



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

September 12, 2024

Model code/Part number: 707B / 7L0094-7020

Customer: TRQSS

Car Model: LEXUS ES HIGHBRID

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-267B

Revision No.:

0

Page No.:

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PARTS:

1. Assy parts 1 & 2; Black SV tube (Vinyl) Ø5 L=40±3mm; Black corrugated tube Ø5 L=305±3mm(no slit); Black Tape; Blue Tape

JIG:

1. Spot taping jig
2. Measuring jig
3. Terminal cover jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

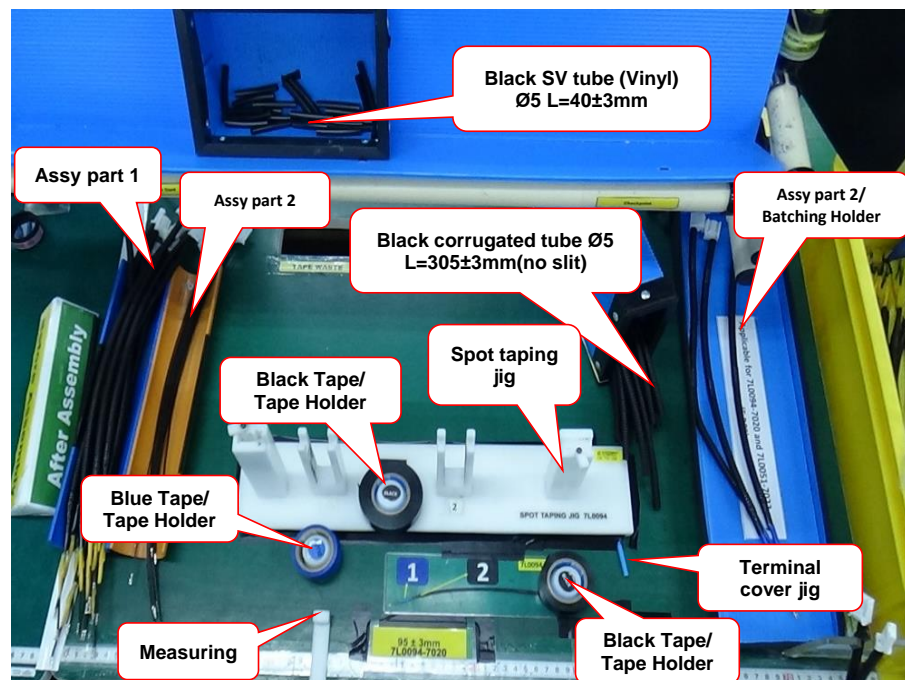
TOOLS/PPE

QUALITY POINTERS

1

P2

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. Please refer to WI-PRO-CNC-017 for the Wire and Strip Length tolerance.

1. No missing parts/ tools.
2. No excess parts/ tools.

Revision History

Prepared by

Reviewed by

Approved by

Noted by

09/12/24 0 Initial issue.

A.Hernandez

C.Villanueva

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n/a

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

September 12, 2024

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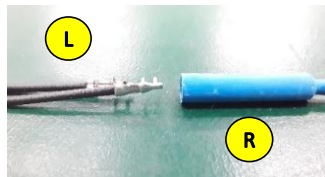


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PARTS:		1. Assy parts 2. Black Corrugated tube Ø5 L=305±3mm (no slit)		3. Black Sv tube (Vinyl) ø5 L= 40±3mm		JIG:	1. Terminal cover jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	P2	Wire insertion to Corrugated tube Ø5 L=305±3mm (no slit)	<div><div></div><div>1. Hold the wires using left hand, get the terminal cover jig using right hand and insert the wires.</div></div> <div><div></div><div>2. Get the corrugated tube Ø5, L=305±3 (no slit) using right hand and insert to wires.</div></div> <div><div></div><div>3. After insertion, remove the terminal cover jig using right hand.</div></div>			<div>Terminal cover jig</div> 	1. No wrong use of parts 2. No deformed terminal
3		Wire insertion to SV tube (Vinyl) ø5 L=40±3mm	<div><div></div><div>1. Hold the assy part using left hand then get the Sv tube (Vinyl) ø5 L= 40±3mm using right hand and insert the Black wires.</div></div>			n/a	1. No wrong use of parts 2. No deformed terminal

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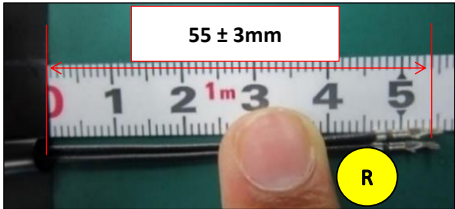

