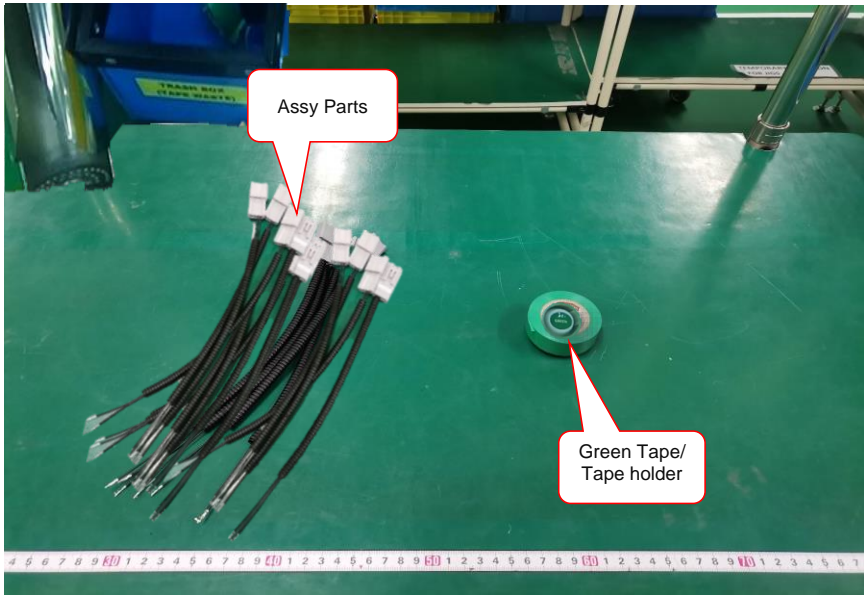




	WORK INSTRUCTION				Effectivity Date:		March 20, 2025	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 311D / 7L0158-7021		Customer: TRQSS		Car Model: TOYOTA-RAV4		Document No.: WI-ENG-PDE-1211	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: 1		Page No.: 1		1 of 4	

PARTS:		1. Assy parts 2. Green Tape		JIG:		n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
1	P1	<p style="text-align: center;">TABLE LAY-OUT</p> 	<p>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>Document reference/s: 1. Refer to WI-ENG-PDE-1210 for Offline assembly process</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>			

Revision History								Prepared by		Checked by		Reviewed by		Approved by	
03/20/25	1	Change from Pre-launch to Masspro.	D. Castillo	J.Loterte	C.Villanueva	A. Arañes		 D. Castillo	 J. Loterte	 C. Villanueva	 A. Arañes	Est. Date: March 5, 2025			
03/05/25	0	Initial issue.	D. Castillo	J.Loterte	C.Villanueva	A. Arañes									
Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved									

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model code/Part number:

311D / 7L0158-7021

Customer:

TRQSS

Car Model:

TOYOTA-RAV4

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

March 20, 2025

Validity Date:

n/a

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1

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PARTS:

1. Assy parts
2. Green Tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

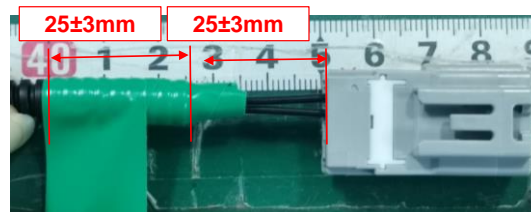
2

P1

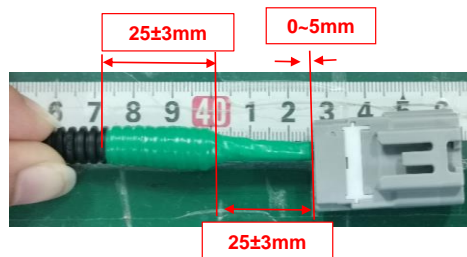
Taping
Corrugated tube to wire
near Connector



Start of
Taping



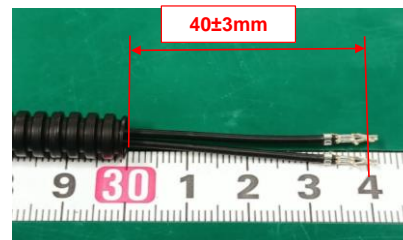
2. Hold the COT using left hand and measure from end of COT up to connector **25±3mm**.



25±3mm

0~5mm

25±3mm



40±3mm

3. After taping, check the measurement, taping condition and wire alignment.

MEASURING
TAPE



1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No wrong dimension
5. No wrong use of tape
6. No missing tape
7. No insufficient tape

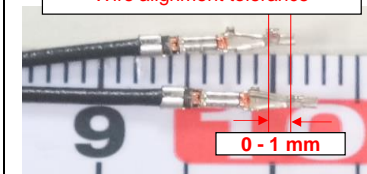
Important reminders/Note/s:

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

Document reference/s:

1. Refer to WI-PRO-ASY-001A for Taping process

Wire alignment tolerance



0 - 1 mm

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TAPING ASSEMBLY PROCESS

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March 20, 2025

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Purpose:


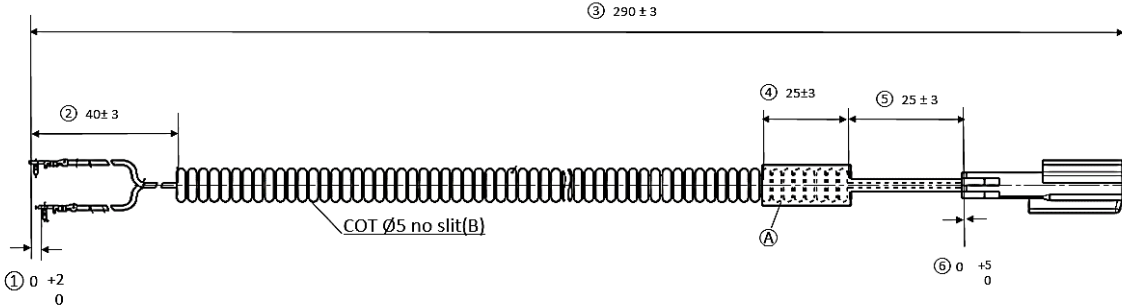
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1	Measurement	<div>MEASURING TAPE</div>   <div>NOTE: Ⓐ - Taping (G)</div>	<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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4 of 4**PARTS:**

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**TAPING - P1****7L0158-7021****① No Unlocked/Half-locked connector****③ No Deformed Terminal****② No Missing Tape****④ No Terminal Backing out**

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