



## WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

September 25, 2024

Model code/Part number:

373D / 7N0173-7020

Customer: TRJ

Car Model: TOYOTA-RAV4

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-606B

Revision No.:

2

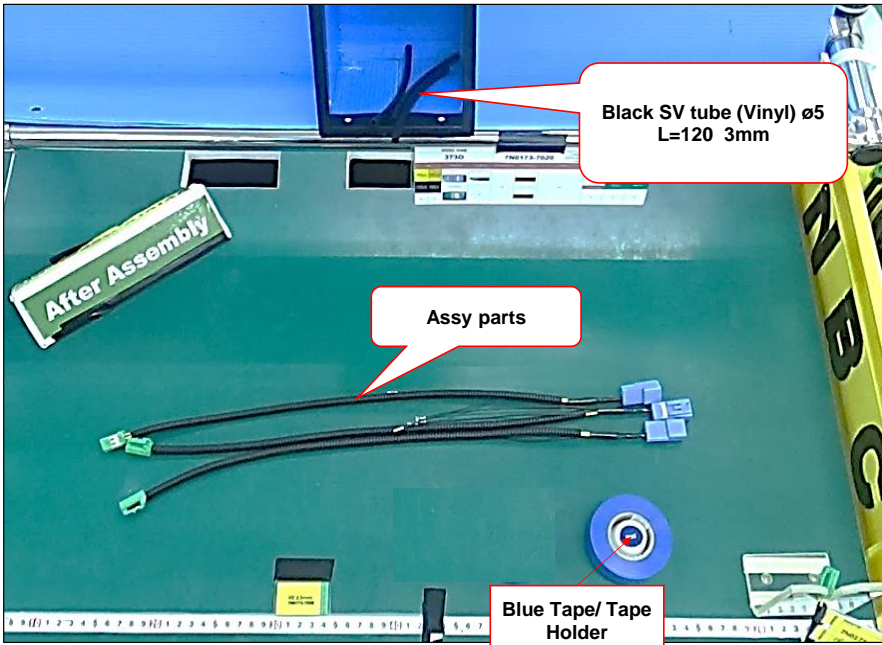
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**PARTS:** 1. Assy parts; Black SV tube (Vinyl) ø5 L=120±3mm; Blue tape 20mm

JIG:

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 Table Lay-out	 <p>Table Lay-out</p> <p>Black SV tube (Vinyl) ø5 L=120 3mm</p> <p>Assy parts</p> <p>Blue Tape/ Tape Holder</p>	<p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>1. No missing parts/tools 2. No excess parts/tools</p> <p><b>Document reference/s:</b> <b>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b> <b>2. Refer to WI-ENG-PDE-630 for 7N0173-7020 Offline Assembly Process</b></p>

## Revision History

							Prepared by	Reviewed by	Approved by	Noted by
09/25/24	2	Work instruction improvement from Genba check audit. Change table lay-out illustration. Inclusion in sequence no. 2 of Spot taping process transferred from P1 . Separate the Continuity tester jig process. Remove by two's inspection. Improvement of Visual Inspection and Quality Checkpoint.	A. Hernandez	C. Villanueva	A. Arañes	n/a				
01/31/23	1	Change from Pre-launch to Masspro. Inclusion of Table lay-out (Page 1), Change tape width to 20mm~22m in Y-taping process.	D.Castillo	J. Loterte	C. Villanueva	A. Arañes	A. Hernandez	C. Villanueva	A. Arañes	n/a
12/16/22	0	Initial issue.	D.Castillo	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	December 16, 2022		

