



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 27, 2024

Validity Date:

n/a

Model code/Part number:

311D

/

7N0195-7020Ea

Customer: TRJ

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-919B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

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PARTS:

1. Assy parts

2. Black Corrugated tube (with slit) Ø5 L=164±3mm

3. Black tape

JIG:

n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Table lay-out	<div><div>TABLE LAY-OUT</div><div>Black Corrugated tube (with slit) Ø5 L=164±3mm</div><div>Assy parts</div><div>Tape holder/Black tape</div><div>COT Adaptor</div></div>	<div><div>Safety Instruction</div><div>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div></div> <div><div>Housekeeping</div><div>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div></div> <div><div>Alert level</div><div>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>	1. No missing part/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
6/27/24	0	Initial issue.	M. Ariola	C. Villanueva	A. Arañes	n/a	M. Ariola	C. Villanueva	A. Arañes	n/a
Est. Date:							June 27, 2024			

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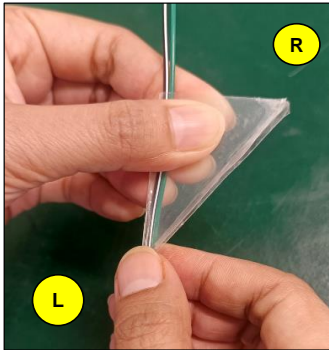
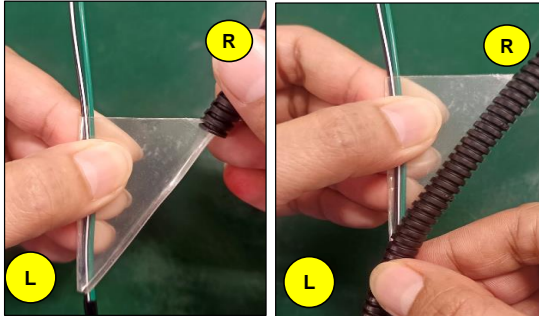

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PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Wire insertion to Black Corrugated tube (with slit) Ø5 L=164±3mm	<div><div>1. Hold the COT Adaptor using left hand. Insert the wires using right hand.</div></div> <div><div>2. Hold the COT Adaptor with wires using left hand , get the Black Corrugated tube (w/ slit) Ø5 L=164±3mm using right hand then insert to COT adaptor. Hold the COT adaptor and push the COT (same timing) using both hands. Make sure all wires are inserted.</div></div>		<div>COT Adaptor</div> 	<div>Important reminders/Notes</div> <div>1. Please use calibrated/verified measuring tape when fetting the measurement.</div> <div>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape</div>

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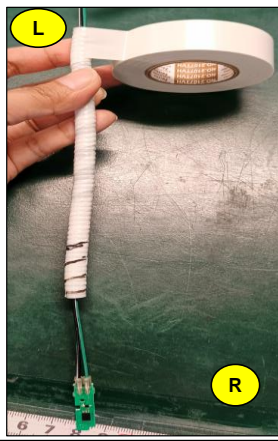
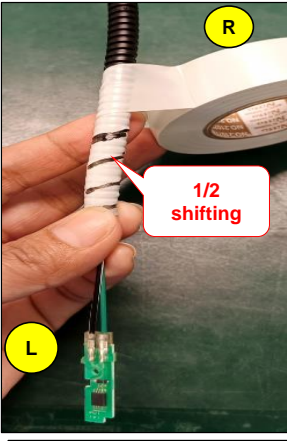
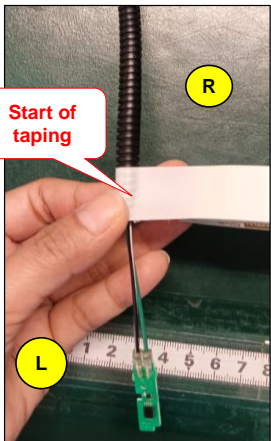
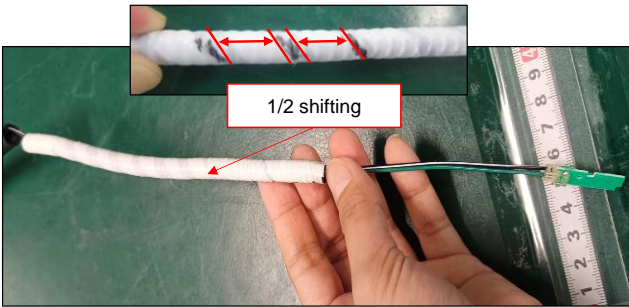

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 Half-wrap Taping	<div><p>1. Hold the corrugated tube (w/slit) using left hand. Get the black tape using right hand. Conduct 2 windings of tape before shifting using both hands.</p><p>2. Make 1/2 shifting. Repeat the process until the end of corrugated tube. Make 3 windings of tape then cut the tape.</p><p>3. Check the taping condition.</p></div>		<div>MEASURING TAPE</div> 	<p>Important reminders/Notes</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. Used WHITE TAPE to easily visualize the tape shifting, but actual should be BLACK TAPE.</p> <p>3. Internal tolerance for halfwrap taping shifting should be 0~14mm only.</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</p>

