



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

January 16, 2025

Process Name/Title:

Model code/Part number:

412D / 628128-0000A

Customer: TRJ

Car Model: TOYOTA-RAV 4

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1173B

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

0

Page No.:

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PARTS: 1. Assy parts; Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

P2

Table Lay-out

TABLE LAY-OUT

Assy parts

Tape holder/ Black tape

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.

Revision History

Prepared by

Reviewed by

Approved by

Noted by

01/16/25 0 Initial issue.

A.Hernandez C. Villanueva A.Arañes n/a

A.Hernandez

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Eff. Date Rev. No

Details of Change

Revised Reviewed

Approved Noted

Est. Date:

January 16, 2025

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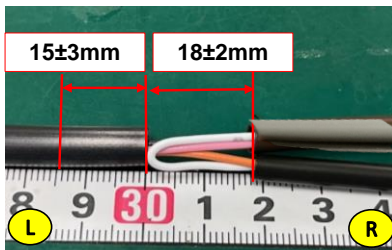
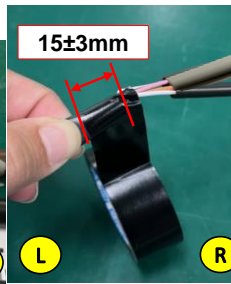

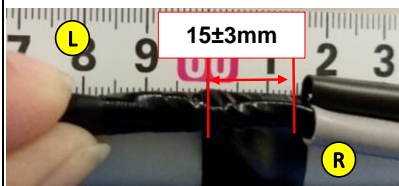

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PARTS:		1. Assy Parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 1 Black VM tube (Sunprene) to Wire	<div></div> <div><p>1. Hold the assy parts using both hands. Measure from end of VM tube to end of VM tube 18±2mm. Measure VM tube up to end of VM tube 15±3mm for taping.</p></div> <div></div> <div><p>2. Measure from end of VM tube (Sunprene) up to end of tape (15±3mm) then continue the taping process.</p></div> <div></div> <div><p>3. Measure from end of VM tube (Sunprene) up to end of tape (15±3mm) then continue the taping process.</p></div> <div></div> <div><p>3. After taping, Check the measurement, wire alignment and taping condition. Note: Taping must be 30mm</p></div> <div></div> <div>MEASURING TAPE</div>		<div>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</div> <div>Important Reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div>	

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PARTS:		1. Assy parts 2. Master sample	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 Visual/By two's Inspection	<div>1. Check the connector lock. Locking of connector is included in Steering Electrical test.</div> <div>2. Check the wire alignment. Must be no tangled wires.</div> <div>3. Check the Terminal if with Backing out (Not fully inserted) or no deformed terminal.</div> <div> ACTUAL PRODUCT</div> <div>4. Check the presence and position of retainer (2 connectors).</div> <div>4. Check the orientation of harness.</div> <div>5. Compare to Master sample by tapping</div> <div> ASSEMBLED PARTS MASTER SAMPLE MASTER SAMPLE</div>		<p>Document reference/s:</p> <p>1. Refer to WI-QAD-QAC-252 Steering Electrical Test</p> <div>MASTER SAMPLE</div> <div></div>

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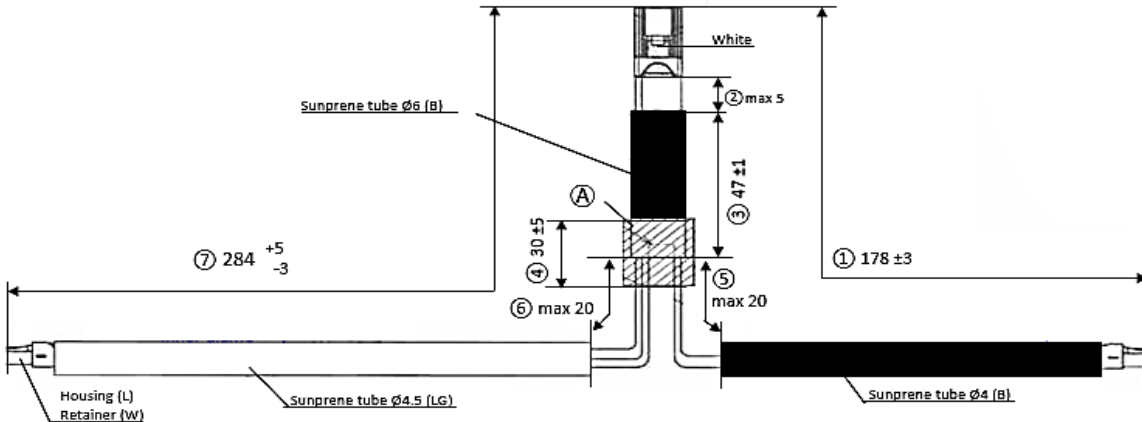
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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Measurement	<div><div>MEASURING TAPE</div></div> 		<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring 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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n/a

JIG:

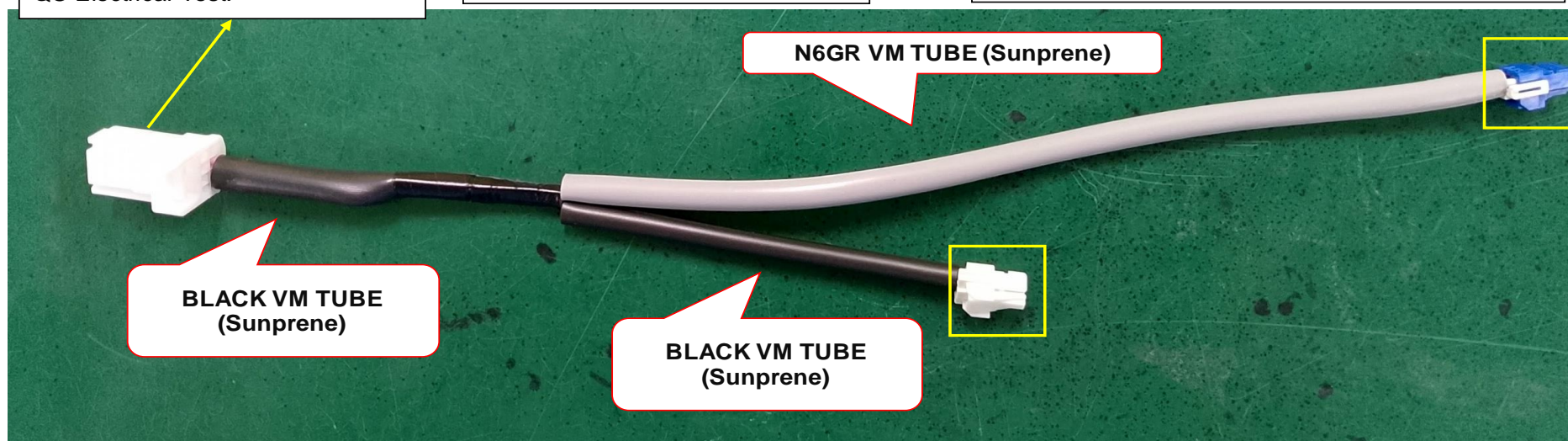
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VISUAL INSPECTION/ QUALITY CHECKPOINTS**P2****628128-0000A**

1. Check the connector lock.
Locking of connector is included in
QC Electrical Test.

2. Check the wire alignment. Make
sure no tangled wires.

3. Check the terminal if with backing out (not fully
inserted) or deformed terminal.



4. Check the orientation of harness.

5. Check if no missing parts.(Retainer)

6. No Missing Tape

7. Compare to Master Sample by
tapping.

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