

**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Effectivity Date:

April 21, 2025

Process Name/Title:

Model code/Part number:

412D / 628128-0000B

Customer:

TRJ

Car Model:

TOYOTA-RAV 4

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1245

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

1 of 5

PARTS:

1. Assy parts; Black tape

JIG:

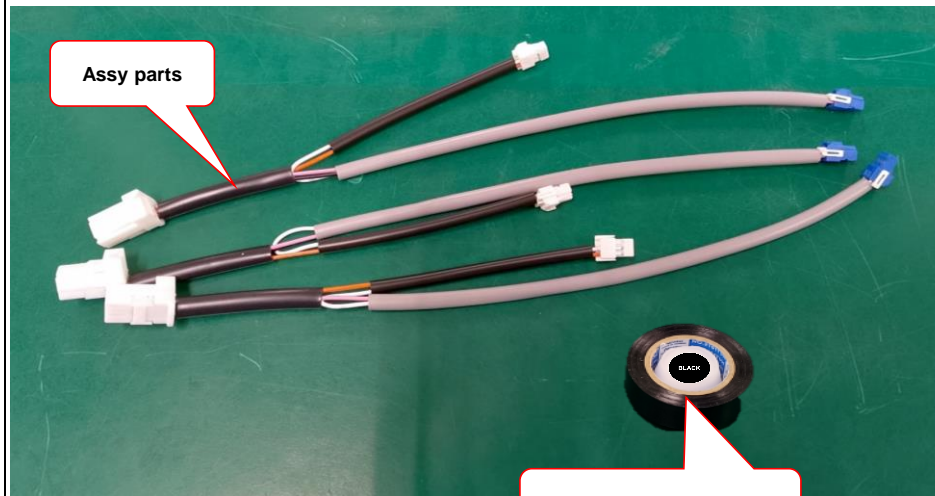
n/a

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

1

P2

Table Lay-out

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 parts/tools.
2. No excess parts/tools.


Revision History

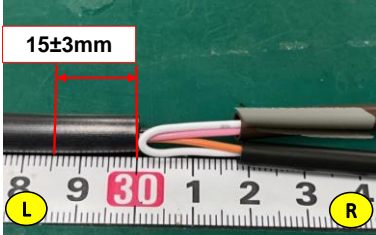
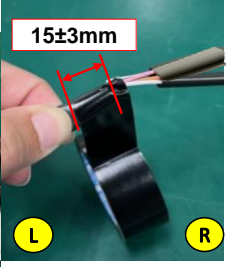
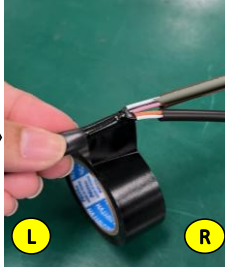
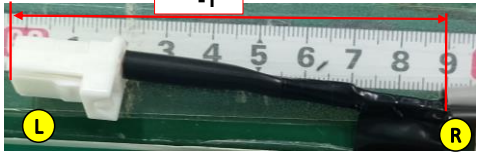
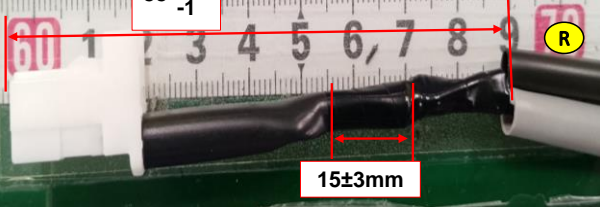


Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved	Est. Date:	Prepared by	Checked by	Approved by	Noted by
04/21/25	1	Change document purpose from pre-launch to mass pro.	A.Hernandez	J.Loterte	C. Villanueva	A.Arañes		A.Hernandez	J.Loterte	C. Villanueva	A.Arañes
04/16/25	0	Initial issue.	A.Hernandez	J.Loterte	C. Villanueva	A.Arañes					


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	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Process Name/Title:	Model code/Part number: 412D / 628128-0000B	Customer: TRJ	Car Model: TOYOTA-RAV 4	Document No.:	WI-ENG-PDE-1245	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	2 of 5

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 VM tube (Sunprene) to Wire	<div>    </div> <div> <p>1. Hold the assy parts using both hands. M Measure VM tube up to end of VM tube 15±3mm for taping.</p> <p>2. Measure from end of VM tube (Sunprene) up to end of tape (15±3mm) then continue the taping process.</p> </div> <div>   </div> <div> <p>3. Measure from end of Connector up to end of tape (88±5/-1) then continue the taping process.</p> <p>3. After taping, Check the measurement, wire alignment and taping condition.</p> </div>	<div>   </div>	<p>Important Reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p>	

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:




WI-ENG-PDE-1245

Revision No.:

1

Page No.:

