



## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

June 24, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number: 920B / 7R0120-7021A

Customer: TRMX

Car Model: TOYOTA-TACOMA

Document No.:

WI-ENG-PDE-651A

Purpose:

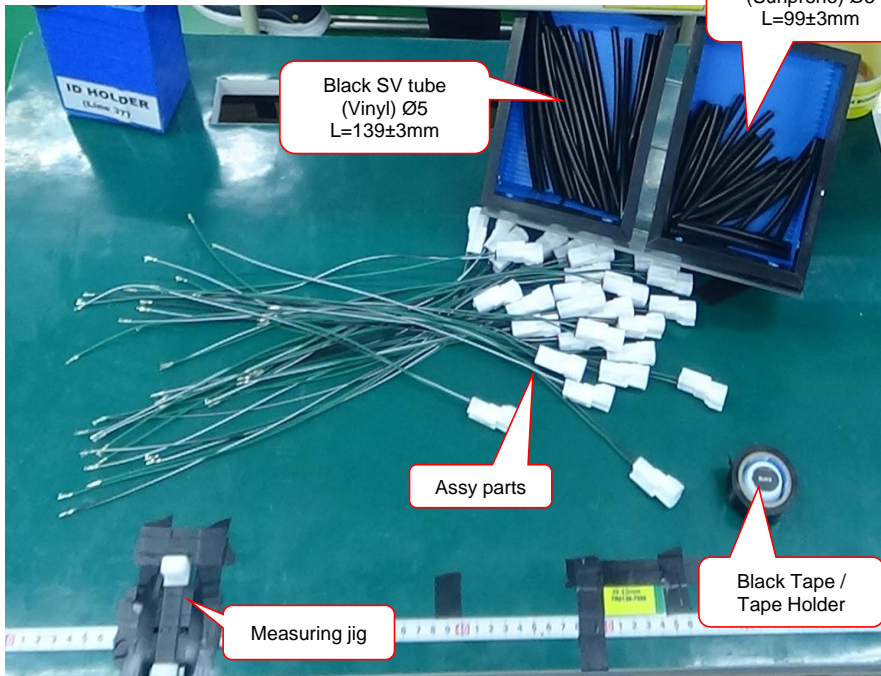
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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PARTS:		1. Assy parts; Black SV tube (Vinyl) Ø5 L=139±3mm; Black VM tube (Sunprene) Ø5 L=99±3mm; Black Tape				JIG:		1. Insertion jig with switch cover 2. Measuring jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	P1	<div>Table Lay-out</div> 				<div>Safety Instruction</div> <p>Be sure to wear required 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>		<div>Document reference/s:</div> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>	
Revision History									
06/24/24	2	Transfer Connector settings, insertion to connector process, to Offline assembly process.				A. Hernandez	C. Villanueva	A. Arañes	n/a
04/17/23	1	Document purpose from prelaunch to masspro. Improve table lay-out. Improve work procedure and illustration due to improvement.				M. Catapang	J. Loterte	C. Villanueva	A. Arañes
03/16/23	0	Initial issue				M. Catapang	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted
						Prepared by		Reviewed by	Approved by
						A. Hernandez		C. Villanueva	A. Arañes
						Est. Date:		March 16, 2023	

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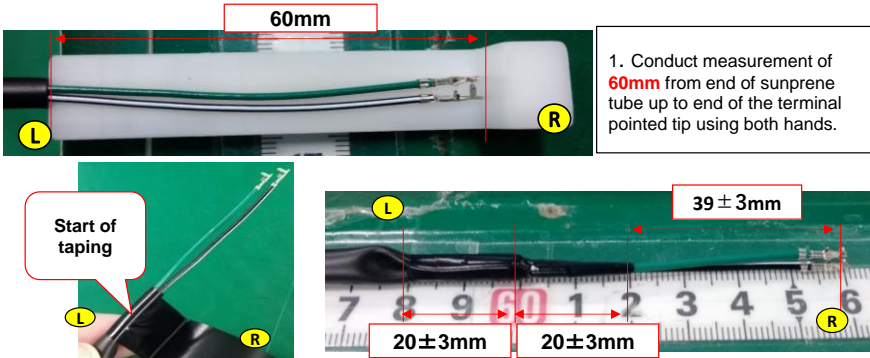
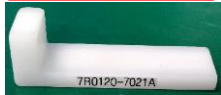

