



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 3, 2024

Process Name/Title:

Model code/Part number: **320B / 7L0053-7025**Customer: **TRQSS**Car Model: **TOYOTA-RAV4**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-139C

Revision No.:

9

Page No.:

1 of 5

PARTS:

1. Assy parts
2. Black Tape

3. Yellow tape

JIG:

1. Measuring jig

NO.

PROCESS NAME

9

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

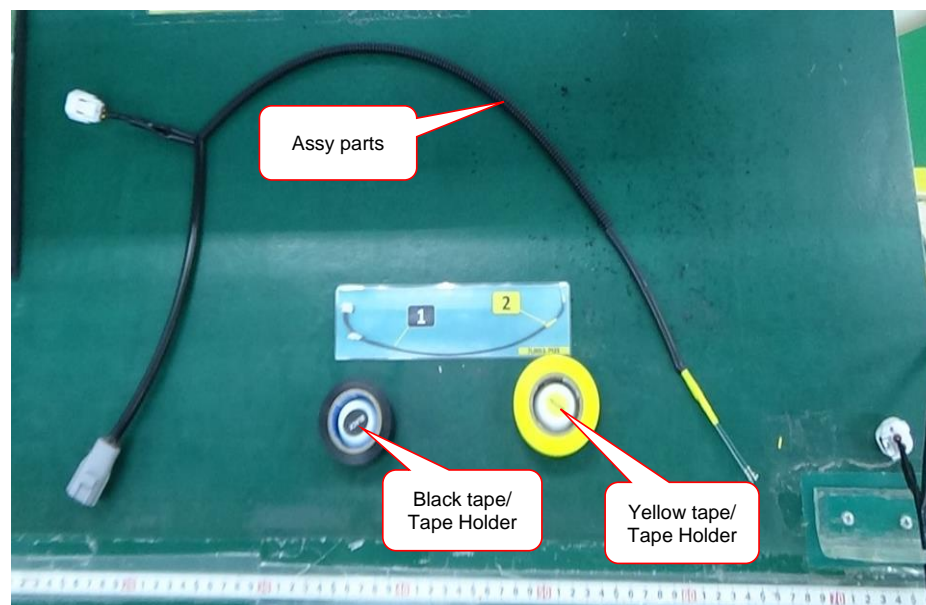
QUALITY POINTERS

1

P3

Table lay-out

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

Prepared by

Reviewed by

Approved by

Noted by

06/03/24

9

improve measurement and visual inspection. Transfer Insertion of sunprene tube , Taping sunprene tube to wire near terminal to P2 and from P2 Y-Taping transfer to P3.

A.Hernandez

C. Villanueva

A. Arañes

n/a

07/25/23

8

Update Template; Inclusion of **CAR MODEL "TOYOTA-RAV4"**; Update Table lay-out; Transferred process of no.2,3,4 and 5 from P2 to P3; Remove process of P3 and transferred to **CLAMP ASSEMBLY PROCESS** due to separation of process. Refer to ENGDRR-127 for Document revision request.

M. Ariola

J. Loterte

C. Villanueva

A. Arañes

05/12/23

7

Inclusion of quality checkpoints

J. Loterte

C. Villanueva

A. Arañes

n/a

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

July 12, 2018

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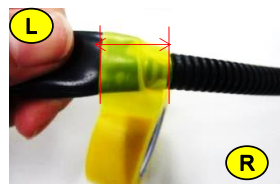
QUALITY POINTERS

2

P3



Y-taping



1. Hold two SV tube (Vinyl) using left hand and fix to COT. Make 1 wind pre-tape before shifting.



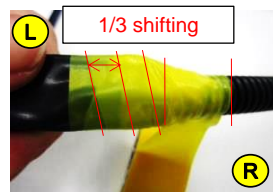
2. Wind the tape down to SV tube (Vinyl) until tape width.



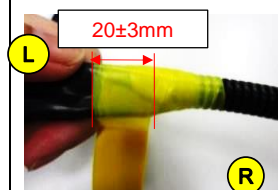
3. Make 1 wind before shifting.



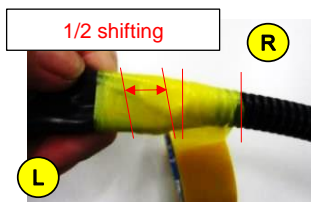
5. From COT, wind the tape down to SV tube (Vinyl) until



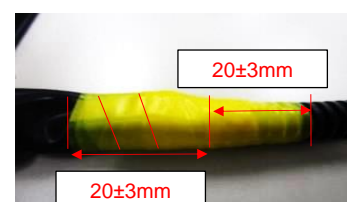
4. From SV tube (Vinyl), make 1/3 shifting to COT until tape width. Wind the tape 1 time before shifting.



6. Wind the tape 2 times before final shifting.



7. From SV (vinyl) tube, make 1/2 shifting to COT until tape width. Wind the tape 2 times and then cut the tape.



8. Check the measurement and taping condition.

MEASURING TAPE



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

Important reminder/Note/s:
1. Use **YELLOW TAPE** to easily visualize the tape shifting. But actual should be **BLACK TAPE ONLY.**

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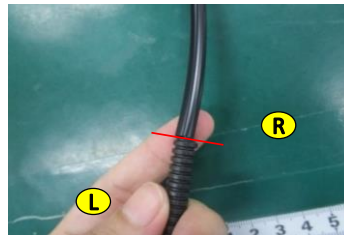
TOOLS/PPE

