



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

September 12, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

320B / 7L0054-7025A

Customer:

TRQSS

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-1038B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1. Assy parts; Black tape ;Yellow tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

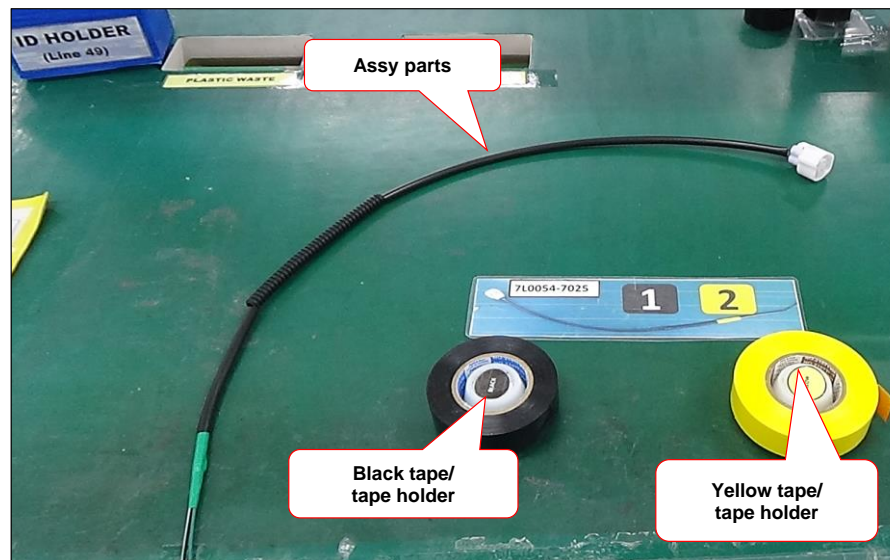
QUALITY POINTERS

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.

1. No missing parts/tools
2. No excess parts/tools
3. No wrong positions of parts/tools


Revision History



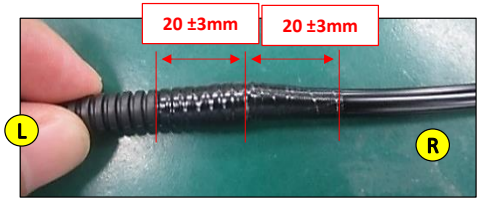

Revision History							Prepared by	Reviewed by	Approved by	Noted by
										n/a
09/12/24	1	Change from Pre-launch to Masspro.	D.Castillo	C. Villanueva	A. Arañes	n/a				
09/10/24	0	Initial issue. Improvement of visual inspection and quality checkpoints.	D.Castillo	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 10, 2024		

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	Model code/Part number: 320B / 7L0054-7025A		Customer: TRQSS	Car Model: TOYOTA-RAV4	Document No.:	WI-ENG-PDE-1038B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	2 of 5

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 2 Black Corrugated tube to Black SV tube (vinyl) near connector	<div><p>1. Hold the Black COT using left hand and fix the Black SV tube (Vinyl) using right hand.</p><p><i>Note: Must be NO GAP between tubes</i></p></div> <div><p>2. Hold the assy parts using left hand. Get the Black tape and start taping process using both hands.</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>		<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. Must be no gap between COT and Vinyl tube.</p> <p>Document references:</p> <p>1. Please refer to WI-PRO-ASY-001 for taping procedure.</p> <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>

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PARTS:

1. Assy parts
2. Yellow tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

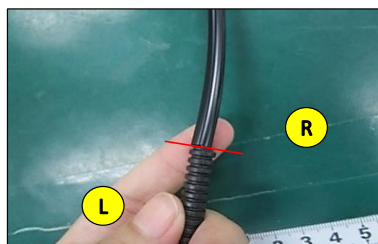
TOOLS/PPE

QUALITY POINTERS

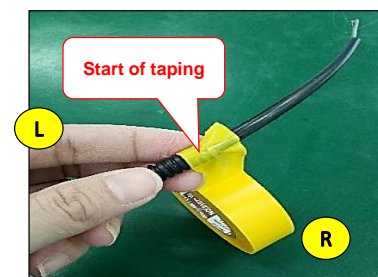
3

P2

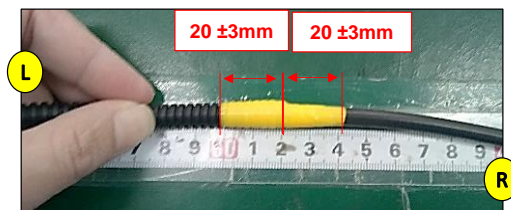
Taping 3
Black corrugated tube to
Black VM tube (Sunprene)
near terminal



1. Hold the Black COT using left hand and fix the Black VM tube (Sunprene) using right hand.



2. Hold the assy parts using left hand. Get the **Yellow tape** and start taping process using both hands.



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

MEASURING TAPE



Important reminders/Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.
2. Must be no gap between COT and Vinyl tube.

