



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

310D / 7N0240-7020

Customer: TRJ

Car Model: TOYOTA RAV 4

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

December 04, 2024

Validity Date:

n/a

Document No.:

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Revision No.:

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PARTS: 1. Assy parts; Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

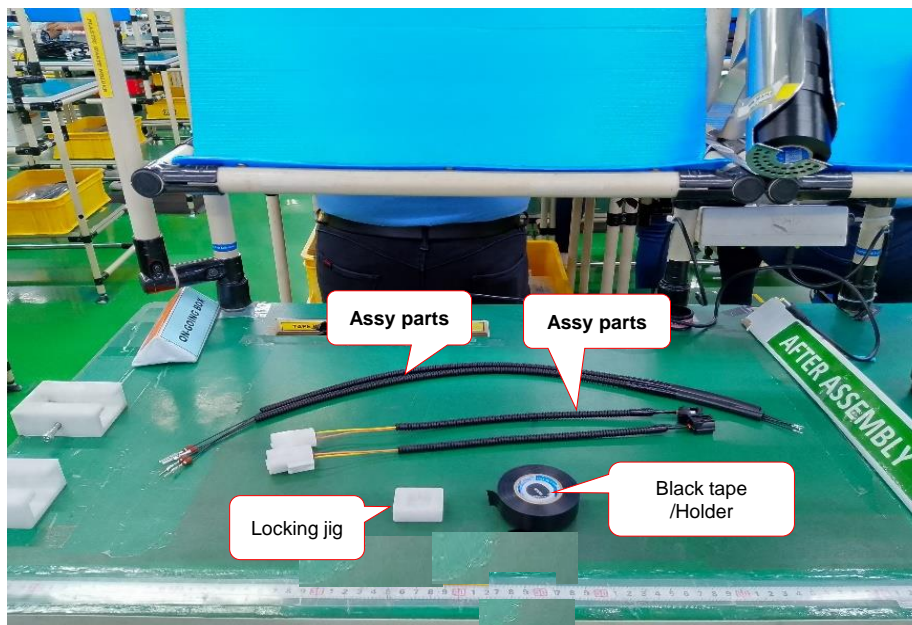
QUALITY POINTERS

1

P2

Table Lay-out

Table Lay-out

**Safety Instruction**

Be sure to wear 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

0

Initial issue.

A.Hernandez

C. Villanueva

A. Arañes

n/a

A.Hernandez

C. Villanueva

A. Arañes

n/a

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

December 04, 2024

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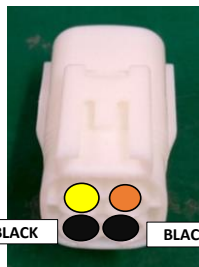




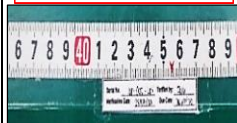
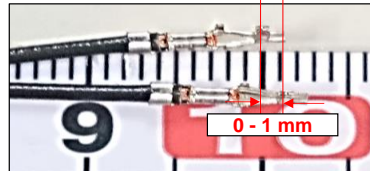
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| | | | | | |
|--------|---|--|--|--|---|
| PARTS: | | 1. Assy parts 2. AVSSf 0.3 B-B wire L=661mm (Assy parts) | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 2 | P2 Wire insertion to connector 6188-0093 (W) | <div><div><p>BLACK BLACK</p><p>VISUAL REFERENCE</p></div><div><p>CONNECTOR ORIENTATION</p></div><div><p>Wire terminal facing</p></div><div><p>L R</p></div><div><p>L R</p></div><div>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.</div><div>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.</div></div> | | <div><p>MEASURING TAPE</p></div> <div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div> | <p>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</p> <p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> |

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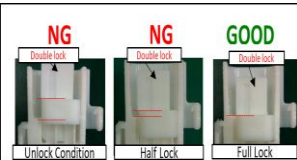



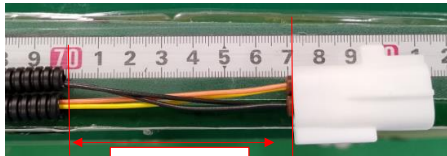
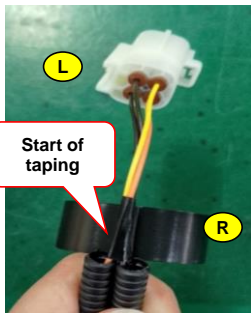
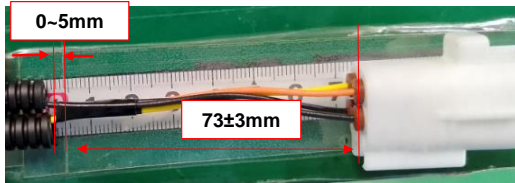

