

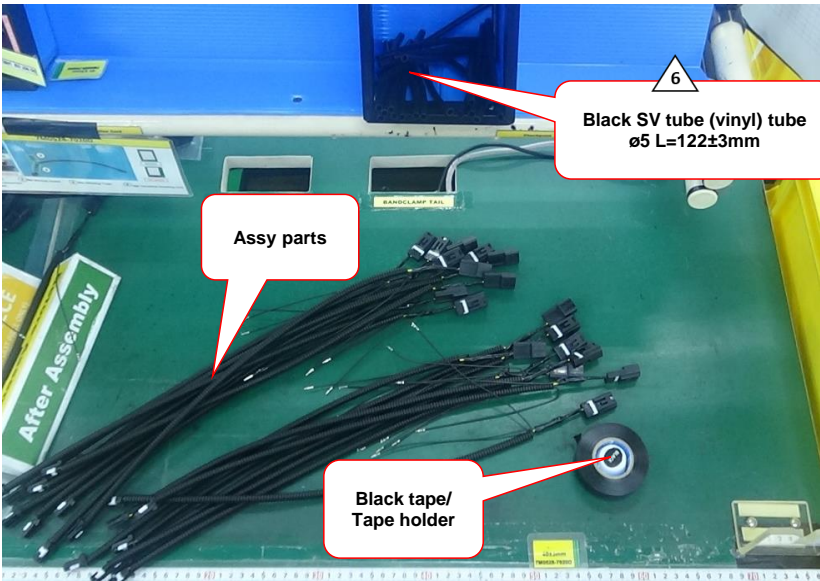


	WORK INSTRUCTION					Effectivity Date:		June 18, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS					Validity Date:		n/a	
	Model code/Part number: 310D / 7M0528-7020D		Customer: TRJ	Car Model: TOYOTA RAV4		Document No.:		WI-ENG-PDE-033B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		6	Page No.:	1 of 6


PARTS:  1. Assy parts; Black SV tube (Vinyl) ø5 L=122±3mm; Black tape			JIG:		n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE		QUALITY POINTERS	
1	P2  Table Lay-out	<div>Table Lay-out</div>  <div>Assy parts</div> <div>Black SV tube (vinyl) tube ø5 L=122±3mm</div> <div>Black tape/ Tape holder</div>	<div>Safety Instruction</div> <div>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping</div> <div>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level</div> <div>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		1. No missing parts/tools 2. No excess parts/tools	

Revision History							Prepared by	Reviewed by	Approved by	Noted by	
06/18/24	6	Separate Continuity testing to Clamp assembly process and transfer Spot taping process from P1 due to process improvement. Inclusion of car model "TOYOTA-RAV 4", Table lay-out and Visual inspection/Quality inspection. Standardize the term of SV tube (Vinyl). Update the Measurement.				D. Castillo	C. Villanueva	A. Arañes	n/a		
05/12/21	5	Removal of validity date. Apply some improvements.				M. Catapang	C. Villanueva	A. Shimamura	A. Arañes		
11/10/20	4	Changed effectivity and validity date. Remove cycle time.				M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes		
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	July 02, 2018


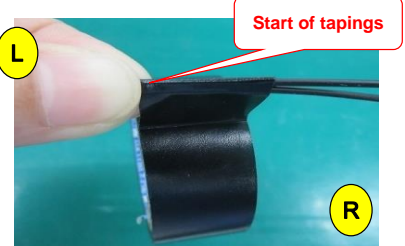
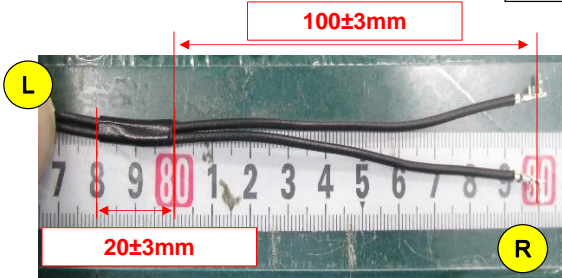

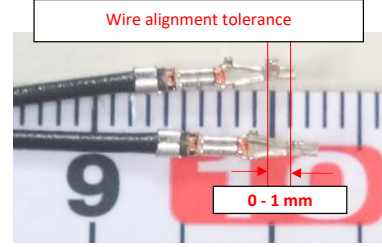

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	<b>6</b>	Page No.:	<b>2 of 6</b>

