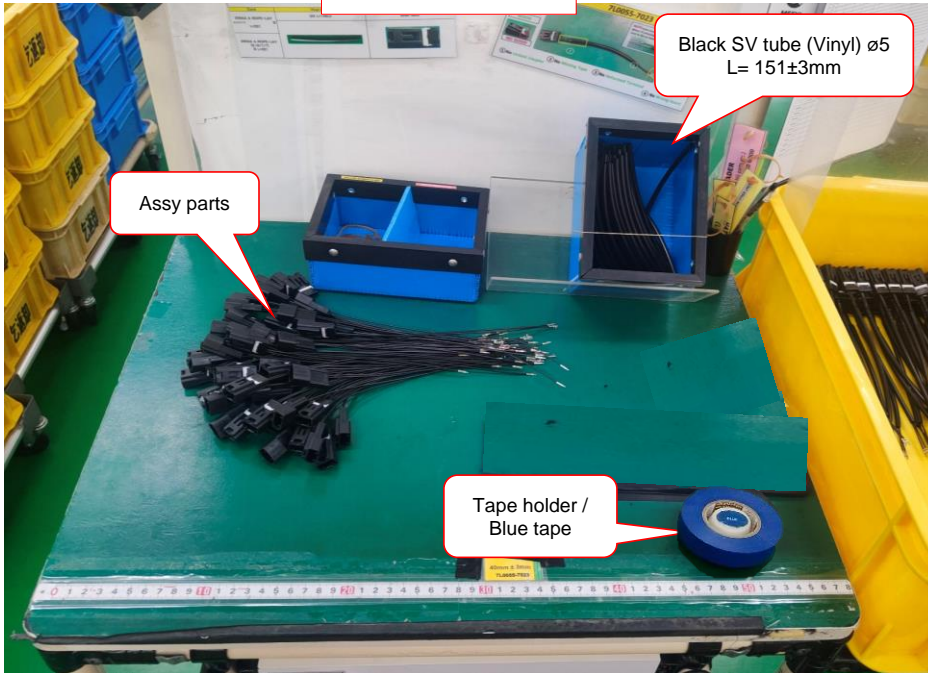






WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	July 02, 2024		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-788		
Revision No.:	1	Page No.:	1 of 4

Process Name/Title:
Model code/Part number: **311D / 7L0157-7021A** Customer: **TRQSS** Car Model: **TOYOTA RAV4**
Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:	1. Connector 6098-3803 (B); Black SV tube (Vinyl) ø5, t=0.5 L=151±3mm; Blue Tape			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1 Table Lay-out	<p>TABLE LAY-OUT</p>  <p>Black SV tube (Vinyl) ø5 L= 151±3mm</p> <p>Assy parts</p> <p>Tape holder / Blue tape</p>		<p>Safety Instruction Be sure to wear prescribed 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. Please refer to WI-ENG-PDE-282 Offline Assembly process</p> <p>1. No missing parts/tools 2.No excess parts/tools</p>

Revision History							Prepared by	Reviewed by	Approved by	Noted by
										n/a
07/02/24	1	Inclusion of table lay-out and transfer wire insertion to connector in Offline assembly process.	A.Hernandez	C. Villanueva	A. Arañes	n/a				
01/03/24	0	Initial issue.	M. Ariola	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change			Revised	Reviewed	Approved	Noted	Est. Date:	January 03, 2024

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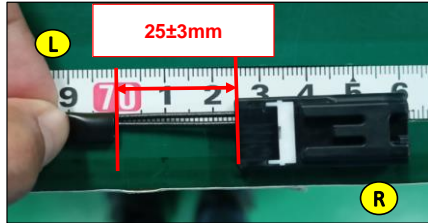
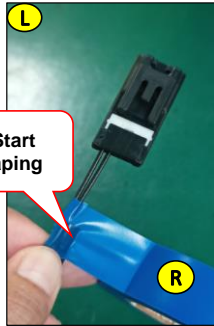

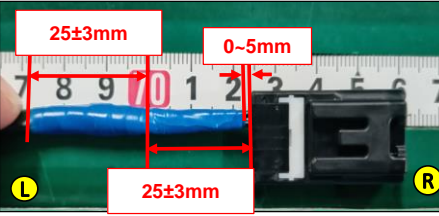
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Black SV tube (Vinyl) $\phi 5$, $t=0.5$ L=151 \pm 3mm 3. Blue tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Black SV tube (Vinyl) $\phi 5$, $t=0.5$ L=151 \pm 3mm	 <div>1. Get the Black SV tube (Vinyl) $\phi 5$, $t=0.5$ L=151\pm3mm using right hand then insert the B-B wire using left hand.</div>		n/a	1. No wrong usage of parts. 2. No deformed terminal.
3	P1 Taping 1 Black SV tube to wire near connector	 <div>1. Hold the Black SV tube (Vinyl) using left hand then measure from end of tube up to end of connector L=25\pm3mm using both hands.</div>  <div>2. Hold the harness using left hand, Get the Blue tape using right hand then start taping process using both hands.</div>   <div>3. After taping, check the measurement and taping condition.</div>			Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Use BLUE TAPE only. 1. No flip-out tape 2. No Pell-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension

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TAPING ASSEMBLY PROCESS

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311D**/****7L0157-7021A**

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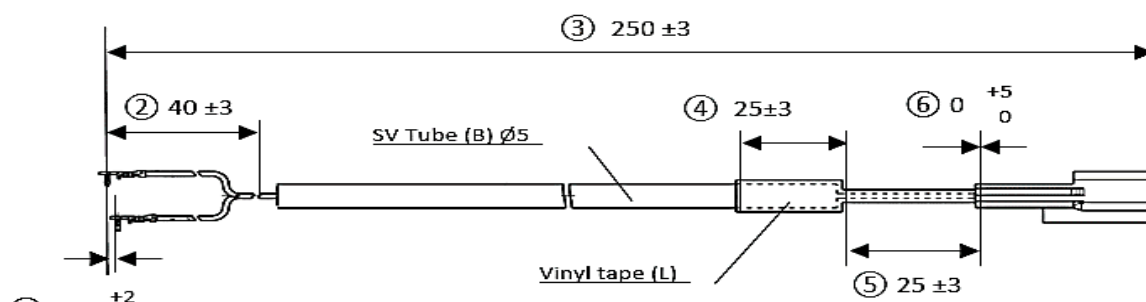
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

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PARTS:		n/a		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	Measurement			<p>1. No wrong dimension</p> <p>Important Reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono only</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub assembly Hatsumono, Nakamono, and Owarimono Inspection.</p>

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Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.: 4 of 4

PARTS:	n/a	JIG:	n/a
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VISUAL INSPECTION/QUALITY CHECKPOINTS

P1

7L0157-7021A



1 No Unlock connector

3 No Deformed terminal

5 No Terminal Backing Out

2 No Wrong insert

4 No Wrong color of tape (Must be BLUE TAPE only)

6 Check the Alignment

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