



## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

311D/ 7L0156-7021

Customer:

TRQSS

Car Model:

TOYOTA-RAV 4

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

July 02, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-781

Revision No.:

1

Page No.:

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PARTS: 1. Assy parts; Black SV tube (vinyl) ø5 t=0.5 L= 129±3mm; Pink Tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

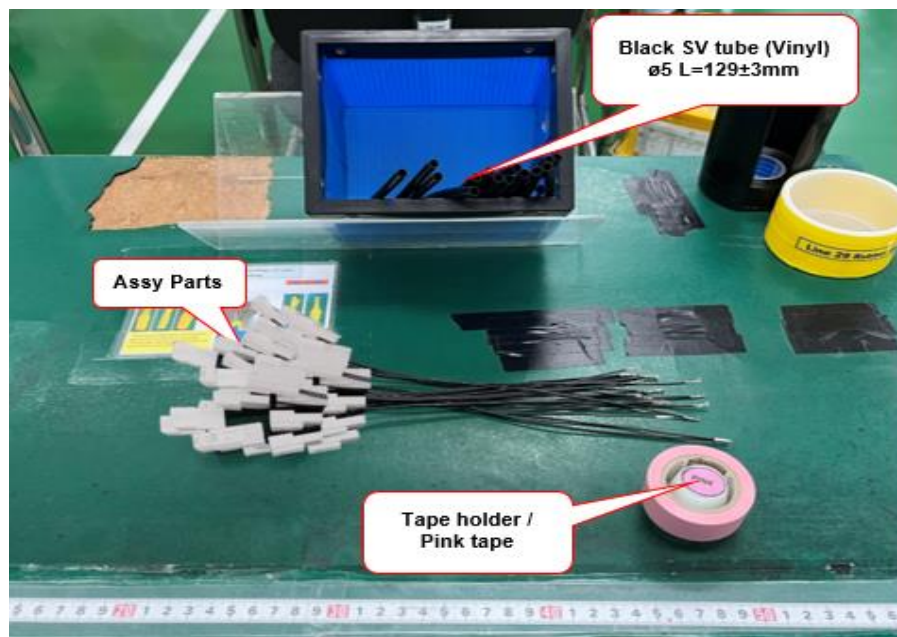
QUALITY POINTERS

1

P1

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

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
07/02/24	1	Inclusion of table lay-out and transfer wire insertion to connector to Offline Assembly Process.	A.Hernandez	C.Villanueva	A. Arañes	n/a	A.Hernandez	C.Villanueva	A. Arañes	n/a
01/03/24	0	Initial issue.	D.Castillo	C.Villanueva	A. Arañes	n/a				

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<b>PARTS:</b>		1. Assy parts 2. Black SV tube (Vinyl) ø5 L=131±3mm		JIG:	1. Terminal cover jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	P1	<div><div>Wire Insertion to Black Black SV tube (Vinyl) ø5 L=131±3mm</div><div></div><div>1. Hold the assy part using left hand and get Black SV tube (Vinyl) <b>ø5 L=131±3mm</b> using right hand then insert.</div></div>		n/a	1. No wrong usage of parts 2. No deformed terminal

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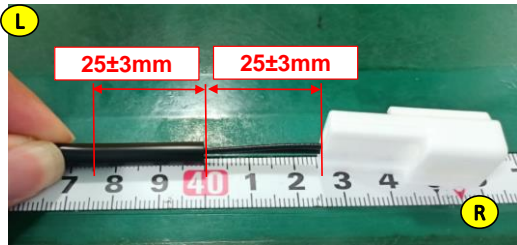
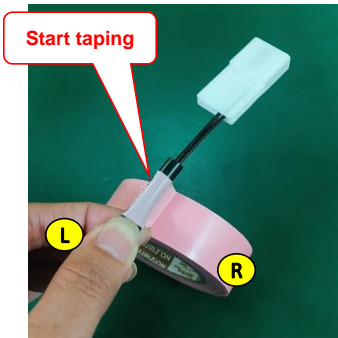
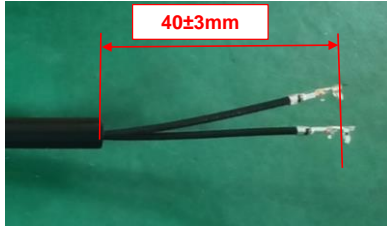
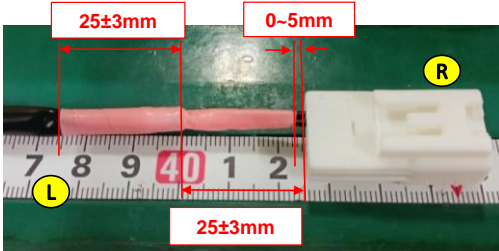

