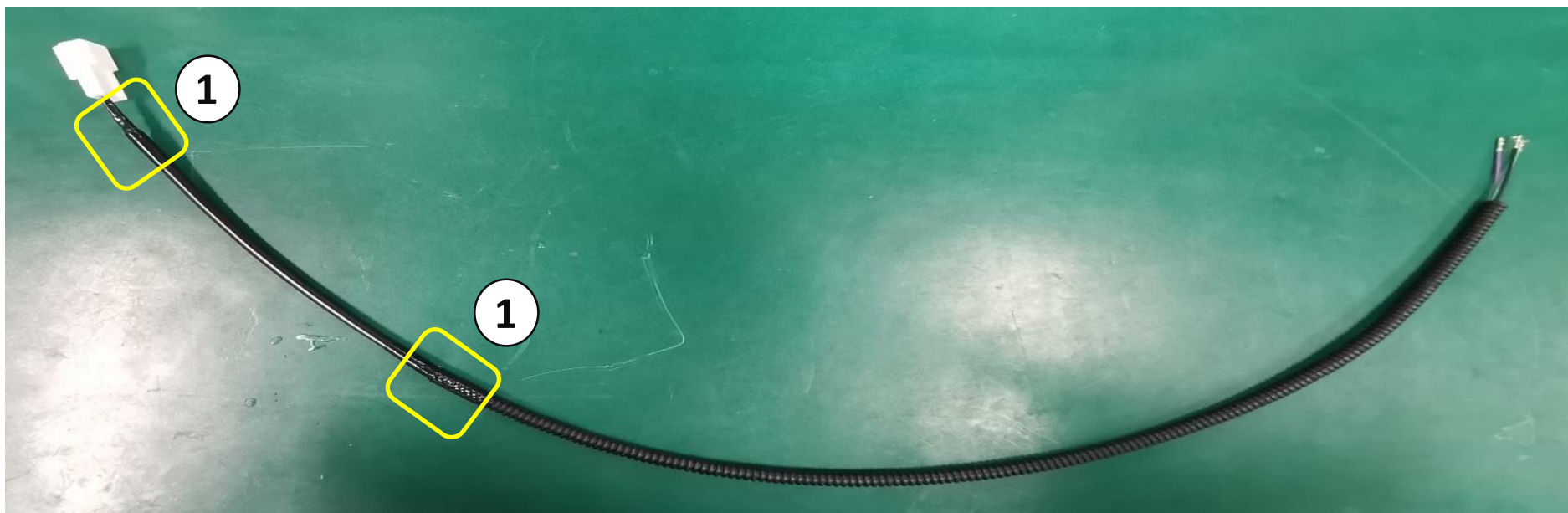
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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**P1****7N0038-7020B****1****No Missing Tape**

(on SV tube (vinyl) to wire near connector and SV tube (vinyl) to COT)

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