



## WORK INSTRUCTION

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

Effectivity Date:

November 4, 2024

Model code/Part number:

310B / 7M0521-7021B

Customer: TRJ

Car Model: TOYOTA-RAV4

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-1127B

Revision No.:

1

Page No.:

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**PARTS:** 1. Assy parts; Black VM tube (Sunprene) Ø11 L=120±3mm; Black tape

JIG:

n/a

NO.

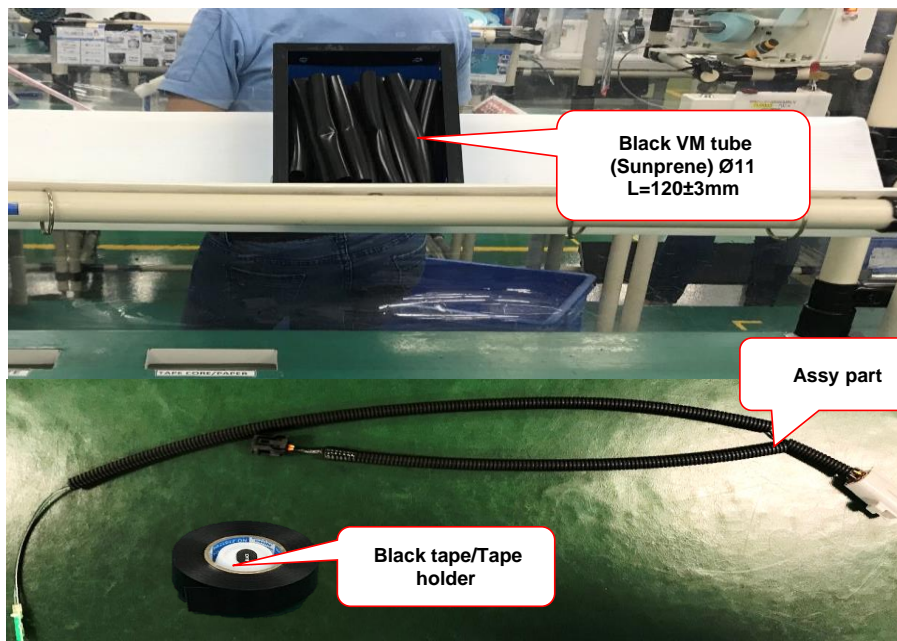
PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

## 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.

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
10/30/24	1	Change purpose from Pre-launch to Masspro.	M. Ariola	C. Villanueva	A. Arañes	n/a	M. Ariola	C. Villanueva	A. Arañes	N/A
10/29/24	0	Initial Issue.	M. Ariola	C. Villanueva	A. Arañes	n/a	M. Ariola	C. Villanueva	A. Arañes	N/A

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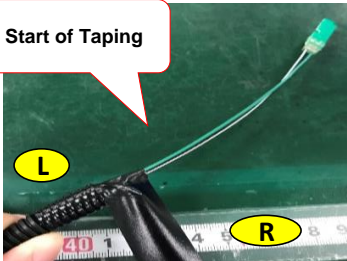
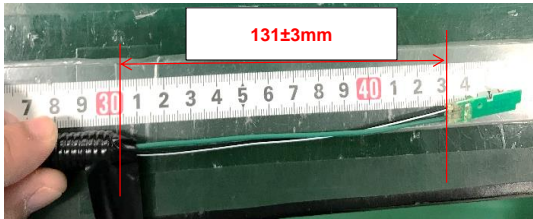
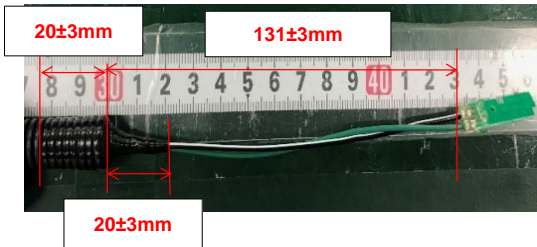

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2  Taping 2 Black corrugated tube to wire near hotmelt	<div><div><div>Start of Taping</div></div><div><div>131±3mm</div></div><div><div>20±3mm</div><div>131±3mm</div></div></div> <div><div>1. Hold the corrugated tube <math>\varnothing 7</math> L= 460±4mm using left hand then start taping between COT and wire using right hand.</div><div>2. Measure from end of the corrugated tube up to edge of hotmelt 131±3mm then continue the taping process.</div><div>3. After taping, check the measurement and tape condition.</div></div>		<div>MEASURING TAPE</div> 	<div>Important reminders/Note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>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</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-ASY-001 for taping procedure</div>

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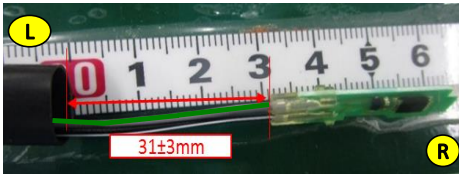



