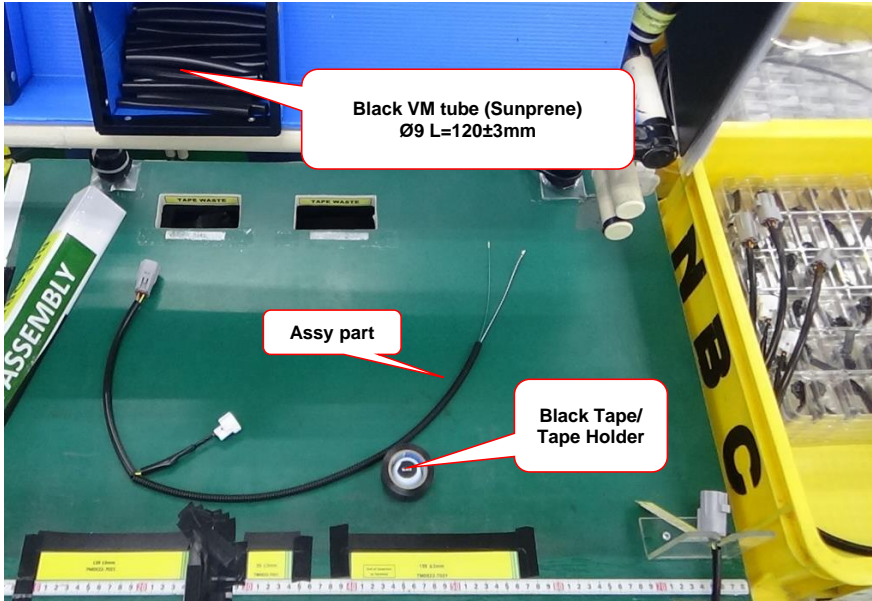
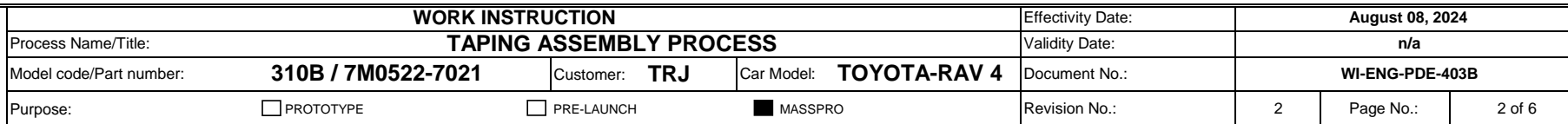
	WORK INSTRUCTION				Effectivity Date: August 08, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date: n/a	
	Model code/Part number: 310B / 7M0522-7021		Customer: TRJ	Car Model: TOYOTA-RAV 4	Document No.: WI-ENG-PDE-403B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: 2		Page No.:	1 of 6

PARTS: 1.Assy part; Black VM tube (Sunprene) Ø9 L=120±3mm ; Black Tape		JIG: n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
1	P2 Table lay-out	<div style="text-align: center;"> <p>Table Lay-out</p>  </div>	<div style="border: 1px solid red; padding: 5px; margin-bottom: 5px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 5px;"> 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	Reviewed by	Approved by	Noted by
08/08/24	2	Transfer Taping 2 process from P1 due to process improvement. Inclusion of car model "TOYOTA-RAV 4" and Measurement. Improved Table lay-out and Visual inspection/Quality checkpoints.				D.Castillo	C.Villanueva	A. Arañes	N/A
05/12/23	1	Inclusion of quality checkpoints; Improve the Important reminders/note/s and document references; standardize VM tube (sunprene) term.				J.Loterte	C.Villanueva	A. Arañes	N/A
02/19/22	0	Initial issue.				K.Doria	J.Loterte	C.Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted
						Est. Date:	February 19, 2022		

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310B / 7M0522-7021

Customer:

TRJ

Car Model:

TOYOTA-RAV 4

Document No.:

WI-ENG-PDE-403B

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☐ PROTOTYPE

☐ PRE-LAUNCH

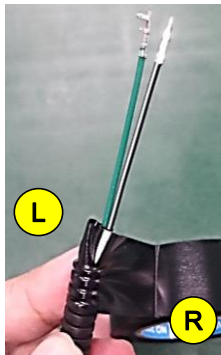
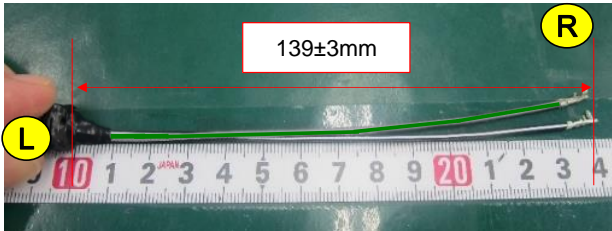
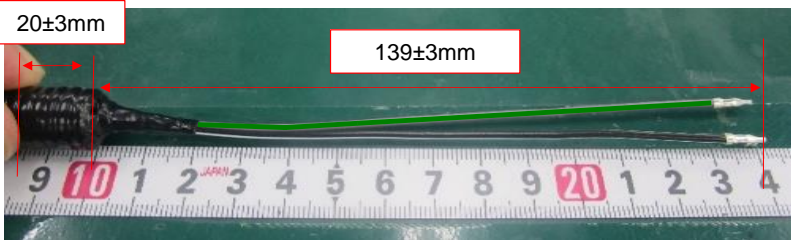

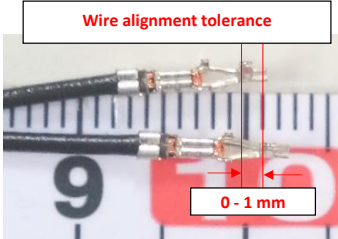
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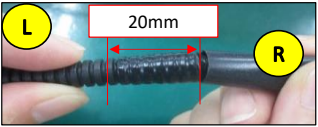

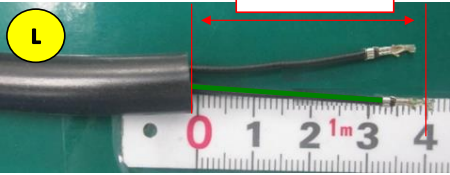



PARTS:	1. Assy parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 Taping 2 COT to wire near terminal	<div data-bbox="568 435 788 791"></div> <div data-bbox="568 804 788 935"><p>1. Get Black tape, hold corrugated tube using left hand then start pre-taping.</p></div> <div data-bbox="837 480 1447 855"><p>2. Measure the end of the corrugated tube up to the tip of terminal 139±3mm. Then continue taping using right hand.</p></div> <div data-bbox="618 995 1406 1235"></div> <div data-bbox="640 1251 1379 1321"><p>3. After taping, check the dimension, taping condition and wire alignment.</p></div>	<div data-bbox="1503 719 1704 799"><p>Measuring tape</p></div> <div data-bbox="1496 820 1711 916"></div>	<div data-bbox="1749 544 2085 783"></div> <div data-bbox="1727 852 1921 986"><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 data-bbox="1760 1027 2069 1050"><p>Important reminders and Note/s:</p></div> <div data-bbox="1760 1050 2069 1114"><p>1. Please use calibrated/verified measuring tape when getting the measurement.</p></div> <div data-bbox="1760 1139 1975 1161"><p>Document reference/s:</p></div> <div data-bbox="1760 1161 2056 1206"><p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p></div>

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	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 310B / 7M0522-7021		Customer: TRJ	Car Model: TOYOTA-RAV 4	Document No.:	WI-ENG-PDE-403B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.:	4 of 6


PARTS:	1. Assy parts 2. Black VM tube (Sunprene) Ø9 L=120±3mm 3. Black Tape			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Wire insertion to Black VM tube (Sunprene) Ø9 L=120±3mm	<div><p>1. Hold the Black wires using left hand and insert the Black VM tube (Sunprene) Ø9 L=120±3mm using right hand.</p></div> <div><p>2. Insert the Sunprene tube to COT 20mm (Tape width).</p></div> <div></div>		n/a	1. No wrong use of parts
5	P2 Taping 3 Corrugated tube to VM tube (Sunprene)	<div><p>1. Hold the COT using left hand and measure the end of Sunprene tube up to the terminal tip 39±3mm.</p></div> <div><p>2. Hold the sunprene tube using left hand then start taping using right hand.</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>		<div>Measuring tape</div> 	<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. Please refer to WI-PRO-ASY-001 for taping procedure</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>