<b>PARTS:</b> 1. Assy parts 2. Black tape	3. Black Sv tube (Vinyl) $\varnothing 5$ L=122 $\pm$ 3mm		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	Spot taping  P2	<div>  <p>1. Hold the wires using both hands and measure from wire up to terminal pointed tip <b>120<math>\pm</math>3mm</b>.</p> </div> <div>  <p>2. Hold the wires using left hand, get black tape then start taping using right hand. Make <b>2 windings</b> then cut the tape.</p> </div> <div>  <p>3. After taping, check the measurement, wire alignment and taping condition.</p> </div>	<div> <b>MEASURING TAPE</b> </div> 	<p><b>Important reminders/Note/s:</b>  <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></p> <ol style="list-style-type: none"> <li>No loose tape</li> <li>No flip-out tape</li> <li>No peel-off tape</li> <li>No wrong dimension</li> <li>No wrong use of tape</li> </ol> <div>  <p>Wire alignment tolerance 0 - 1 mm</p> </div>
3	Wire insertion to Black SV tube (vinyl ) $\varnothing 5$ L=122 $\pm$ 3mm	<div>  <p>1. Get the SV tube (vinyl ) <math>\varnothing 5</math> L=122<math>\pm</math>3mm using right hand and insert the wires using left hand.</p> </div>	n/a	<ol style="list-style-type: none"> <li>No wrong use of parts</li> <li>No deformed terminal</li> </ol>

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PARTS:	1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2	Y-taping	n/a	<p><b>Important reminders and note/s;</b></p> <p><b>1. USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE BLACK TAPE.</b></p> <p>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension 6. No wide interval between the COT 7. No exposed wire</p>

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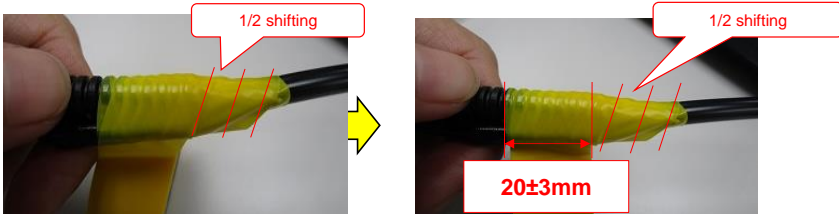
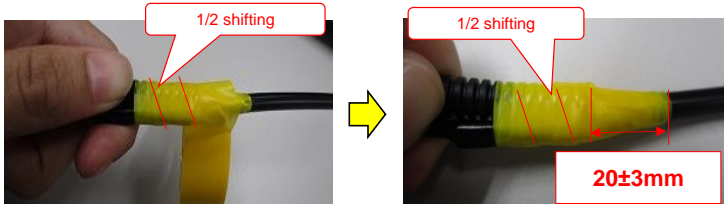
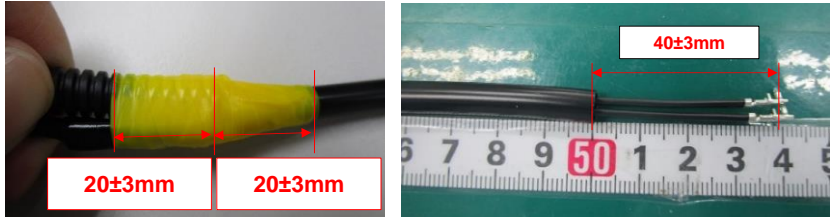

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2  Y-taping (Continuation)	<div><div><div></div><div>5. Make 1/2 shifting to the left until 20±3mm then wind the tape 2x.</div></div><div><div></div><div>6. Make 1/2 shifting to the right until 20±3mm on vinyl tube, wind the tape 2x then cut the tape.</div></div><div><div></div><div>7. After taping, check the measurement from vinyl tube up to terminal pointed 40±3mm and taping condition.</div></div></div>		<div>MEASURING TAPE</div> 	<div>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension 6. No wide interval between the COT 7. No exposed wire</div> <div><b>Important reminders and note/s;</b> <b>1. USE YELLOW TAPE FOR EASY VISUALIZATION OF SHIFTING LINES, BUT ACTUAL SHOULD BE <u>BLACK</u> TAPE.</b> <b>2. Please use calibrated/verified measuring tape when getting the measurement.</b></div>