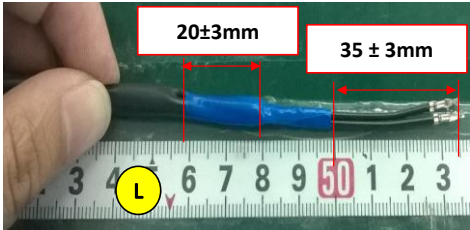

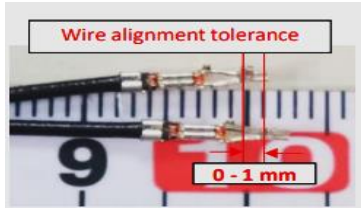
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PARTS:		1. Assy parts 2. Blue tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2 Taping 1 Vinyl tube to wire near terminal	<div></div> <div><p>1. Measure the end of the SV tube (Vinyl) up to the end of the terminal pointed tip 55 ± 3mm using both hands.</p></div> <div></div> <div><p>2. Get Blue tape using right hand, hold the SV tube (Vinyl) (ø5 L=40±3mm) using left hand then fold the Sv tube (Vinyl) and start taping using right hand.</p></div> <div></div> <div><p>3. After taping check the measurement, wire alignment and taping condition.</p></div>		<div></div> <p>MEASURING TAPE</p>	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. Use Blue tape only</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> <div></div>

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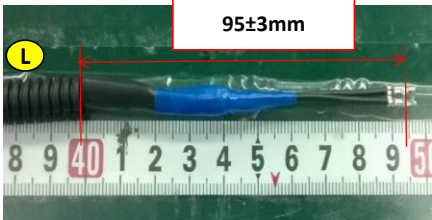
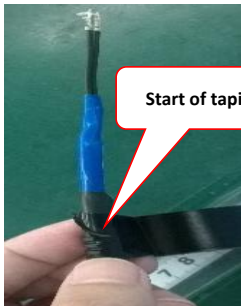
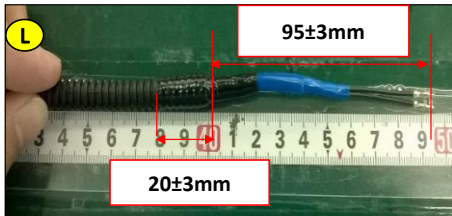

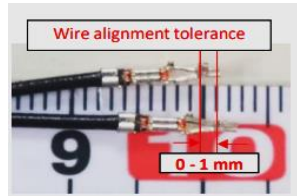
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PARTS:		1. Assy parts 2. Blue tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2	<div><div>1. Measure the end of the Sv tube (Vinyl) up to the end of the terminal pointed tip 95±3mm using both hands.</div></div> <div><div>2. Get Black tape using right hand, hold the cot using left hand and start taping using right hands.</div></div> <div><div>3. After taping, check the dimension and taping condition.</div></div>		<div>MEASURING TAPE</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> <div>Important reminders/Note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div></div>

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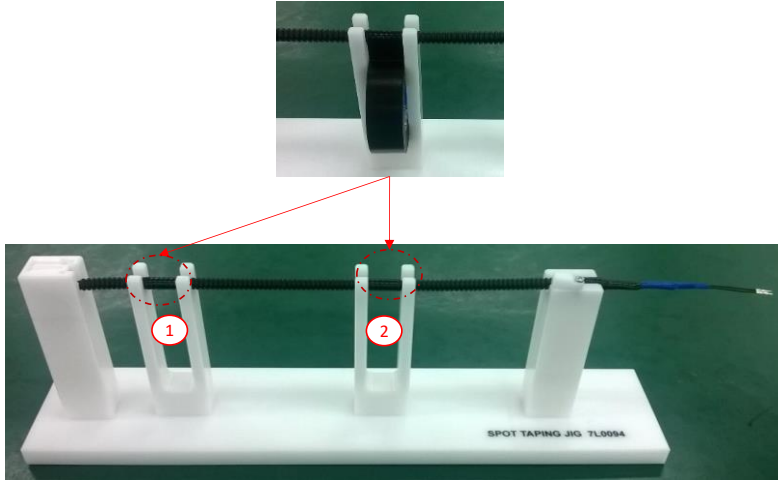
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PARTS:		1. Assy parts (with Blue tape) 2. Black tape		JIG:	1. Spot taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P2	<div></div> <div>1. Get the assy part (with Blue tape) using both hands and set to spot taping jig. First, set the connector to receiver base. Last, put the COT to COT guide and lock.</div> <div>2. Get the Black tape and begin spot taping on location 1 using both hands. Make 2 windings then cut the tape.</div> <div>3. Get the Black tape and begin spot taping on location 2 using both hands. Make 2 windings then cut the tape.</div> <div>4. Remove the assy parts from jig using both hands and put to holder.</div>		n/a	1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong use of tape 5. No missing tape 6. No wrong position of spot tape

