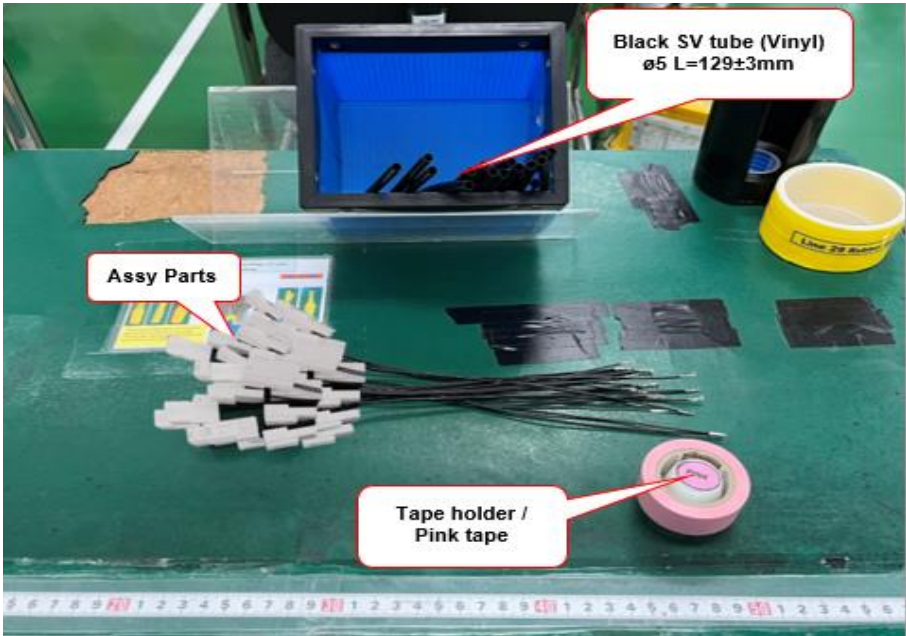







WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	May 21, 2024		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-798		
Revision No.:	2	Page No.:	1 of 4

Process Name/Title:	TAPING ASSEMBLY PROCESS		
Model code/Part number:	310D / 7N0189-7020A	Customer:	TRJ
		Car Model:	TOYOTA RAV4
Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO

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	<div>TABLE LAY-OUT</div>  <p>Black SV tube (Vinyl) ø5 L=129±3mm</p> <p>Assy Parts</p> <p>Tape holder / Pink tape</p>	<div>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 1.No missing parts/tools 2.No excess parts/tools

Revision History							Prepared by	Reviewed by	Approved by	Noted by	
										n/a	
05/21/24	2	Split type process. Transfer wire insertion to connector to offline process and inclusion of table lay-out.	A.Hernandez	C.Villanueva	A. Arañes	n/a					
03/06/24	1	Change Pre-launch to Mass pro. Provide insertion jig process.	A.Hernandez	C.Villanueva	A. Arañes	n/a					
02/13/24	0	Initial issue.	C.Hernandez	C.Villanueva	A. Arañes	n/a					
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	February 13, 2024

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

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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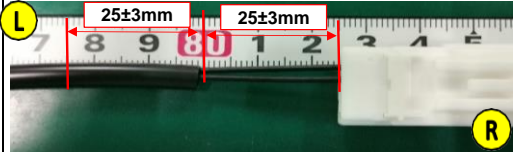
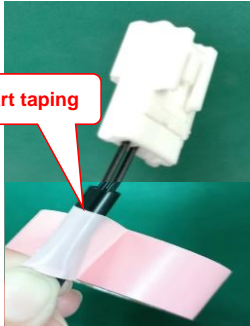
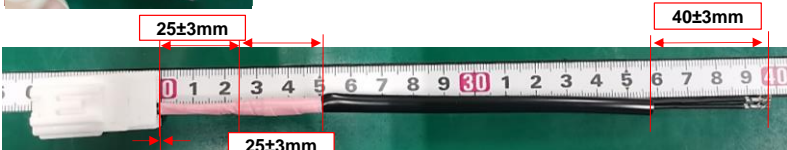
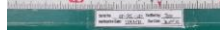


