



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

July 18, 2024

Model code/Part number:

550B / 7L0081-7023

Customer:

TRQSS

Car Model:

TOYOTA-HIGHLANDER

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

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PARTS:

2

1. Assy Part; Black VM tube(Sunprene) $\phi 5$ L=130 \pm 3mm; Black Tape [1pc.]

JIG:

n/a

NO.

PROCESS NAME

2

WORK PROCEDURE/ ILLUSTRATION

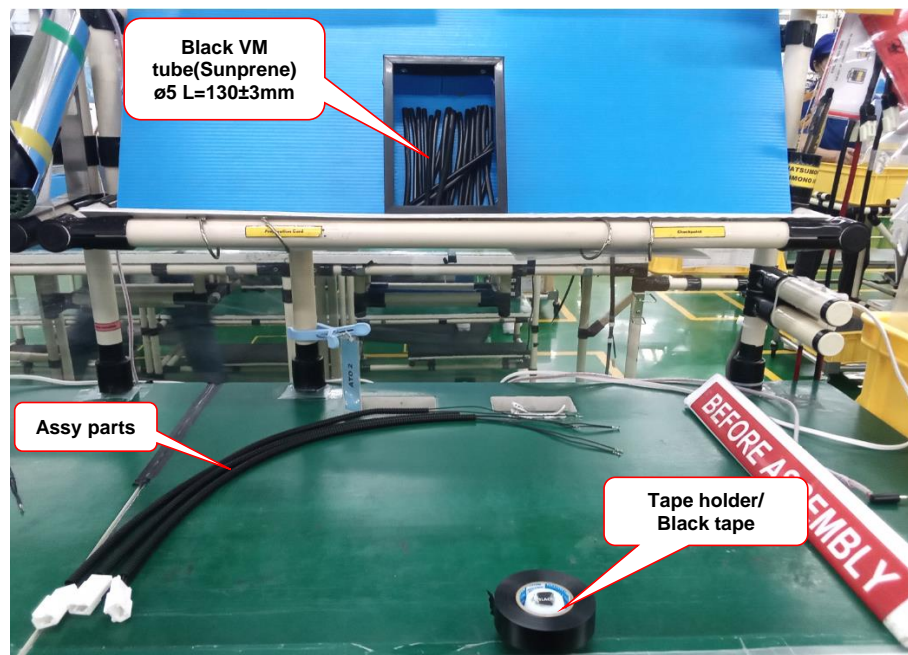
TOOLS/PPE

QUALITY POINTERS

1

P1

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.

- 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
07/18/24	2	Split type process. Transfer Clamp process to Clamp Assembly Process. Improve measurement and visual inspection/quality pointers	A.Hernandez	C. Villanueva	A. Arañes	n/a				
02/11/23	1	Work instruction improvement: Change MP from 2MP to 1MP. Update table lay-out and include batching. Change term Black sunprene tube to VM tube (Sunprene). Inclusion of Quality check point (Page 9).	D.Castillo	J. Loterte	C. Villanueva	A. Arañes	A.Hernandez	C. Villanueva	A. Arañes	n/a
02/14/22	0	Initial Issue.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				

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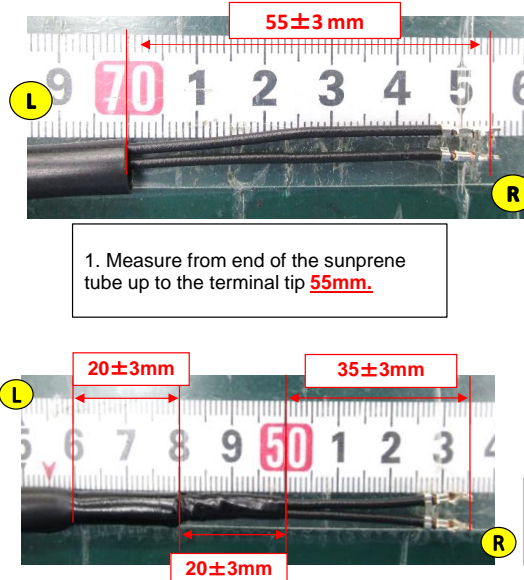

