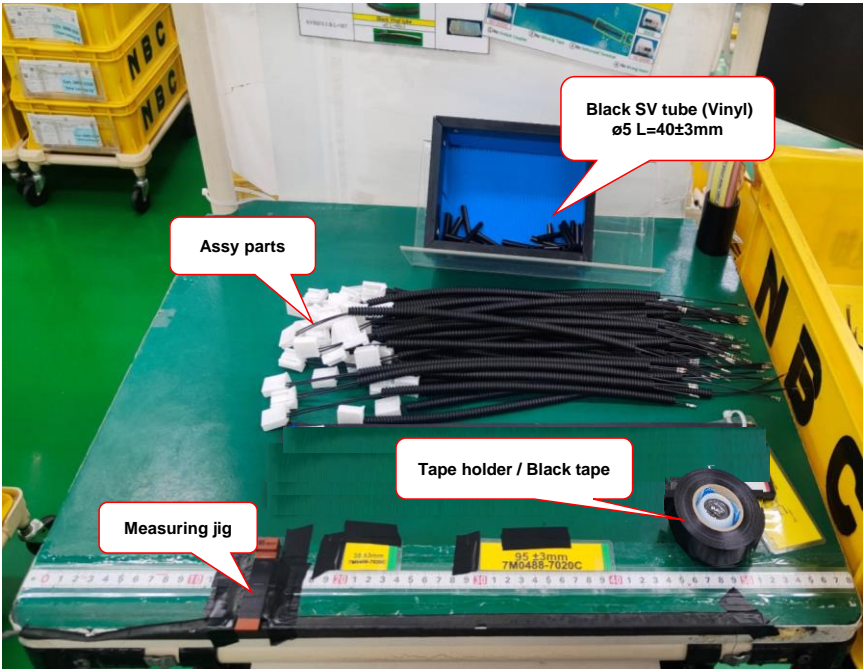



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	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 240B / 7M0488-7020C		Customer: TRJ		Car Model: LEXUS ES	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.:		Revision No.:		4 Page No.: 1 of 5	

PARTS:		1. Pre-assy parts (Connector 6098-5677 (W); AVSSF 0.3 wires B L=406mm [2pcs]; Black Corrugated tube ø5 L=303±3mm (no slit); Black SV tube (Vinyl) ø5 L=40±3mm; Black tape		JIG:		1. Measuring jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1	P1 <div>4</div> Table Lay-out	<div>TABLE LAY OUT</div> 		<div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <div>Alert level</div> <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	
04/11/24	4	Inclusion of Table lay-out and Visual inspection. Change term SV tube (Vinyl). improve improve important reminders/note's and document references. Remove By two's inspection and Update Measurement.		D.Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
07/08/21	3	Removal of marking process; Additional process on taping from COT to Vinyl tube		J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
02/20/21	2	Remove cycle time; Change connector colors in accordance with color standardization for plastic parts (Refer to GL-COM-003); Put assy parts on pg. 2 parts section; Put measuring tape illustration and instruction on measurement process		J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted	Est. Date: January 27, 2020			

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# WORK INSTRUCTION

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## TAPING ASSEMBLY PROCESS

Effectivity Date:

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Model code/Part number:

240B / 7M0488-7020C

Customer:

TRJ

Car Model:

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PARTS:

4

1. Assy parts
2. Black SV tube (Vinyl)  $\phi 5$  L=40 $\pm$ 3mm

3. Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

4

Wire Insertion to Black SV tube (Vinyl)  $\phi 5$  L=40 $\pm$ 3mm



1. Get the **Black SV tube (Vinyl)  $\phi 5$  L=40 $\pm$ 3mm** using right hand then insert the Black wires.

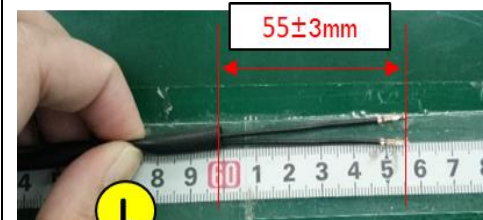
n/a

1. No deformed terminal
2. No wrong usage of parts

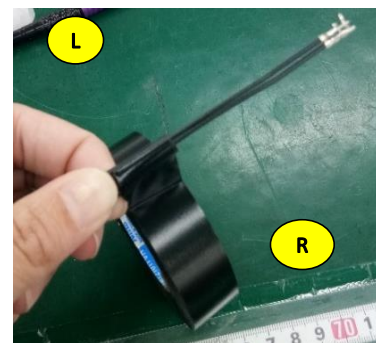
3

P1

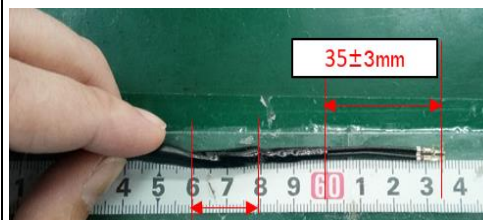
Taping 1 SV tube (Vinyl) to wire near terminal



