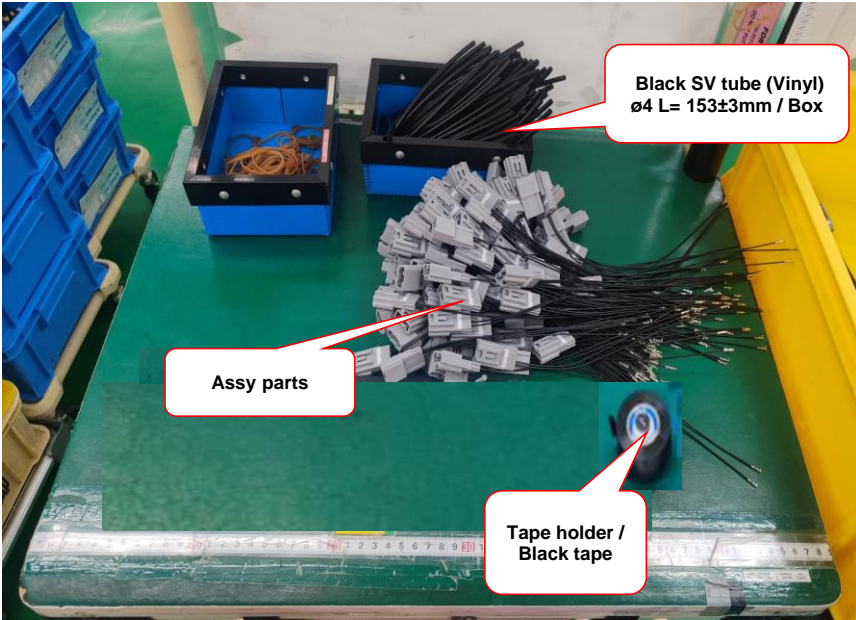



	<b>WORK INSTRUCTION</b> <b>TAPING ASSEMBLY PROCESS</b>				Effectivity Date:	June 3, 2024		
	Process Name/Title:				Validity Date:	n/a		
	Model code/Part number: <b>320B / 7L0056-7022</b>		Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA-RAV4</b>	Document No.:	<b>WI-ENG-PDE-112</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		6	Page No.:	1 of 4	


<b>PARTS:</b>		1. Assy parts ;Black SV tube (Vinyl) ø4 L= 153±3mm; Black tape		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
1	P1	<div style="text-align: center;"> <b>TABLE LAY-OUT</b> </div> 	<p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p><b>Document reference/s:</b> 1. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length Tolerance 2. Refer to <b>WI-ENG-PDE-111</b> for Offline assembly process</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>	


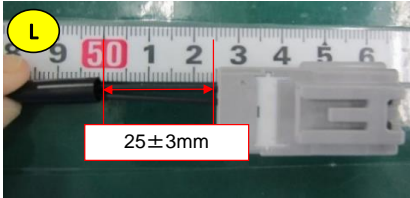
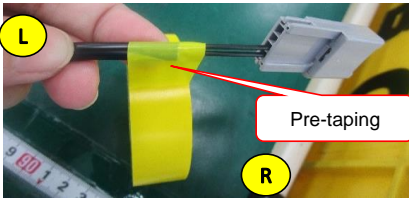
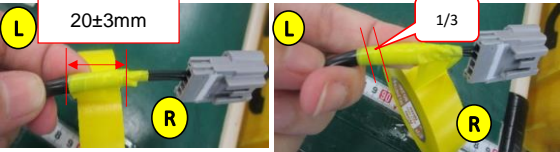
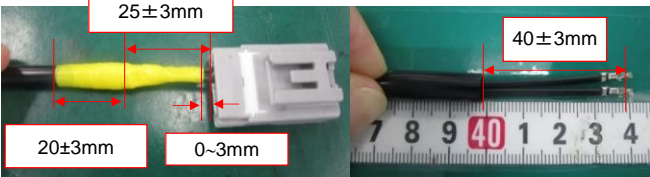

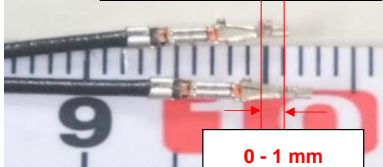
  

Revision History						Prepared by	Reviewed by	Approved by	Noted by	
06/03/24	6	Inclusion of Car model "TOYOTA-RAV 4". Update Table lay-out. Improved Measurement and Visual inspection/Quality checkpoints.	D.Castillo	C.Villanueva	A. Arañes	N/A	 D.Castillo	 C. Villanueva	 A. Arañes	n/a
06/09/23	5	Inclusion of table lay-out and quality check points; improve important reminders/note/s and document references; improve by two's inspection; Standardize SV tube (vinly) term	J. Loterte	C.Villanueva	A.Arañes	n/a				
05/26/21	4	Remove marking due to change black mark to punch mark. Remove validity date.	D.Castillo	C.Villanueva	A.Shimamura	A.Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	November 27, 2018		