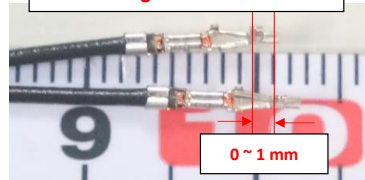
WI-ENG-PDE-408

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PARTS:		1. Pre-assy parts from Kitting 2. Black sunprene tube $\phi 5$ L=130 \pm 3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Black VM tube(Sunprene) $\phi 5$ L=130 \pm 3mm	 <div>1. Get the Black sunprene tube $\phi 5$ L=130\pm3mm using right hand then insert the B-B wires using left hand.</div>		n/a	1. No wrong use of parts 2. No deformed terminal
3	Taping 1 Black VM tube(Sunprene) to wire near terminal	 <div>1. Measure from end of the sunprene tube up to the terminal tip <u>55mm</u>.</div> <div>2. Hold the sunprene tube using left hand, get the Black tape then start taping using right hand.</div> <div>3. After taping, check the condition of tape, measurement and wire alignment.</div>		 <div>MEASURING TAPE</div>	 <div>Wire alignment tolerance 0 ~ 1 mm</div> <div>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</div> <div>Important reminders/note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</div>

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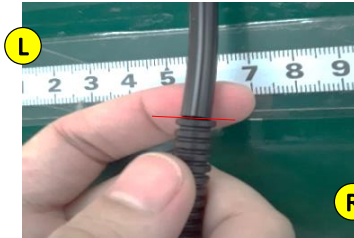

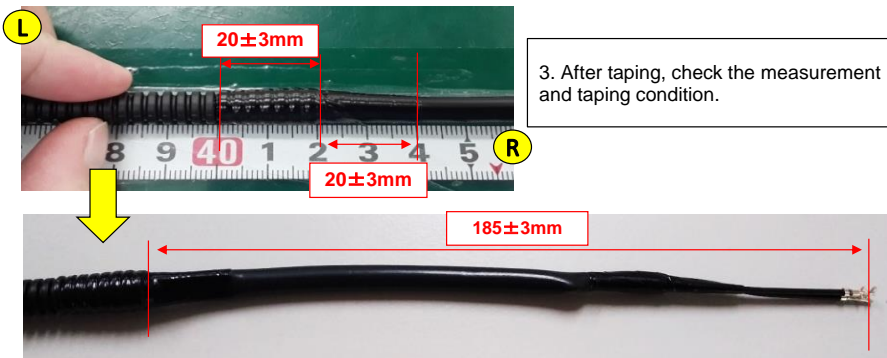

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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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 Taping 2 Black Corrugated tube to Black Sunprene tube	 <p>1. Fix the corrugated tube and sunprene tube using both hands.</p>  <p>2. Hold the COT and sunprene tube using left hand, get the Black tape then start taping process using both hands.</p>  <p>3. After taping, check the measurement and taping condition.</p>			<p>Important reminders/note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</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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PARTS:

1. Assy parts
2. Black tape

JIG:

n/a

NO.**PROCESS NAME****2****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****2****QUALITY POINTERS**

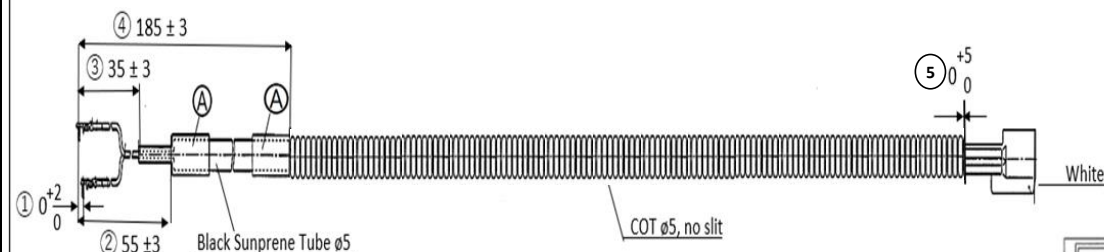
5

P1

Measurement

2

Illustration

**NOTE:**

Ⓐ - Taping (B)

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

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

2. For Hatsumono, Nakamono and Owarimono.

Document reference/s:

1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection.

