



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

311D/ 7L0156-7022

Customer:

TRQSS

Car Model:

TOYOTA-RAV 4

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

March 15, 2025

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1201

Revision No.:

1

Page No.:

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PARTS:

1. Assy parts
2. Black SV tube (vinyl) $\phi 5$ t=0.5 L=95 \pm 3mm
3. Pink Tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

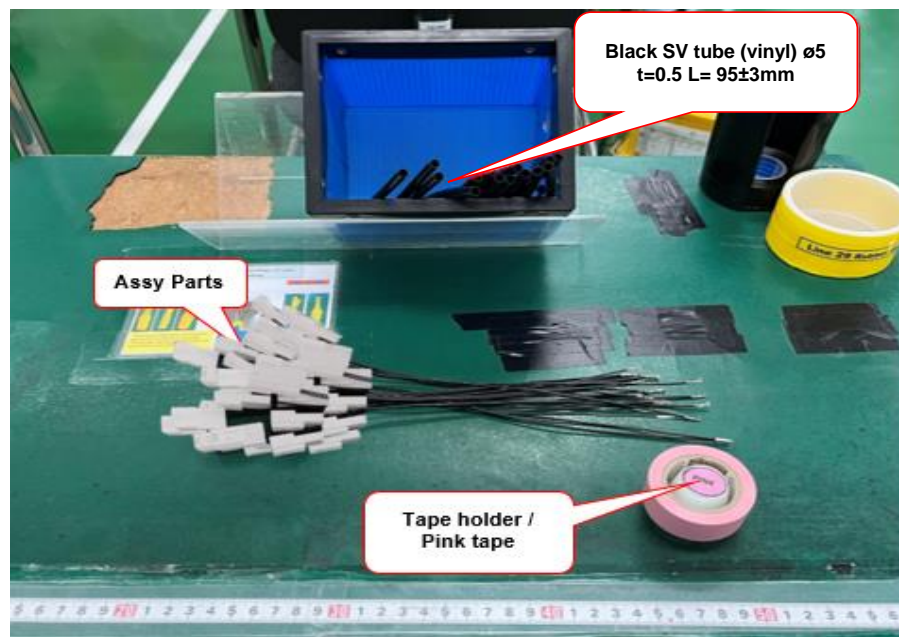
QUALITY POINTERS

1

P1

Table Lay-out

TABLE LAY-OUT

**Safety Instruction**

Be sure to wear required 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	Prepared by	Checked by	Reviewed by	Approved by
03/15/25	1	Change purpose from Pre-launch to Masspro.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
02/12/25	0	Initial issue.	M. Ariola	n/a	C. Villanueva	A. Arañes	M. Ariola	J. Loterte	C. Villanueva	A. Arañes

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PARTS:		1. Assy parts 2. Black SV tube (Vinyl) ø5 L=95±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	Wire Insertion to Black Black SV tube (Vinyl) ø5 L=95±3mm	 <div>1. Hold the assy part using left hand and get Black SV tube (Vinyl) ø5 L=95±3mm using right hand then insert.</div>	n/a	1. No wrong usage of parts 2. No deformed terminal

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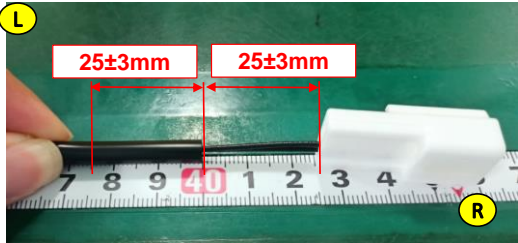
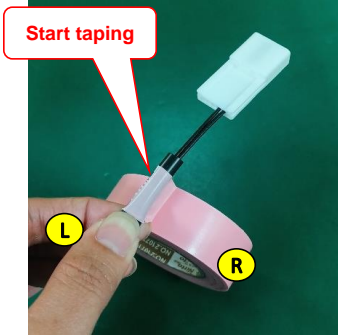
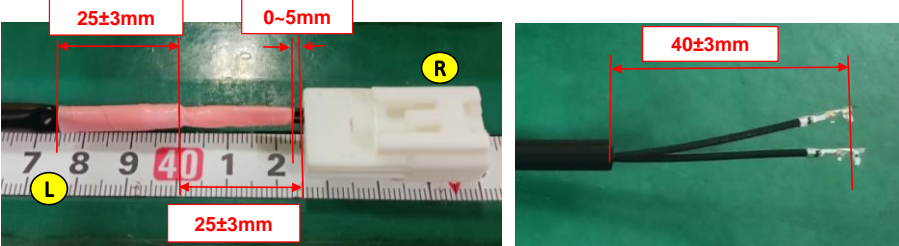