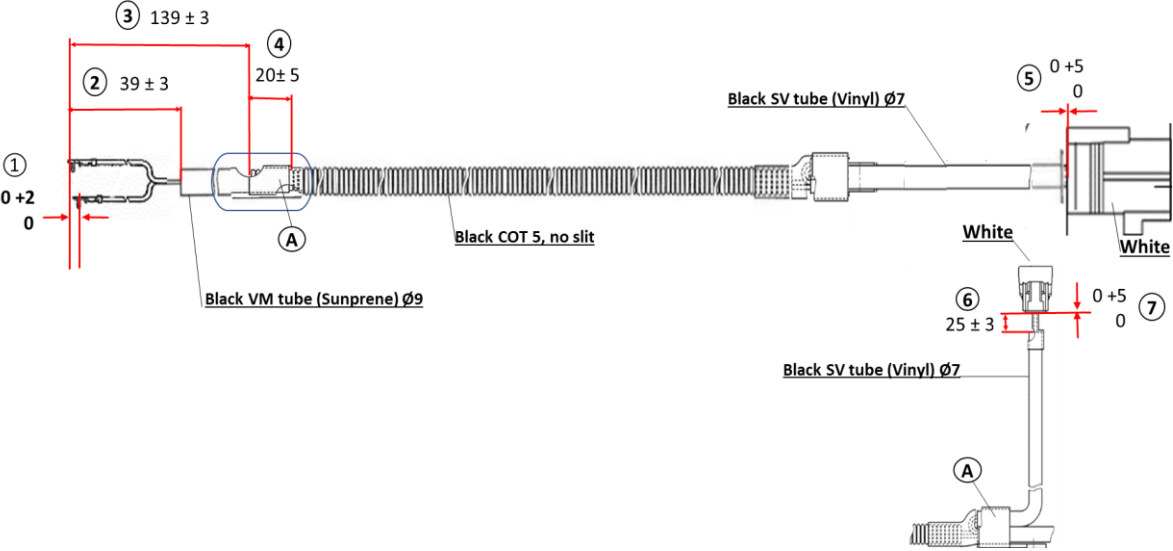
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	Model code/Part number: 310B / 7M0522-7021		Customer: TRJ	Car Model: TOYOTA-RAV 4	Document No.: WI-ENG-PDE-403B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	2	Page No.:	5 of 6

PARTS:	1. Assy parts			JIG:	n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
6	P2	Measurement	<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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☐ PRE-LAUNCH

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PARTS:

1. Assy parts

JIG:

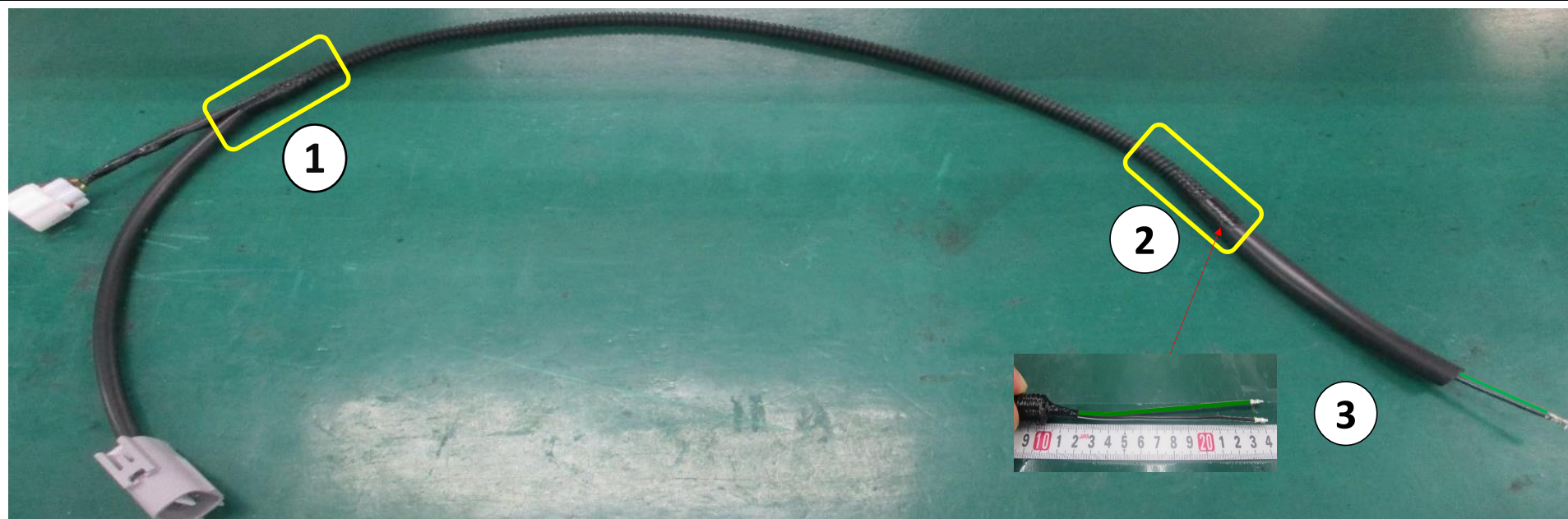
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VISUAL INSPECTION/ QUALITY CHECKPOINTS

P2

7M0522-7021



1 2 3 No Missing Tape(Black Tape)

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