Document references:

1. Please refer to WI-PRO-ASY-001 for taping procedure.

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

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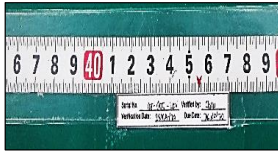
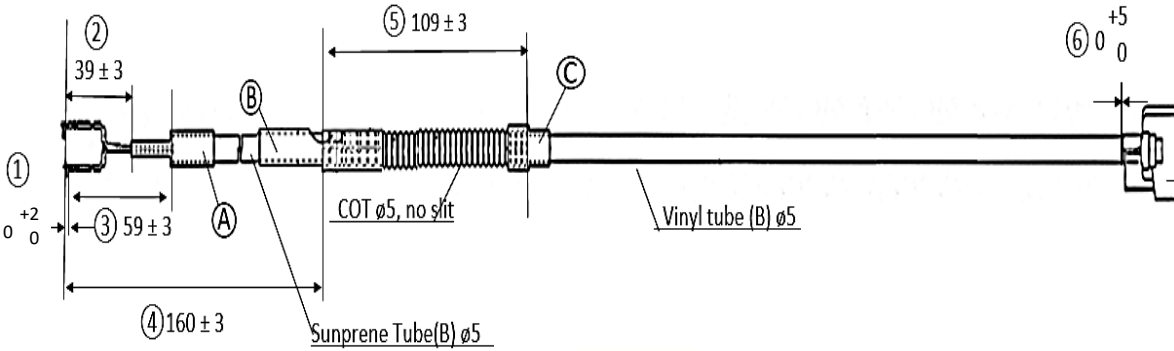
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

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PARTS:		1.Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Measurement		<div><div>MEASURING TAPE</div></div>  <div><p>NOTE:</p><ul style="list-style-type: none">Ⓐ - Taping (G)Ⓑ - Taping (Y)Ⓒ - Taping (B)</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,Nakamono 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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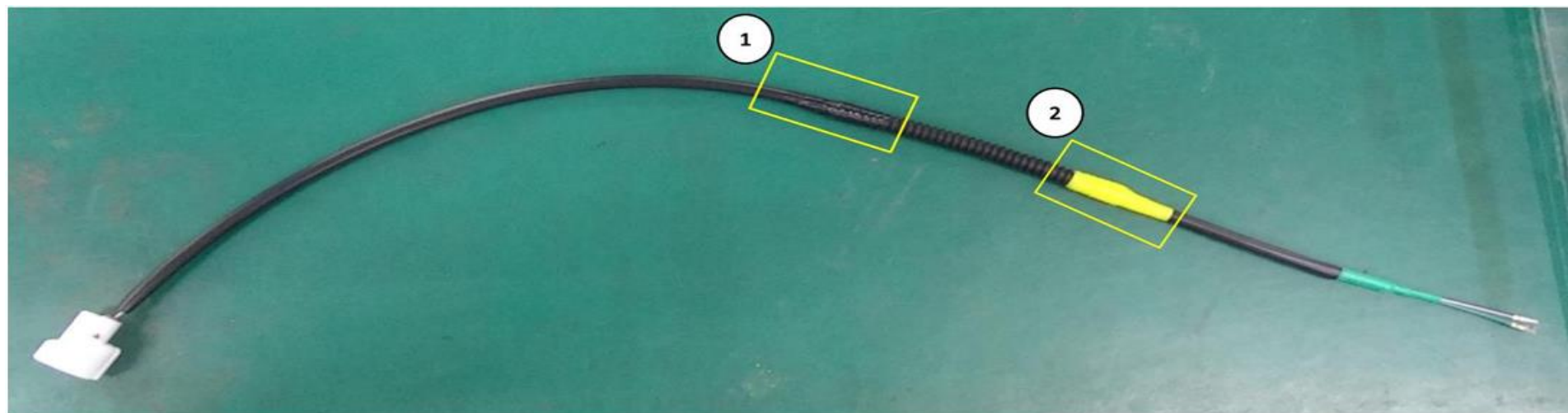
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**TAPING - P2****7L0054-7025A****1**

No Missing Tape
No wrong use of tape (Black)

2

No Missing Tape
No wrong use tape (Yellow)

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