


	WORK INSTRUCTION				Effectivity Date:		June 11, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 320B / 7L0057-7022		Customer: TRQSS		Car Model: TOYOTA-RAV4		Document No.: WI-ENG-PDE-288	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.: 3		Page No.:	1 of 4



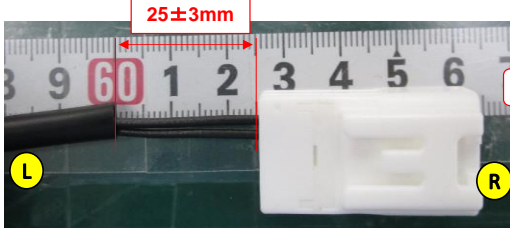
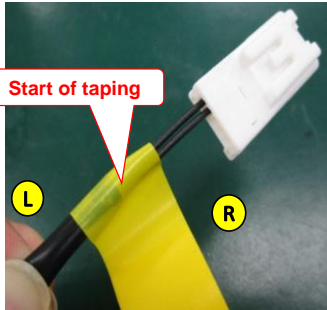
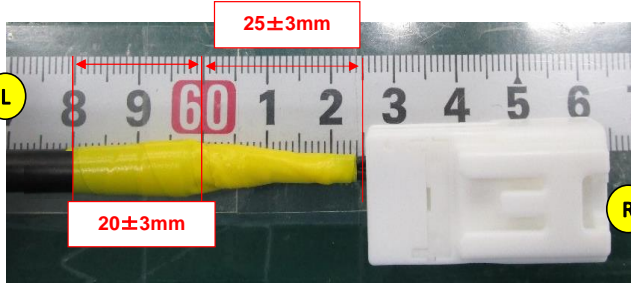

PARTS:		1. Pre-assy parts (AVSSf 0.3 wires B L=202mm [2pcs.]); Black SV tube (vinyl) ø4 L=130±3mm; Yellow tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
1	P1 Table Lay-out	<div style="text-align: center; border: 1px solid red; padding: 5px; margin-bottom: 10px;">TABLE LAY-OUT</div>	<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px solid red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	1.No missing parts/tools 2.No excess parts/tools	

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
06/11/24	3	Inclusion of Car model "TOYOTA-RAV-4" all improvements (Table lay-out; Quality checkpoints; Important reminders and note/s; Document references;). Standardized tube description SV tube (vinyl). Improved measurements and visual inspection.	D.Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a					
06/15/21	2	Transfer process owner from production WI (WI-PRO-ASY-128) to Engineering WI (WI-ENG-PDE-288). Improve process illustration and quality pointers. Removal of marking in process.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes									
03/17/20	1	Change process procedure	J. Silang	A. Morcozo	O. Merin										
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:		June 02, 2018						

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	3	Page No.:	2 of 4

PARTS:	1. Assy parts 2. Black SV tube (vinyl) ø4 L=130±3mm 3. Yellow tape				JIG:	n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
2	Wire insertion to Black SV tube (vinyl) ø4 L=130±3mm	 <div>1. Get the black SV tube (Vinyl) ø4 L=130±3mm using right hand then insert the B-B wires using left hand.</div>			 <div>MEASURING TAPE</div>	1. No wrong usage of parts 2. No deformed terminal		
3	P1 Taping 1 Black SV tube (vinyl) to wire near terminal	 <div>1. Hold the black SV tube (Vinyl) using left hand then measure from end of the tube up to connector 25±3mm using both hands.</div>  <div>2. Get the Yellow tape using right hand then start taping process using both hands.</div>  <div>3. After taping, check the measurement, wire alignment and taping condition.</div>			 <div>MEASURING TAPE</div>	<p><i>Important reminders and note/s;</i></p> <p>1. USE YELLOW TAPE only.</p> <p>2. <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p> <p>3. No need to fold the tube since it's ø4</p> <p>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</p> <p><i>Document reference/s:</i></p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p>		

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Effectivity Date:

June 11, 2024Model code/Part number: **320B / 7L0057-7022** Customer: **TRQSS** Car Model: **TOYOTA-RAV4**

Validity Date:

n/aPurpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

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3 of 4**PARTS:**

1. Assy parts

JIG:

