

	WORK INSTRUCTION				Effectivity Date:		January 22, 2025	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 311D / 7L0155-7023		Customer: TRQSS		Car Model: TOYOTA RAV4	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.: WI-ENG-PDE-1054B		Revision No.: 1		Page No.: 1 of 5	

PARTS:		1. Assy parts; Black VM tube (Sunprene) ø9, L=97±3mm ; Black tape				JIG:		n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	P2	<div style="text-align: center; border: 1px solid red; padding: 5px; margin-bottom: 10px;">Table Lay-out</div>				<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> 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>		Important reminders/Note/s: 1. Refer to WI-ENG-PDE-675 for Offline assembly process 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 1. No missing parts/tools 2. No excess parts/tools	

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
											n/a				
01/22/25	1	Additional Quality pointers "No insufficient tape" and add document references (Page 2-3) as countermeasure to customer claim.	D. Castillo	C. Villanueva	A. Arañes	n/a									
10/03/24	0	Initial issue.	A. Hernandez	C. Villanueva	A. Arañes	n/a									
Eff. Date	Rev. No	Details of Change					Revised	Reviewed	Approved	Noted	Est. Date:	October 03, 2024			

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PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1. Assy parts
2. Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

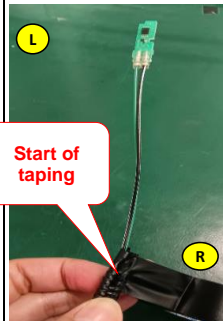
TOOLS/PPE

QUALITY POINTERS

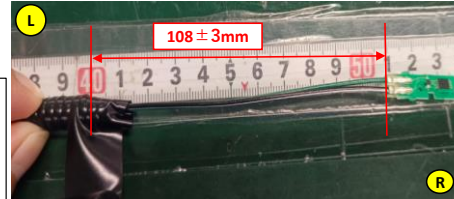
2

P2

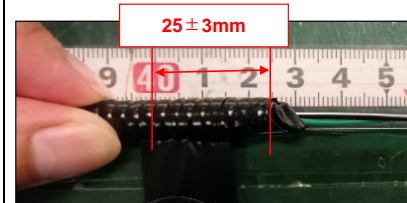
Taping 1
Black Corrugated tube to
Wire near PCB



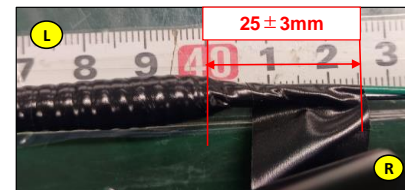
1. Get the **Black tape** using right hand then start taping process using both hand.



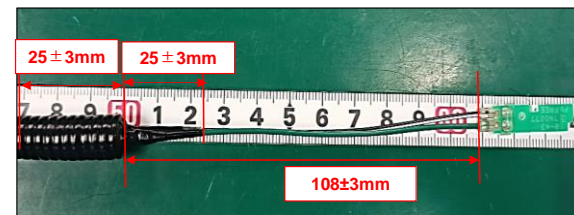
2. Measure from end of COT up to Hotmelted wires **L=108±3mm** then continue the taping process using both hands.



3. Confirm measurement from end of tape up to end of COT **25±3mm** then continue the taping process using both hands.



4. Confirm measurement from end of COT up to end of tape **25±3mm** then continue the taping process using both hands.



5. After taping, check the measurement, wire alignment and taping condition.

MEASURING TAPE



1

Important reminders/Note/s:
1. Please use calibrated/verified measuring tape when getting the measurement.

Document references:

1. Refer to WI-PRO-ASY-001A for Taping process

1

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

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PROTOTYPE



PRE-LAUNCH




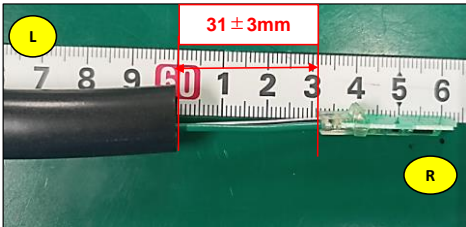
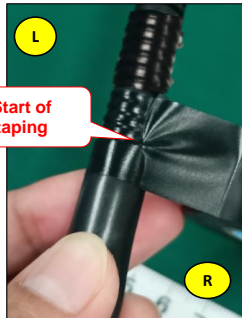


MASSPRO

Revision No.:

1

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PARTS:		1. Black VM tube (Sunprene) $\varnothing 9$, L=97 \pm 3mm 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3		Wire insertion to Black VM tube (Sunprene) $\varnothing 9$, L=97 \pm 3mm	 <p>1. Get the Black VM tube (Sunprene) $\varnothing 9$, L=97\pm3mm using right hand then insert the hotmelted wires (B/W-G) using left hand.</p>	n/a	1. No wrong use of parts.
4	P2 Taping 2 Black Corrugated tube to VM tube (Sunprene)	 <p>1. Measure the end of VM tube (Sunprene) up to hotmelted wires L=31\pm3mm.</p>  <p>2. Hold the VM tube (Sunprene) using left hand, get the Black tape then start taping using right hand.</p>  <p>3. After taping, check the measurement and taping condition.</p>		 <p>MEASURING TAPE</p>	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document references:</p> <p>1. Refer to WI-PRO-ASY-001B for Taping process</p> <p>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</p>

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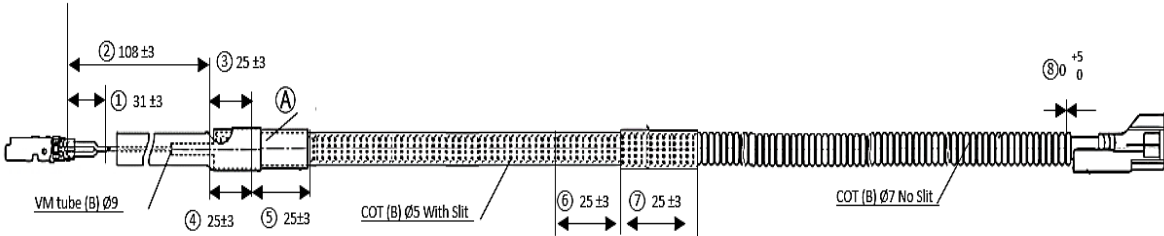
WI-ENG-PDE-1054B

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1

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2	Measurement	<div><p>② 108 ±3 ① 31 ±3 ③ 25 ±3 ④ 25 ±3 ⑤ 25 ±3 ⑥ 25 ±3 ⑦ 25 ±3 ⑧ $\begin{smallmatrix} +5 \\ 0 \end{smallmatrix}$</p><p>VM tube (B) Ø9 COT (B) Ø5 With Slit COT (B) Ø7 No Slit</p><p>Half Wrap</p><p>NOTE: Ⓐ - Taping (B) Ⓑ - Clamp (B) ③ - Dimension overlapped COT & sunprene tube</p><p><i>*Unit of dimension is in millimeter (mm)</i></p></div>	<p>1. No wrong dimension</p> <p>Important reminders/Notes</p> <p>1. Please use calibrated/verified measuring tape when fetting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono</p> <p>Document reference/s:</p> <p>1. Please refer to WI-PRO-ASY-056 for Sub-Assy Hatsumono, Nakamono and Owarimono inspection.</p>

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WI-ENG-PDE-1054BPurpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

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1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P2****7L0155-7023**

① ② **No Missing TAPE** ③ **No Missing VM tube (Sunprene)**

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