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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) Ø11, L=120±3mm		3. Black tape	JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	Wire insertion to assy parts	<div><p>1. Get the VM tube (Sunprene) Ø11 L=120±3mm using right hand then insert the G-B/W wire using left hand.</p></div>		n/a	1. No wrong use of parts
4		Taping 3 Black VM tube (Sunprene) to Black Corrugated tube	<div><div><p>1. Measure from end of the VM tube (Sunprene) up to edge of hotmelt 31±3mm.</p></div><div><p>2. Hold the VM tube (Sunprene) using left hand then start taping using right hand.</p></div><div><p>3. After taping, check the measurement and tape condition.</p></div></div>		<div><div>MEASURING TAPE</div></div>	<p><b>Important reminders/Note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>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</p> <p><b>Document reference/s:</b></p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p>

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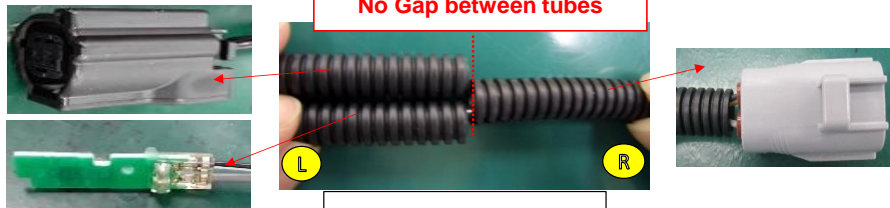

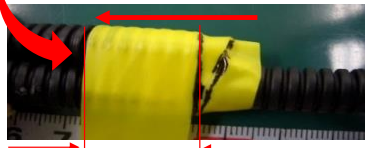
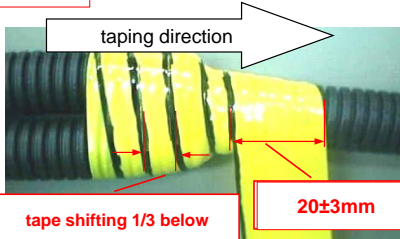
☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2	Y-Taping	<div><div><p>No Gap between tubes</p><p>1. Fix the corrugated tube .</p></div><div><p>Note: Do not exert excessive force during pulling &amp; winding of tape.</p></div><div><p>20±3mm</p><p>2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side , width must be 20±3mm.</p></div><div><p>taping direction</p><p>tape shifting 1/3 below</p><p>20±3mm</p><p>3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be 20±3mm).</p></div></div> <div>n/a</div> <td><p><b>Important reminders/Note/s:</b></p><p>1. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines but actual should be <b>BLACK TAPE</b></p><p>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</p><p><b>Document reference/s:</b></p><p>1. Refer to <b>WI-PRO-ASY-001</b> for taping procedure.</p></td>	<p><b>Important reminders/Note/s:</b></p> <p>1. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines but actual should be <b>BLACK TAPE</b></p> <p>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</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-ASY-001</b> for taping procedure.</p>	

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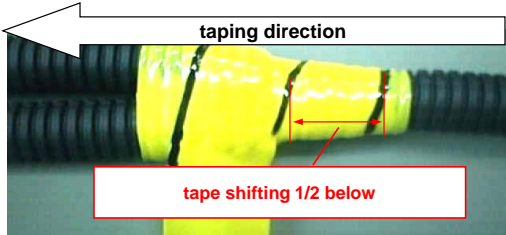
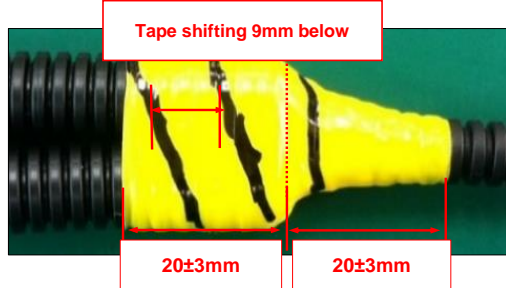

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<b>PARTS:</b>		1. Assy parts 2. Black tape		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
5	P2 Y-Taping (Continuation)	<div><p>4. Wind the tape backward <b>1/2 shifting</b></p></div> <div><p>5. Wind the tape <b>1/2 shifting</b> going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.</p></div>		<div><b>MEASURING TAPE</b></div> 	<p><b>Important reminders/Note/s:</b></p> <p>1. Use <b><u>YELLOW TAPE</u></b> for easy visualization of shifting lines but actual should be <b><u>BLACK TAPE</u></b></p> <p>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</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b><u>WI-PRO-ASY-001</u></b> for taping procedure.</p>

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Measurement	<p><b>NOTE:</b> (A) - Taping (B)</p>	<div>MEASURING TAPE</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****TAPING - P2****7M0521-7021B****1 2 No Missing tape****3 No Missing VM tube  
(Sunprene)**

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