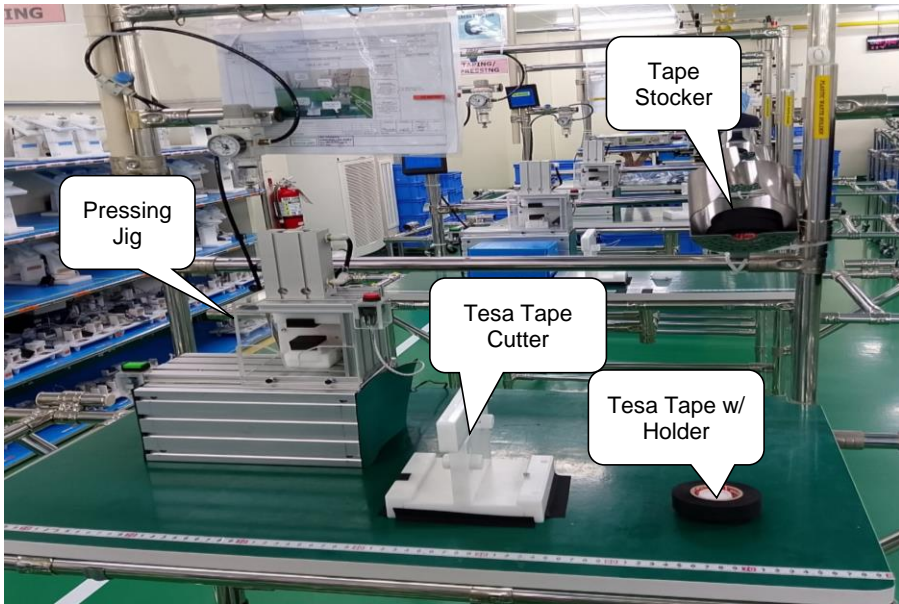
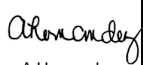



	WORK INSTRUCTION				Effectivity Date:		April 02, 2025	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 311D/400D / 17L991-7111		Customer: TRMX	Car Model: TOYOTA RAV-4 TOYOTA Bz4x (BEV)	Document No.:		WI-ENG-PDE-1170B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		2	Page No.:	1 of 8	

PARTS:		1. Assy parts; Tesa Tape 51036		JIG:		1. Pressing Jig 2. Tesa tape Cutter	
NO.	PROCESS NAME	2 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1	P2 TABLE LAY-OUT	<div>TABLE LAY-OUT</div> 		<div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>		1. No deformed terminal 2. No wrong usage of parts	

Revision History								Prepared by	Checked by	Reviewed by	Approved by		
04/02/25	2	Update table lay-out and inclusion of taping condition in page 3.4. Change picture of pressign jig from old pressing jig to new.				A.Hernandez	J.Loterte	C. Villanueva	A. Arañes				
03/18/25	1	Additional model code "400D" due to new project.				A.Hernandez	J.Loterte	C. Villanueva	A. Arañes				
12/10/24	0	Initial issue.				A.Hernandez	n/a	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Checked	Reviewed	Approved	Est. Date:	December 10, 2024		

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

311D/400D / 17L991-7111

Customer:

TRMX

Car Model:

TOYOTA RAV-4
TOYOTA Bz4x (BEV)

Purpose:

☐

PROTOTYPE

☐

PRE-LAUNCH

☒

MASSPRO

Effectivity Date:

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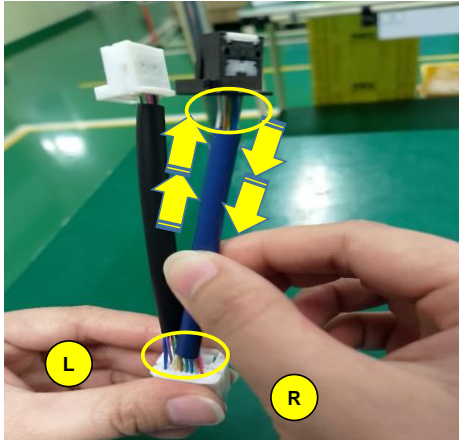
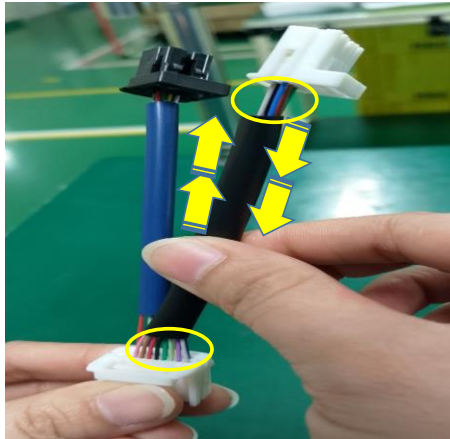


