



## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

311D / 7L0152-7024

Customer:

TRQSS

Car Model:

TOYOTA RAV 4

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

May 15, 2025

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1257A

Revision No.:

1

Page No.:

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## PARTS:

1. Assy parts; AVSSf 0.3 B-B wire L=661mm; Black corrugated tube ø5 L=445±3mm (no slit); Black VM tube (Sunprene) Ø9 L=112±3mm ; Black Tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

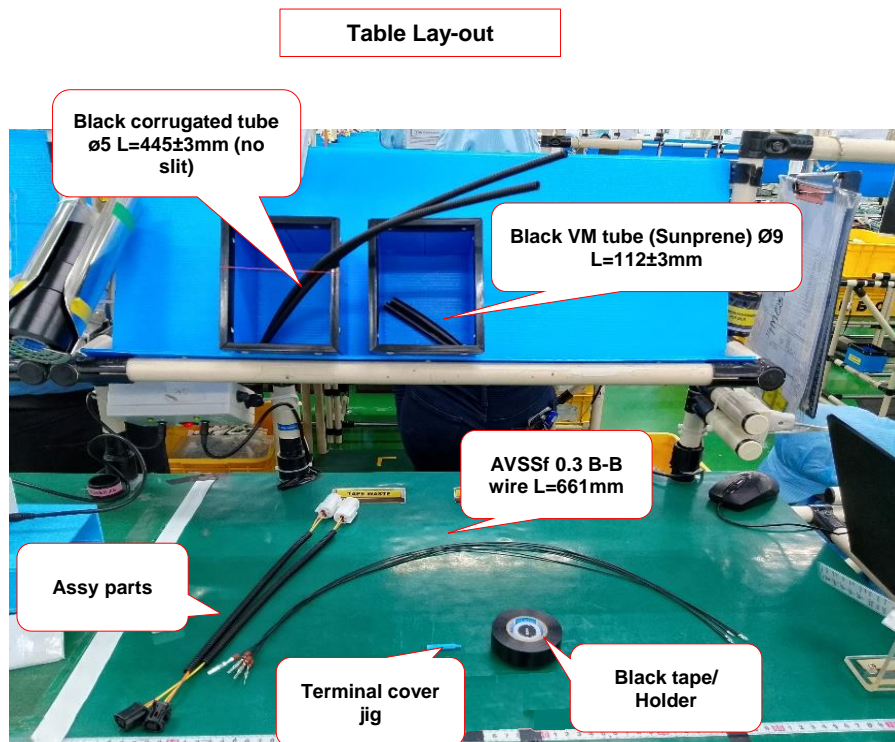
TOOLS/PPE

QUALITY POINTERS

1

P1

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.

**Important reminders/Note/s:**

1. Refer to WI-ENG-PDE-675 for Offline assembly process
2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

1. No missing parts/tools
2. No excess parts/tools

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Checked by	Reviewed by	Approved by
05/15/25	1	Change documents purpose from pre-launch to mass pro.	A.Hernandez	J.Loterte	C. Villanueva	A. Arañes	A.Hernandez	J.Loterte	C. Villanueva	A. Arañes
04/28/25	0	Initial issue.	A.Hernandez	J.Loterte	C. Villanueva	A. Arañes	A.Hernandez	J.Loterte	C. Villanueva	A. Arañes

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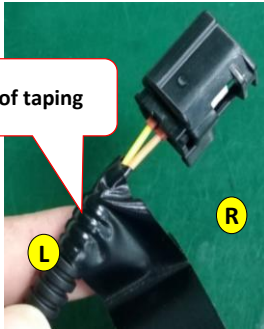
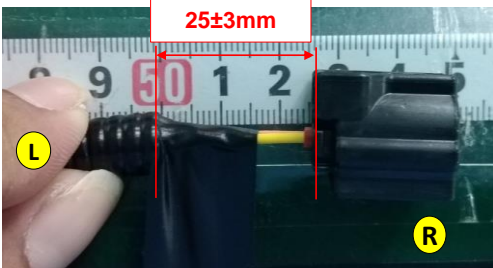
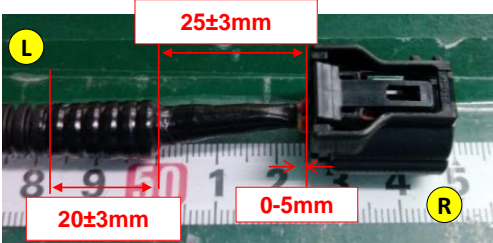