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PARTS:		1. Assy parts 2. Black SV tube (vinyl) $\phi 5$ t=0.5 L= 129 \pm 3mm 3. Pink Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2		Wire insertion to Black SV tube (vinyl) $\phi 5$ t=0.5 L= 129 \pm 3mm	<div></div> <div>1. Get the Black SV tube (vinyl) $\phi 5$ t=0.5 L= 129\pm3mm using right hand then insert the Black wires.</div>	N/A	1. No wrong usage of parts. 2. No deformed terminal
3	P1 Taping 1 Black SV tube (vinyl) to Wire near Connector	<div><div></div><div></div><div><div></div><div>3. After taping, check the dimension, taping condition and wire alignment.</div></div><div>1. Hold the SV tube (vinyl) using right hand and measure the end of the SV tube up to connector 25mm.</div><div>2. Get the PINK TAPE and start taping using both hands. <i>Refer to WI-PRO-ASY-001.</i></div></div>		<div>MEASURING TAPE</div> <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 <i>Note:</i> <i>Please use calibrated/verified measuring tape when getting the measurement.</i> <div><div>Wire alignment tolerance</div><div></div><div><div>Wire alignment tolerance</div><div></div></div></div>

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Validity Date:

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Model code/Part number:

310D / 7N0189-7020A

Customer: TRJ

Car Model: TOYOTA RAV4

Document No.:

WI-ENG-PD-798

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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PARTS:

1. Assy parts

JIG:

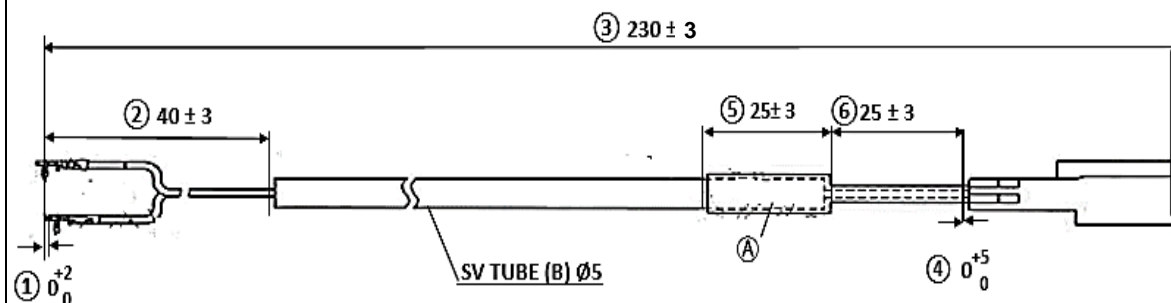
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NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

4

P1

Measurement



NOTE:

Ⓐ - Taping (P)

WIRE TYPE TABLE

No.	Color	Wire Type
1	B	AVSS 0.3 f
2	B	AVSS 0.3 f

MEASURING TAPE**Important reminders/Note/s:**

1. Please use calibrated/verified measuring tape when getting the measurement.

2. For Hatsumono, Nakamono and Owarimono.

Document reference/s:

1. Refer to WI-PRO-ASY-056 for Sub assembly Hatsomono, Nakamono, and Owarimono Inspection.

1. No wrong dimension

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☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS

P1

7N0189-7020A

1



GOOD



NO GOOD

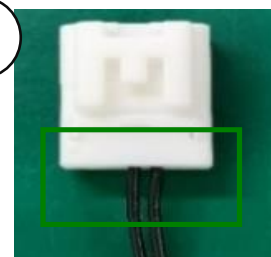
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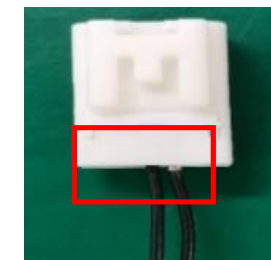
2

4

5



GOOD



NO GOOD

2

No Missing Tape

4

No Wrong Insert

1

No Unlock/Halflock Connector

3

No Deformed Terminal

5

No Terminal Backing Out

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