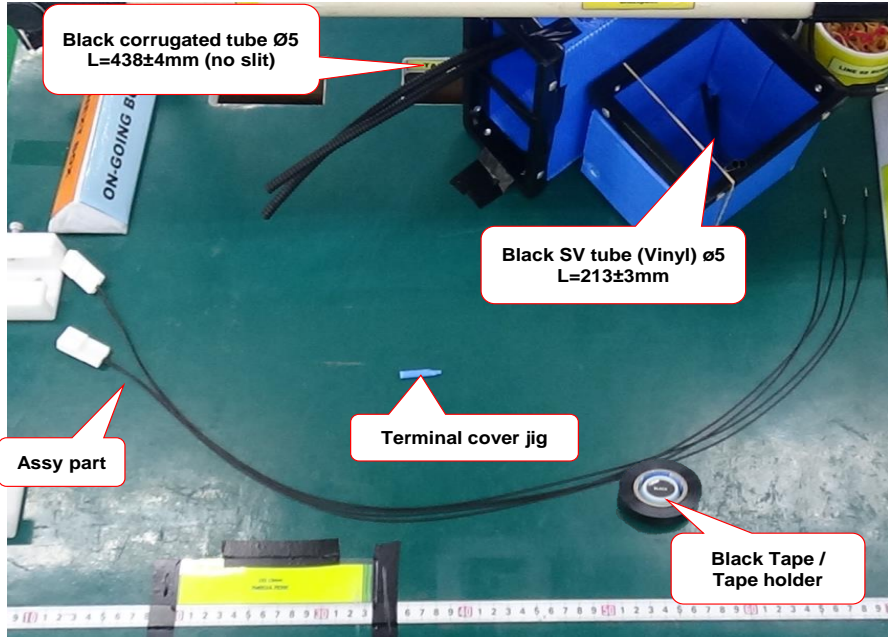







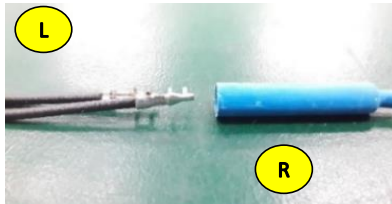

	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>December 05, 2024</b>			
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a			
	Process Name/Title:		Model code/Part number: <b>310B / 7M0524-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-RAV 4</b>	Document No.:	<b>WI-ENG-PDE-163A</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	9	Page No.:	1 of 4

PARTS:		1. Assy parts; Black SV tube (Vinyl) ø5 L=213±3mm; Black corrugated tube Ø5 L=438±4mm (no slit); Black Tape			JIG:	1. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
1	P1	<div> <div>TABLE LAY-OUT</div>  </div>			<div> <div>Safety Instruction</div> <div>Be sure to wear required 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>	<div> <div>Document references:</div> <div>1. Refer to WI-ENG-PDE-167 for Offline assembly process</div> </div> <div> <div>1. No missing parts/tools</div> <div>2. No excess parts/tool</div> </div>	

Revision History								Prepared by	Reviewed by	Approved by	Noted by
12/05/24	9	Transfer Wire insertion to SV tube (Vinyl) and Black Corrugated tube from Offline assembly process. Transfer Taping 2 COT to SV tube taping to P2. Update Table lay-out and Visual inspection/ Quality checkpoint. Additional Quality pointers "No insufficient tape" and add document references (Page 3) as countermeasure to customer claim.	D.Castillo	C.Villanueva	A. Arañes	n/a					
07/28/23	8	Update Table lay-out. Transfer process of Wire insertion to COT From P1 to OFFLINE ASSEMBLY PROCESS; Transfer Taping process of Wire insertion to VM tube (Sunprene) and Taping process of COT to VM tube (Sunprene) from P1 to P2 due to new process distribution.	M Ariola	J. Loterte	C. Villanueva	A. Arañes					
04/28/23	7	Inclusion of Quality checkpoints.	M Ariola	J. Loterte	C. Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 17, 2018			


	<b>WORK INSTRUCTION</b>				Effectivity Date:	December 05, 2024			
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	Process Name/Title:		Model code/Part number: <b>310B / 7M0524-7020C</b>	Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-RAV 4</b>	Document No.:	WI-ENG-PDE-163A		
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	9	Page No.:	2 of 4