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	<b>WORK INSTRUCTION</b>				Effectivity Date:		<b>June 3, 2024</b>	
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Model code/Part number: <b>320B / 7L0056-7022</b>		Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA-RAV4</b>	Document No.:		<b>WI-ENG-PDE-112</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		6	Page No.: 2 of 4

<b>PARTS:</b>	1. Pre-assy parts from kitting (Connector 6098-5673 (GR); AVSSf wires B L= 224±2mm [2pcs] )		2. Black SV tube (Vinyl) ø4 L= 153±3mm		JIG:	n/a
			3. Black tape			
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	Wire insertion to SV tube (Vinyl) ø4 L=153mm	<div></div> <p>Get the <b>SV tube (Vinyl) ø4 L= 153±3mm</b> using right hand then insert the <b>2 Black wires</b>.</p>			n/a	1. No wrong usage of parts 2. No deformed terminal
3	P1 Taping 1 SV tube (Vinyl) to wire near connector	<div><div><p>25±3mm</p><p>1. Measure the end of the vinyl tube up to edge of connector <b>25mm</b>.</p></div><div><p>Pre-taping</p><p>2. Get the <b>Black tape</b> and start taping using both hands.</p></div><div><p>20±3mm</p><p>1/3</p><p>3. Make 1 wind going to vinyl tube then make 2 winds (must be tape width). Make 1/3 shifting from SV tube (vinyl) to wire. Make 3 winds then cut the tape.</p></div><div><p>25±3mm</p><p>20±3mm</p><p>0~3mm</p><p>40±3mm</p><p>4. After taping, check the wire alignment, measurement and tape condition.</p></div></div>			<div><b>MEASURING TAPE</b></div> 	<div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div> <p><b>Important reminders and Note/s;</b></p> <p><b>1. USED YELLOW TAPE FOR EASY VISUALIZATION OF TAPE SHIFTING, BUT ACTUAL SHOULD BE BLACK.</b></p> <p><b>2. Please use calibrated/verified measuring tape when getting the measurement.</b></p> <p><b>3. No need to fold the vinyl tube.</b></p> <p><b>Document reference/s:</b></p> <p><b>1. Refer to WI-PRO-ASY-001 for taping procedure.</b></p> <p>1. No peel-off tape 2. No flip-out tape 3. No loose tape 4. No wrong use of tape 5. No wrong tape measurement 6. No missing tape</p>

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**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**

Effectivity Date:

**June 3, 2024**Model code/Part number: **320B / 7L0056-7022** Customer: **TRQSS** Car Model: **TOYOTA-RAV4**

Validity Date:

**n/a**Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Document No.:


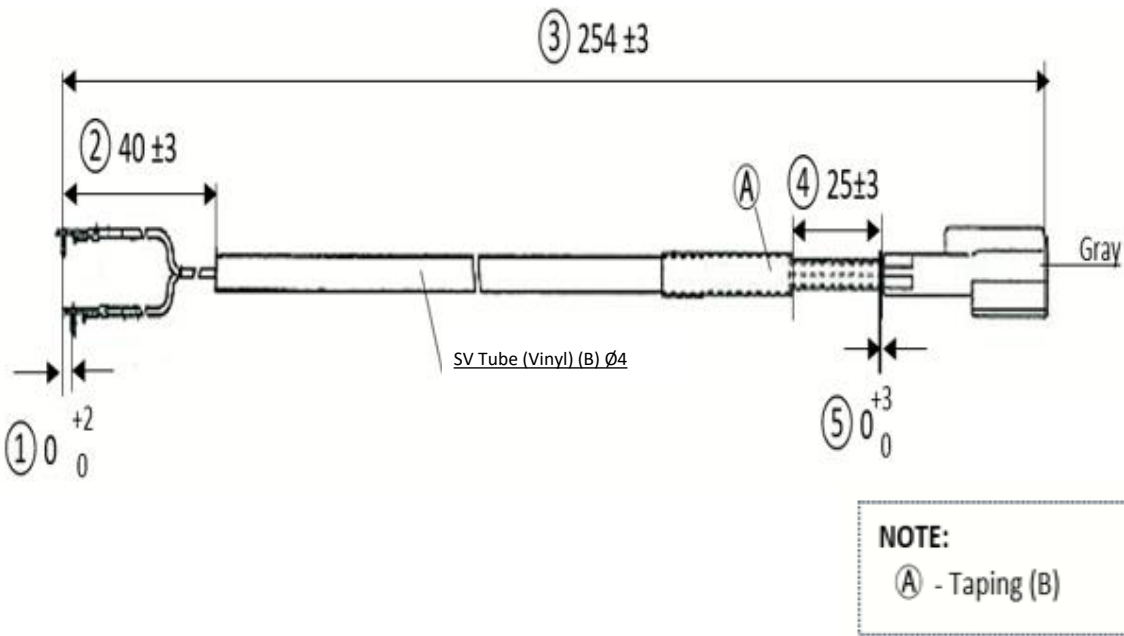

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PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	 <b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
4	P1 Measurement		<div data-bbox="1440 383 1709 539"><b>MEASURING TAPE</b> </div> <div data-bbox="1422 1157 1697 1292"><b>NOTE:</b> (A) - Taping (B)</div>	<p><b>Important reminders and note/s:</b></p> <p><b>1. Please use calibrated /verified measuring tape when getting the measurement.</b></p> <p><b>2. For Hatsumono, Nakamono and Owarimono.</b></p> <p><b>Document reference/s:</b></p> <p><b>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection.</b></p> <p>1. No wrong dimension</p>	

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**WORK INSTRUCTION**

Process Name/Title:

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Effectivity Date:

**June 3, 2024**

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**320B****/****7L0056-7022**

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Document No.:

**WI-ENG-PDE-112**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

**6**

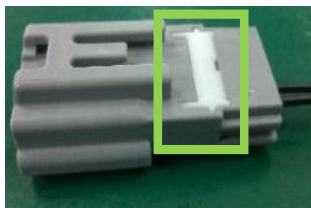
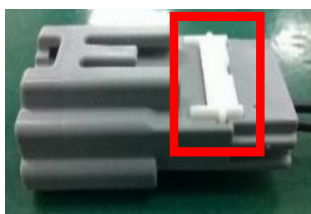
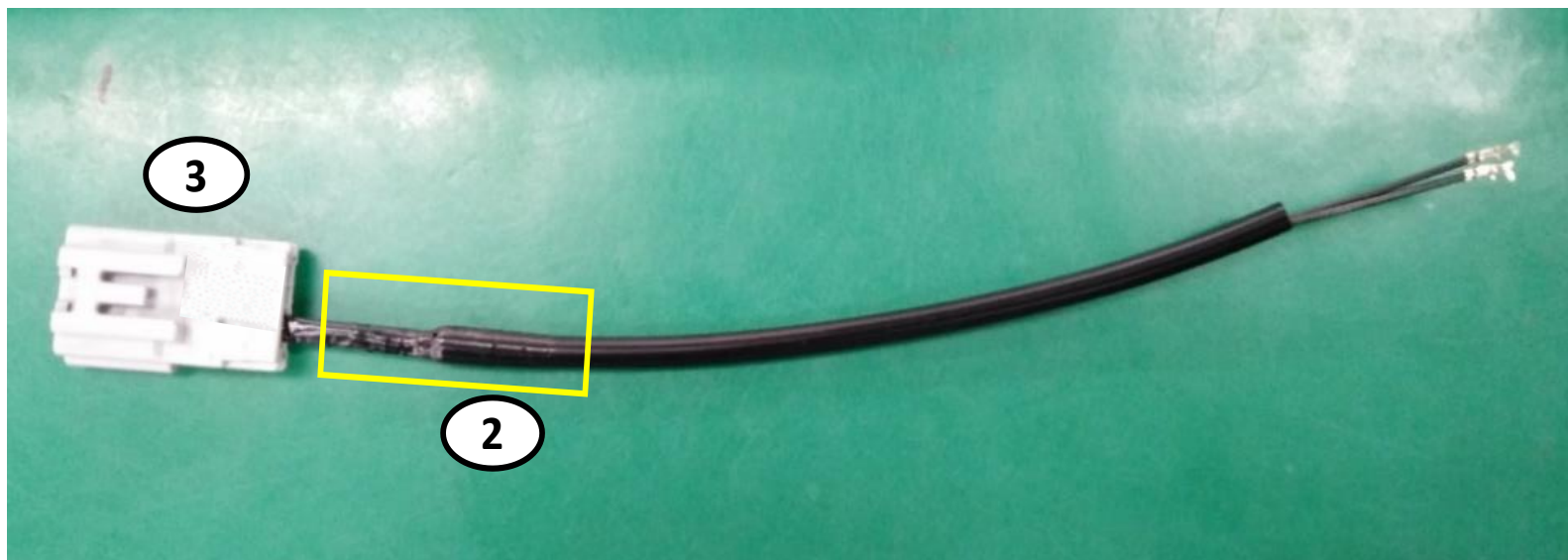
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**4 of 4****PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING-P1****7L0056-7022****GOOD****NO GOOD****① No Unlocked/Half-locked connector****② No Missing Tape****③ No Deformed Terminal**

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