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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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	P1 Taping 1 Black Corrugated tube to Wire near connector	<div><p>Start of taping</p></div> <div><p>25±3mm</p></div> <div><p>20±3mm 0-5mm</p></div> <div>1. Hold the COT then get <b>Black tape</b> using right hand then start taping process using both hands.</div> <div>2. Measure from end of COT up to edge of connector <b>25±3mm</b> then continue the taping process using both hands.</div> <div>3. After taping, check the measurement and taping condition.</div>		<div><b>MEASURING TAPE</b></div> 	<p><b>Important reminders and Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></p> <p><b>Document reference/s:</b> <b>1. Refer to WI-PRO-ASY-001A for taping procedure.</b></p> <ul 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 wrong dimension</li><li>5. No wrong use of tape</li><li>6. No missing tape</li><li>7. No insufficient tape</li></ul>

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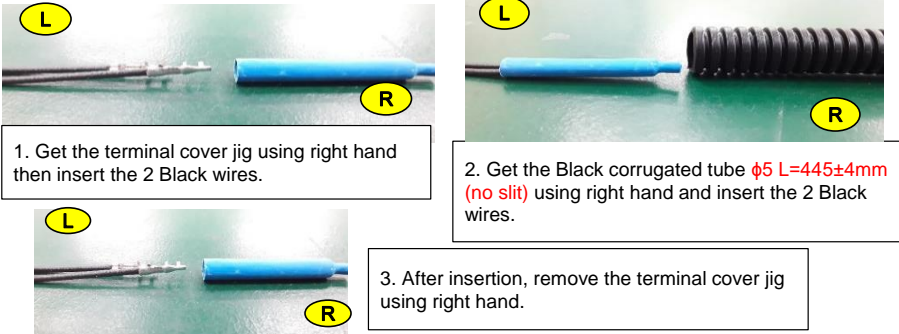
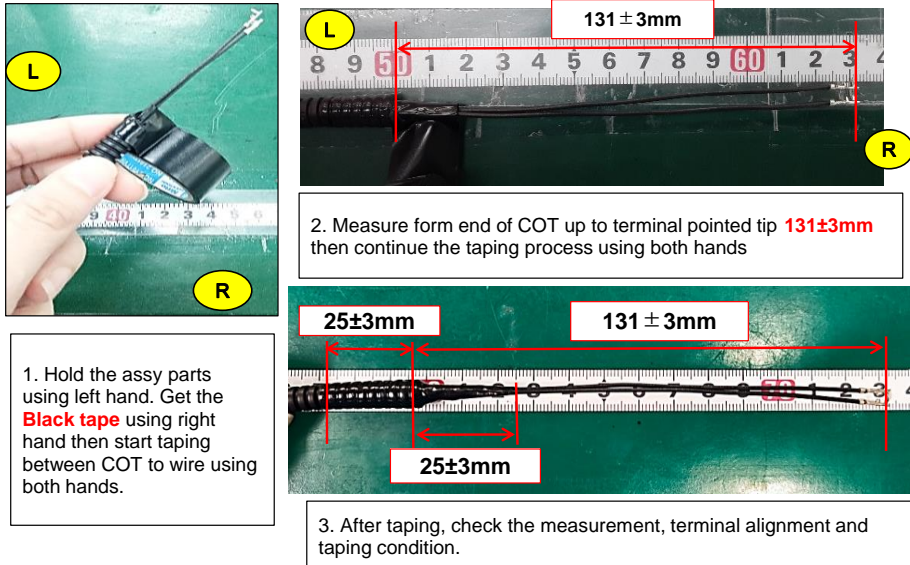

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PARTS:		1. AVSSf 0.3 B-B wire L=661mm 2. Black corrugated tube $\phi 5$ L=445 $\pm$ 3mm (no slit) 3. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Wire Insertion to Black corrugated tube $\phi 5$ L=445 $\pm$ 3mm (no slit)	 <p>1. Get the terminal cover jig using right hand then insert the 2 Black wires.</p> <p>2. Get the Black corrugated tube <math>\phi 5</math> L=445<math>\pm</math>4mm (no slit) using right hand and insert the 2 Black wires.</p> <p>3. After insertion, remove the terminal cover jig using right hand.</p>		n/a	1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape
4		 <p>1. Hold the assy parts using left hand. Get the <b>Black tape</b> using right hand then start taping between COT to wire using both hands.</p> <p>2. Measure from end of COT up to terminal pointed tip <b>131<math>\pm</math>3mm</b> then continue the taping process using both hands</p> <p>3. After taping, check the measurement, terminal alignment and taping condition.</p>			<b>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b> <b>Document references:</b> <b>1. Refer to WI-PRO-ASY-001A for Taping process</b> 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 7. No insufficient tape

