



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

November 04, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

178D / 7N0127-7021C

Customer: TRJ

Car Model: TOYOTA-COROLLA

Document No.:

WI-ENG-PDE-1159

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS: 1. Assy Parts; Black Corrugated tube $\phi 7$ L=469 \pm 3mm; Black Tape

JIG:

1. Terminal cover jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

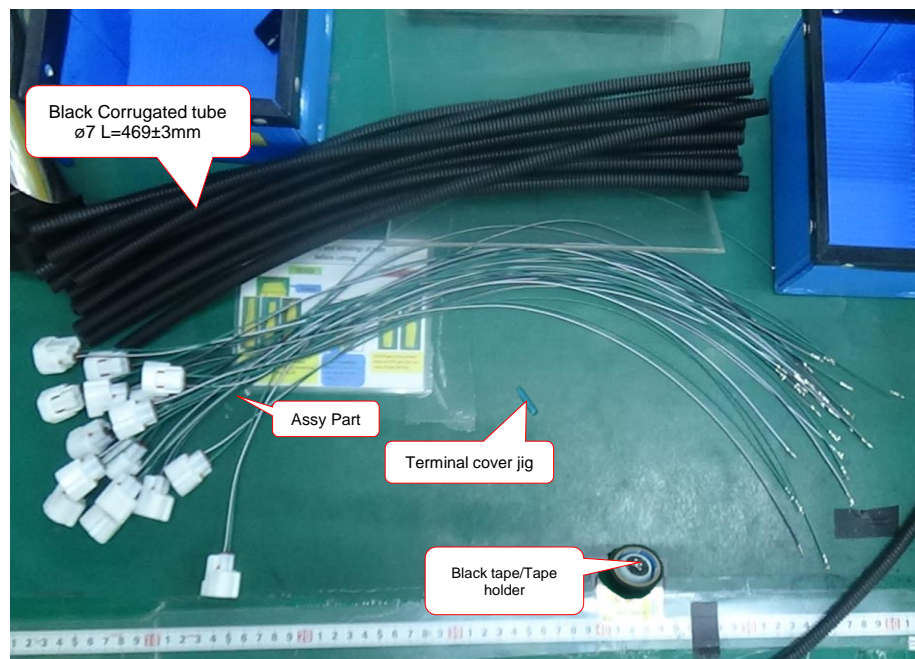
QUALITY POINTERS

1

P1

Table Lay-out

TABLE LAY-OUT



Safety Instruction

Be sure to wear 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.

Document reference/s:

1. Refer to **WI-PRO-CNC-017** for Wire and Strip Length Tolerance
2. Refer to **WI-ENG-PDE-925** for Offline assembly process

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

Revision History

Prepared by

Reviewed by

Approved by

Noted by

11/04/24 1 Change pre-launch to mass pro.

A. Hernandez C. Villanueva A. Arañes n/a

10/29/24 0 Initial issue.

A. Hernandez C. Villanueva A. Arañes n/a

Eff. Date Rev. No Details of Change

Revised Reviewed Approved Noted

Est. Date:

October 29, 2024

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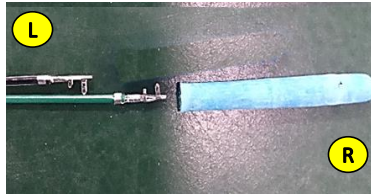


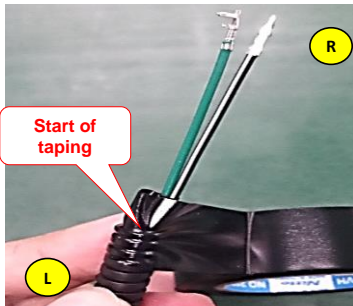
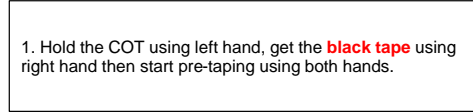

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Black corrugated tube $\phi 7$ L= 469 \pm 3mm (no slit) 2. Assy parts		3. Black tape	JIG:	1.Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	P1	Wire insertion to corrugated tube $\phi 7$ L=469 \pm 3mm (no slit)			<div>TERMINAL COVER JIG</div> 	1. No wrong usage of parts 2. No deformed terminal
3		Taping 1 Black COT to wire near terminal			<div>MEASURING TAPE</div> 	1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.

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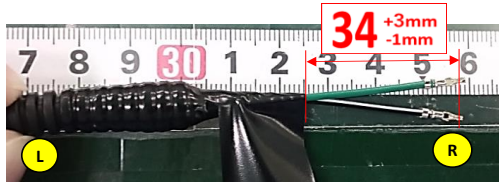
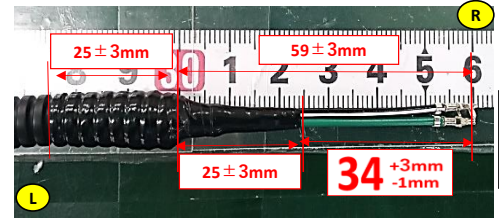

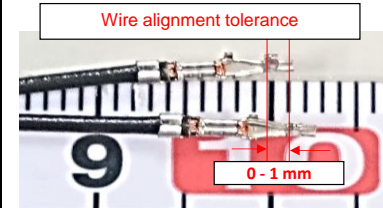
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Taping 1 Black COT to wire near terminal (Continuation)	 <p>2. Confirm measurement from end of tape up to end of COT 25±3mm then continue the taping process using both hands.</p>  <p>3. Measure from end of COT up to terminal pointed tip 59±3mm then continue the taping process using both hands.</p>  <p>4. Measure from end of tape up to terminal pointed tip 34+3/-1mm then continue the taping process using both hands.</p>  <p>5. After taping, check the measurement, wire alignment and taping condition.</p>			 <p>Wire alignment tolerance</p> <p>0 - 1 mm</p> <p>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <ul style="list-style-type: none">1. No peel-off tape2. No flip out tape3. No loose tape4. No wrong use of tape5. No wrong dimension6. No missing tape

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PARTS:	1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1 Measurement	<div><p>NOTE: A Taping (B) for item number ② , Dimension tolerance is different from the master drawing due to Internal change only.</p></div>	<div>MEASURING TAPE</div> <div> </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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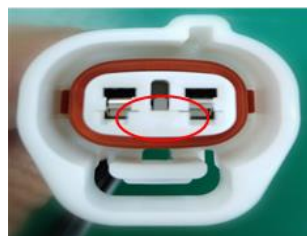
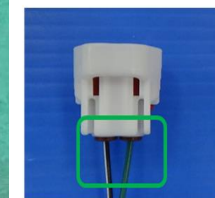
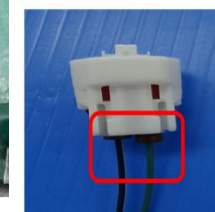
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PARTS:

1.Assy Parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**P1****7N0127-7021C****GOOD****NO GOOD****1 No Unlock/ Half Lock Connector****3 No Missing Tape****2 No Wrong Insert****4 No Terminal Backing Out****4****GOOD****NO GOOD**

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