



## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

October 18, 2024

Process Name/Title:

Model code/Part number:

310D

/

7N0199-7020B

Customer: TRJ

Car Model:

TOYOTA-RAV4

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1061B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

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## PARTS:

1. Assy parts; Black VM tube (Sunprene) Ø9 L=112±3mm; Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

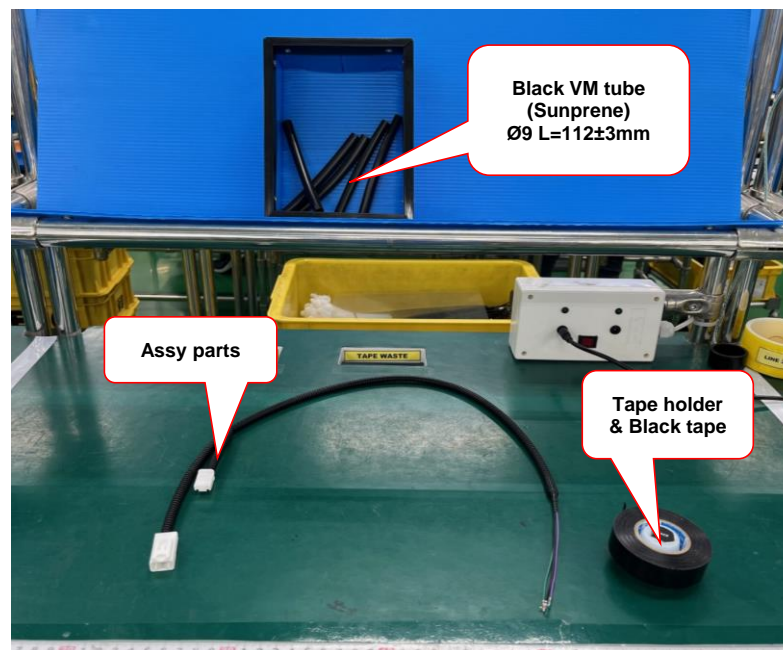
QUALITY POINTERS

1

P2

Table lay-out

## TABLE LAY-OUT

**Safety Instruction**

Be sure to wear 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 wrong use of parts/tools
2. No missing parts/tools

## Revision History

							Prepared by	Reviewed by	Approved by	Noted by
10/18/24	1	Change purpose from Pre-launch to Masspro.	M. Ariola	C.Villanueva	A. Arañes	n/a				n/a
09/24/24	0	Initial issue.	M. Ariola	C.Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date	September 24, 2024		

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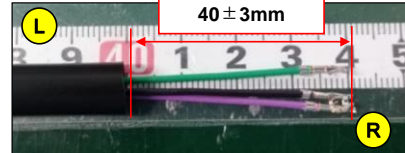
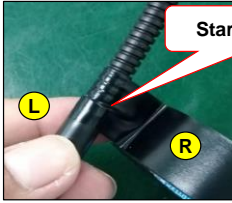
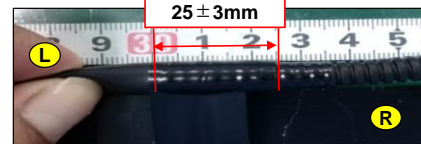



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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) Ø9 L=112±3mm		3. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Black VM tube (Sunprene) Ø9 L=112±3mm	<div><div></div><div>1. Get the Black VM tube (Sunprene) Ø9 L=112±3mm using right hand then insert the B-G-V wires.</div></div>				n/a	1. No wrong usage of parts. 2. No deformed terminal
3	P2  Taping 3 Black Corrugated tube to Balck VM tube (Sunprene)	<div><div><div><div>40 ± 3mm</div></div><div>1. Measure from end of VM tube (Sunprene) up to terminal pointed tip 40±3mm using both hands.</div></div><div><div><div>Start of taping</div><div>2. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.</div></div><div><div><div>25 ± 3mm</div></div><div>3. Confirm measurement of 25±3mm from end of tape up to end of tube then continue the taping process using both hands.</div></div><div><div><div>25 ± 3mm</div></div><div>4. Confirm measurement of 25±3mm from end of tube up to end of tape then continue the taping process using both hands.</div></div><div><div><div>25 ± 3mm</div><div>40 ± 3mm</div></div><div>5. After taping, check the measurement, terminal appearance and taping condition.</div></div></div></div>				<div>MEASURING TAPE</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  <b>Important reminders and Note/s:</b> 1. Please use calibrated/verified measuring tape when getting the measurement.  <b>Document reference/s:</b> 1. Refer to WI-PRO-ASY-001 for taping procedure.