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PROTOTYPE



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2. Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

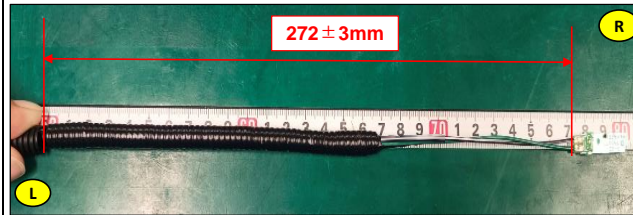
TOOLS/PPE

QUALITY POINTERS

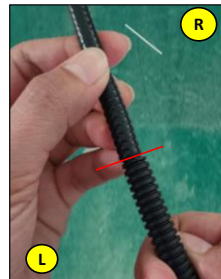
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P2

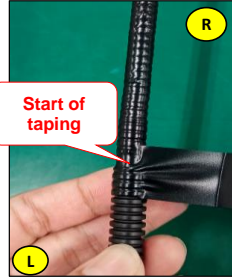
Taping 2
Black Corrugated tube (No slit)
to Corrugated tube (w/
slit)



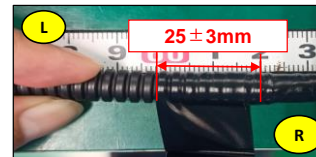
1. Measure from end of the Corrugated tube (No slit) up to end of hotmelted wire **272mm** using both hands.



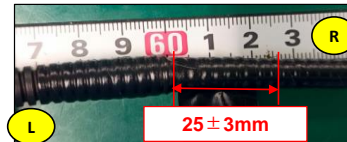
2. Fix the **Corrugated tube (No slit)** and the **Corrugated tube (w/slit)** using both hands.



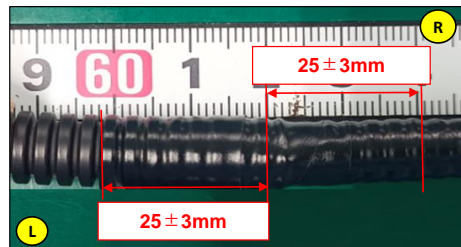
3. Get the black tape and start taping process using both hands.



4. Measure from end of tape up to end of Corrugated tube (No slit) **25±3mm**.



5. Measure from end of Corrugated tube (No slit) to end of tape **25±3mm**.



6. After taping, check the measurement and taping condition.

MEASURING TAPE



Important reminders/Notes

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

1. No peel-off tape
2. No flip out tape
3. No loose tape
4. No wrong use of tape
5. No wrong dimension
6. No missing tape

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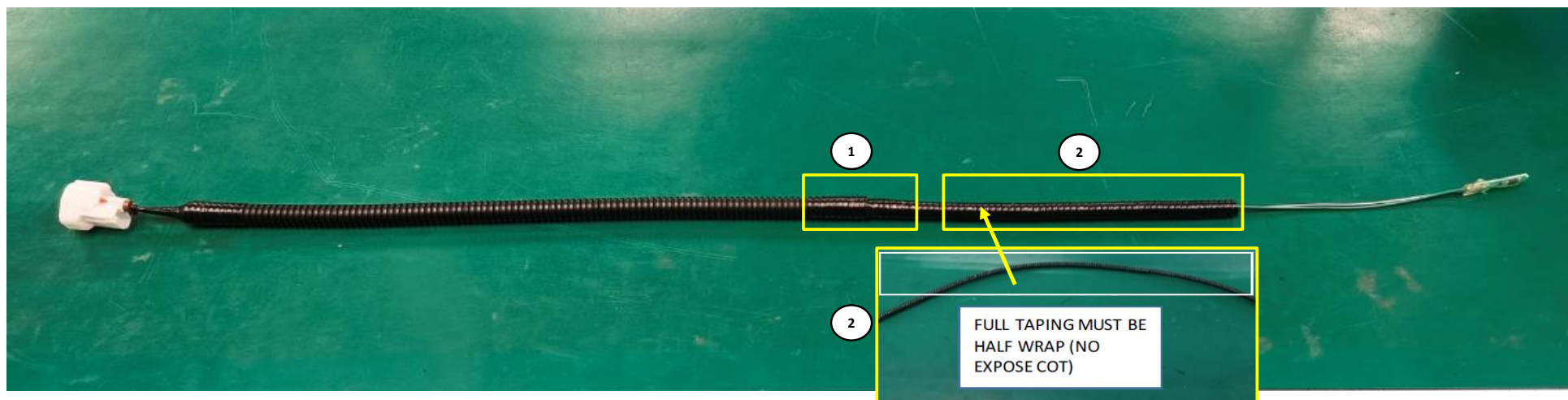
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PARTS:

n/a

JIG:

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QUALITY CHECKPOINTS**P2****7N0195-7020Ea**

1

No MISSING TAPE

2

No EXPOSED COT

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