



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

311D / 7L0152-7024

Customer:

TRQSS

Car Model:

TOYOTA RAV 4

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

May 15, 2025

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1257B

Revision No.:

1

Page No.:

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PARTS: 1. Assy parts; Black tape

JIG:

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

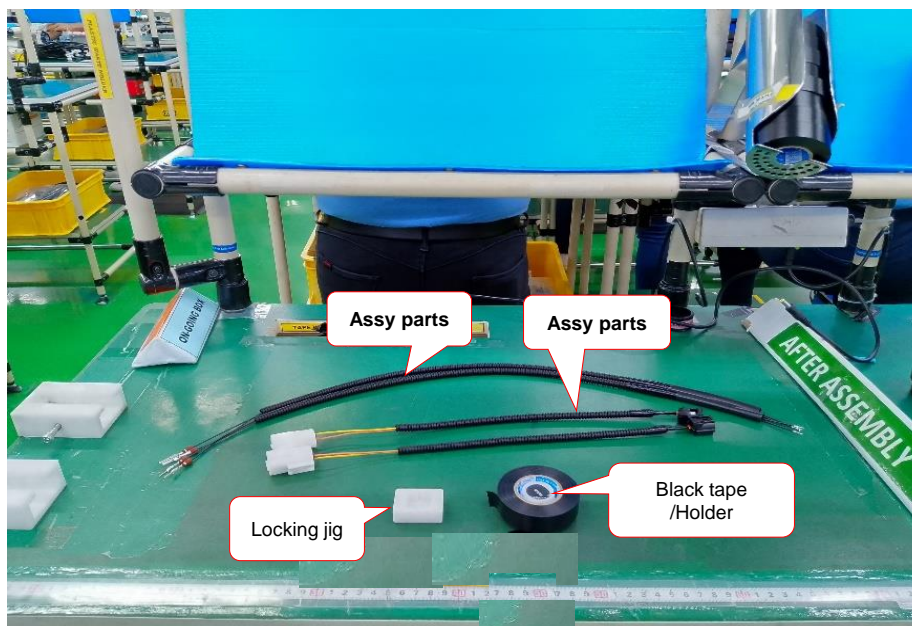
QUALITY POINTERS

1

P2

Table Lay-out

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

Checked by

Reviewed by

Approved by

05/15/25 1 Change documents purpose from pre-launch to mass pro.

A.Hernandez J.Loterte C. Villanueva A. Arañes

04/28/25 0 Initial issue.

A.Hernandez J.Loterte C. Villanueva A. Arañes

Eff. Date Rev. No Details of Change

Revised Checked Reviewed Approved

Est. Date:

April 28, 2025

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2 of 6**PARTS:**

1. Assy parts
2. AVSSf 0.3 B-B wire L=661mm (Assy parts)

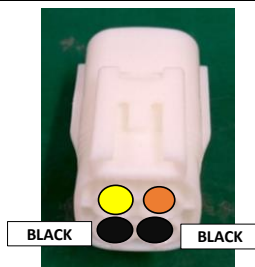
JIG:

n/a

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

2

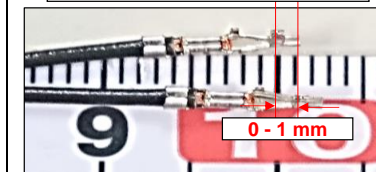
P2

Wire insertion to
connector 6188-0093
(W)**VISUAL REFERENCE****CONNECTOR
ORIENTATION****Wire terminal facing**

1. Get the connector **6188-0093 (W)** then hold the **Black wire** and insert to terminal **slot 1** of connector using right hand. Conduct **2x** push pull after wire insertion.



2. Hold the connector **6188-0093 (W)** then get the **Black wire** and insert to terminal **slot 2** of connector using right hand. Conduct **2x** push pull after wire insertion.