1. Measure from SV tube (Vinyl) to terminal tip **55 $\pm$ 3mm** using both hands.



2. Hold the SV tube (Vinyl) using left hand, get Black tape using right hand and begin taping process.



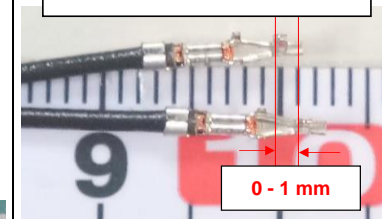
20 $\pm$ 3mm

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

Measuring tape



Wire alignment tolerance



**Important reminders/note/s:**

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

4

**Document references;**


1. Please refer to **WI-PRO-ASY-001** for taping procedure.

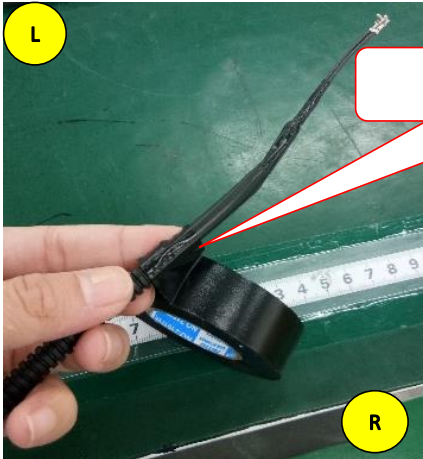
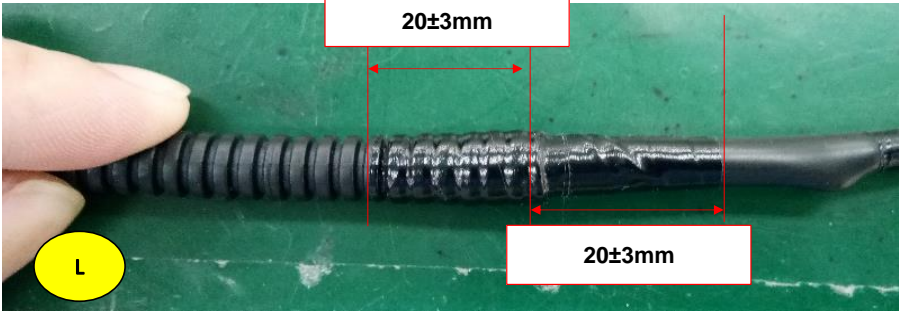

1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong use of tape
6. No wrong dimension

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	<b>WORK INSTRUCTION</b>				Effectivity Date:	April 11, 2024		
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>240B / 7M0488-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS ES</b>	Document No.:	<b>WI-ENG-PDE-072</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	4	Page No.:	3 of 5

<b>PARTS:</b>	1. Black tape 2. Assy parts			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
4	P1  Taping 2 Corrugated tube to SV tube (Vinyl)	<div><p>1. Fix the Corrugated tube and SV tube (Vinyl) using left hand, get the Black tape using right hand and begin the taping process.</p></div> <div><p>2. After taping, check the measurement and taping condition.</p></div>	<div><b>Measuring tape</b></div> 	<p><b>Important reminders/note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p><b>Document references;</b></p> <p>1. Please refer to <b>WI-PRO-ASY-001</b> for taping procedure.</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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**TAPING ASSEMBLY PROCESS**

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Model code/Part number:

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**PARTS:**

n/a

JIG:

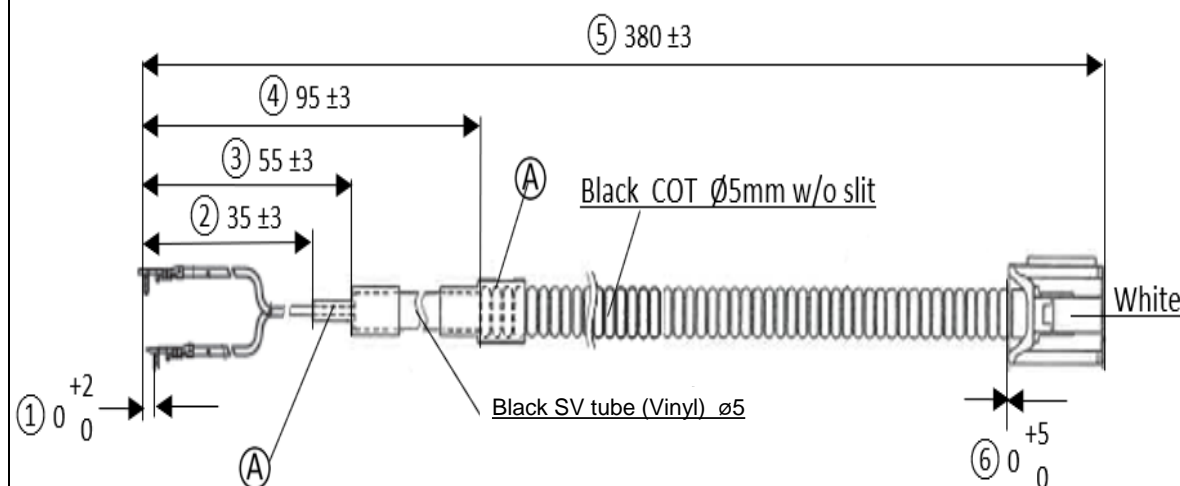
n/a

**NO.****PROCESS NAME****④ WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

5

P1

Measurement

**NOTE:**

(A) - Taping (B)

**Important reminders and note/s:**

1. Please use calibrated/verified measuring tape when getting the measurement.
2. For Hatsumono, Nakamono and Owarimono.

**Document reference/s:**

1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection

1. No wrong dimension

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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION****TAPING - P1****7M0488-7020C****1****No Missing Tape**

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