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PARTS:		1. Assy Parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2	Visual Checkpoints (Bend Wire)	<div></div> <div></div> <div>1. Get Assy parts using left hand hold the connector and right hand hold the Blue VM tube (sunprene) and then conduct up down-up down 2x.</div> <div>2. Hold the Hold the VM tube (sunprene) and then conduct up down-up down 2x.</div>	n/a	<div>WIRE ILLUSTRATION</div> <div></div> <div>GOOD - W/OUT BEND WIRE</div> <div></div> <div>NO GOOD - WITH BEND WIRE</div> <div>1. No Bend Wire 2. No Tangled wire.</div>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

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Model code/Part number:

311D/400D / 17L991-7111

Customer:

TRMX

Car Model:

TOYOTA RAV-4
TOYOTA Bz4x (BEV)

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

April 02, 2025

Validity Date:

n/a

Document No.:

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Revision No.:

2

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PARTS:

1. Assy parts
2. Tesa Tape 51036

JIG:

1. Tesa Tape Cutter

NO.

PROCESS NAME

2

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

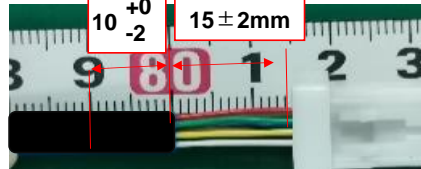
2

QUALITY POINTERS

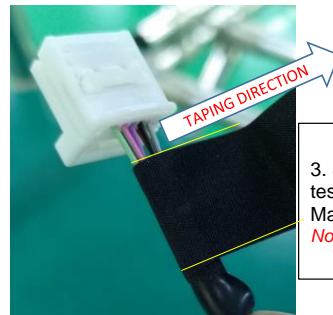
3

P2

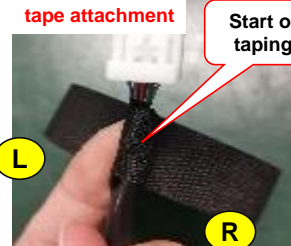
Taping 1
Black Tesa tape 51036
to Wire near connector



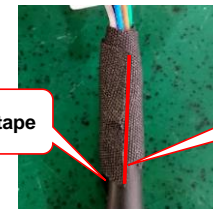
1. Position the end of Black VM tube (sunprene) to **15±2mm**. Then hold the wire and position the terminal **10 +0/-2mm** using both hands.
Note: Follow the above illustration.



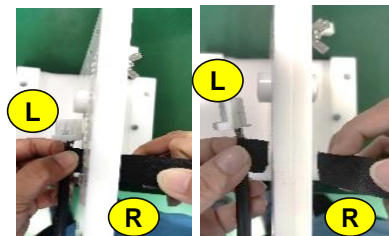
3. Slightly winding the the tesa tape going to left side. Make **1 winding** only.
Note: No tape shifting



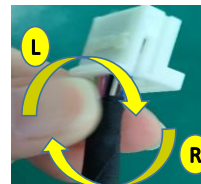
2. Get the Black tesa tape 51036, position the tape to Black VM tube (sunprene). Make **1 wind** only using both hands.



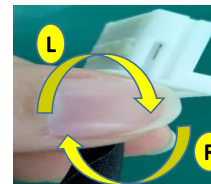
First wind



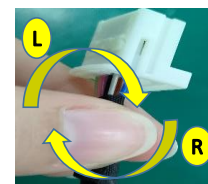
4. Cut the tape using tape cutter using both hands.



5. Conduct proper pressing of end tape using left hand (**top part**).



6. Conduct proper pressing of end tape using left hand (**middle part**).



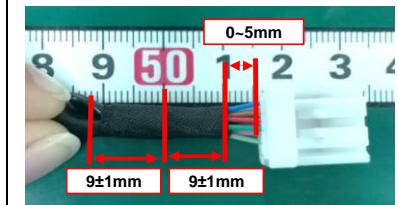
7. Conduct proper pressing of end tape using left hand (**bottom part**).

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

MEASURING TAPE



8. Check the taping condition, measurement and wire alignment



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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

April 02, 2025

Process Name/Title:

Model code/Part number:

311D/400D / 17L991-7111

Customer:

TRMX

Car Model:

TOYOTA RAV-4
TOYOTA Bz4x (BEV)

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1170B

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

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PARTS:

1. Assy parts
2. Tesa Tape 51036

JIG:

1. Tesa Tape Cutter

NO.

