

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

July 13, 2023

Validity Date:

n/a

Model code/Part number:

320B

7L0054-7025

Customer:

TRQSS

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-141B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

8

Page No.:

1 of 4

PARTS:

1. Assy parts; Black tape;Yellow tape

JIG:

n/a

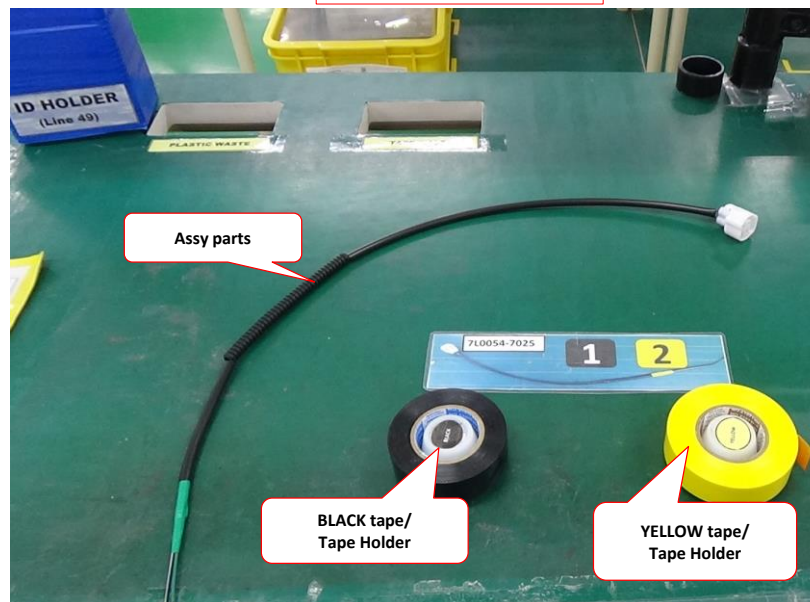
NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

1

P2

Table lay-out

8

**TABLE LAY-OUT****Safety Instruction**

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

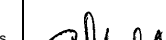



1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

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
07/13/23	8	Updated Template; Inclusion of CAR MODEL "TOYOTA RAV4"; Remove and transferred process of Taping 1- Black VM tube (Sunprene) to wire near terminal from P2 to P1; Process no. 2, 4, 5 and 6 from P2 to CLAMP ASSEMBLY PROCESS ; Updated Table lay-out and Quality Checkpoints illustrations.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
02/08/23	7	Work instruction improvement. Improved quality pointers. Change term Black sunprene tube to VM tube (Sunprene). Inclusion of Quality check point (Page 4).	D. Castillo	J. Loterte	C. Villanueva	A. Arañes				
01/15/22	6	Change part number from 7L0054-7024 to 7L0054-7025 due to change in PCB from 2 chip(61C619-0002) to 1 chip(7N0994-7060);Change in wire color from Gray (GR) to Green (G).	K. Doria	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	July 12, 2018		

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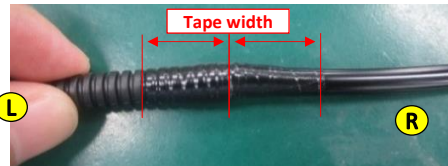

☒ MASSPRO

Revision No.:

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Page No.:

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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	<div>8</div> P2 Taping 1 Black Corrugated tube to Black SV tube (vinyl) near connector	<div><p>1. Hold the COT using left hand and fix the SV tube (Vinyl) using right hand. Note: Must be no gap between tubes</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>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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☐ PROTOTYPE

☐ PRE-LAUNCH

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8

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PARTS:

1. Assy parts
2. Yellow tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

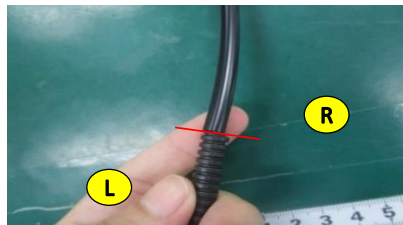
QUALITY POINTERS

3

8

P2

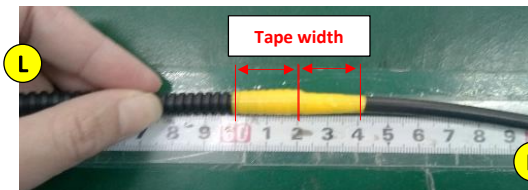
Taping 2
Black corrugated tube to
Black VM tube
(Sunprene) near
terminal



1. Hold the COT using left hand and fix the 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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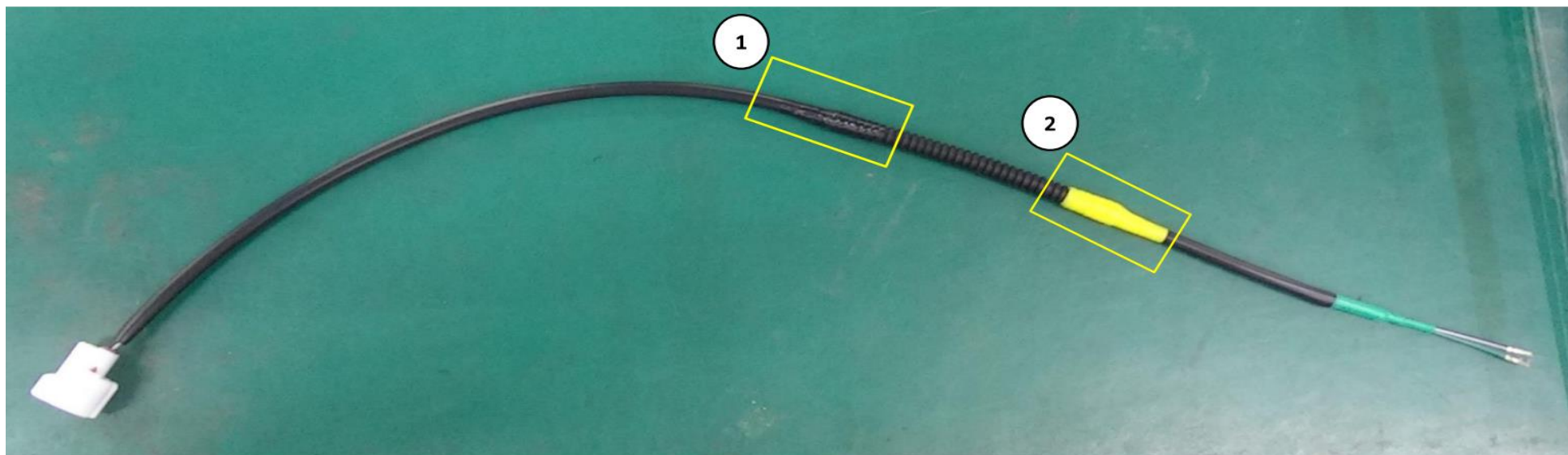
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PARTS:

n/a

JIG

n/a

**QUALITY CHECKPOINTS****P2****7L0054-7025****1****No Missing Tape****No Wrong use of tape (BLACK)****2****No Missing Tape****No Wrong use of tape (YELLOW)**

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