



## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

311D / 7L0152-7023

Customer:

TRQSS

Car Model:

TOYOTA RAV 4

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

October 4, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1002B

Revision No.:

0

Page No.:

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PARTS: 1. Assy parts; Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

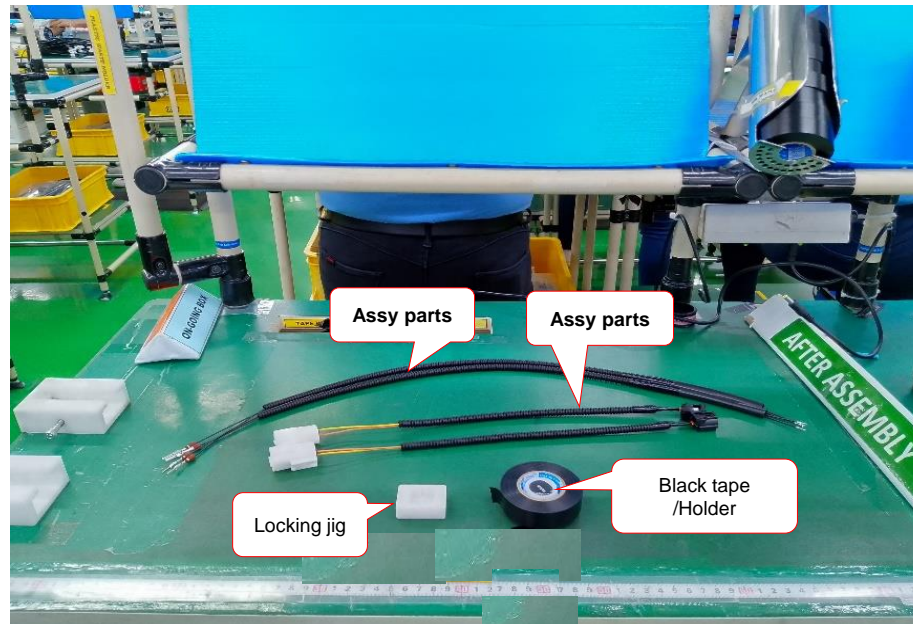
QUALITY POINTERS

1

P2

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.

**Important reminders/Note/s:**

1. Refer to WI-ENG-PDE-675 for Offline assembly process
2. 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

10/04/24 0

Initial issue.

A.Hernandez

C. Villanueva

A. Arañes

n/a

A.Hernandez

C. Villanueva

A.Arañes

n/a

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

October 4, 2024

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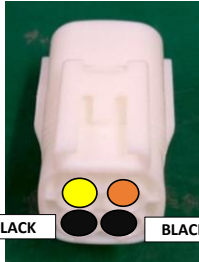




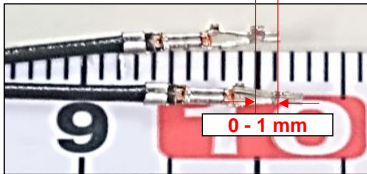
☒ MASSPRO

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PARTS:		1. Assy parts 2. AVSSf 0.3 B-B wire L=661mm (Assy parts)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2  Wire insertion to connector 6188-0093 (W)	<div><div><p>BLACK BLACK</p><p>VISUAL REFERENCE</p></div><div><p>CONNECTOR ORIENTATION</p></div><div><p>Wire terminal facing</p></div><div><p>L R</p></div><div><p>L R</p></div><div><p>1. Get the connector <b>6188-0093 (W)</b> then hold the <b>Black wire</b> and insert to terminal <b>slot 1</b> of connector using right hand. Conduct <b>2x</b> push pull after wire insertion.</p></div><div><p>2. Hold the connector <b>6188-0093 (W)</b> then get the <b>Black wire</b> and insert to terminal <b>slot 2</b> of connector using right hand. Conduct <b>2x</b> push pull after wire insertion.</p></div></div>		<p>MEASURING TAPE</p> 	<div><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></div> <div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div> <p><b>Important reminders/Note/s:</b></p> <p><b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></p>

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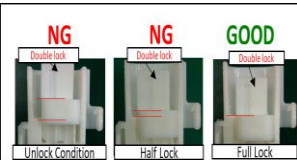



