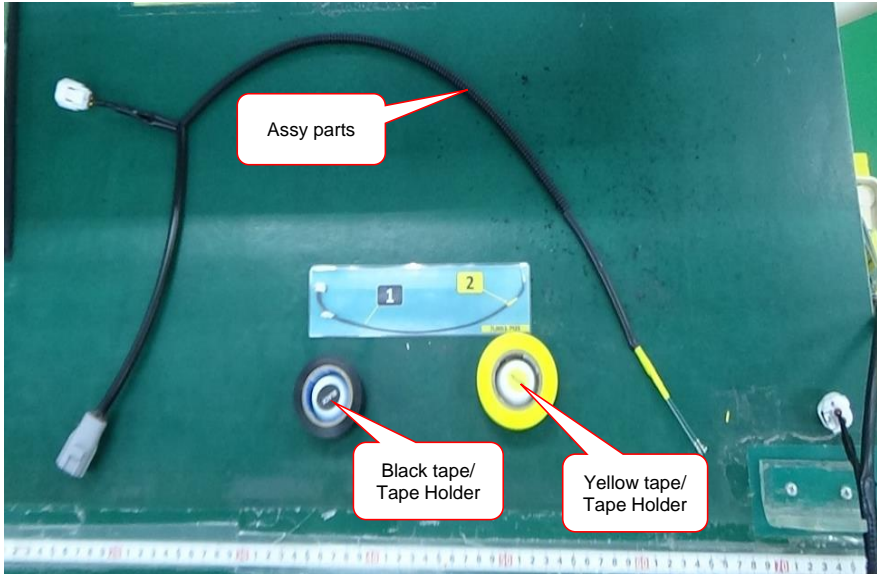
	WORK INSTRUCTION				Effectivity Date:		September 12, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 320B / 7L0053-7025A		Customer: TRQSS	Car Model: TOYOTA-RAV4	Document No.:		WI-ENG-PDE-1035C	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		1	Page No.:	1 of 5	

PARTS:		1. Assy parts; Black tape; Yellow tape			JIG:		n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	P3	<div>TABLE LAY-OUT</div> 				<div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>		<p>1. No missing parts/tools 2. No excess parts/tools</p>	

Revision History								Prepared by		Reviewed by		Approved by		Noted by		
09/12/24 1 Change from Pre-launch to Masspro.								D. Castillo		C. Villanueva		A. Arañes		n/a		
09/11/24 0 Initial issue.								D. Castillo		C. Villanueva		A. Arañes		n/a		
Eff. Date	Rev. No	Details of Change						Revised	Reviewed	Approved	Noted	Est. Date:	September 11, 2024			

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## PARTS:

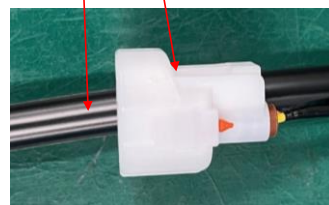
1. Assy parts
2. Black tape

JIG:

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3	Y-taping		

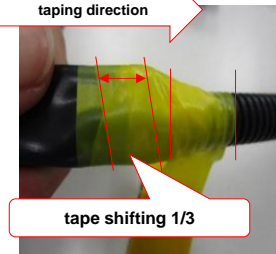
No Gap



1. Fix the two (2) SV tubes (Vinyl) and COT using both hands.

*Note: Connector facing and position of two (2) SV tube (Vinyl) must be same with the illustration.*

taping direction



tape shifting 1/3

## Connector facing and Y-taping facing

Top of tube



taping direction



tape shifting 1/2

2. Start taping at the middle of combined tubes, attach the tape on the top of tube. Then make pre-tape **2 windings**. Winding the tape **1/2 shifting** going to the left side. Make **2 windings**, width must be **20±3mm**.  
*Note: Do not exert excessive force during pulling & winding of tape.*

3. Winding the tape **1/3 shifting** going to the right side until reach the other side of tube. Make **2 windings**, width must be **20±3mm**.

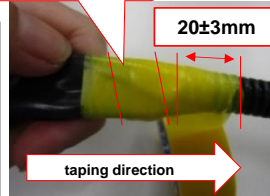


tape shifting 1/2

20±3mm

4. Winding the tape **1/2 shifting** going to the left side. Make **2 windings**, width must be **20±3mm**.

tape shifting 1/2



20±3mm

5. Winding the tape **1/2 shifting** going to the right side until it reach the other side of tube. Make **3 winds**, width must be **20±3mm**. Then cut the tape.

## Document reference/s:

1. Refer to WI-PRO-ASY-001C for taping procedure (special).

## Important reminders/Note/s:

1. Use **YELLOW TAPE** for easy visualization of shifting lines, but actual should be **BLACK TAPE**.
2. Please use calibrated/verified measuring tape when getting the measurement.