1. No wrong dimension

WIRE TYPE TABLE

	Color	Wire type
1	B	AVSS 0.3f
2	B	AVSS 0.3f

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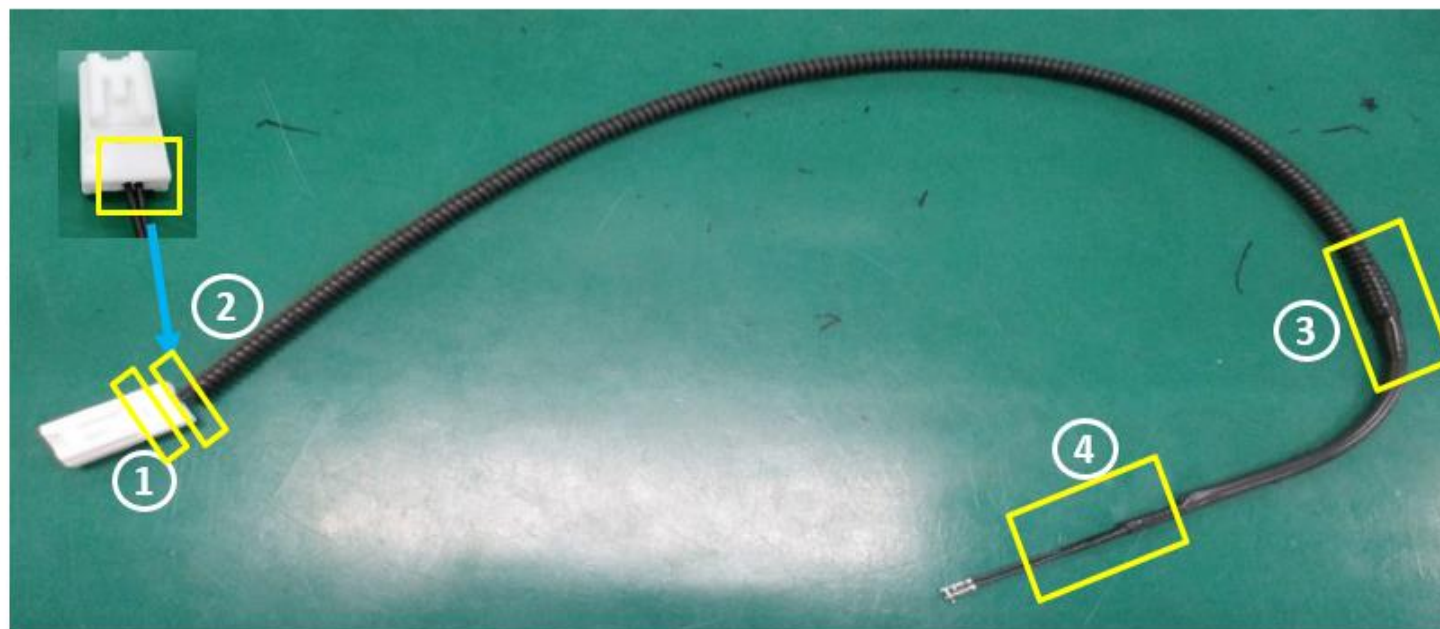
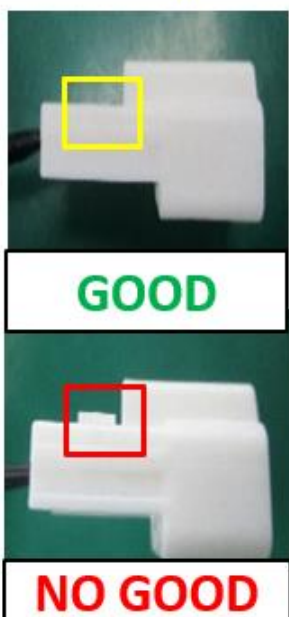
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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**P1****7L0081-7023****① No UNLOCKED/HALF LOCKED CONNECTOR****③ ④ No Missing Tape****② No Wrong Insert****⑤ No Terminal Backing Out**

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