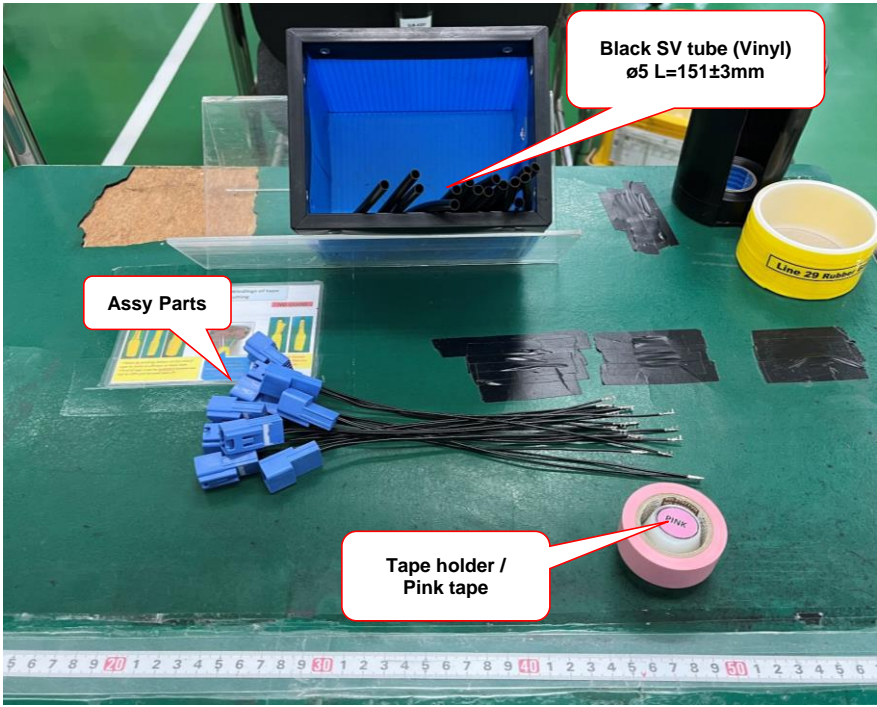




WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	May 10, 2024		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-801		
Revision No.:	1	Page No.:	1 of 5


Process Name/Title:	TAPING ASSEMBLY PROCESS		
Model code/Part number:	310D/ 7N0191-7020A	Customer:	TRJ
		Car Model:	TOYOTA-RAV 4
Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO



PARTS:	1. Assy parts; Black SV tube (Vinyl) ø5 L=151±3mm			JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
1	P1 Tape lay-out	<div>TABLE LAY OUT</div>  <div>Black SV tube (Vinyl) ø5 L=151±3mm</div> <div>Assy Parts</div> <div>Tape holder / Pink tape</div>		<div>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	<div>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to WI-ENG-PDE-890 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	
05/10/24	1	Change from Pre-launchh to Masspro. Transfer Wire insertion to connector and Connector lock process to Offline assembly process. Inclusion of table lay-out. Improved Measurement and Quality pointers.	D.Castillo	C.Villanueva	A. Arañes	N/A
02/08/24	0	Initial issue.	C.Hernandez	C.Villanueva	A. Arañes	N/A
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
				Est. Date:	February 8, 2024	

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	Model code/Part number: 310D/ 7N0191-7020A		Customer: TRJ	Car Model: TOYOTA-RAV 4	Document No.:		WI-ENG-PDE-801	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		1	Page No.:

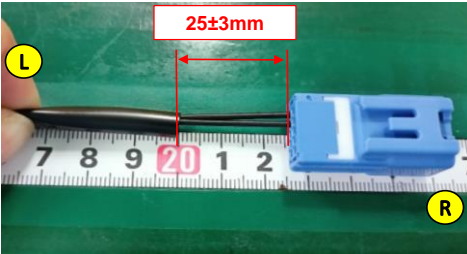

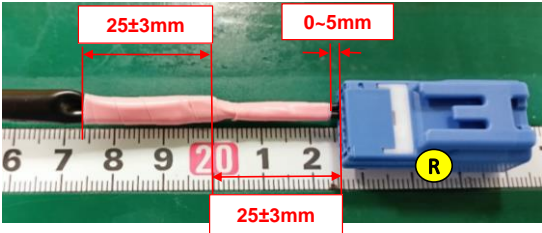
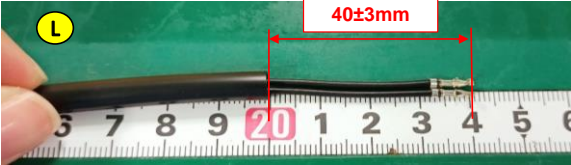

