

	WORK INSTRUCTION				Effectivity Date:		May 05, 2025	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 559D / 7N0242-7020B		Customer: TRJ		Car Model: TOYOTA HI-ACE	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.:		WI-ENG-PDE-1250B	
				Revision No.:		1		Page No.:
								1 of 6

PARTS:	1. Assy parts 2. Clamp 82711-1E360 (W)			<div style="border: 1px solid black; padding: 2px; display: inline-block;">1</div>	3. Black SV tube (Vinyl) ø5 L=534±2mm 4. White tape			JIG:	n/a
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Table lay-out	<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px solid red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	1. No missing parts/tools 2. No excess parts/tools


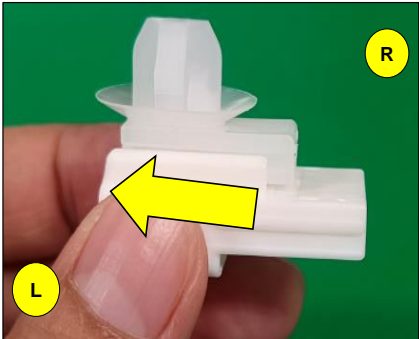
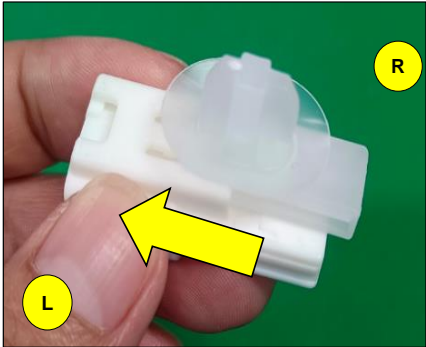


Revision History						Prepared by		Checked by		Reviewed by		Approved by	
05/05/25	1	Change from pre-launch to masspro. Aligned SV tube (Vinyl) length based on Cutting ledger from L=535±3mm to L=534±2mm. Update Measurement work procedure.	D.Castillo	J. Loterte	C.Villanueva	A. Arañes							
04/16/25	0	Initial issue.	D.Castillo	J. Loterte	C.Villanueva	A. Arañes							
Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved	Est. Date:	April 16, 2025					

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	2 of 6


PARTS:		1. Clamp 82711-1E360 (W) 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Clip attachment (Clip type clamp)	<div></div> <div></div> <div>1. Hold the Connector using left hand, get the clip type clamp 82711-1E360 (W) then insert the clamp using right hand. Note: Follow the illustration. Sound will be heard if properly inserted.</div>		n/a	<div>1. No wrong used of clamp 2. No damaged clamp 3. No missing clamp</div> <div>CLIP CLAMP ILLUSTRATION</div> <div><div>GOOD</div>82711-1E360 (W)</div> <div><div>NG</div>82711-12B10 (W)</div>

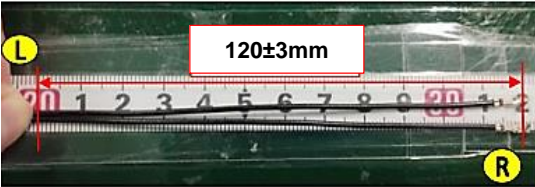
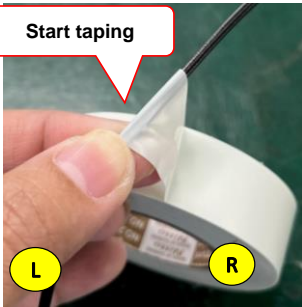
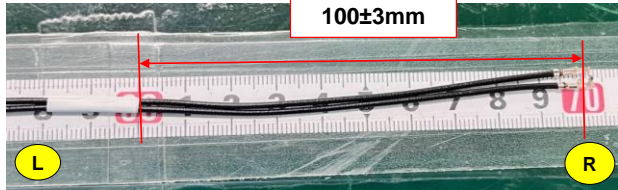

