



## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

June 27, 2024

Process Name/Title:

Model code/Part number:

311D / 7L0158-7020A

Customer:

TRQSS

Car Model:

TOYOTA-RAV4

Validity Date:

n/a

Document No.:

WI-ENG-PDE-789

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS: 1. Assy parts; Green Tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

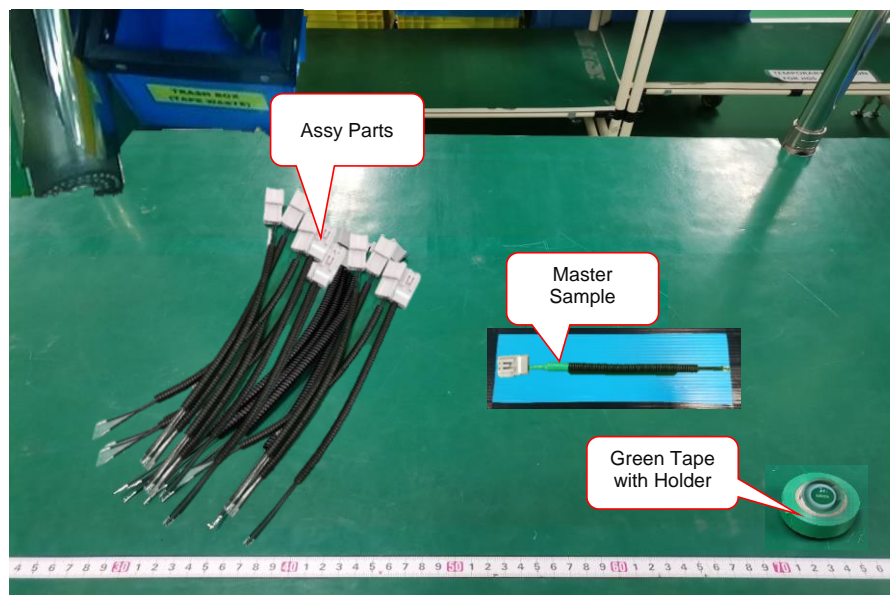
QUALITY POINTERS

1

n/a

Table Lay-out

## TABLE LAY-OUT

**Safety Instruction**

Be sure to wear required 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

## Revision History

Prepared by

Reviewed by

Approved by

Noted by

06/27/24 1 Transfer insertion process and wire insert to corrugated tube to offline assembly process. Inclusion of Table lay-out.

A.Hernandez

C.Villanueva

A. Arañes

n/a

02/05/24 0 Initial issue.

A.Hernandez

C.Villanueva

A. Arañes

n/a

Eff. Date Rev. No Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

February 05, 2024

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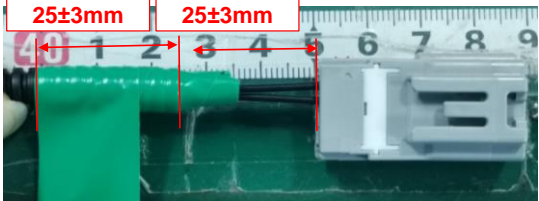
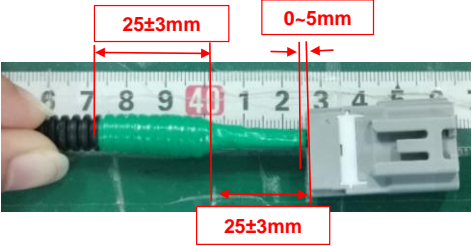
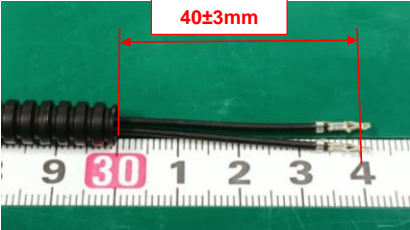

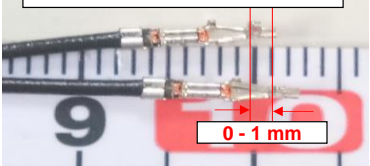
☒ MASSPRO

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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	n/a Taping Corrugated tube to wire near Connector	<div><p>Start of Tape</p></div> <div><p>25±3mm 25±3mm</p></div> <div><p>25±3mm 0~5mm 25±3mm</p></div> <div><p>40±3mm</p></div> <div><p>1. Get the <b>Green tape</b> using right hand then start taping process using both hands.</p><p>2. Hold the COT using left hand and measure from end of COT up to connector <b>25±3mm</b>.</p><p>3. After taping, check the measurement, taping condition an wire alignment.</p></div> <div><p><b>MEASURING TAPE</b></p></div>			<p>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</p> <p><b>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></p> <div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div>

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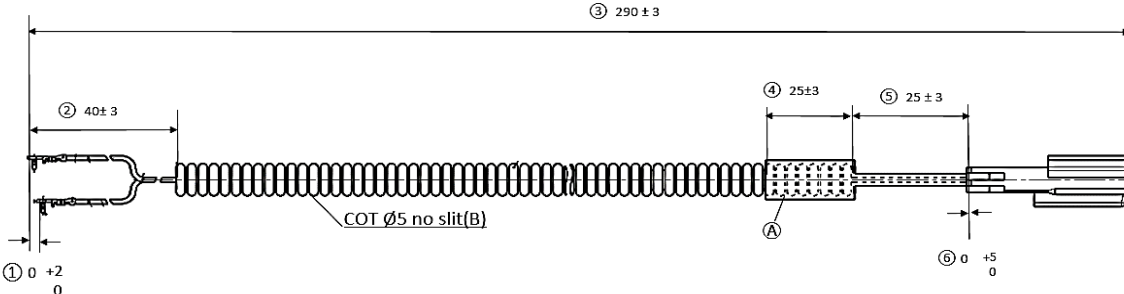
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts		JIG:	n/a											
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS											
3	n/a  Measurement	<div><div>MEASURING TAPE</div></div> <div><p>NOTE: Ⓐ - Taping (G)</p><table><tr><th colspan="3">WIRE TYPE TABLE</th></tr><tr><th>No.</th><th>Color</th><th>Wire Type</th></tr><tr><td>1</td><td>B</td><td>IRRAX 0.3</td></tr><tr><td>2</td><td>B</td><td>IRRAX 0.3</td></tr></table></div>	WIRE TYPE TABLE			No.	Color	Wire Type	1	B	IRRAX 0.3	2	B	IRRAX 0.3	<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>
WIRE TYPE TABLE															
No.	Color	Wire Type													
1	B	IRRAX 0.3													
2	B	IRRAX 0.3													

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PARTS:

n/a

JIG:

n/a

**VISUAL INSPECTION/QUALITY CHECKPOINTS****P1****7L0158-7020A****GOOD****NO GOOD****1****No Unlock/Halflock  
Connector****2****No Missing Tape****3****No Deformed  
Terminal**

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