

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 6, 2024

Model code/Part number:

310B / 7M0555-7020A

Customer:

TRJ

Car Model:

TOYOTA-RAV4

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-116B

Revision No.:

10

Page No.:

1 of 6

PARTS: 1. Assy Parts ; Black tape ; Black VM tube (Sunprene) ø9 L=97±3mm

JIG:

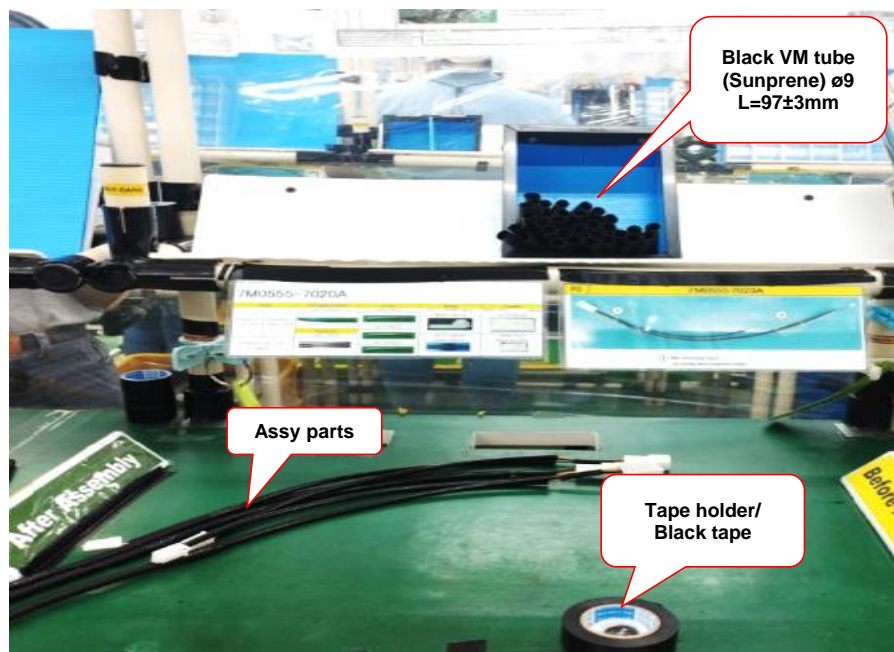
n/a

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

1

P2

Table Lay-out

**Safety Instruction**

Be sure to wear required 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
06/06/24	10	Change process sequence. Inclusion of Measurement and Quality pointers process on page 5 and improve visual inspection on page 6.	A.Hernandez	C. Villanueva	A. Arañes	n/a				
04/26/23	9	Inclusion of Quality Checkpoints on page no.5. Standardize tube description: VM tube (Sunprene) and SV tube (Vinyl) due to document process improvement.	M. Ariola	J.Loterte	C. Villanueva	A. Arañes				
11/17/22	8	Improve Quality pointer; Reminders/Notes and references on pages no.2,3 and 4 due to document improvement.	M. Ariola	J.Loterte	C. Villanueva	A. Arañes				
06/02/22	7	Remove and transfer process 1 and 3 to P1 due to process improvement. Additional Table Lay-out. Remove old revision triangles.	M. Ariola	J.Loterte	C. Villanueva	A. Arañes	A.Hernandez	C. Villanueva	A. Arañes	n/a
							Est. Date:	October 17, 2018		