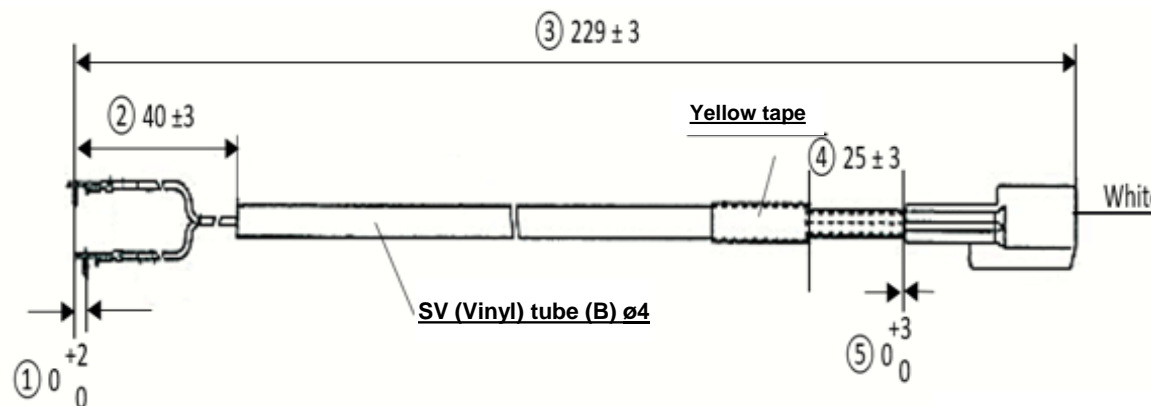
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NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

4

P1

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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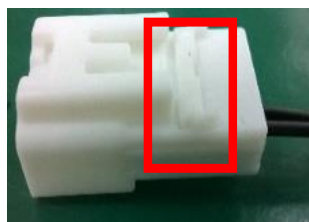
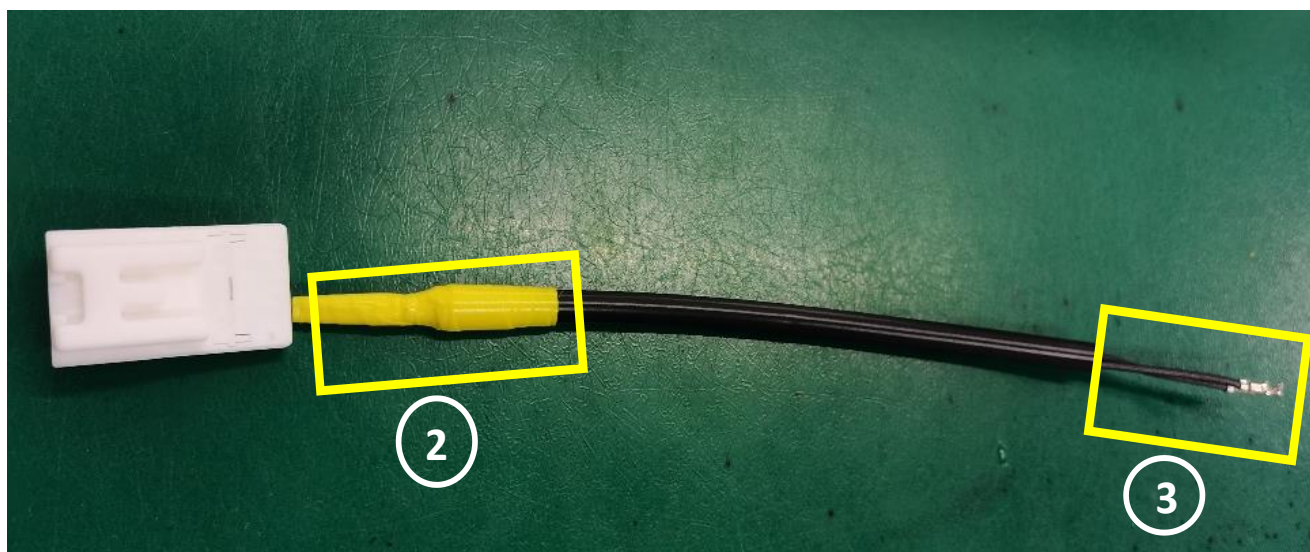
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PARTS:

1. Assy patrts

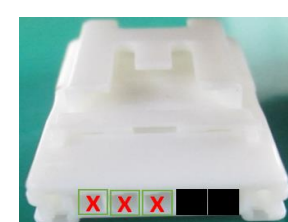
JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING-P1****7L0057-7022****GOOD****NO GOOD**

2

3

**GOOD****NO GOOD****① No Unlock Coupler****② No Missing Tape****③ No Deformed Terminal****④ No Wrong Insert**

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