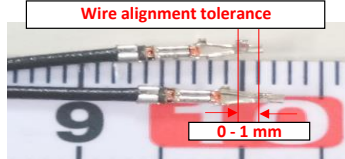
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<b>PARTS:</b>		1. Assy parts 2. Black SV tube (Vinyl) Ø5 L=139±3mm 3. Black VM tube (Sunprene) Ø5 L=99±3mm 4. Black tape	JIG:	1. Measuring jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	Wire Insertion to Black SV tube (Vinyl) Ø5 L=139±3mm	 <p>1. Get the Black SV tube (Vinyl) Ø5 L=139±3mm using right hand then insert the G-B/W wires using left hand.</p>	n/a	1. No wrong use of parts
3	Wire Insertion to Black VM tube (Sunprene) Ø5 L=99±3mm	 <p>1. Get the Black VM tube (Sunprene) Ø5 L=99±3mm using right hand then insert the G-B/W wires using left hand.</p>	n/a	1. No wrong use of parts
4	P1 Taping 1 Black VM tube (Sunprene) to wire near terminal	 <p>1. Conduct measurement of 60mm from end of sunprene tube up to end of the terminal pointed tip using both hands.</p> <p>2. Hold the tube using left hand, get the Black tape using right hand then start taping process using both hands.</p> <p>3. After taping, check the taping condition, measurement and wire alignment.</p>	<b>MEASURING JIG</b>  <b>MEASURING TAPE</b> 	<p><b>Wire alignment tolerance</b></p>  <p>0 - 1 mm</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> <p><b>Important reminders/Note/s:</b> 1. Please use calibrated/verified measuring tape when getting the measurement.</p>

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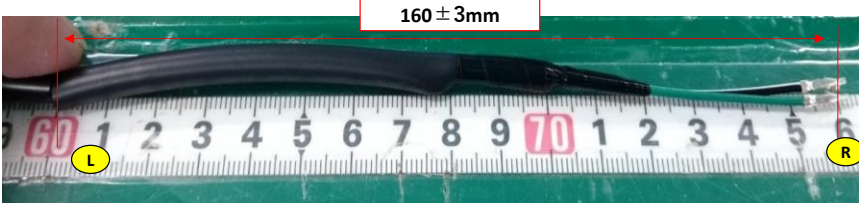
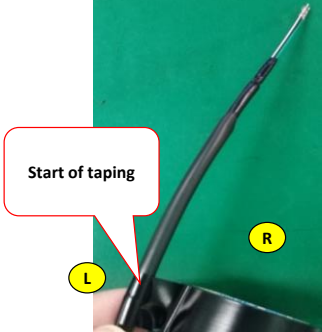
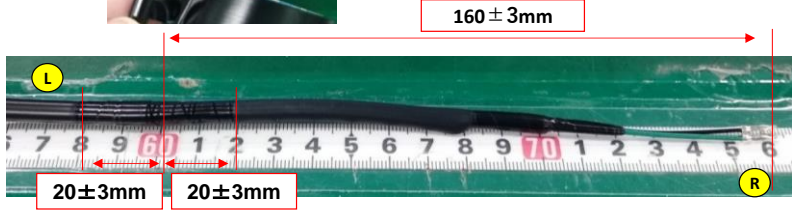

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1	<p>Taping 2 Black SV tube (Vinyl) to Black VM tube (Sunprene) near terminal</p>  <p>1. Measure from end of corrugated tube up to terminal pointed tip <math>184 \pm 3\text{mm}</math> using both hands.</p>  <p>2. Hold the corrugated tube and sunprene tube using left hand, get the <b>Black tape</b> then start taping process using both hands.</p>  <p>3. After taping, check the taping condition, measurement and wire alignment.</p>		<p><b>MEASURING TAPE</b></p> 	<p><b>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></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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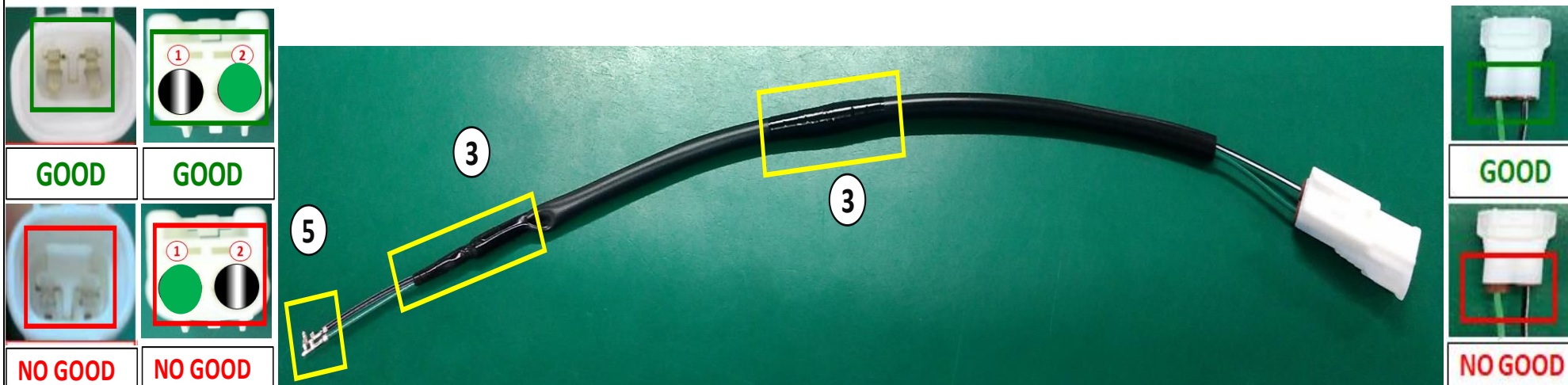
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/QUALITY CHECKPOINTS****P1****7R0120-7021A****① No Wrong Insert****③ No Missing tape****② No Terminal Backing Out****④ No Deformed Terminal**

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