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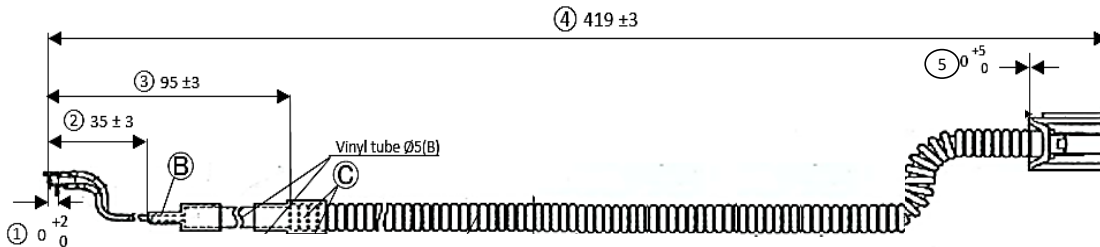

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PARTS:	1. Assy Parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P2 Measurement	<div></div> <div>NOTE: ② - Taping (L) ③ - Taping (B)</div> <div><div>MEASURING TAPE</div></div>		<p>Important reminders and note/s:</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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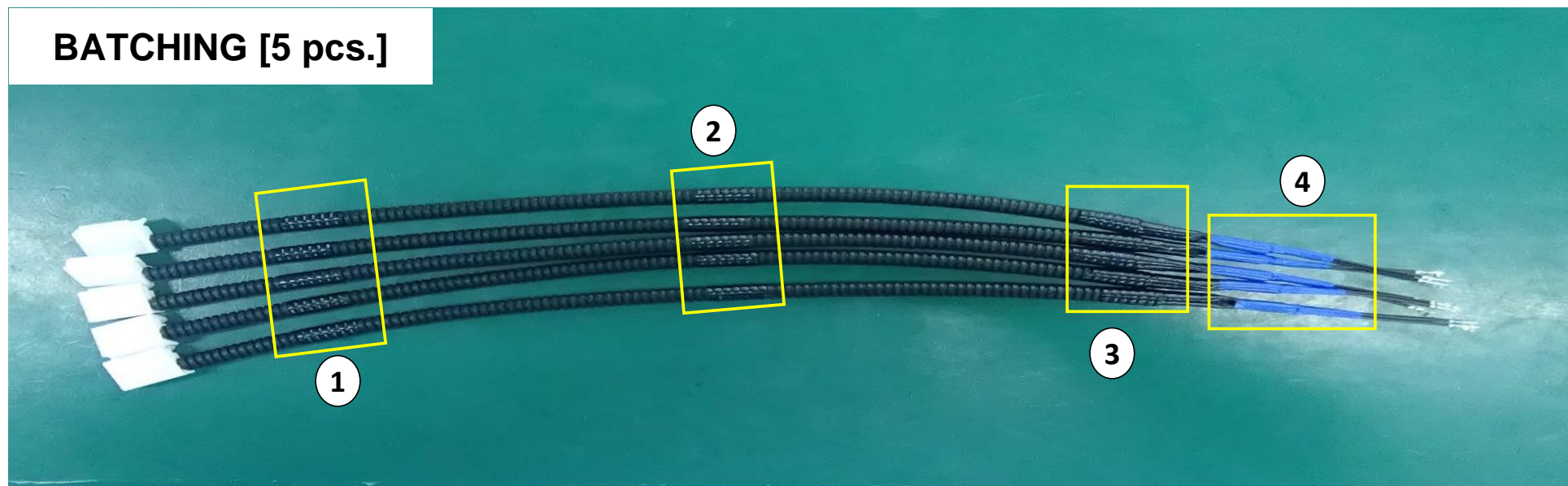
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**P2****7L0094-7020****BATCHING [5 pcs.]****1 2****No Missing Spot Tape
(Black Tape)****3 4****No Missing Tape (Black Tape)/ Wrong Used of
Tape(Blue Tape)**

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