QUALITY POINTERS

3

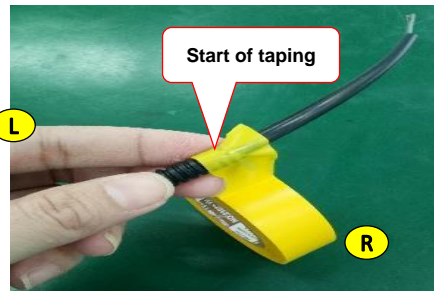
P3

Taping 2
Corrugated tube to
Black VM tube
(Sunprene)

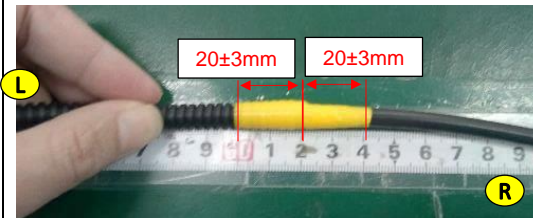


1. Hold the COT using left hand and fix the sunprene tube using right hand.

Note: Must be no gap between tubes



2. Hold the assy parts using left hand. Get the **Yellow tape** and start taping process using both hands.



3. After taping, check the measurement and taping condition.

MEASURING TAPE



Important reminder/Note/s:
1. Please use calibrated/verified measuring tape when getting the measurement.

Document references:
1. Please refer to WI-PRO-ASY-001 for taping procedure.

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

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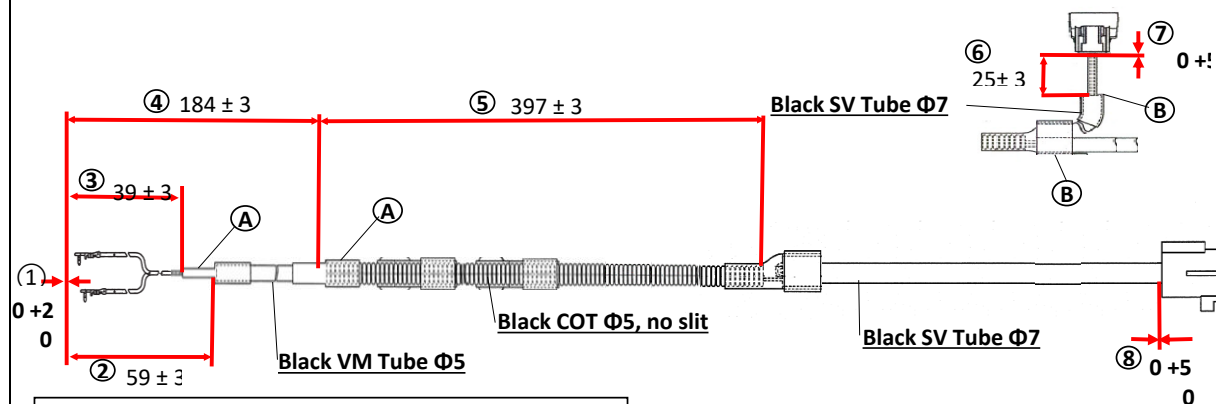


QUALITY POINTERS

4

P3

Measurement



WIRE TYPE TABLE

NO.	COLOR	WIRE TYPE	
1	G	AVSS 0.3f	Tinned
2	B/W	AVSS 0.3f	Tinned
3	OR	AVSS 0.3f	
4	Y	AVSS 0.3f	

NOTE:

- (A) Taping (Y)
- (B) Taping (B)

Important reminders and note/s:

- Please use calibrated/verified measuring tape when getting the measurement.
- For Hatsumono, Nakamono and Owarimono.

Document reference/s:

- Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection

- No wrong dimension

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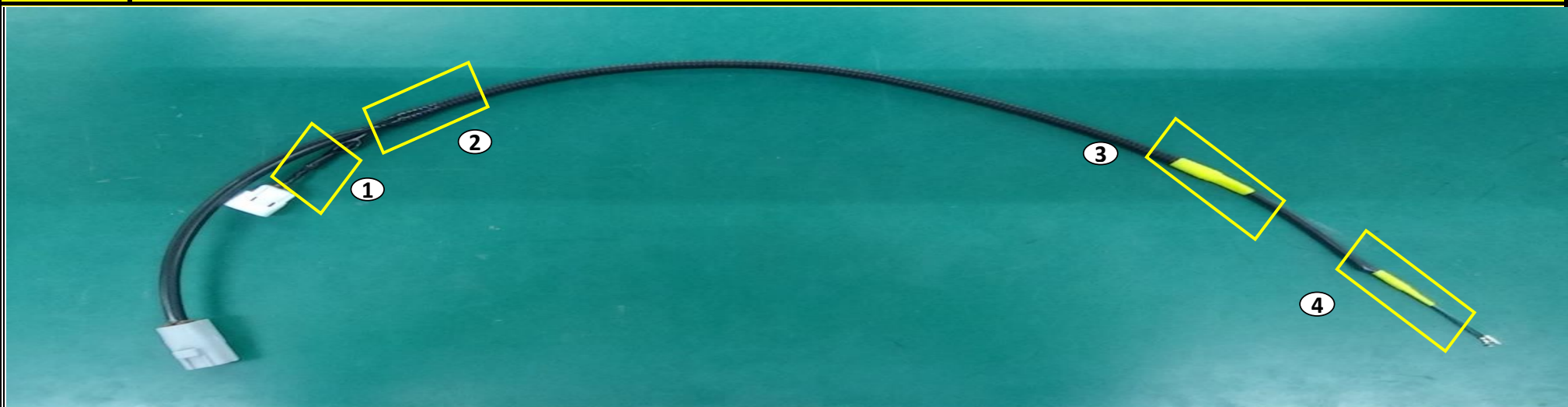
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VISUAL INSPECTION/QUALITY CHECKPOINTS

P3

7L0053-7025



1 2 3 4

No Missing/ Wrong use

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