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☐ PROTOTYPE

☐ PRE-LAUNCH

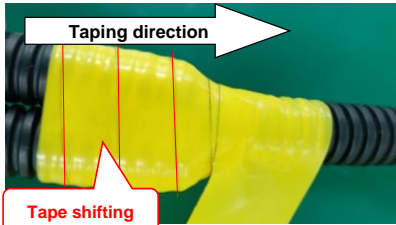
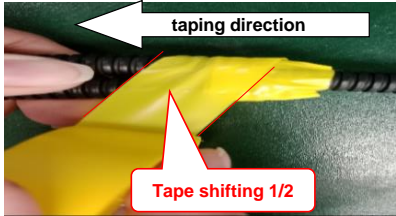
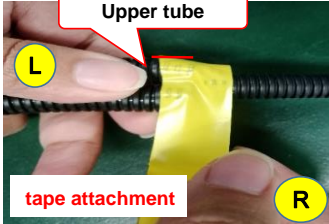

☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Y-taping	<div><p>1. Fix the 3 corrugated tube .</p><p>2. Start taping at the middle of combined tubes, attach the tape on the upper tube. Then make pre-tape <b>2 windings</b>. <i>Note: Do not exert excessive force during pulling &amp; winding of tape.</i></p><p>3. Winding the tape <b>1/2 shifting</b> going to the left side.</p><p>4. Make <b>2 windings</b>, width must be <b>23±2mm</b>.</p><p>5. Winding the tape <b>1/3 shifting</b> going to the right side until reach the other side of tube.</p><p>6. Make <b>2 windings</b>, width must be <b>25±3mm</b>.</p></div>		<p><b>Document reference/s:</b></p> <p>1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p><b>Important reminders/Note/s:</b></p> <p>1. Use <b>yellow tape</b> for easy visualization of tape shifting, but actual should be <b>BLACK TAPE</b>. 2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension-out tape 6. No exposed wire 7. No gap between tubes</p>