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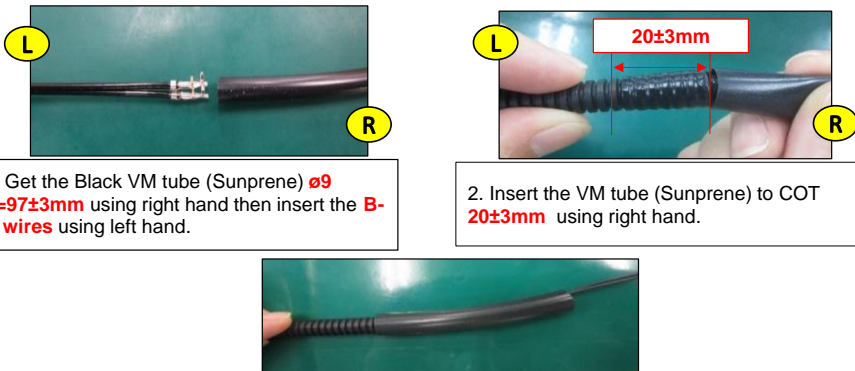
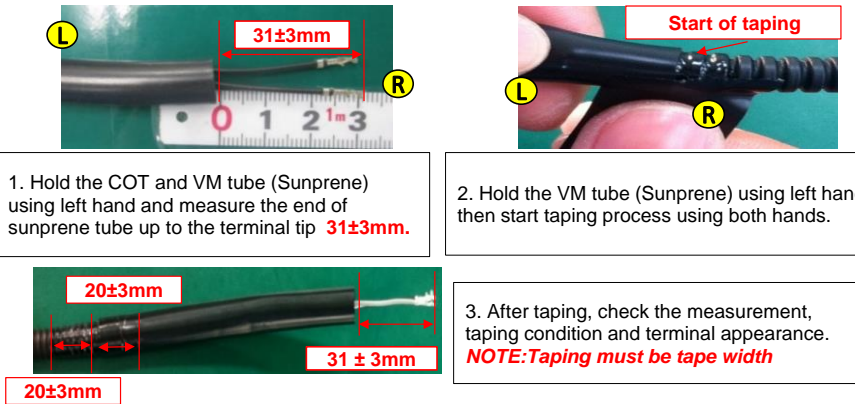
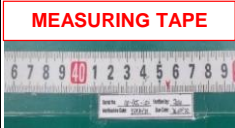
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) $\varnothing 9$ L=97 \pm 3mm 3. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Black VM tube (Sunprene) $\varnothing 9$ L=97 \pm 3mm	 <p>1. Get the Black VM tube (Sunprene) $\varnothing 9$ L=97\pm3mm using right hand then insert the B-B wires using left hand.</p> <p>2. Insert the VM tube (Sunprene) to COT 20\pm3mm using right hand.</p>		n/a	1. No wrong use of parts
3	P2 Taping 1 Black Corrugated tube (Assy Part) to Black VM tube (Sunprene) $\varnothing 9$ L=97 \pm 3mm	 <p>1. Hold the COT and VM tube (Sunprene) using left hand and measure the end of sunprene tube up to the terminal tip 31\pm3mm.</p> <p>2. Hold the VM tube (Sunprene) using left hand then start taping process using both hands.</p> <p>3. After taping, check the measurement, taping condition and terminal appearance. NOTE: Taping must be tape width</p>		 <p>MEASURING TAPE</p>	<p>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</p> <p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <p>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p>

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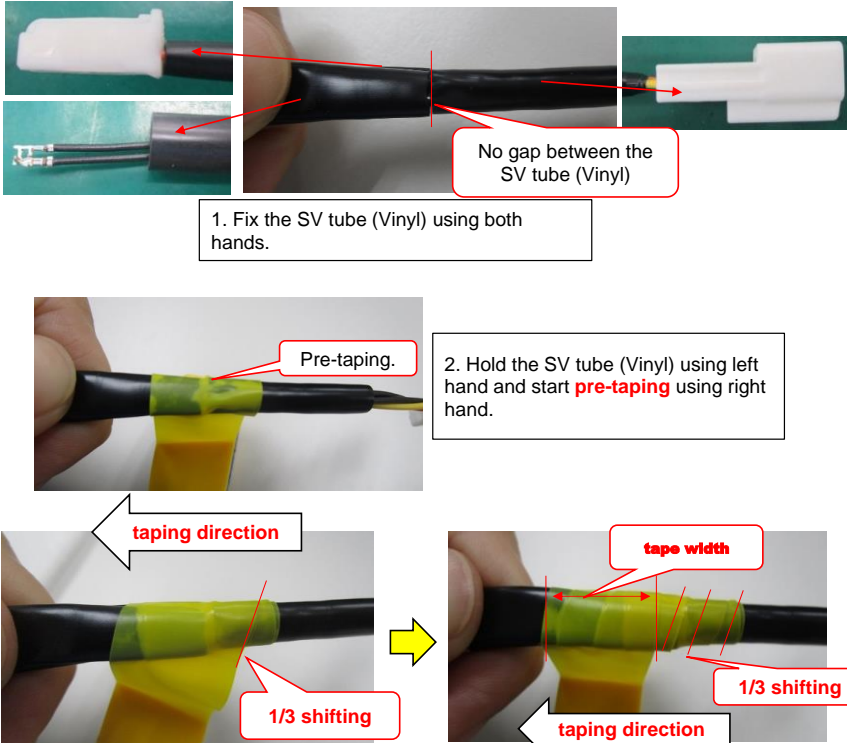
☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Y- Taping	<div></div>	n/a	<p>Important reminders/Note/s:</p> <p>1. Use YELLOW TAPE for the easy visualization of tape shifting, but actual should be BLACK TAPE.</p> <p>2. 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 use of tape 6. No wrong dimension</p>