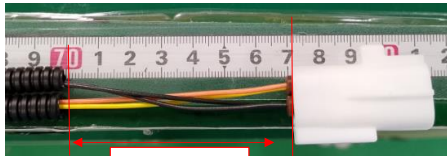
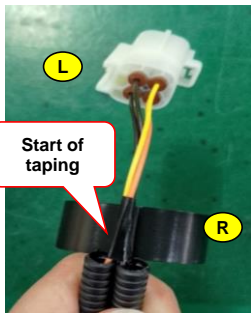
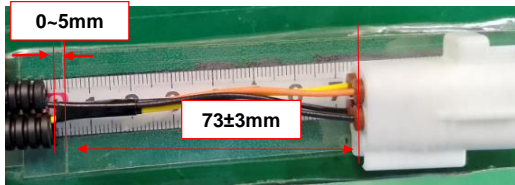

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PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Connector lock	    <p>1. Put the connector into locking jig using both hands and then press <b>2x</b>. Check the connector lock if properly lock.</p>		<b>LOCKING JIG</b> 	1. Use provided locking jig per model. 2. No unlock/half-locked connector  <b>Document reference/s:</b>  <b>1. Please refer to GL-PRO-ASY-029 for Pull-Push procedure.</b>
4	Spot taping	 <p>73±3mm</p>  <p>Start of taping</p>  <p>0~5mm 73±3mm</p> <p>1. Combine the 2 COT and wires. Measure from end of Combined COT up to edge of connector <b>73±3mm</b> using both hands.</p> <p>2. Get the <b>Black tape</b> using right hand then conduct <b>2 windings of tape</b> using both hands.</p> <p>3. After taping, check the measurement and taping condition.</p>		<b>MEASURING TAPE</b> 	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  <b>Important reminders/Note/s:</b>  <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b>

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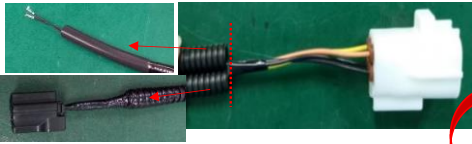
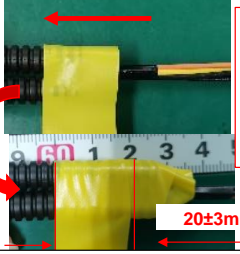
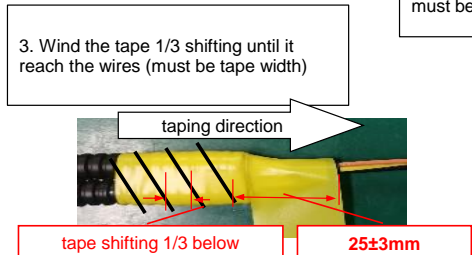
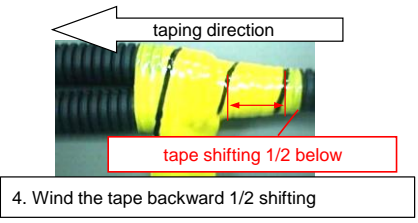
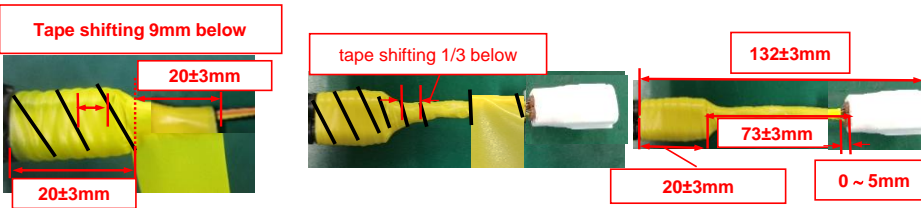
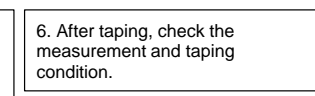

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PARTS:		1. Assy Parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2	Y-taping	<div><p>1. Fix the 2 corrugated tube. Follow the correct connector orientation. <i>Note: 2 COT must be aligned.</i></p></div> <div><p>2. Start taping at the middle of combined COT &amp; wires, then wind the tape going to 2 corrugated tubes (2 windings) , width must be same with tape (20mm)</p></div> <div><p>3. Wind the tape 1/3 shifting until it reach the wires (must be tape width)</p></div> <div><p>4. Wind the tape backward 1/2 shifting</p></div> <div><p>5. Wind the tape 1/2 shifting going to spot tape. Cover the spot tape &amp; wire 1/3 shifting. Measure end of COT up to connector <b>73±3mm</b> then make <b>3 windings</b> of tape before cutting of tape.</p></div> <div><p>6. After taping, check the measurement and taping condition.</p></div>		<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>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b> <b>2. Used yellow tape to easily visualize the tape shifting but actual should be <u>BLACK TAPE</u></b></p>

