



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

September 10, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

311D

/

7L0154-7022

Customer: TRJ

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-942A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

1 of 5

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

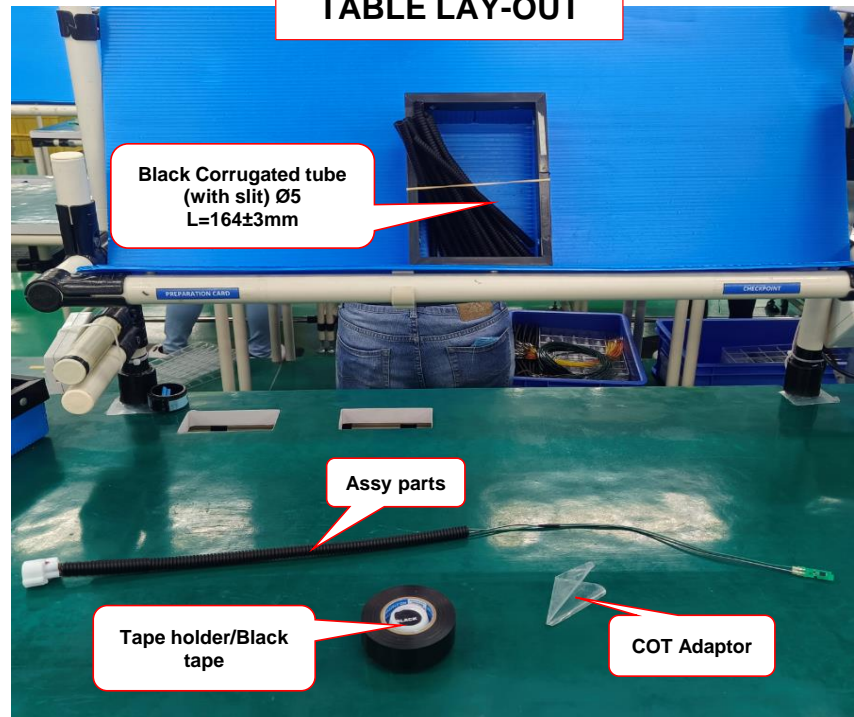
TOOLS/PPE

QUALITY POINTERS

1

P1

Table lay-out

**Safety Instruction**

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

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
09/10/24	1	Change purpose from Pre-launch to Masspro. Additional Table lay-out and Inclusion of Visual inspection/Quality Checkpoints.	M. Ariola	C. Villanueva	A. Arañes	n/a				
06/27/24	0	Initial issue. Change COT length (No slit) Ø5 L=510±3mm to Ø5 L=346±3mm; Additional COT length (w/slit) Ø5 L=510±3mm	M. Ariola	C. Villanueva	A. Arañes	n/a	M. Ariola	C. Villanueva	A. Arañes	n/a

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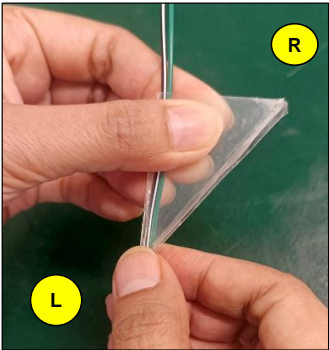
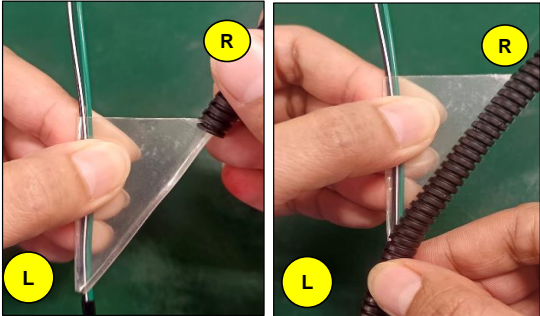

WI-ENG-PDE-942A

Revision No.:

1

Page No.:

2 of 5

PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1 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> 	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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3 of 5

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2. Black tape

JIG:

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PROCESS NAME

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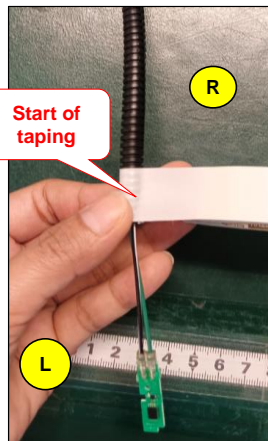
TOOLS/PPE

QUALITY POINTERS

3

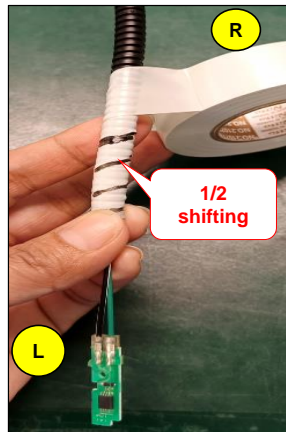
P1

Half-wrap Taping

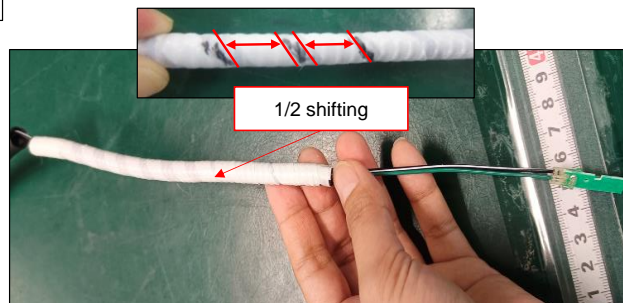


1. Hold the **corrugated tube (w/slit)** using left hand. Get the black tape using right hand. Conduct **2 windings** of tape before shifting using both hands.