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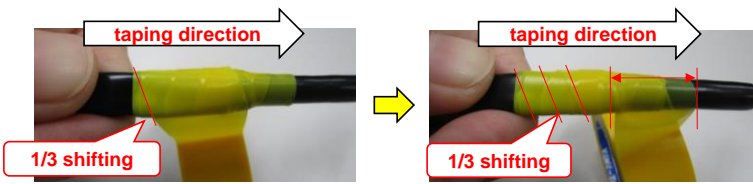
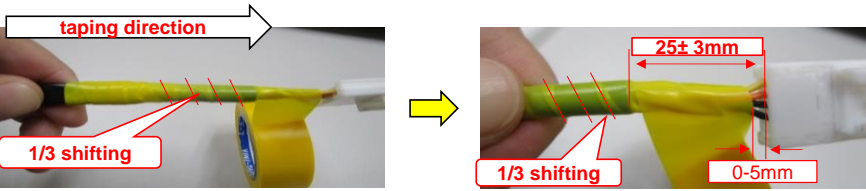
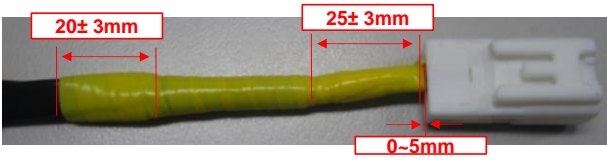

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PARTS:		1. Assy parts 2. Black tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2 Y- Taping (Continuation)	<div><p>4. Make 1/3 shifting going to the right side.</p><p>5. Make 1/3 shifting, cover the SV tube (Vinyl) and wire. Measure SV tube (Vinyl) up to connector 25± 3mm then make 3 winds in wire before cutting of tape. Note: No folding of vinyl tube.</p><p>6. After taping, check the measurement and taping condition.</p></div>	<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Use YELLOW TAPE for the easy visualization od tape shifting, but actual should be BLACK TAPE.2. Please use calibrated/verified measuring tape when getting the measurement. <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension

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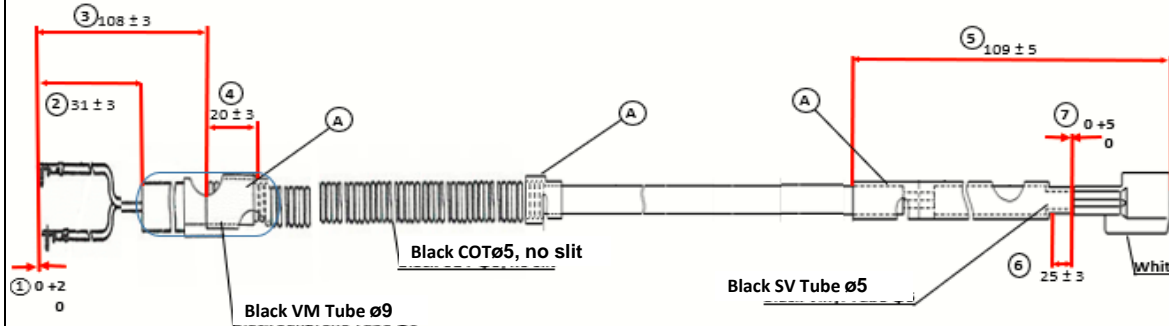
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PARTS:		1.Assy parts		JIG:	n/a
NO.	PROCESS NAME	<div>10</div> WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	<div>10</div> QUALITY POINTERS
5	P2	<div>Measurement</div> <div></div>			<div>Important reminders and note/s:</div> <div>1.Please use calibrated /verified measuring tape when getting the measurement.</div> <div>2. For Hatsumono,Nakamono and Owarimono.</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection.</div> <div>1.No wrong dimension</div>

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PARTS:

1. Assy Parts

JIG:

n/a

**VISUAL INSPECTION****TAPING-P2****7M0555-7020A**

1 No Missing Tape
(Y-Taping and COT to VM tube)

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