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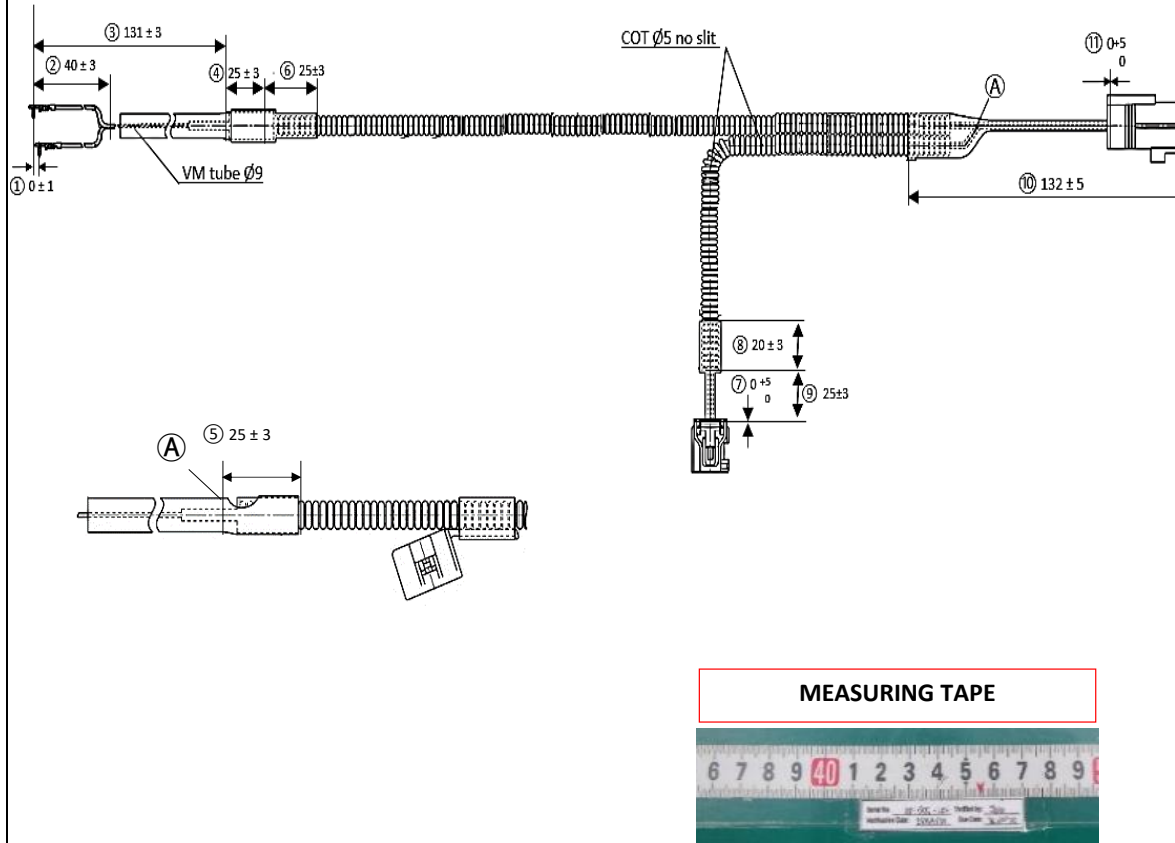
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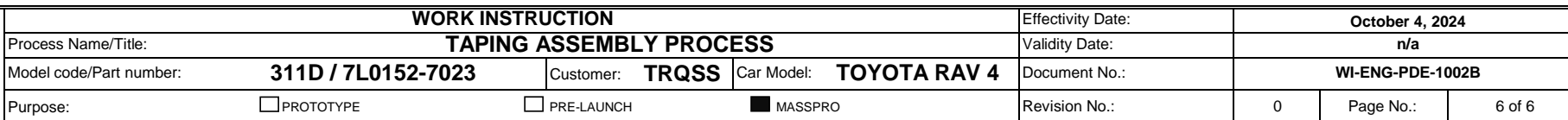
PARTS:	1. Assy Parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P2	Measurement	<div></div>	<p><b>Important reminders and note/s:</b></p> <p><b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></p> <p><b>2. For Hatsumono, Nakamono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

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PARTS:	n/a	JIG:	n/a
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VISUAL INSPECTION / QUALITY CHECKPOINTS	
1. Material Quality	Check for material quality and consistency.
2. Workmanship	Check for workmanship and assembly quality.
3. Dimensions	Check for dimensions and tolerances.
4. Surface Finish	Check for surface finish and appearance.
5. Assembly	Check for assembly and component fit.
6. Packaging	Check for packaging and labeling.
7. Documentation	Check for documentation and records.
8. Compliance	Check for compliance with standards.
9. Safety	Check for safety and hazard identification.
10. Environmental	Check for environmental impact and sustainability.

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