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| PARTS: | | 1. Assy parts | | JIG: | n/a |
|--------|----------------|---|--|--|---|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 3 | Connector lock |     <p>1. Put the connector into locking jig using both 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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☐ PRE-LAUNCH

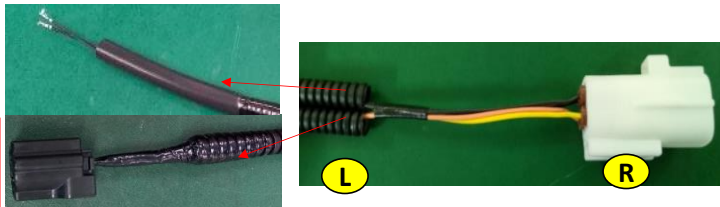
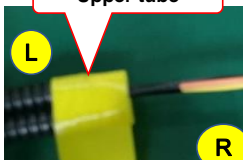

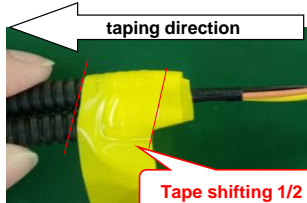
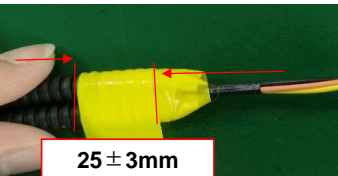
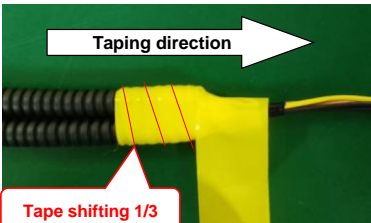

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|--------|--------------|--------------------------------|--|-----------|------------------|
| PARTS: | | 1. Assy Parts 2. Black Tape | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 5 | P2 | Y-taping | <div><div>CONNECTOR CORRECT FACING</div><div></div><div><div>Upper tube</div><div></div><div>tape attachment</div><div></div><div>pre-tape</div><div><div>taping direction</div><div></div><div>Tape shifting 1/2</div><div><div>3. Winding the tape 1/2 shifting going to the left side.</div><div></div><div>25 ± 3mm</div><div><div>Taping direction</div><div></div><div>Tape shifting 1/3</div><div></div><div>5. Winding the tape 1/3 shifting going to the right side until reach the other side of connector. Then make 2 windings.</div></div></div></div><div><div>1. Fix the 3 corrugated tube. Note: Follow the connector correct facing.</div><div>2. Start taping at the middle of combined tubes and wire, attach the tape on the upper tube. Then make pre-tape 2 windings. Note: Do not exert excessive force during pulling & winding of tape.</div><div>4. Make 2 windings, width must be 25±3mm.</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 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 <u>BLACK TAPE</u></div></div></div> | | |

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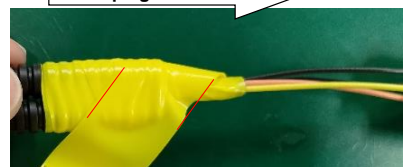
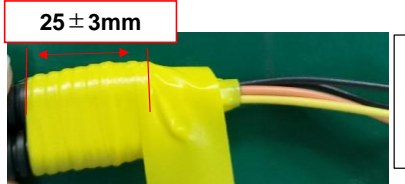



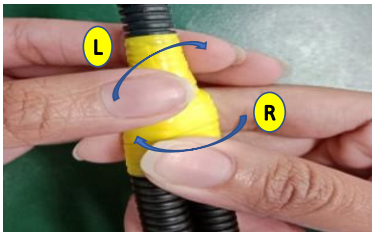
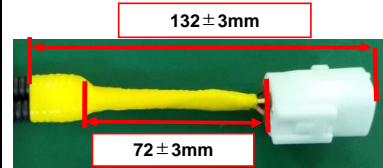
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| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 5 | P2 | Y-taping (continuation) | | | |
| | | <div><div><div> </div><div> 25 ± 3mm</div><div> tape cutting</div><div> L R</div><div> L R</div><div> L R</div><div>7. Make 2 windings, width must be 25±3mm.</div><div>6. Winding the tape 1/2 shifting going to the left side.</div><div>8. Winding the tape 1/3 shifting going to the right side until it reach the other side of connector</div><div>9. Make 3 windings, width must be 25±3mm. Then cut the tape.</div><div>10. conduct proper pressing of end tape using left hand (top part). Note: Reference only.</div><div>11. conduct proper pressing of end tape using left hand (Middle part). Note: Reference only.</div><div>12. conduct proper pressing of end tape using left hand (bottom part). Note: Reference only.</div></div><div><div>13. Check the Measurement and condition of tape.</div><div> 132 ± 3mm 72 ± 3mm</div></div><div>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 <u>BLACK TAPE</u></div></div> | | | |