3. Check the taping condition.



2. Make **1/2 shifting**. Repeat the process until the end of corrugated tube. Make **3 windings** of tape then cut the tape.



MEASURING TAPE



Important reminders/Notes

1. Please use calibrated/verified measuring tape when getting the measurement.
2. Used **WHITE TAPE** to easily visualize the tape shifting, but actual should be **BLACK TAPE**.
3. Internal tolerance for halfwrap taping shifting should be 0~14mm only.

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

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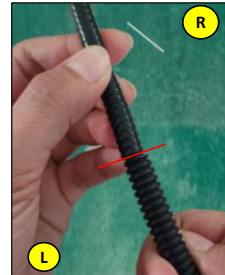

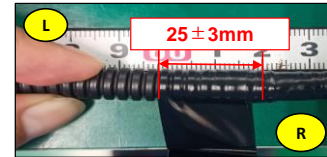
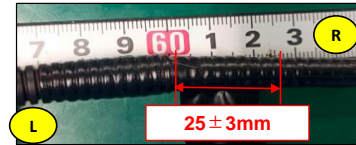
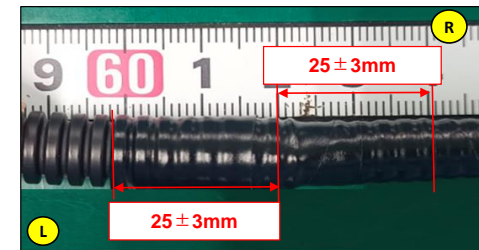

WI-ENG-PDE-942A

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Page No.:

4 of 5

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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	<p>Taping 2 Black Corrugated tube (No slit) to Corrugated tube (w/ slit)</p>  <p>1. Measure from end of the Corrugated tube (No slit) up to end of hotmelted wire 272mm using both hands.</p>  <p>2. Fix the Corrugated tube (No slit) and the Corrugated tube (w/slit) using both hands.</p>  <p>3. Get the black tape and start taping process using both hands.</p>  <p>4. Measure from end of tape up to end of Corrugated tube (No slit) 25±3mm.</p>  <p>5. Measure from end of Corrugated tube (No slit) to end of tape 25±3mm.</p>  <p>6. After taping, check the measurement and taping condition.</p>		<p>MEASURING TAPE</p> 	<p>Important reminders/Notes</p> <p>1. Please use calibrated/verified measuring tape when fetting the measurement.</p> <p>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</p>

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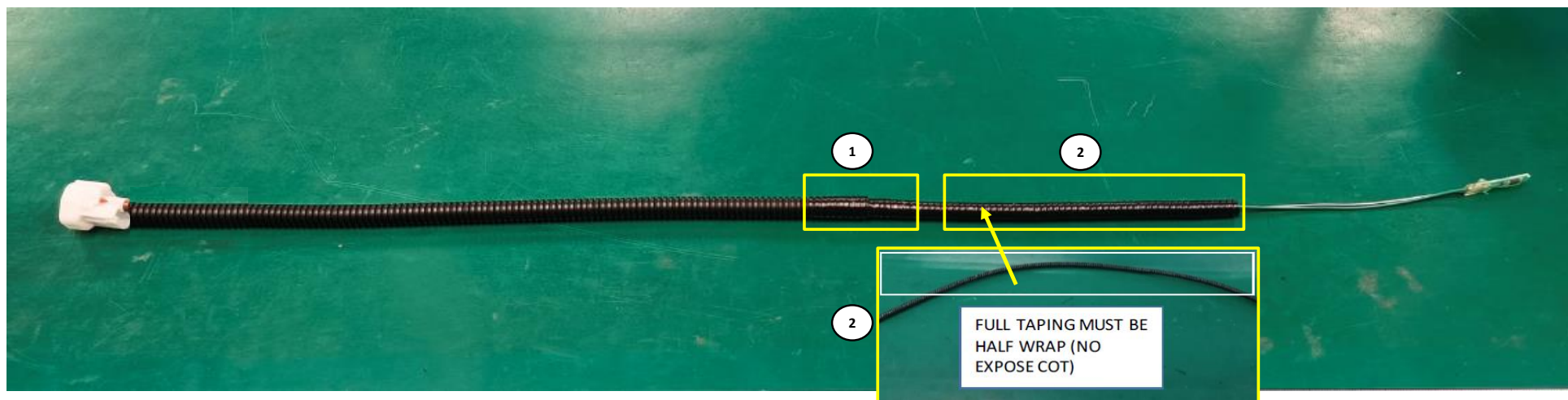
n/a



QUALITY CHECKPOINTS

P1

7L0154-7022



1

No MISSING TAPE

2

No EXPOSED COT

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