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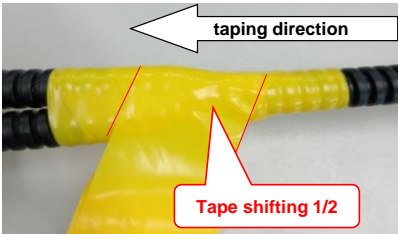
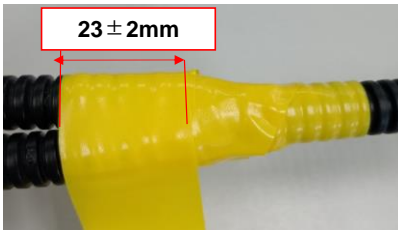
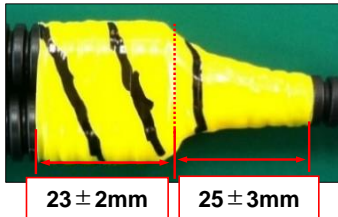
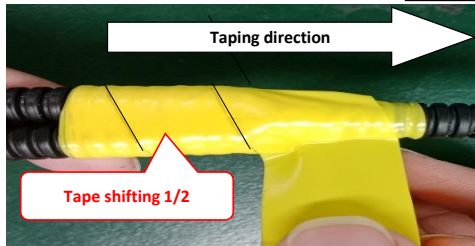
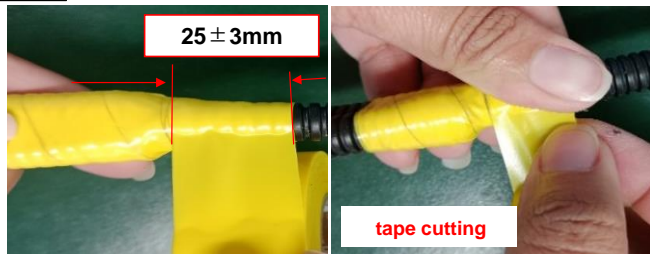
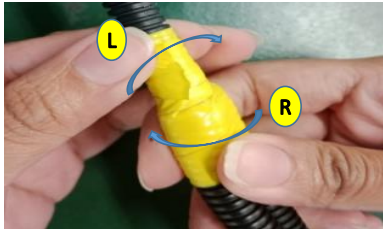
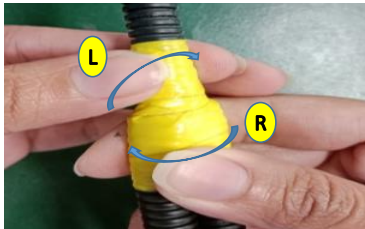
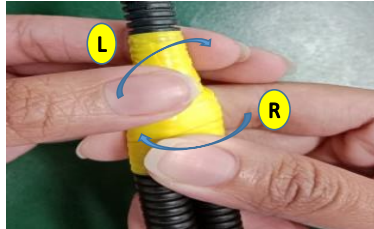
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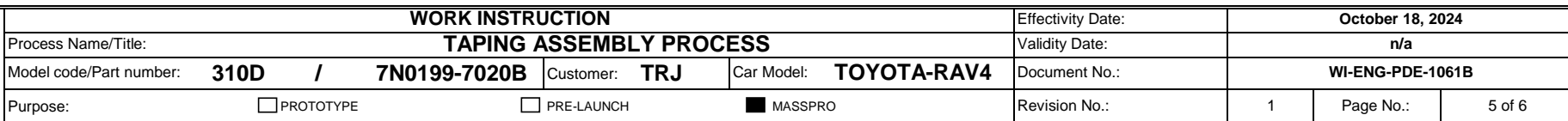
PARTS:		1. Assy parts 2. Black tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
4	P2	Y-taping (Continuation)	<div></div> <div>7. Winding the tape <b>1/2 shifting</b> going to the left side.</div>	<div></div> <div>8. Make <b>2 windings</b>, width must be <b>23±2mm</b>.</div>	<p><b>Document reference/s:</b> <b>1. Refer to WI-PRO-ASY-001C for taping procedure (special).</b></p> <p><b>Important reminders/Note/s:</b> <b>1. Use yellow tape for easy visualization of tape shifting, but actual should be BLACK TAPE.</b> <b>2. Please use calibrated/verified measuring tape when getting the measurement.</b></p> <ul style="list-style-type: none"><li>1. No loose tape</li><li>2. No flip-out tape</li><li>3. No peel-off tape</li><li>4. No wrong use of tape</li><li>5. No wrong dimension-out tape</li><li>6. No exposed wire</li><li>7. No gap between tubes</li></ul> <div></div> <div>14. Check the Measurement and condition of tape.</div>	
			<div></div> <div>9. Winding the tape <b>1/2 shifting</b> going to the right side until it reach the other side of tube</div>	<div></div> <div>10. Make <b>3 winds</b>, width must be <b>25±3mm</b>. Then cut the tape.</div>		
			<div></div> <div>11. conduct proper pressing of end tape using left hand (<b>top part</b>)</div>	<div></div> <div>12. conduct proper pressing of end tape using left hand (<b>Middle part</b>)</div>		<div></div> <div>13. conduct proper pressing of end tape using left hand (<b>bottom part</b>)</div>

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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P2****7N0199-7020B****1 2 No Missing tape**

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