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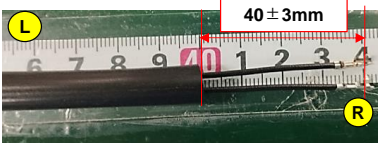

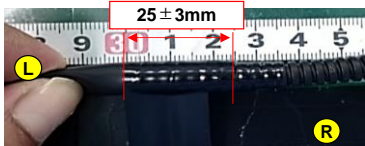
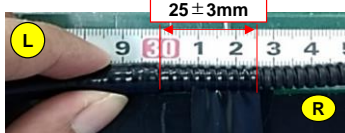
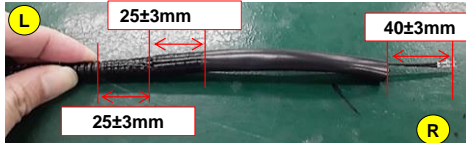


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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) Ø9 L=112±3mm 3. Black Tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5		<p>Wire insertion to Black VM tube (Sunprene) Ø9 L=112±3mm</p>  <p>1. Get the Black VM tube (Sunprene) Ø9 L=112±3mm using right hand then insert the assy parts using left hand.</p>	n/a	1. No wrong use of parts 2. no deformed terminal
6	P1	<p>Taping 3 COT to VM tube (Sunprene)</p>  <p>1. Measure from end of tube up to terminal pointed tip 31±3mm using both hands.</p>  <p>2. Hold the Assy parts using left hand, get the Black tape using right hand then start pre-taping using both hands.</p>  <p>3. Confirm measurement of 25±3mm from end of tape up to end of tube then continue the taping process using both hands.</p>  <p>4. Confirm measurement of 25±3mm from end of tube up to end of tape then continue the taping process using both hands.</p>  <p>5. After taping, check the measurement, terminal appearance and taping condition.</p>	<p>MEASURING TAPE</p> 	<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 7. No insufficient tape 8. Check the tape from COT to VM tube (Sunprene) (Conduct bending for verification)</p> <p><b>Important reminders/Note/s:</b> 1. Please use calibrated/verified measuring tape when getting the measurement.</p>  <p><b>Document references:</b> 1. Refer to WI-PRO-ASY-001A for Taping process</p>

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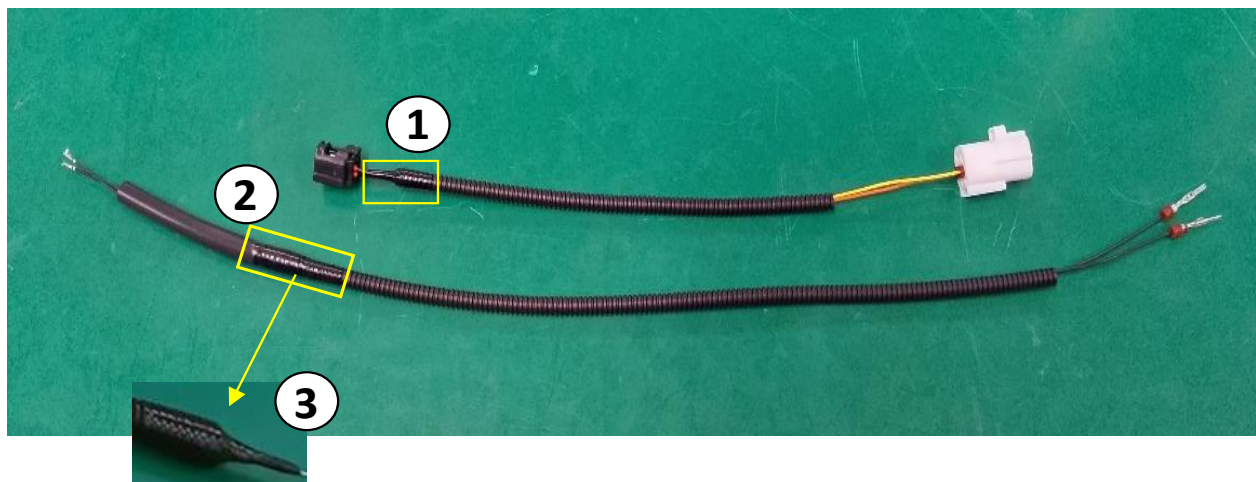
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**PARTS:**

1. Assy Parts

JIG:

n/a

**VISUAL INSPECTION / QUALITY CHECKPOINTS****TAPING - P1****7L0152-7024**

- ① ② No Missing TAPE
- ③ No Missing Inside Taping
- ④ No Deformed Terminal

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