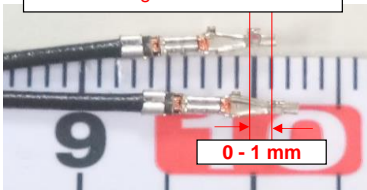

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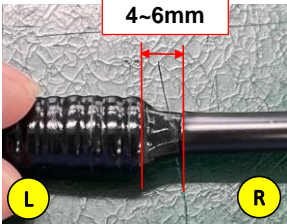
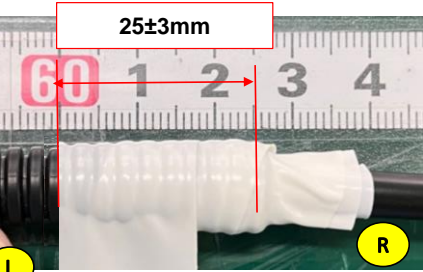
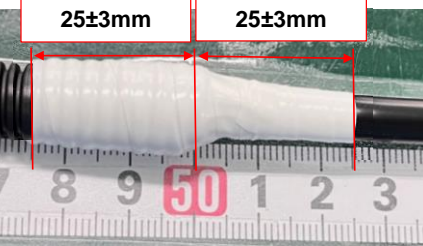
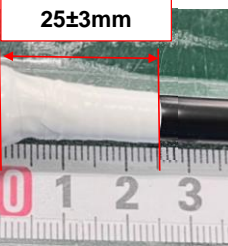
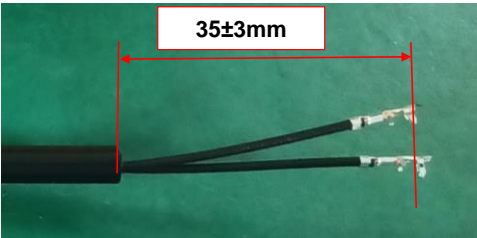
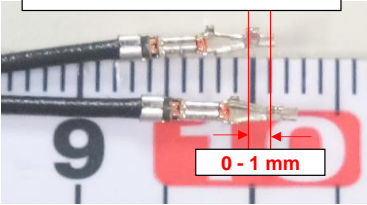
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	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:	1	Page No.:

PARTS:		1. Assy part 2. White tape		3. Black SV tube (VInyl) $\phi 5$ L=534 \pm 2mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS
3	P2 Spot taping	<div>  <p>120\pm3mm</p> </div> <div>  <p>Start taping</p> </div> <div> <p>1. Hold the wires using left hand and measure from wire up to terminal pointed tip 120\pm3mm</p> </div> <div> <p>2. Get the Sky Blue tape and start taping on the Black wires. Conduct 2 windings of tape before cut the tape using both hands.</p> </div> <div>  <p>100\pm3mm</p> </div> <div> <p>3. After taping, check the measurement, tape condition and terminal appearance.</p> </div>				<div>  <p>MEASURING TAPE</p> </div>	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No flip-off tape 2.No peel-off tape 3. No loose tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape 7. No insufficient tape</p> <div>  <p>Wire alignment tolerance</p> <p>0 - 1 mm</p> </div>
4	1 Wire Insertion to Black Black SV tube (VInyl) $\phi 5$ L=534 \pm 2mm	<div>  </div> <div> <p>1. Hold the assy part using left hand and get Black SV tube (VInyl) $\phi 5$ L=534\pm2mm using right hand then insert.</p> </div>				n/a	<p>1. No wrong usage of parts 2. No deformed terminal</p>

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	4 of 6

PARTS:	1. Assy part 2. White tape			JIG:	n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
4	P2 Taping 2 Black corrugated tube to Black SV tube (Vinyl)	<div><div><p>4~6mm</p></div><div><p>1. Hold the COT using left hand and hold the SV tube (Vinyl) using right hand. Insert the SV tube (Vinyl) to tape until no movement. <i>Note: Do not use to much force during insertion.</i></p></div><div><p>25±3mm</p></div><div><p>2. Get the White tape using right hand then start taping process using both hands.</p></div><div><p>25±3mm</p></div><div><p>25±3mm</p></div><div><p>35±3mm</p></div><div><p>3. After taping, check the measurement, taping condition and terminal appearance.</p></div></div> <div><p>Start taping</p></div> <div><p>MEASURING TAPE</p></div>			<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-001B for taping procedure.</p> <p>1. No flip-out tape 2.No peel-off tape 3. No loose tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape</p> <div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div>		

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Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

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PARTS:

1. Assy parts

JIG:

n/a

NO.**PROCESS NAME**

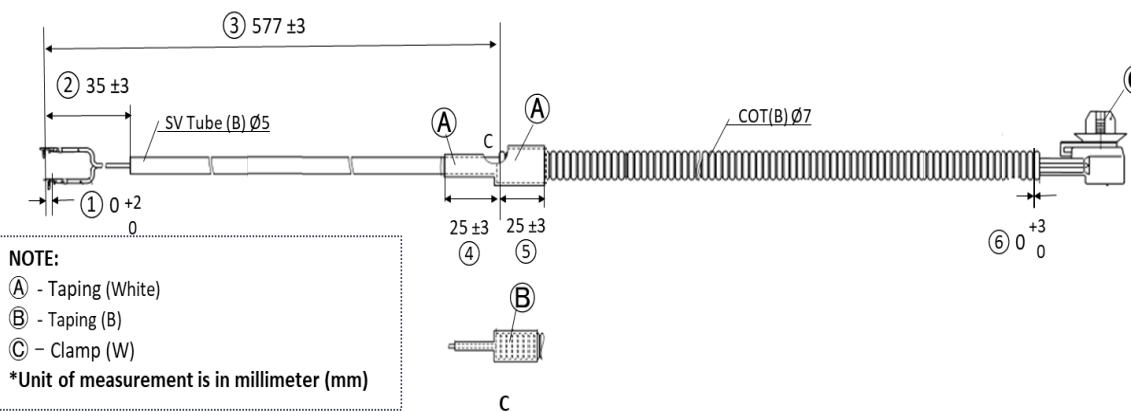
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WORK PROCEDURE/ ILLUSTRATION**TOOLS/PPE****QUALITY POINTERS**

5

P2

Measurement

**MEASURING
TAPE****Important reminders and note/s:**

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

2. For Hatsumono 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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PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

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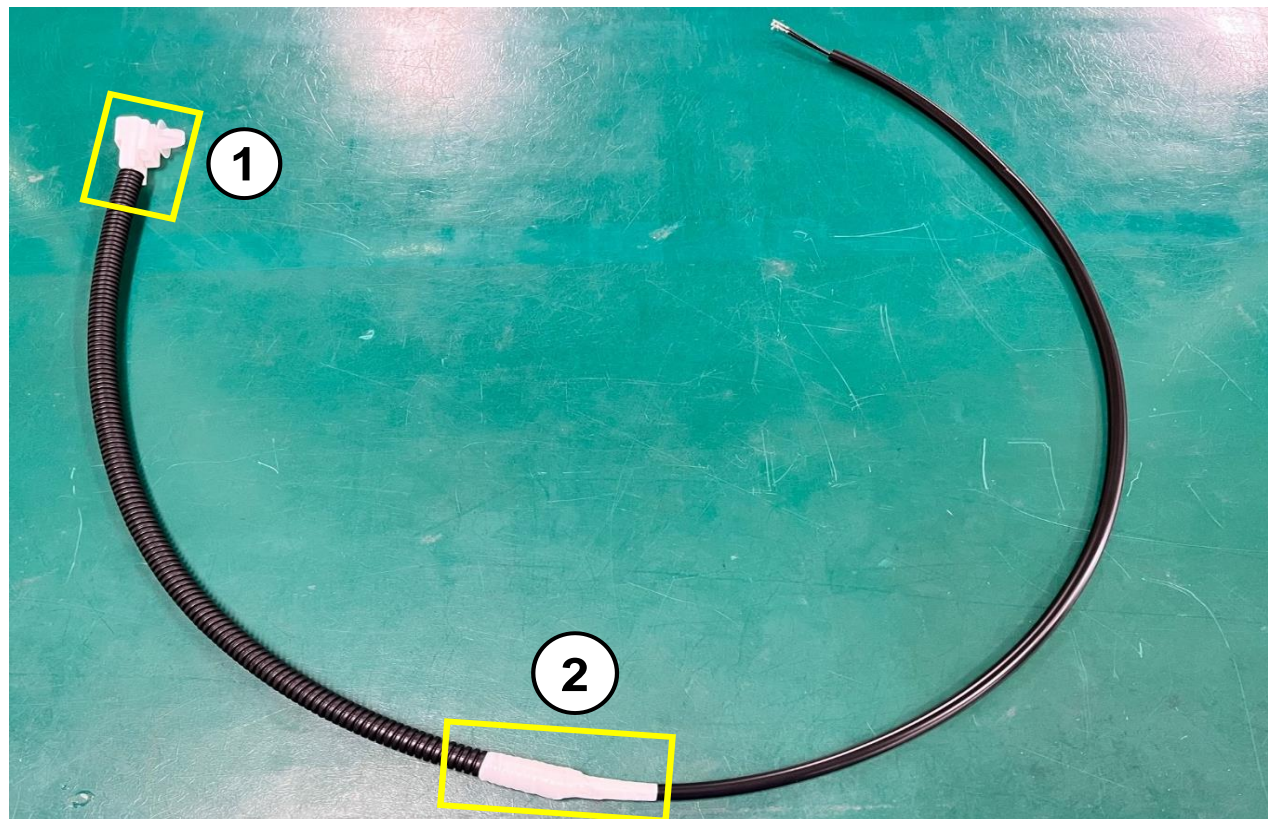
Page No.:

6 of 6**PARTS:**

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P2****7N0242-7020B**

① **No Missing Clip
Clamp**

② **No Missing tape**

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