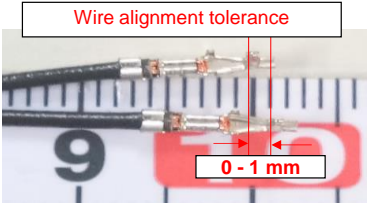
PARTS:		1. Assy parts 2. Black SV tube (Vinyl) ø5 L=151±3mm			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	P1 Wire Insertion to Black SV tube (Vinyl) ø5 L=151±3mm	<div><div>1. Get the Black SV tube (Vinyl) ø5 L=151±3mm using right hand then insert the B-B wires.</div></div>			N/A	1. No wrong usage of parts 2. No deformed terminal

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	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 310D/ 7N0191-7020A		Customer: TRJ	Car Model: TOYOTA-RAV 4	Document No.: WI-ENG-PDE-801		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	3 of 5

PARTS:		1. Assy parts 2. Pink tape [1pc]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	P1 Taping 1 SV tube (Vinyl) to wire near Connector	<div></div> <div>1. Hold the Black vinyl tube using left hand and measure from end of vinyl tube up to connector 25±3mm.</div> <div></div> <div>2. Get the Pink tape using right hand then start taping process using both hands.</div> <div></div> <div>3. After taping, check the measurement, taping condition and wire alignment.</div> <div></div>	<div>MEASURING TAPE</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</div> <div>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</div> <div></div>	

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TAPING ASSEMBLY PROCESS

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310D/ 7N0191-7020A

Customer:

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TOYOTA-RAV 4

Document No.:

WI-ENG-PDE-801

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

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PARTS:

1. Assy parts

JIG:

n/a

NO.**PROCESS NAME**

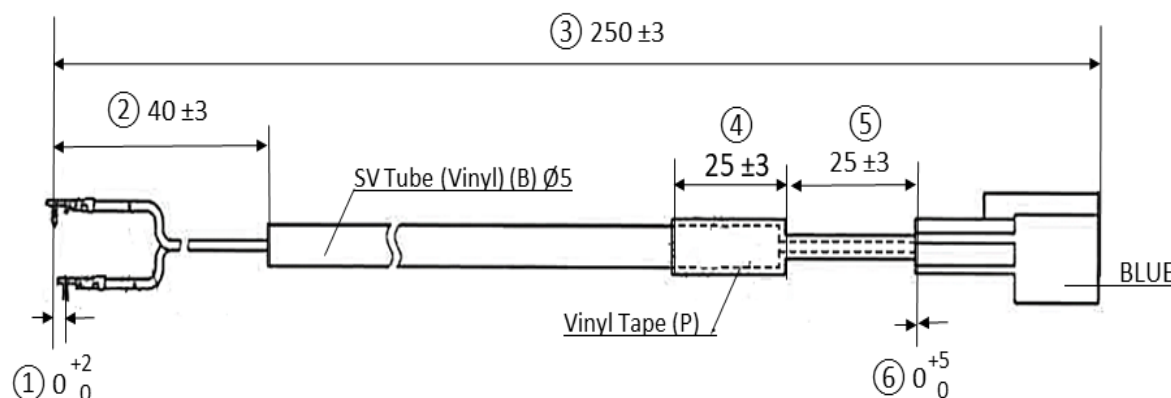
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WORK PROCEDURE/ ILLUSTRATION**TOOLS/PPE****QUALITY POINTERS**

4

P1

Measurement

**MEASURING
TAPE****Important reminders and note/s:**

1. Please use calibrated/verified measuring tape when getting the measurement.

2. For Hatsumono, Nakamono and Owarimono.

Document reference/s:

1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection

1. No wrong dimension

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310D/ 7N0191-7020ACustomer: **TRJ**

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Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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5 of 5**PARTS:**

1. Assy parts

JIG:

N/A

**VISUAL INSPECTION****TAPING - P1****7N0191-7020A****1****No Terminal Backing Out****2****No Missing Tape/
No wrong color of tape**

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