



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 24, 2024

Validity Date:

n/a

Model code/Part number:

550B / 7L0082-7023

Customer:

TRQSS

Car Model: TOYOTA-HIGHLANDER

Document No.:

WI-ENG-PDE-386B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

1 of 5

PARTS:

1. All parts: Assy Parts; Black Tape [1pc]

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

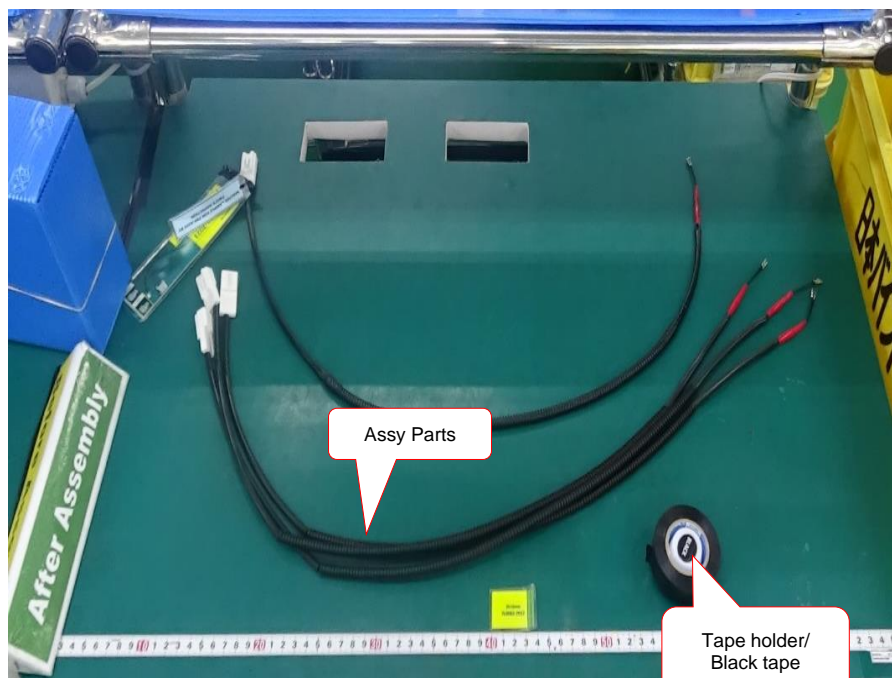
TOOLS/PPE

QUALITY POINTERS

1

P2

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


Revision History

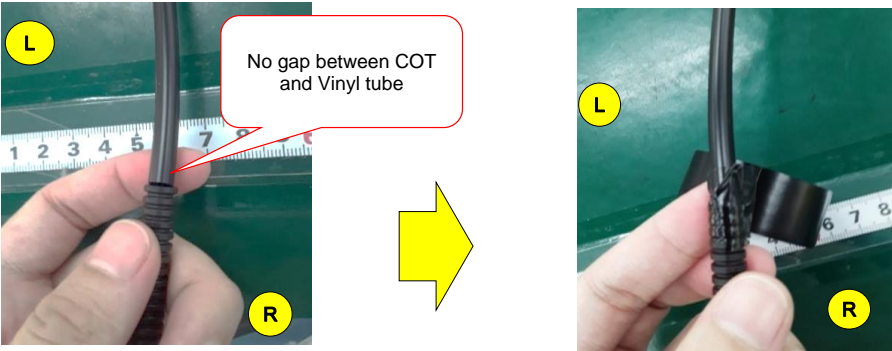
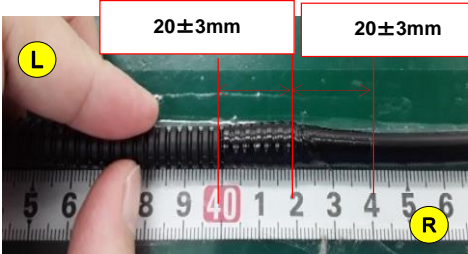

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
06/24/24	0	Transfer Taping 1 and Taping 2 from WI-ENG-PDE-386A due to Process improvement.	D.Castillo	C.Villanueva	A. Arañes	n/a	D. Castillo	C. Villanueva	A. Arañes	n/a