MEASURING TAPE**Wire alignment tolerance****Important reminders/Note/s:**

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

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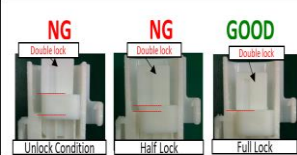



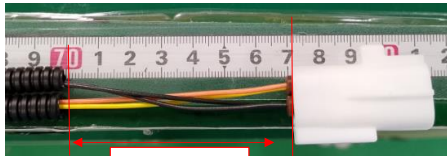
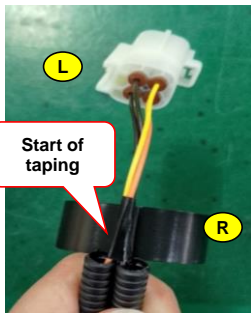
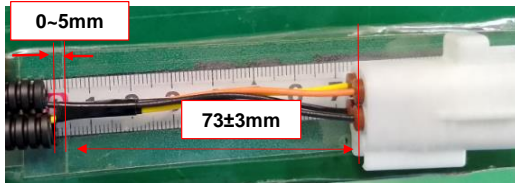

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PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Connector lock	    <p>1. Put the connector into locking jig using both hands and then press 2x. Check the connector lock if properly lock.</p>		LOCKING JIG 	1. Use provided locking jig per model. 2. No unlock/half-locked connector Document reference/s: 1. Please refer to GL-PRO-ASY-029 for Pull-Push procedure.
4	Spot taping	 <p>73±3mm</p>  <p>Start of taping</p>  <p>0~5mm 73±3mm</p> <p>1. Combine the 2 COT and wires. Measure from end of Combined COT up to edge of connector 73±3mm using both hands.</p> <p>2. Get the Black tape using right hand then conduct 2 windings of tape using both hands.</p> <p>3. After taping, check the measurement and taping condition.</p>		MEASURING TAPE 	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 Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.

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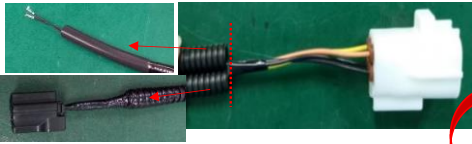
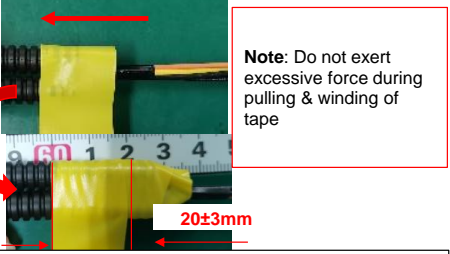
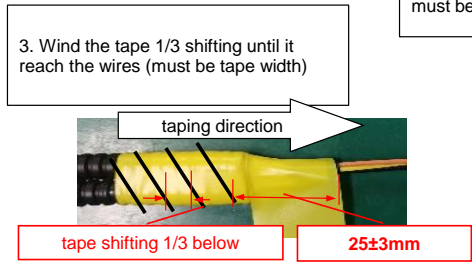
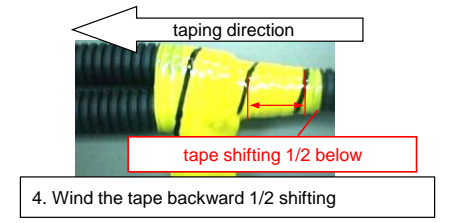
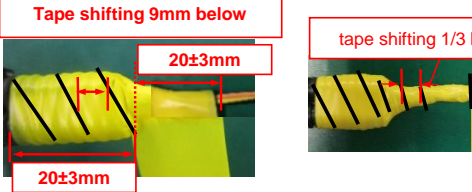
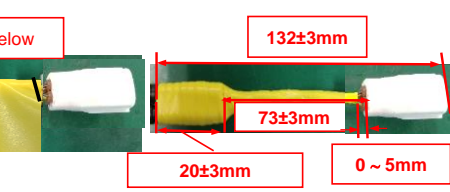

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PARTS:		1. Assy Parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2	Y-taping			
		<div><div></div><div><p>1. Fix the 2 corrugated tube. Follow the correct connector orientation. <i>Note: 2 COT must be aligned.</i></p></div><div></div><div><p>2. Start taping at the middle of combined COT & wires, then wind the tape going to 2 corrugated tubes (2 windings) , width must be same with tape (20mm)</p></div><div></div><div><p>3. Wind the tape 1/3 shifting until it reach the wires (must be tape width)</p></div><div></div><div><p>4. Wind the tape backward 1/2 shifting</p></div><div></div><div><p>5. Wind the tape 1/2 shifting going to spot tape. Cover the spot tape & wire 1/3 shifting. Measure end of COT up to connector 73±3mm then make 3 windings of tape before cutting of tape.</p></div><div></div><div><p>6. After taping, check the measurement and taping condition.</p></div><div><p>Note: Do not exert excessive force during pulling & winding of tape</p></div><div><p>20±3mm</p></div><div><p>25±3mm</p></div><div><p>20±3mm</p></div><div><p>132±3mm</p></div><div><p>73±3mm</p></div><div><p>20±3mm</p></div><div><p>0 ~ 5mm</p></div></div> <div><div>MEASURING TAPE</div></div> <div><p>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Used yellow tape to easily visualize the tape shifting but actual should be BLACK TAPE</p></div> <div><div>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</div></div>			