PROCESS NAME

2

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

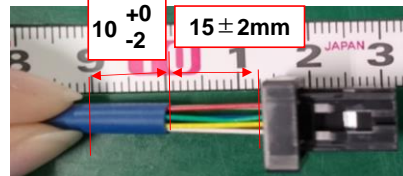
2

QUALITY POINTERS

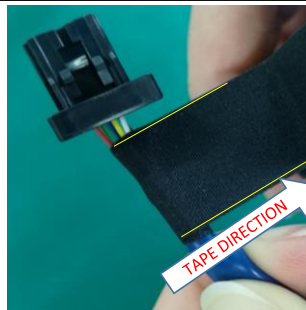
3

P2

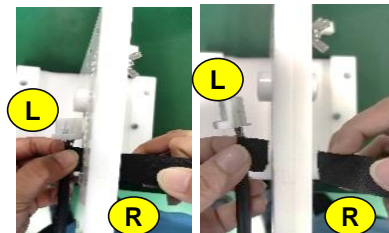
Taping 1
Black Tesa tape 51036
to Wire near connector



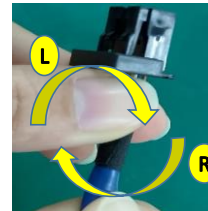
1. Position the end of Black VM tube (sunprene) to **15±2mm**. Then hold the wire and position the terminal **10+0/-2mm** using both hands.
Note: Follow the above illustration.



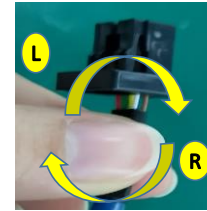
3. Slightly winding the the tesa tape going to left side. Make **1 winding** only.
Note: No tape shifting



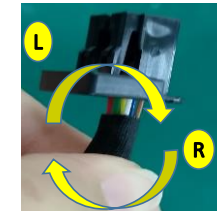
4. Cut the tape using tape cutter using both hands.



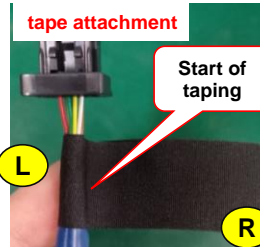
5. Conduct proper pressing of end tape using left hand (**top part**).



6. Conduct proper pressing of end tape using left hand (**middle part**).

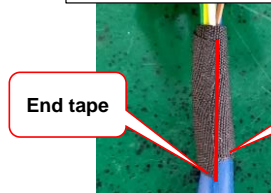


7. Conduct proper pressing of end tape using left hand (**bottom part**).



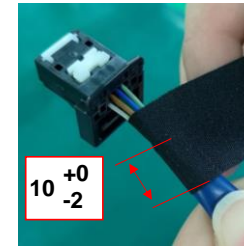
2. Get the Black tesa tape 51036, position the tape to Black VM tube (sunprene). Make **1 winding** only using both hands.

WRONG POSITION OF
END TAPE



End tape

First
wind

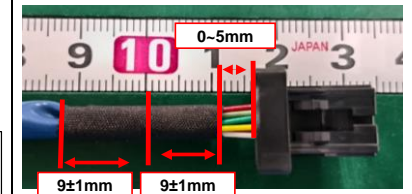


1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong use of tape
6. No wrong dimension

MEASURING TAPE



8. Check the taping condition, measurement and wire alignment



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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

311D/400D / 17L991-7111

Customer:

TRMX

Car Model:

TOYOTA RAV-4
TOYOTA Bz4x (BEV)

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

April 02, 2025

Validity Date:

n/a

Document No.:

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Revision No.:

2

Page No.:

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PARTS: 1. Assy Parts

JIG:

1. Pressing jig

NO.

PROCESS NAME

2

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

5

P2

Wire harness setting to pressing jig

PRESSURE GAUGE



PNEUMATIC PRESSING JIG SET-UP



Press Button

Emergency Button

Pressing Foam Top

Sensor

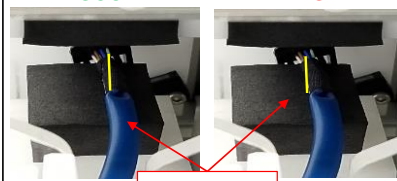
Pressing Foam Bottom

1. Perform the checking of Pneumatic Pressing jig using inspection checksheet.
(Refer to F-PRO-ASY-024 A-B)

Lever con Setting

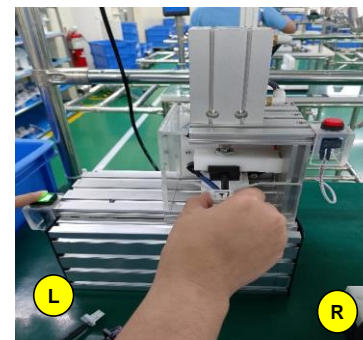
GOOD

NG



END TAPE

2. Set the Black VM tube (Sunprene) to pressing jig using right hand. Place the lever con in the middle and place the **END tape** into top.