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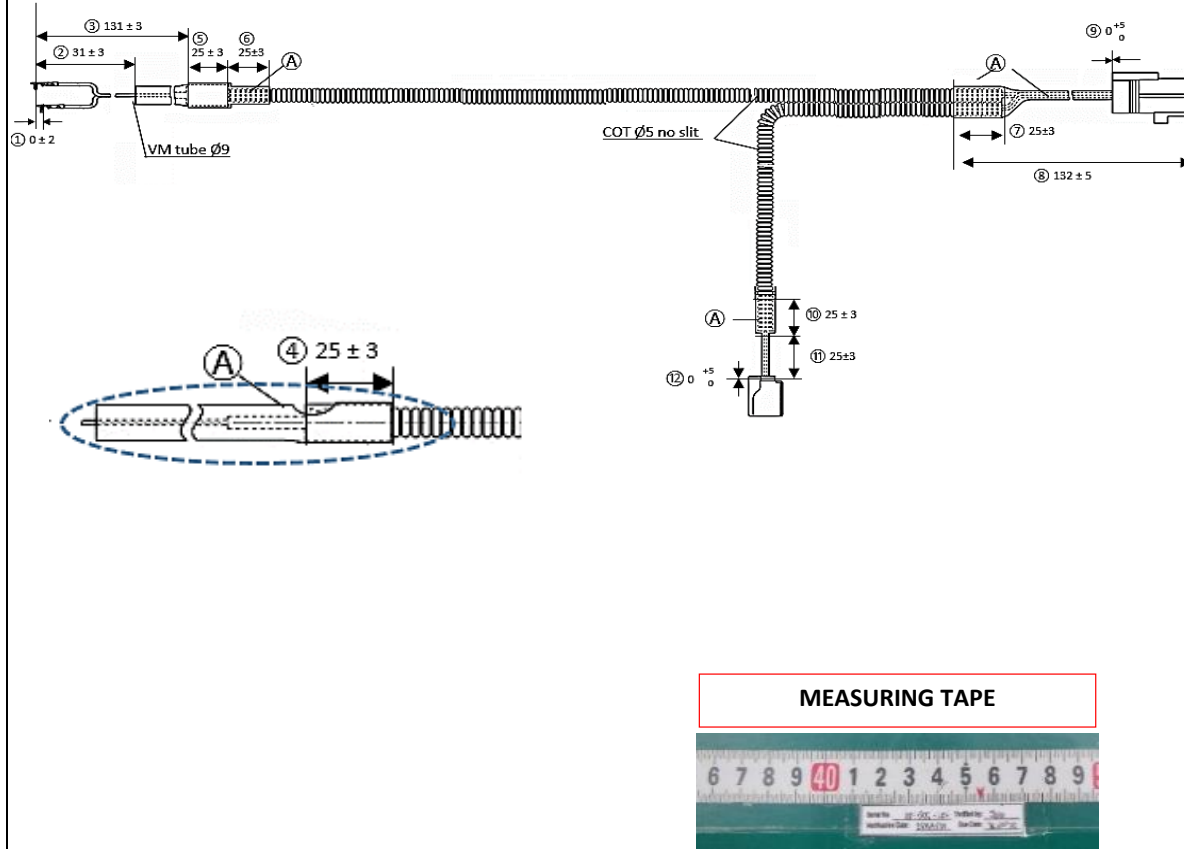
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| PARTS: | | 1. Assy Parts | | JIG: | n/a |
|--------|--------------|------------------------------|---|-----------|--|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 6 | P2 | Measurement |  | | Important reminders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

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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION / QUALITY CHECKPOINTS**TAPING - P2****7N0240-7020****1 No Half locked/Unlocked Connector****2 No Missing Tape****3 No Wrong facing of Y-Taping**

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