



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

December 04, 2024

Process Name/Title:

Model code/Part number:

310D / 7N0240-7020

Customer: TRJ

Car Model: TOYOTA RAV 4

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1003A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1. Assy parts; 1. AVSSf 0.3 B-B wire L=661mm; Black corrugated tube $\phi 5$ L=450 \pm 3mm (no slit); Black VM tube (Sunprene) $\phi 9$ L=120 \pm 3mm ; Black Tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

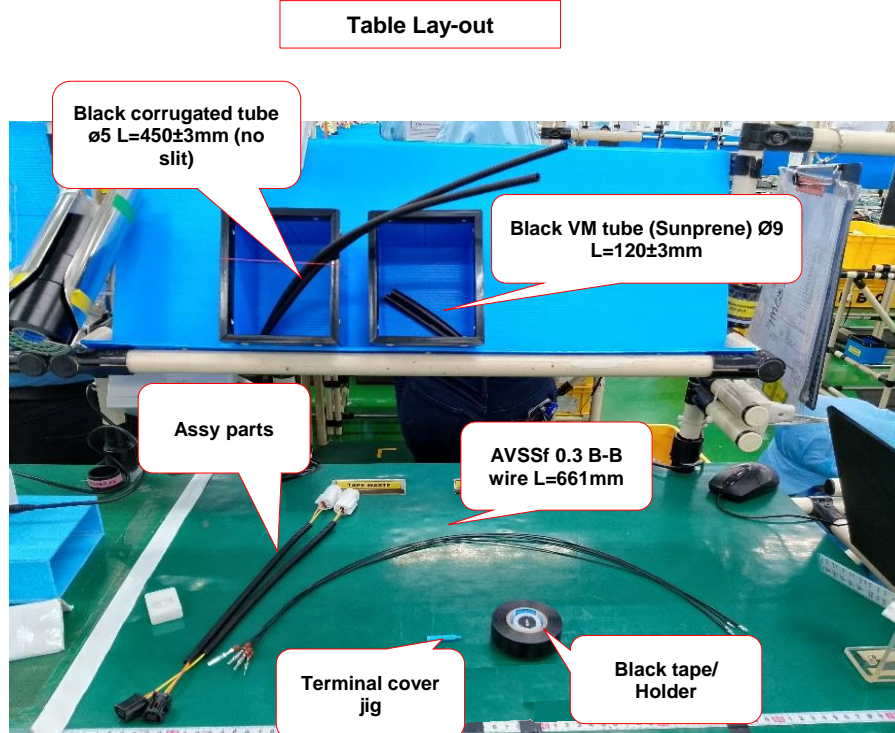
TOOLS/PPE

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.

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

12/04/24 1 Change pre launch to mass pro. Inclusion of table lay-out. Transfer insertion process to offline assembly and clamp taping assembly.

A.Hernandez

C. Villanueva

A. Arañes

n/a

09/09/24 0 Initial issue.

A.Hernandez

C. Villanueva

A. Arañes

n/a

Eff. Date Rev. No Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

September 09, 2024

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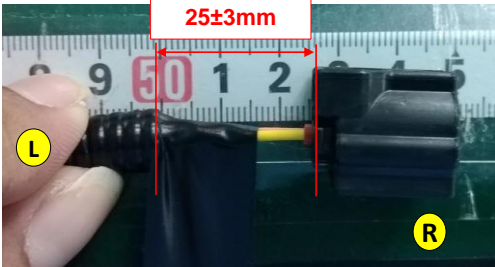
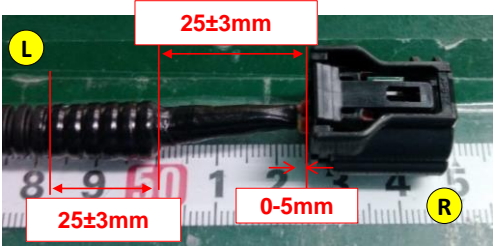

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PARTS:		1. Assy parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1 Taping 1 Black Corrugated tube to Wire near connector	 <p>Start of taping</p>  <p>25±3mm</p>  <p>25±3mm 0-5mm</p> <p>1. Hold the COT then get Black tape using right hand then start taping process using both hands.</p> <p>2. Measure from end of COT up to edge of connector 25±3mm then continue the taping process using both hands.</p> <p>3. After taping, check the measurement and taping condition.</p>		MEASURING TAPE 	Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure. 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

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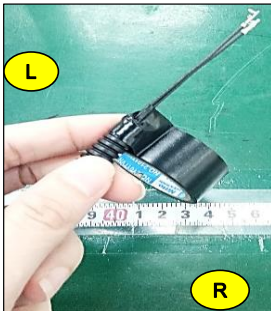
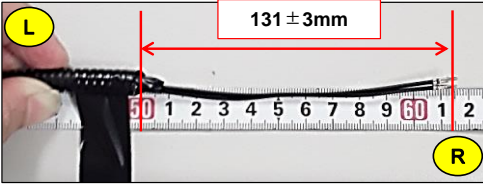
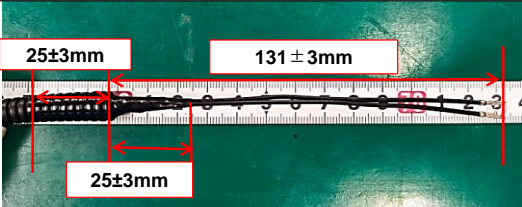

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PARTS:		1. AVSSf 0.3 B-B wire L=661mm 2. Black corrugated tube $\phi 5$ L=450 \pm 3mm (no slit) 3. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Wire Insertion to Black corrugated tube $\phi 5$ L=450 \pm 3mm (no slit)	  		n/a	1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape
4		  			1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.

