



## WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

September 12, 2024

Model code/Part number:

320B / 7L0054-7025A

Customer:

TRQSS

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-1038A

Purpose:

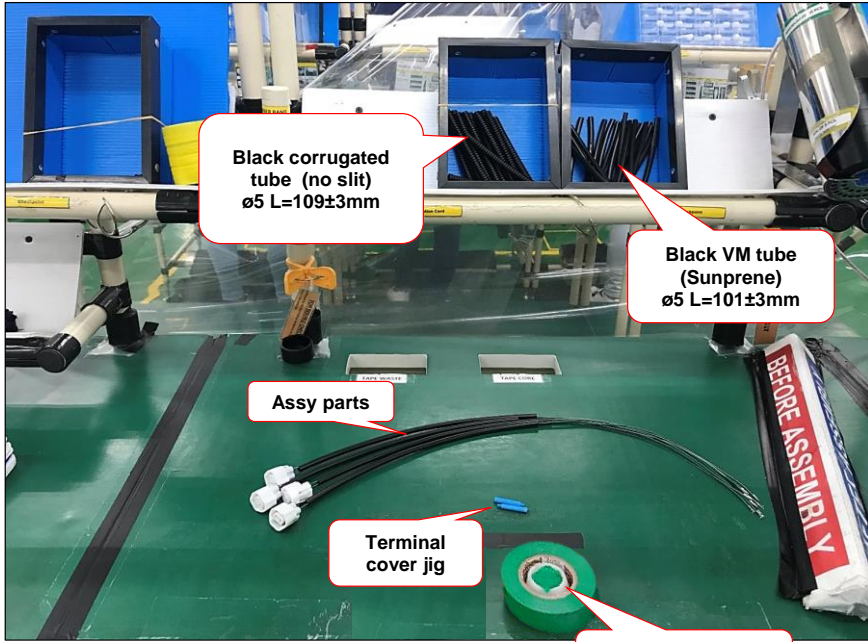
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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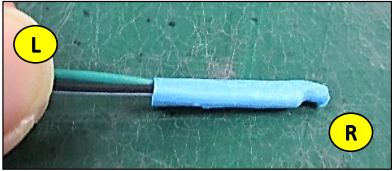



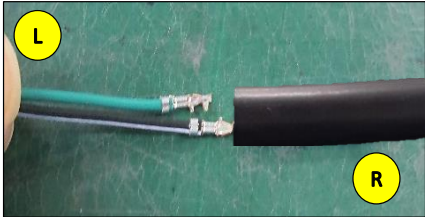
PARTS:		1. Assy parts; Black corrugated tube (no slit) $\phi 5$ L=109 $\pm$ 3mm; Black VM tube (Sunprene) $\phi 5$ L=101 $\pm$ 3mm; Green tape				JIG:		1. Terminal Cover jig					
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS				
1	P1	Table lay-out	<div><div>TABLE LAY-OUT</div></div>				<div><div><b>Safety Instruction</b></div><div>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div></div> <div><div><b>Housekeeping</b></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><b>Alert level</b></div><div>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>		<div><b>Document reference/s:</b> 1. Refer to WI-ENG-PDE-1037 for Offline assembly process</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>				
Revision History						Prepared by		Reviewed by		Approved by		Noted by	
09/12/24	1	Change from Pre-launch to Masspro.				D.Castillo	C. Villanueva	A. Arañes	n/a				
09/10/24	0	Initial issue. Improvement of visual inspection and quality checkpoints.				D.Castillo	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	September 10, 2024		

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		1	Page No.: 2 of 4

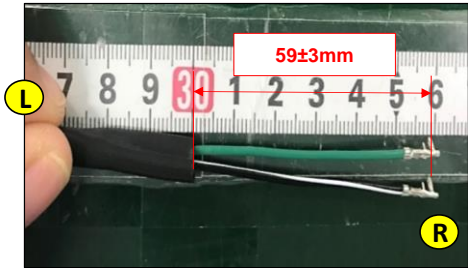
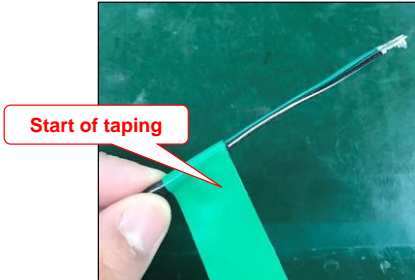
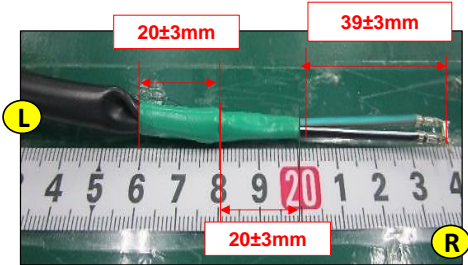

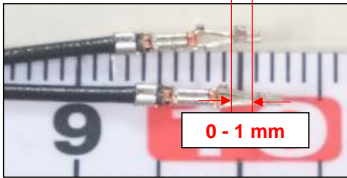
<b>PARTS:</b>		1. Assy parts 2. Black corrugated tube (no slit) ø5 L=109±3mm 3. Black VM tube (Sunprene) ø5 L=101±3mm		JIG:	1. Terminal cover jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	P1	<div><div>1. Get the terminal cover jig using right hand then insert the <b>G-B/W wires</b> using left hand.</div><div>2. Get the Black corrugated tube (<b>no slit</b>) ø5 L=109±3mm using right hand then insert the <b>G-B/W wires</b> using left hand.</div><div>3. After insertion, remove the terminal cover jig using right hand.</div></div> <td><div><b>TERMINAL COVER JIG</b></div></td> <td>1. No wrong usage of parts 2. No deformed terminal</td>		<div><b>TERMINAL COVER JIG</b></div> 	1. No wrong usage of parts 2. No deformed terminal
3		Wire insertion to Black VM tube (Sunprene) ø5 L=101±3mm	<div><div>1. Get the <b>Black VM tube (Sunprene) ø5 L=101±3mm</b> using right hand then insert the <b>G-B/W wires</b> using left hand.</div></div>	n/a	1. No wrong usage of parts 2. No deformed terminal

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	3 of 4

<b>PARTS:</b>		1. Assy parts 2. Green 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 Black VM tube (Sunprene) to Wire near terminal	<div><p>59±3mm</p></div> <div><p>Start of taping</p></div> <div><p>20±3mm 39±3mm 20±3mm</p></div>	<div><p><b>MEASURING TAPE</b></p></div> <div><p><b>Wire alignment tolerance</b></p></div>	<p><b>Important reminders/Note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. Please 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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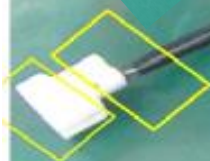
Page No.:

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

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/QUALITY CHECKPOINTS****TAPING - P1****7L0054-7025A****2****3****1****No Unlocked/Half-locked connector****3****No Missing Tape****2****No Wrong Insert****4****No Wrong use of tape (Green)****No Terminal backing out**

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