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	2 of 5

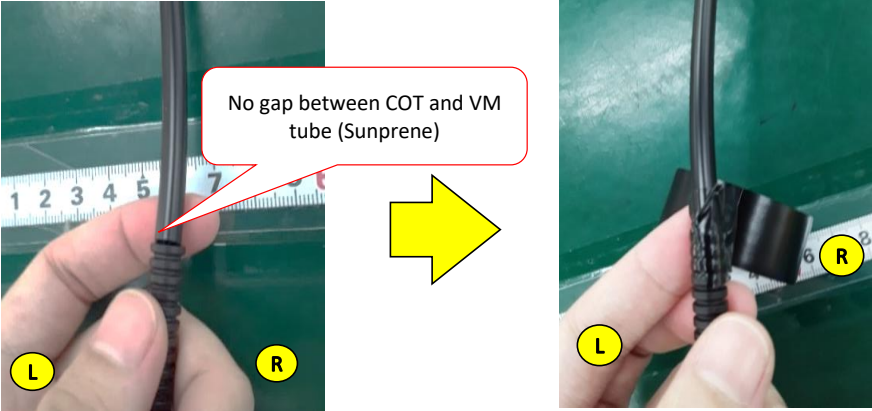
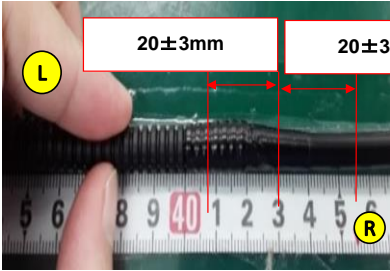

PARTS:	1. Assy Parts 2.Black Tape [1pc]			JIG:	n/a			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
2	P2 Taping 1 Corrugated tube to Vinyl tube	<div></div> <div>1. Fix the corrugated tube to SV tube (Vinyl) using left hand and start taping using right hand.</div> <div></div> <div>2. Check the measurement and taping condition after taping.</div>			<div>MEASURING TAPE</div> 	<div>Important reminders/Note/s: 1. <i>Please use calibrated measuring tape when getting the measurement.</i></div> <div>Document references: 1. <i>Refer to WI-PRO-ASY-001 for Taping process</i></div> <div>1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape</div>		

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	Model code/Part number: 550B / 7L0082-7023		Customer: TRQSS	Car Model: TOYOTA-HIGHLANDER	Revision No.: 0 Page No.: 3 of 5		
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO							


PARTS:		1. Assy Parts 2. Black tape [1pc]		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
3	P2 Taping 2 Corrugated tube to Sunprene tube	<div></div> <div></div> <div>1. Fix the corrugated tube to VM tube (Sunprene) using left hand and start taping using right hand.</div> <div>2. Check the measurement and taping condition after taping.</div>		<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated measuring tape when getting the measurement.</p> <p>Document references:</p> <p>1. Refer to WI-PRO-ASY-001 for Taping process</p> <p>1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape</p>	

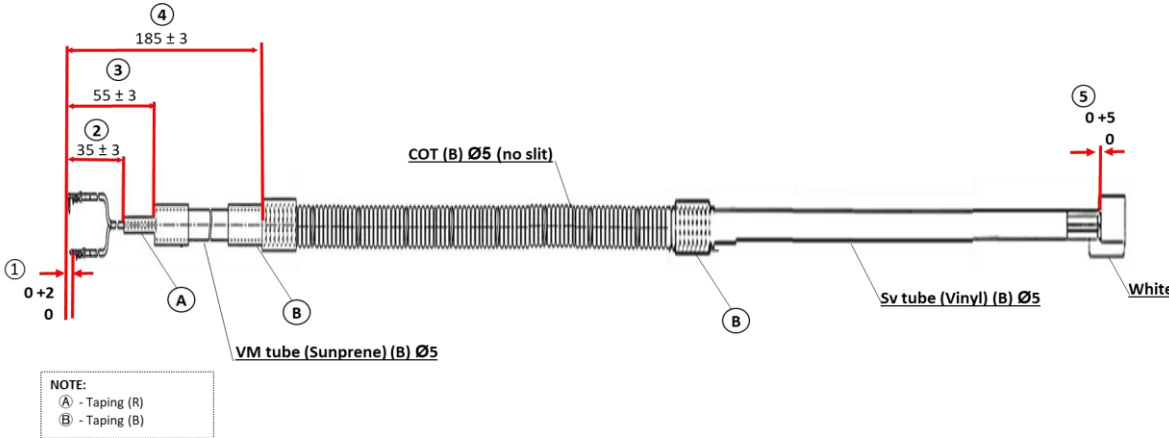

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PARTS:	1. Assy Parts			JIG:	n/a				
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS			
4	P2	Measurement	<div></div>			<div>MEASURING TAPE </div>	<div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension</div>		

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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**P2****7L0082-7023****1****No Missing Tape (COT to SV
tube (Vinyl)****2****No Missing Tape (COT to VM
tube (Sunprene)**

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