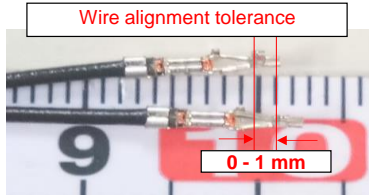
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PARTS:		1. Assy parts 2. Pink tape [1pc]	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1 Taping 1 Corrugated tube to wire near Connector	<div><p>1. Hold the Black SV tube (Vinyl) using left hand and measure from end of SV tube (Vinyl) up to connector <b>25±3mm</b>.</p></div> <div><p>2. Get the <b>Pink tape</b> using right hand then start taping process using both hands.</p></div> <div><p>3. After taping, check the measurement, taping condition an wire alignment.</p></div>	<div><b>MEASURING TAPE</b></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 0 - 1 mm</p></div>

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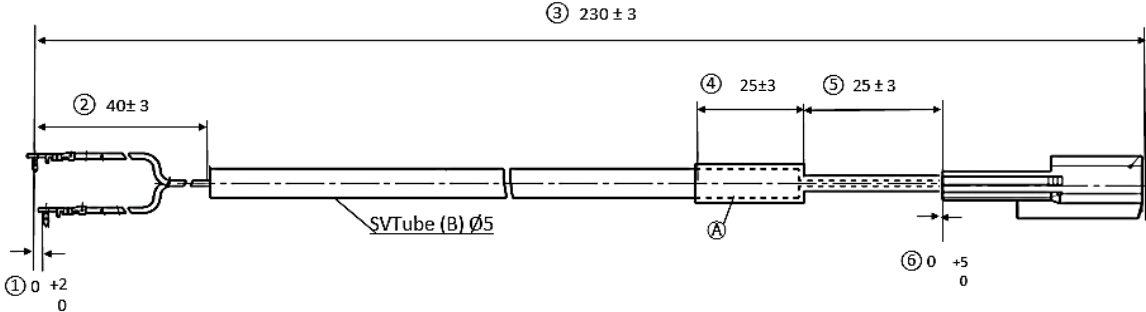
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1  Measurement	<div><div>MEASURING TAPE</div></div> 		<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono 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>

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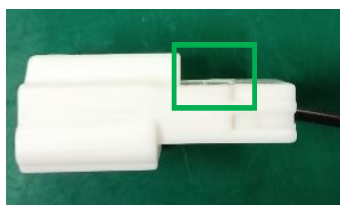
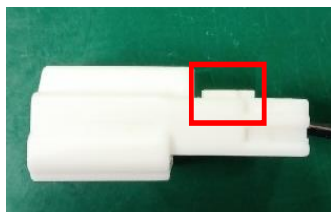
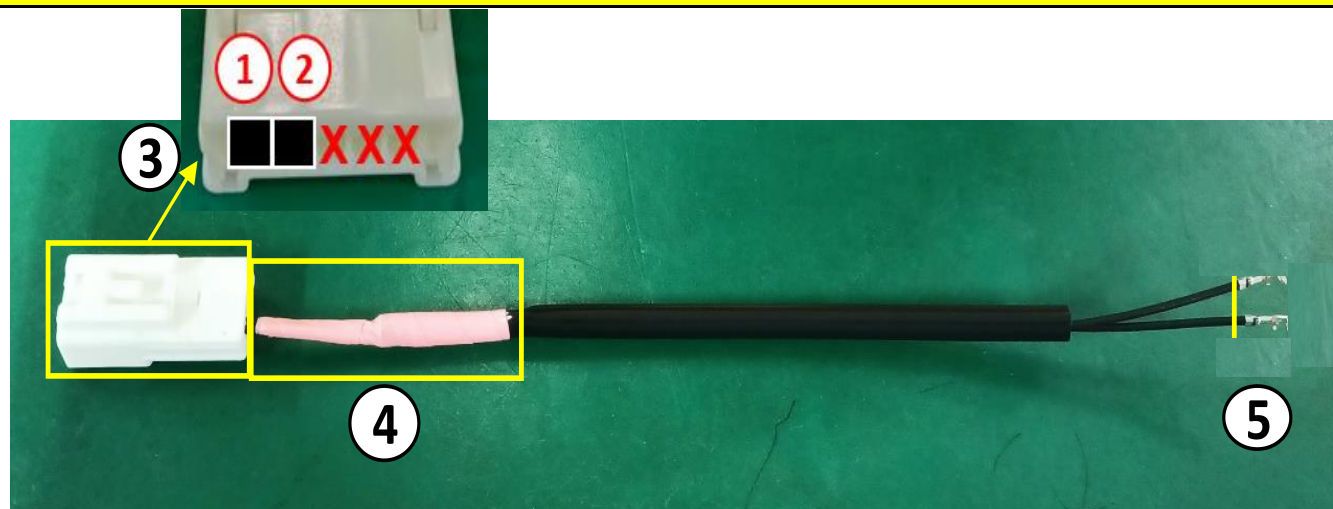
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PARTS:

n/a

JIG:

n/a

**VISUAL INSPECTION/QUALITY CHECKPOINTS****P1****7L0156-7021****GOOD****NO GOOD****①** No **Unlocked/ Half Locked Connector****②** No **Terminal Backing Out****③** No **wrong insert****④** No **Missing Tape/ No wrong color of tape****⑤** No **Deformed Terminal****GOOD****NO GOOD**

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