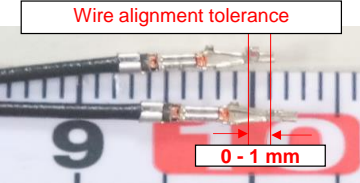
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PARTS:		1. Assy parts 2. Pink tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Taping 1 Corrugated tube to wire near Connector	<div><p>1. Hold the Black SV tube (Vinyl) using left hand and measure from end of SV tube (Vinyl) up to connector 25±3mm.</p></div> <div><p>2. Get the Pink tape using right hand then start taping process using both hands.</p></div> <div><p>3. After taping, check the measurement, taping condition an wire alignment.</p></div>		<div>MEASURING TAPE</div> 	<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</p> <p>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 1. Prefer to WI-PRO-ASY-001B Rev.2 Sub Assy Taping Procedure (VT to wire and COT to VT)</p> <div><p>Wire alignment tolerance 0 - 1 mm</p></div>

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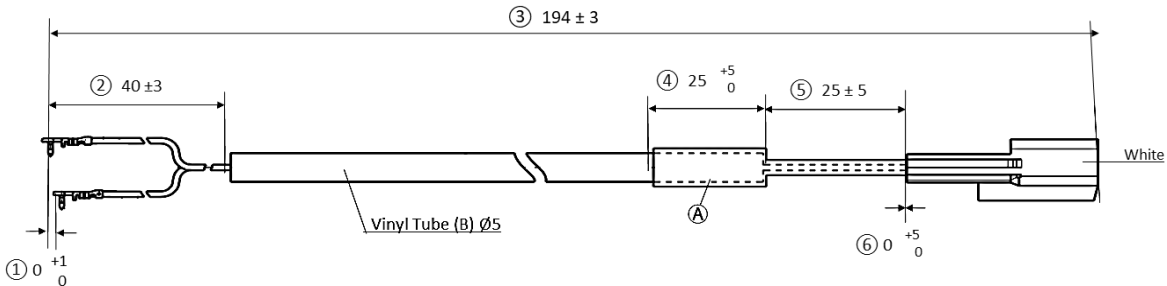
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1 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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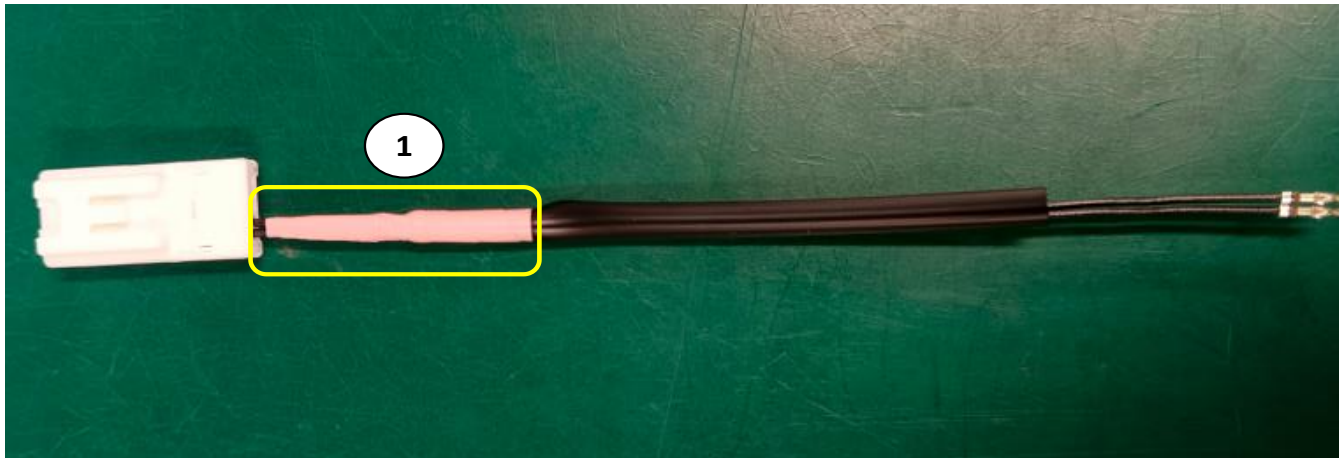
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n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**TAPING -P1****7L0156-7022**

① **No Missing Tape/Wrong color of tape**

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