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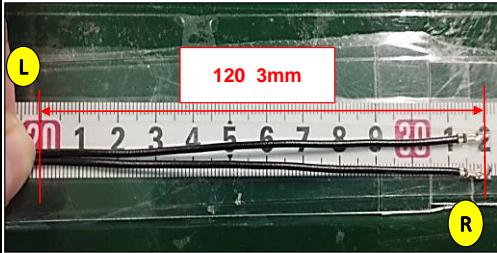
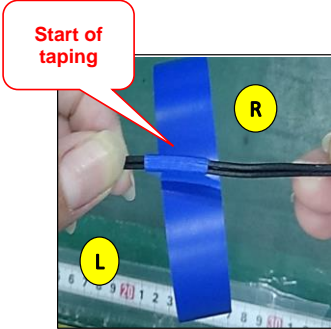
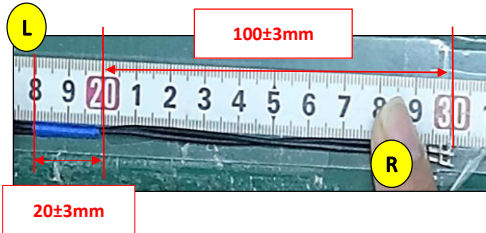

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Blue tape 20mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2	Spot taping	<div><p>1. Hold the wires using both hands and measure from wire up to terminal pointed tip <b>120 3mm</b>.</p></div> <div><p>2. Hold the wires using left hand, get <b>Blue tape</b> then start taping using right hand. Make <b>2 windings</b> then cut the tape.</p></div> <div><p>3. After taping, check the measurement, wire alignment and taping condition.</p></div>	<div></div>	<p><b>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"><li>1. Please use calibrated/verified measuring tape when getting the measurement.</li><li>2. Use <b>YELLOW</b> tape to easily visualize the tape shifting. But actual should be <b>BLUE TAPE</b>.</li></ol> <ol style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No wrong dimension</li><li>5. No wrong use of tape</li><li>6. No missing tape</li></ol>

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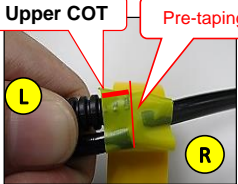
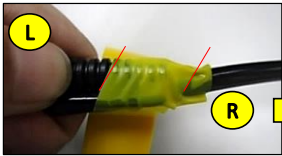

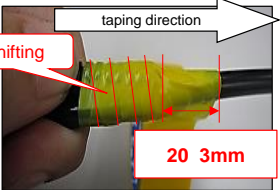

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Blue tape 20mm		3. Black SV tube (Vinyl) ø5 L=120±3mm		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS	
3		Wire Insertion to Black SV tube (Vinyl) ø5 L=120±3mm	<div></div> <div>1. Get the <b>Black SV tube (Vinyl) ø5 L=120 3mm</b> using right hand then insert the B-B wires.</div>				n/a	1. No wrong use of parts
4	P2  Y-Taping	<div><div></div><div></div><div><div>40±3mm</div></div><div>2. Measurement from end of SV tube (Vinyl) up to terminal tip. Must be <b>40 3mm</b>.</div><div><div><div>Upper COT</div><div>Pre-taping</div></div><div>3. Start taping at the middle of combined tubes, position the tape into upper COT (<b>2 winds</b>).</div><div><div><div>20~22mm</div></div><div><div>20~22mm</div></div><div>4. Wind the tape to left side, width must be <b>20~22mm (2 winds)</b>.</div><div><div><div>taping direction</div><div>1/3 shifting</div><div>20 3mm</div></div><div>5. Wind the tape <b>1/3 shifting</b> until it reach the other side of Black SV Tube (Vinyl) then wind the tape, width must be <b>20 3mm (2 winds)</b>.</div></div><div>MEASURING TAPE</div><div></div></div></div></div>					1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension 6. No wide interval between the COT 7. No exposed wire  <b>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b> <b>2. Use <u>YELLOW</u> tape to easily visualize the tape shifting. But actual should be <u>BLUE TAPE</u>.</b>	

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☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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### PARTS:

1. Assy parts
2. Blue tape 20mm

JIG:

n/a

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

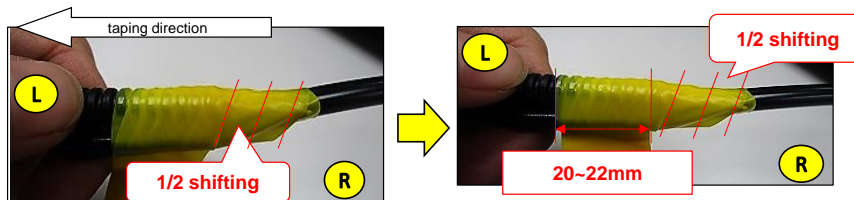
### TOOLS/PPE

### QUALITY POINTERS

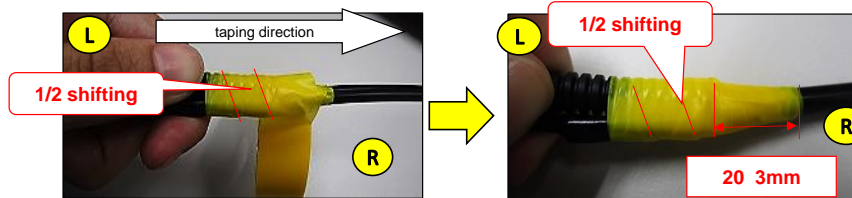
4

P2

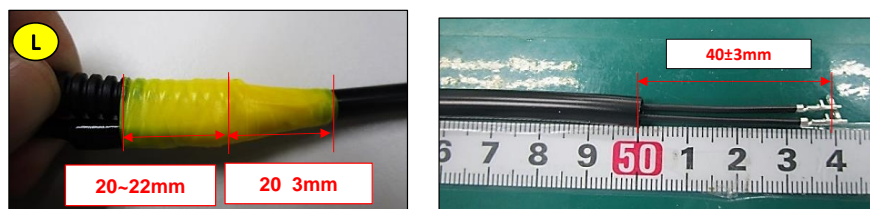
Y-Taping  
(Continuation)



6. Wind the tape backward **1/2 shifting** until it reach the COT. Then wind the tape, width must be **20~22mm (2 winds)**.

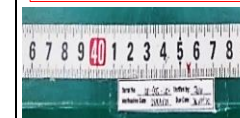


7. Wind the tape **1/2 shifting** going to other side of Black SV Tube (Vinyl). Then wind the tape, width must be **20 3mm (2 winds)** and cut the tape.



8. After taping, check the condition of tape and measurement from SV tube up to terminal pointed **40 3mm** and taping condition.

### MEASURING TAPE



### Important reminders/Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.
2. Use **YELLOW** tape to easily visualize the tape shifting. But actual should be **BLUE TAPE**.

1. No loose tape
2. No flip-out tape
3. No peel-off tape
4. No wrong use of tape
5. No wrong dimension
6. No wide interval between the COT
7. No exposed wire

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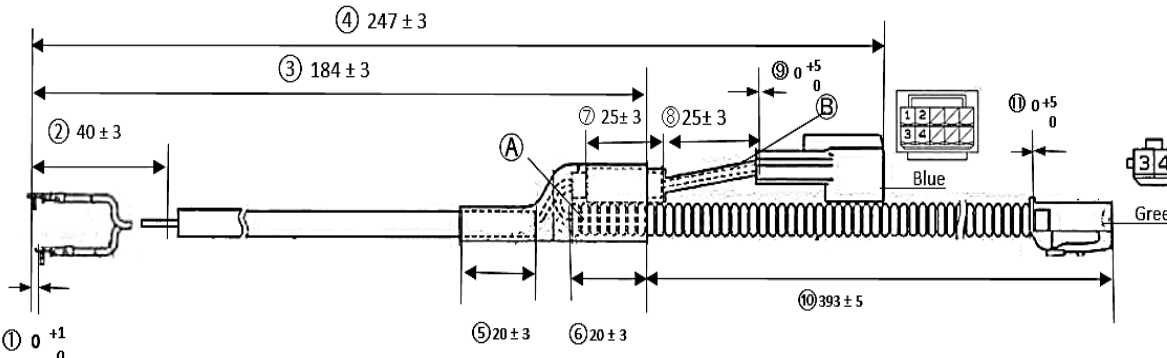

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2 Measurement			1. No wrong dimension  <b>Important reminders/Note/s:</b> 1. FOR HATSUMONO AND OWARIMONO 2. Please use calibrated/verified measuring tape when getting the measurement.