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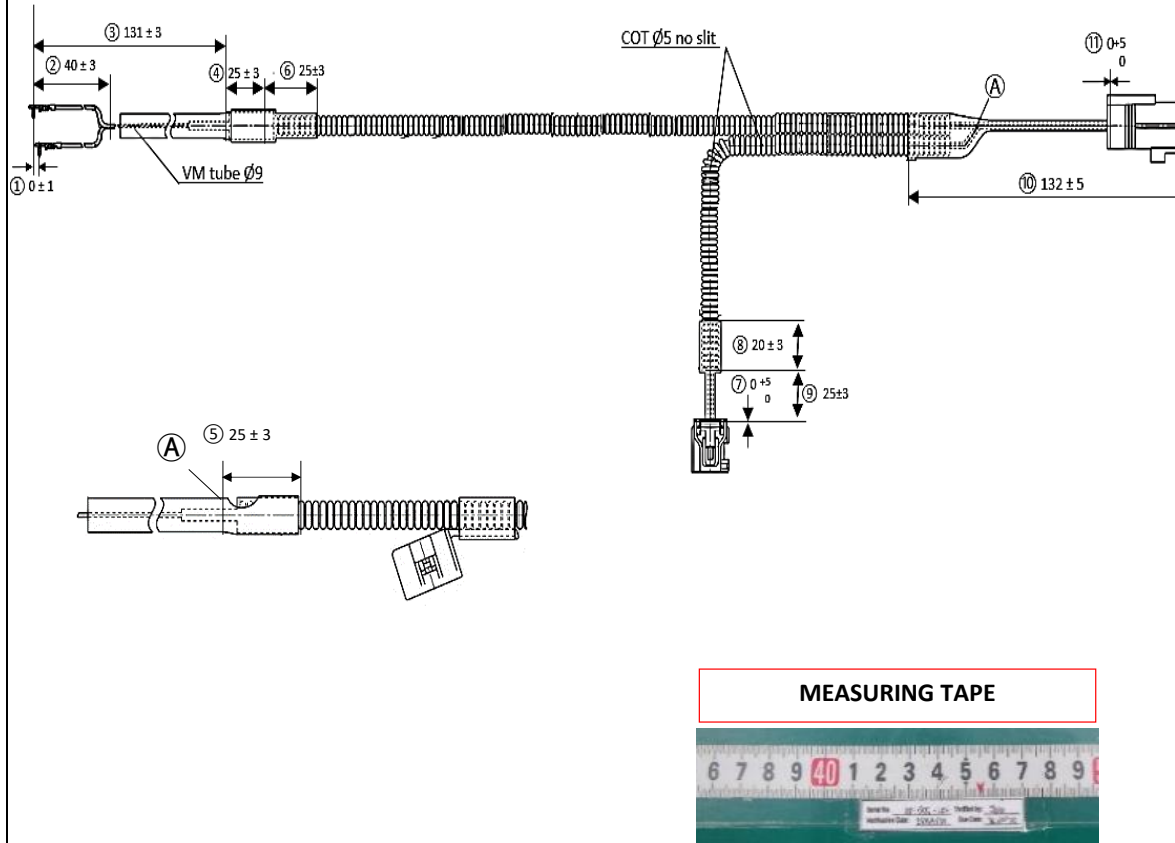
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PARTS:		1. Assy Parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P2	Measurement			<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to <i>WI-PRO-ASY-056</i> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>

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PARTS:

1. Assy Parts

JIG:

n/a

VISUAL INSPECTION / QUALITY CHECKPOINTS**TAPING - P2****7L0152-7024****1 No Half locked/Unlocked Connector****2 No Missing Tape****3 No Wrong facing of Y-Taping**

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