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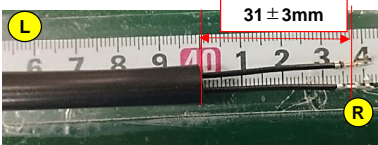

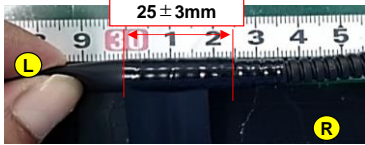

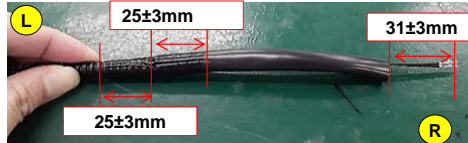


☒ MASSPRO

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1

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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) Ø9 L=120±3mm 3. Black Tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Wire insertion to Black VM tube (Sunprene) Ø9 L=120±3mm	 <p>1. Get the Black VM tube (Sunprene) Ø9 L=120±3mm using right hand then insert the assy parts using left hand.</p>	n/a	1. No wrong use of parts 2. no deformed terminal
6	P1 Taping 3 COT to VM tube (Sunprene)	 <p>1. Measure from end of tube up to terminal pointed tip 31±3mm using both hands.</p>  <p>2. Hold the Assy parts using left hand, get the Black tape using right hand then start pre-taping using both hands.</p>  <p>3. Confirm measurement of 25±3mm from end of tape up to end of tube then continue the taping process using both hands.</p>  <p>4. Confirm measurement of 25±3mm from end of tube up to end of tape then continue the taping process using both hands.</p>  <p>5. After taping, check the measurement, terminal appearance and taping condition.</p>	 <p>MEASURING TAPE</p> 	1. Check the tape from COT to VM tube (Sunprene) (Conduct bending for verification) 2. No flip out tape. 3. No tape peeling. 4. No loose tape Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.

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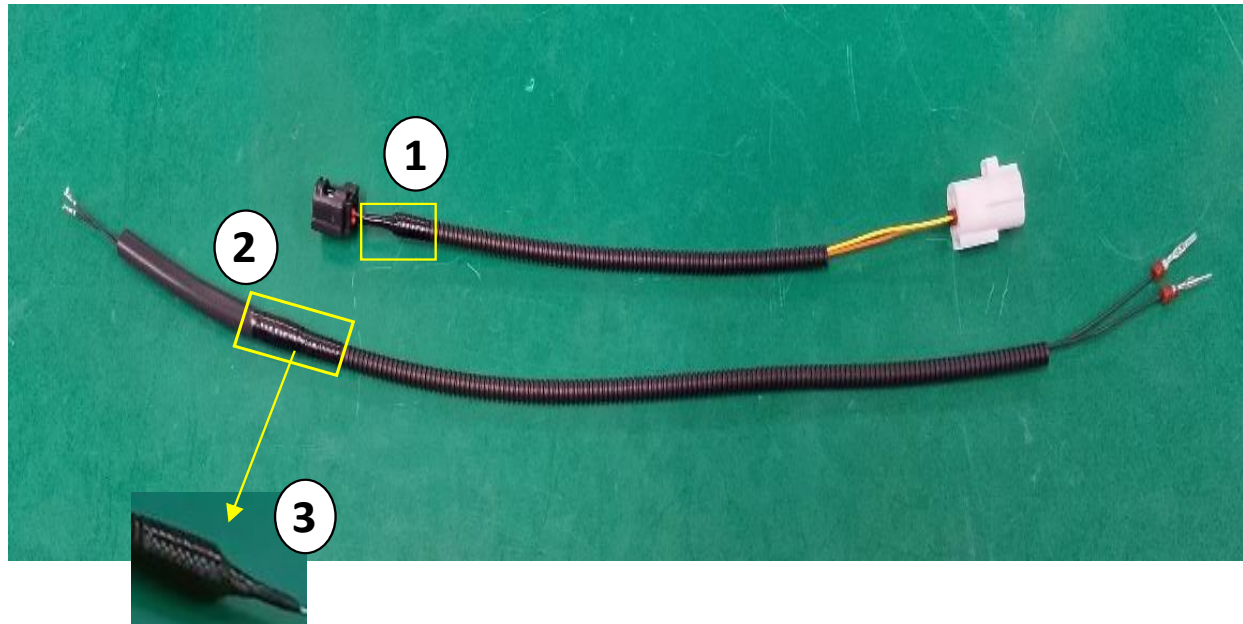
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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION / QUALITY CHECKPOINTS**TAPING - P1****7N0240-7020****1 2 3 No Missing TAPE****4 No Deformed Terminal**

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