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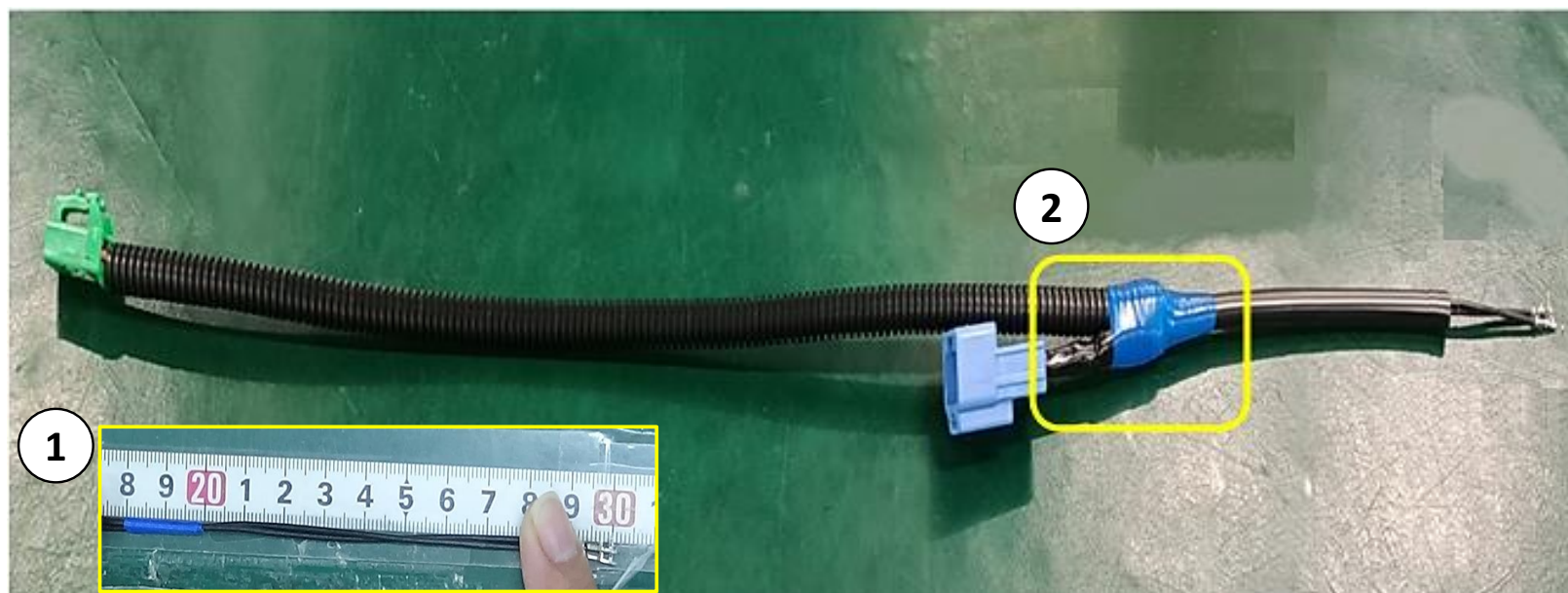
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION QUALITY CHECKPOINTS****P2****7N0173-7020****1 No Missing Spot tape (BLUE tape)****2 No Missing Tape (BLUE tape) ( Y-taping)****3 Check the Tape Appearance**

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