



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

July 13, 2023

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

320B / 7L0054-7025

Customer:

TRQSS

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-141A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

7

Page No.:

1 of 4

PARTS:

1. Assy parts; Black corrugated tube (no slit) $\phi 5$ L=109 \pm 3mm; Black VM tube (Sunprene) $\phi 5$ L=101 \pm 3mm; Green tape

JIG:

1. Terminal cover jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

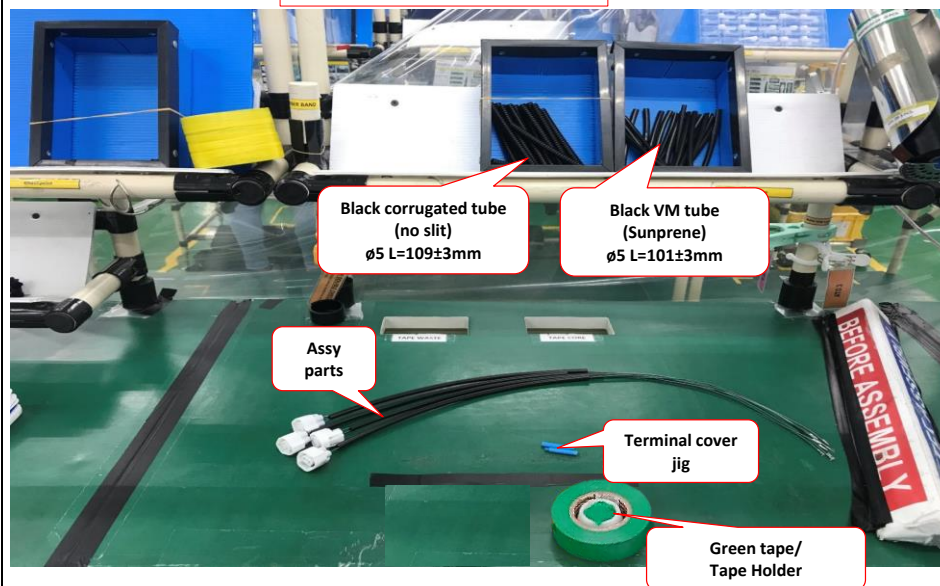
QUALITY POINTERS

1

P1

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

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
07/13/23	7	Updated Template; Inclusion of CAR MODEL "TOYOTA- RAV4". Updated Table lay-out illustration; Change Quality checkpoints; Remove and transferred process no. 3 and 5 from P1 to P2; Transferred process of Taping 1 (page 3, process 4) from P2 to P1 due to new process distribution. Refer to ENGDRR-125 for Document revision request	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
02/08/22	6	Work instruction improvement. Improved quality pointers. Change term Black sunprene tube to VM tube (Sunprene). Inclusion of Quality check point (Page 4).	D.Castillo	J. Loterte	C. Villanueva	A. Arañes				
01/15/22	5	Change part number from 7L0054-7024 to 7L0054-7025 due to change in PCB from 2 chip(61C619-0002) to 1 chip(7N0994-7060);Change in wire color from Gray (GR) to Green (G).	K. Doria	J. Loterte	C. Villanueva	A. Arañes				
							M. Ariola	J. Loterte	C. Villanueva	A. Arañes
							Est. Date:	July 12, 2018		

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PARTS:		1. Assy parts 2. Black corrugated tube (no slit) $\phi 5$ L=109 \pm 3mm 3. Black VM tube (Sunprene) $\phi 5$ L=101 \pm 3mm	JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Wire insertion to Black corrugated tube (no slit) $\phi 5$ L=109 \pm 3mm	 1. Get the terminal cover jig using right hand then insert the G-B/W wires using left hand.  2. Get the Black corrugated tube (no slit) $\phi 5$ L=109 \pm 3mm using right hand then insert the G-B/W wires using left hand.  3. After insertion, remove the terminal cover jig using right hand.	 TERMINAL COVER JIG	1. No wrong usage of parts 2. No deformed terminal
3	Wire insertion to Black VM tube (Sunprene) $\phi 5$ L=101 \pm 3mm	 1. Get the Black VM tube (Sunprene) $\phi 5$ L=101\pm3mm using right hand then insert the G-B/W wires using left hand.	n/a	1. No wrong usage of parts 2. No deformed terminal

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PARTS:

1. Assy parts
2. Green tape

JIG

n/a

NO.

PROCESS NAME

7

WORK PROCEDURE/ ILLUSTRATION

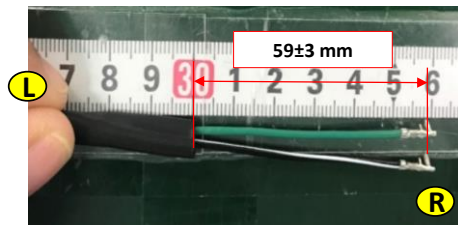
TOOLS/PPE

QUALITY POINTERS

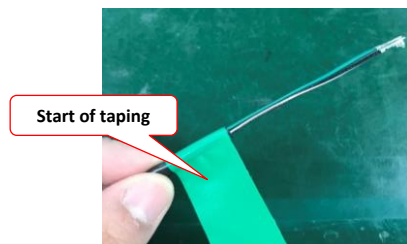
4

P1

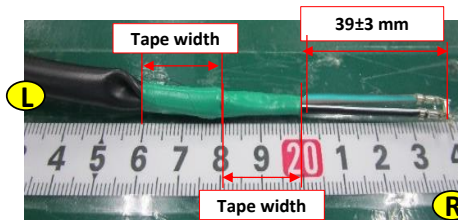
Taping 1
Black VM tube (Sunprene)
to Wire near terminal



1. Hold the sunprene tube using left hand and measure from end of VM tube (Sunprene) up to terminal pointed tip **59±3mm**.



2. Hold the VM tube (Sunprene) using left hand. Get the **Green tape** using right hand and begin taping process using both hands.



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

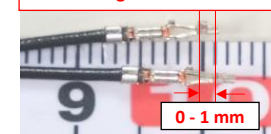
MEASURING TAPE



Important reminders/Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.
2. Please refer to WI-PRO-ASY-001 for taping procedure.

Wire alignment tolerance



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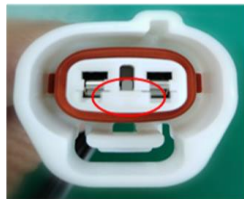
n/a



QUALITY CHECKPOINTS

P1

7L0054-7025



GOOD



NO GOOD



GOOD



NO GOOD

1

No Unlock/ Half Lock Connector

3

No Missing Tape

No Wrong use of tape (GREEN)

2

No Wrong Insert

4

No Terminal Backing Out

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