1. No peel-off tape
2. No flip out tape
3. No loose tape
4. No wrong use of tape
5. No wrong dimension
6. No missing tape
7. Must follow the connector facing

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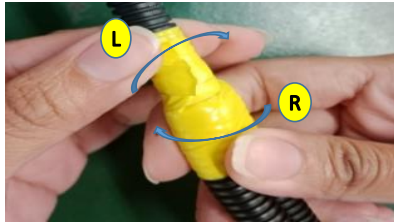
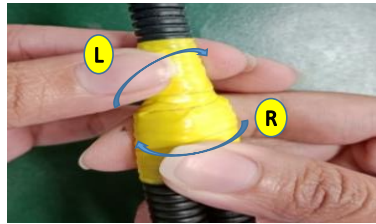
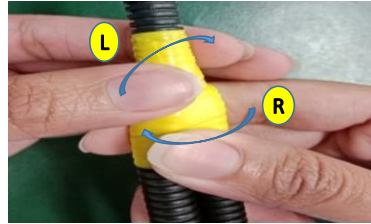
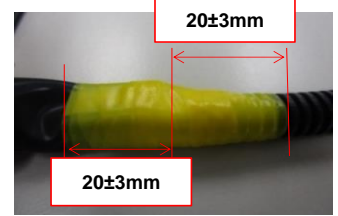

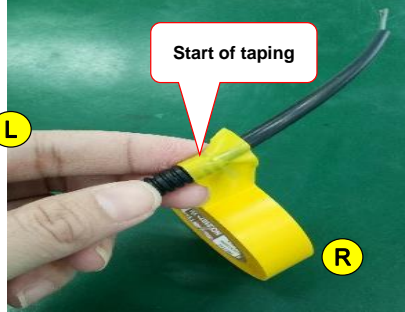
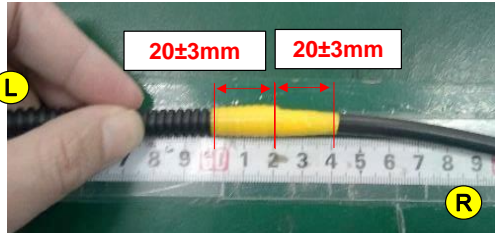

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### PARTS:

1. Assy parts
2. Yellow tape

JIG:

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Y-taping (Continuation)	 6. conduct proper pressing of end tape using left hand ( <b>top part</b> )  7. conduct proper pressing of end tape using left hand ( <b>Middle part</b> )  8. conduct proper pressing of end tape using left hand ( <b>bottom part</b> )		 9. Check the Measurement and condition of tape.
3	P3  Taping 3 Black Corrugated tube to VM tube (Sunprene)	 1. Hold the COT using left hand and fix the sunprene tube using right hand. <b>Note: Must be no gap between tubes</b>  2. Hold the assy parts using left hand. Get the <b>Yellow tape</b> and start taping process using both hands.  3. After taping, check the measurement and taping condition.	 <b>MEASURING TAPE</b>	<ol style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong dimension</li><li>6. No wrong use of tape</li></ol> <p><b>Important reminder/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></p> <p><b>Document references:</b> <b>1. Please refer to WI-PRO-ASY-001 for taping procedure.</b></p>

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**PARTS:**

1. Assy parts

JIG:

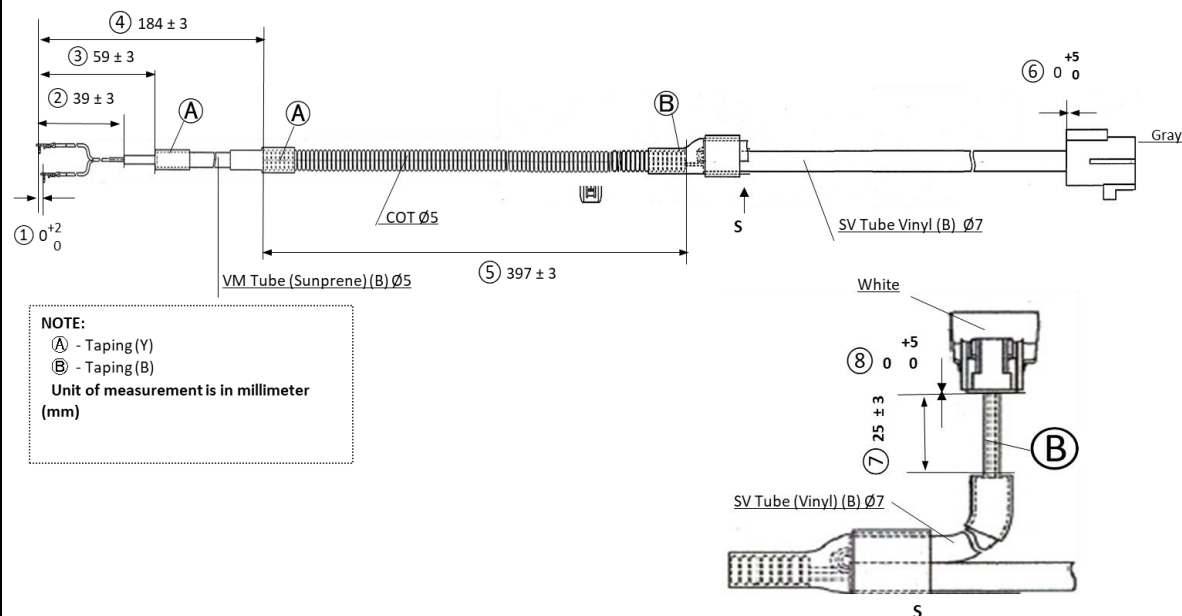
n/a

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

4

P3

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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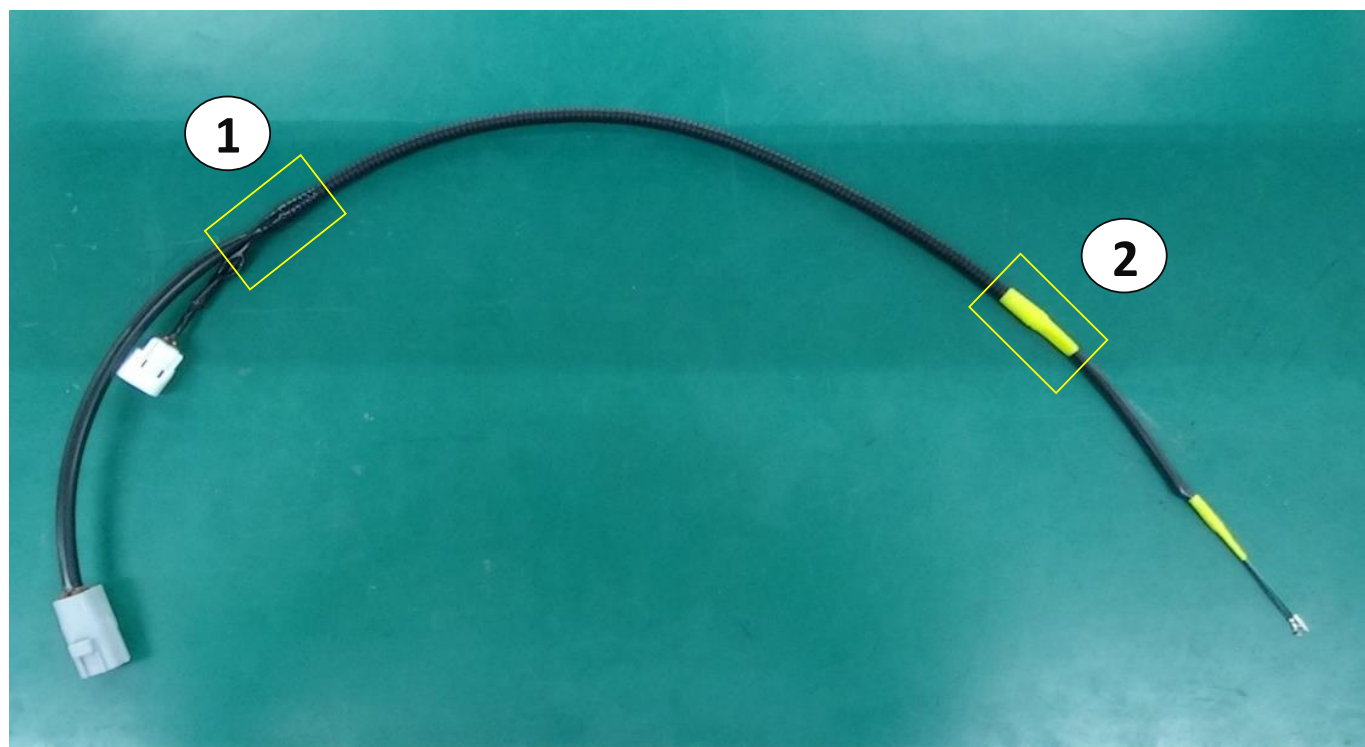
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P3****7L0053-7025A**

① **No Missing Tape**  
**No wrong use of**  
**tape (Black tape)**

② **No Missing Tape**  
**No wrong use**  
**tape (Yellow)**

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