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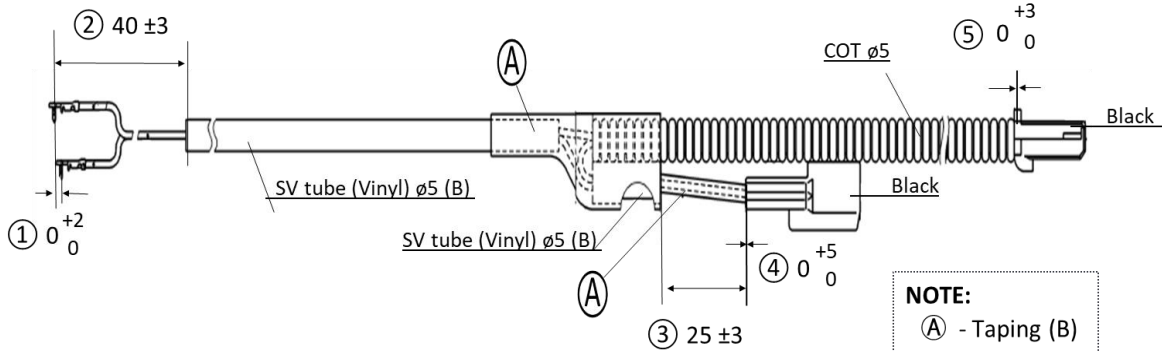
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<b>PARTS:</b>		1. Assy parts		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
5	P2	Measurement	<div>MEASURING TAPE</div>   <div>NOTE: (A) - Taping (B)</div>	<p><b>Important reminders 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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PARTS:

1. Assy parts

JIG:

n/a



### VISUAL INSPECTION/ QUALITY CHECKPOINTS

P2

7M0528-7020D

①



GOOD

③



GOOD

②

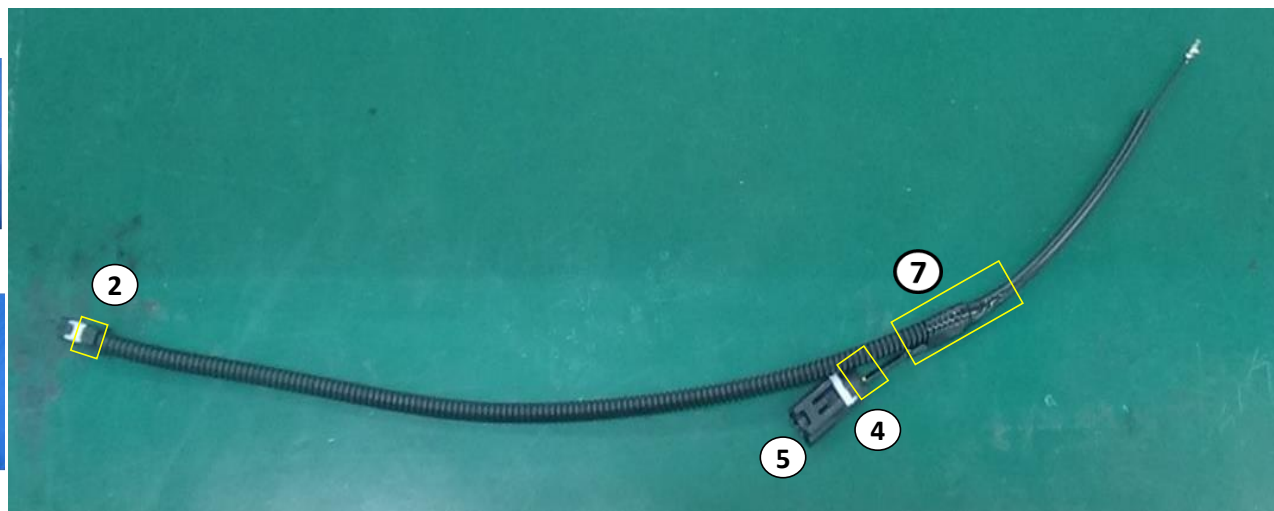


NO GOOD

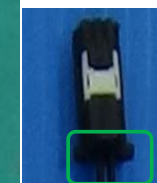
④



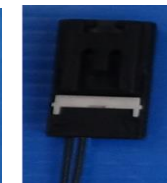
NO GOOD



⑥

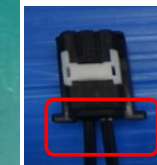


GOOD



GOOD

⑦



NO GOOD



NO GOOD

① ③ No Unlocked/Half-locked connector

② ④ No Wrong insert

⑤ No Deformed Terminal

⑥ No Terminal Backing Out

⑦ No Missing Tape

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