3 of 5

PARTS:		1. Assy parts 2. Master sample		JIG:	n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
3	P2	Visual/By two's Inspection	<div>1. Check the connector lock. Locking of connector is included in Steering Electrical test.</div> <div>2. Check the wire alignment. Must be no tangled wires.</div> <div>3. Check the Terminal if with Backing out (Not fully inserted) or no deformed terminal.</div> <div><div>ACTUAL PRODUCT</div></div> <div><div>4. Check the presence and position of retainer (2 connectors).</div><div>4. Check the orientation of harness.</div><div>5. Compare to Master sample by tapping</div><div><div>ASSEMBLED PARTS</div><div>MASTER SAMPLE</div><div>MASTER SAMPLE</div></div></div>				<div>Document refence/s:</div> <div>1. Refer to WI-QAD-QAC-252 Steering Electrical Test</div> <div>MASTER SAMPLE</div> <div></div>

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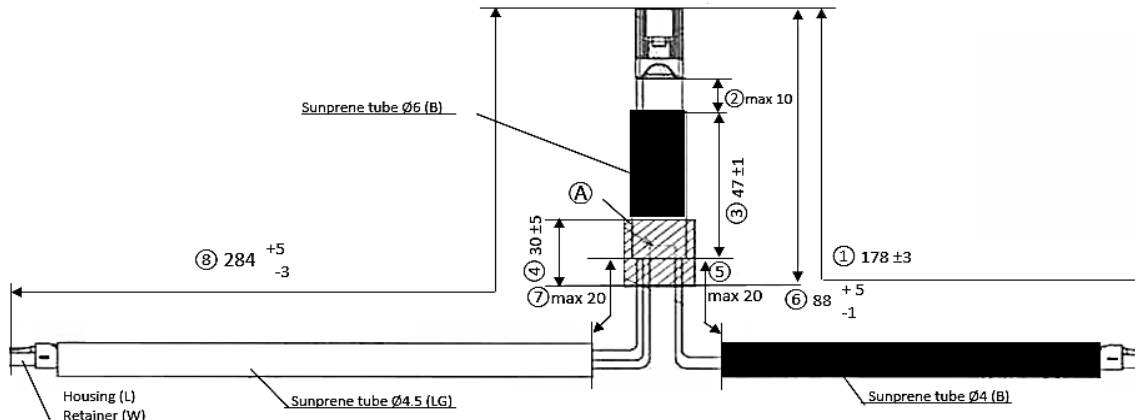

WI-ENG-PDE-1245

Revision No.:

1

Page No.:

4 of 5

PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Measurement	<div><div>MEASURING TAPE</div></div>		<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>

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5 of 5

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1. Assy parts

JIG:

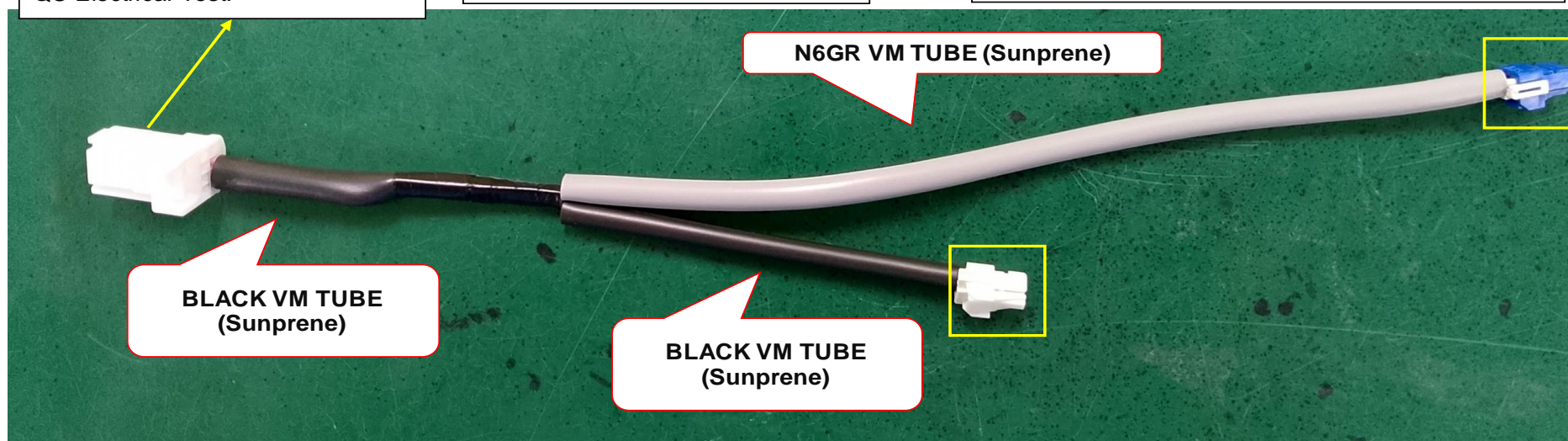
n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**P1****628128-0000B**

1. Check the connector lock.
Locking of connector is included in
QC Electrical Test.

2. Check the wire alignment. Make
sure no tangled wires.

3. Check the terminal if with backing out (not fully
inserted) or deformed terminal.



4. Check the orientation of harness.

5. Check if no missing parts.(Retainer)

6. No Missing Tape

7. Compare to Master Sample by
tapping.

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