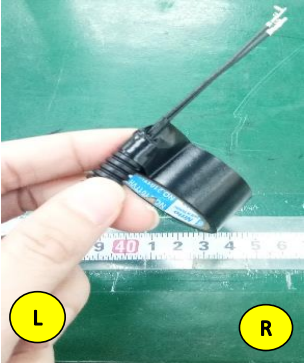
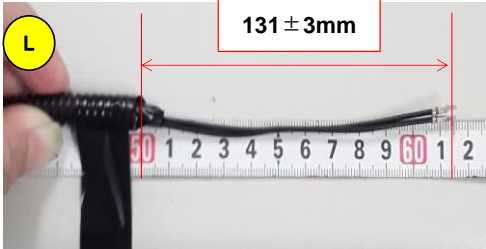
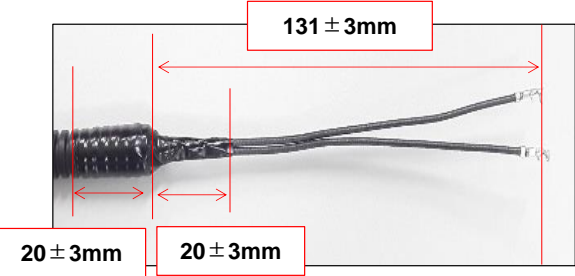

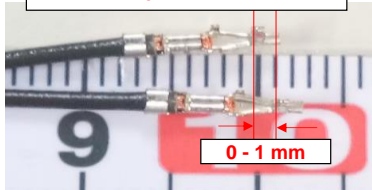
  

<b>PARTS:</b>	1. Assy parts 2. Black SV tube (Vinyl) Ø5 L=213±3mm 3. Black corrugated tube Ø5 L=438±4mm (no slit)				JIG:	1. Terminal cover jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
2	9 Wire insertion to SV tube (Vinyl) Ø5 L=213±3mm	 <div>         1. Hold the SV tube (Vinyl) Ø5 L=213±3mm using left hand. Get 2 Black wires and insert to SV tube (Vinyl) using right hand.       </div>		n/a	1. No wrong use of parts 2. No deformed terminal.	
3	P1 Wire Insertion to Black Corrugated tube (no slit) Ø5 L=438±4mm	<div>  <div>1. Get the terminal cover jig using right hand then insert the 2 Black wires.</div> </div> <div>  <div>2. Get the Black corrugated tube Ø5 L=438±4mm (no slit) using right hand and insert the 2 Black wires.</div> </div> <div>  <div>3. After insertion, remove the terminal cover jig using right hand.</div> </div>		<div> <b>TERMINAL COVER JIG</b> </div> 	1. No wrong use of parts 2. No deformed terminal.	

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	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>December 05, 2024</b>		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>310B / 7M0524-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-RAV 4</b>	Document No.: <b>WI-ENG-PDE-163A</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	9	Page No.:	3 of 4

<b>PARTS:</b>		1. Assy part 2. Black tape		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
4	P1 Taping 1 Corrugated tube to wire near Connector	<div></div> <div></div> <div></div> <div><p>1. Hold the COT using left hand, get <b>Black tape</b> using right hand and start pre-taping between COT and wire.</p><p>2. Hold the corrugated tube using left hand and measure from end of COT to terminal pointed tip <b>131mm</b> and proceed to taping process.</p><p>3. After taping, check the measurement and taping condition.</p></div>	<div><b>MEASURING TAPE</b></div> 	<div><div>9</div><div>1. No flip-out tape 2.No peel-off tape 3. No loose tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape 7. No insufficient tape</div></div> <div><b>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></div> <div><b>Document references:</b> <b>1. Refer to WI-PRO-ASY-001A for Taping process</b></div> <div><div>Wire alignment tolerance</div></div>	

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**December 05, 2024**

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**310B / 7M0524-7020C**Customer: **TRJ**Car Model: **TOYOTA-RAV 4**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-163A**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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**9**

Page No.:

**4 of 4****PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P1****7M0524-7020C****① No Missing SV tube (Vinyl)****② No Missing Tape**

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