3. Hold the lever con using right hand then press the Green button using left hand.

1. No damage parts
2. No floating or peel-off tape
3. No foreign material

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

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Customer:

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TOYOTA Bz4x (BEV)

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1170B

Purpose:



PROTOTYPE



PRE-LAUNCH



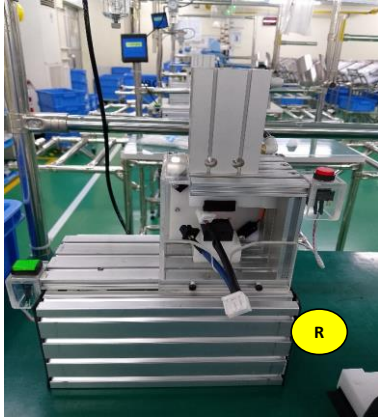


MASSPRO

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PARTS:	1. Assy Parts		JIG:	1. Pressing jig
NO.	PROCESS NAME	<div>2</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	Wire harness setting to pressing jig (Continuation) P2	<div><div>4. After 25-35 seconds, pressing jig will automatically release.</div><div>5. Get the lever con using right hand. Repeat the Blue VM tube (Sunprene).</div></div>		1. No damage parts 2. No floating or peel-off tape 3. No foreign material

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Car Model:

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TOYOTA Bz4x (BEV)

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1170B

Purpose:


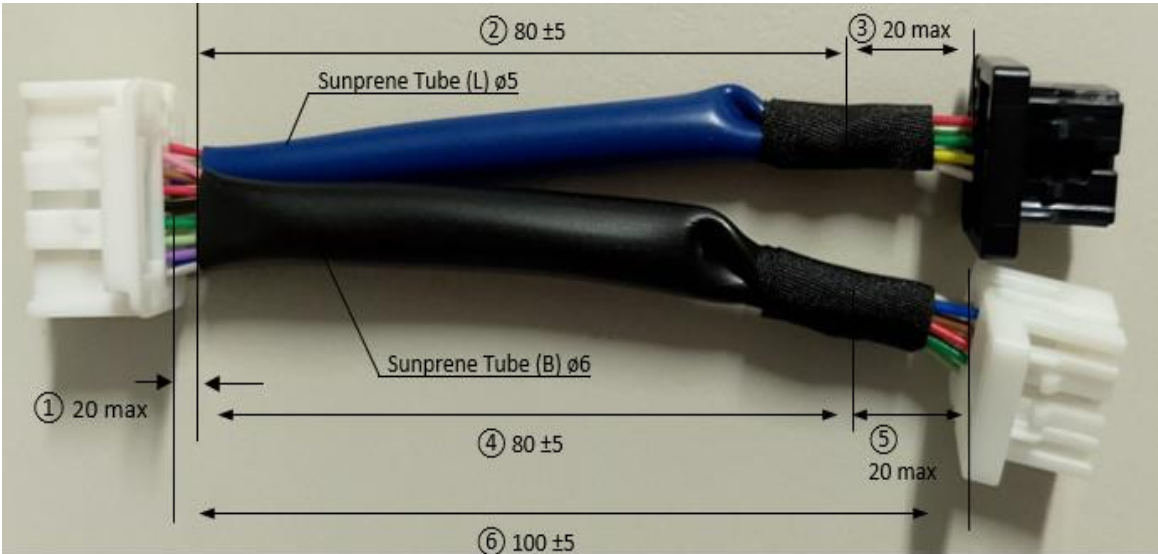
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

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PARTS:	1. Assy Parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P2	<div><div>MEASURING TAPE</div></div> 		<p>Important reminders and note/s:</p> <p>1. Please use calibrated /verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection.</p> <p>1. No wrong dimension</p>

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311D/400D / 17L991-7111

Customer:

TRMX

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**TOYOTA RAV-4
TOYOTA Bz4x (BEV)**

Document No.:

WI-ENG-PDE-1170B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**P2****17L991-7111****1****No Missing
Tesa Taping****2****No Wrong used
of Tesa Tape
(51036)****3****No Peel-Off
Tape**

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