

	WORK INSTRUCTION						Effectivity Date:		April 12, 2025	
	TAPING ASSEMBLY PROCESS						Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 310D / 7N0246-7020		Customer: TRJ	Car Model: TOYOTA-RAV4	Document No.:		WI-ENG-PDE-1231	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		1	Page No.:	1 of 4	

PARTS:	1. Assy Parts 2. Black SV tube (Vinyl) ø5 L=130±3mm 3. Blue tape				JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS
1	P1 Table Lay out	<div style="text-align: center; border: 1px solid red; padding: 5px; margin-bottom: 10px;">TABLE LAY OUT</div>				<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker. </div> <div style="border: 1px solid red; padding: 5px;"> 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		Checked by		Reviewed by		Approved by	
Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved	Est. Date:	March 29, 2025							
04/12/25	1	Change pre-launch to masspro	A. Buban	J. Loterte	C. Villanueva	A. Arañes		<div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> A. Buban </div> <div style="text-align: center;"> J. Loterte </div> <div style="text-align: center;"> C. Villanueva </div> <div style="text-align: center;"> A. Arañes </div> </div>							
03/29/25	0	Initial issue	A. Buban	J. Loterte	C. Villanueva	A. Arañes									

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PROTOTYPE



PRE-LAUNCH



MASSPRO

Document No.:


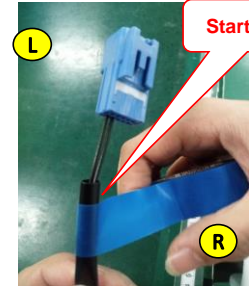
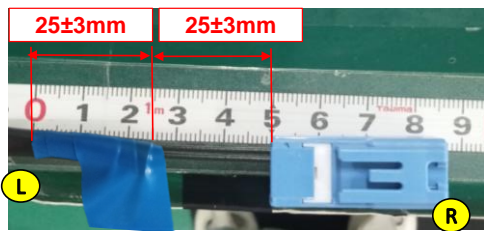
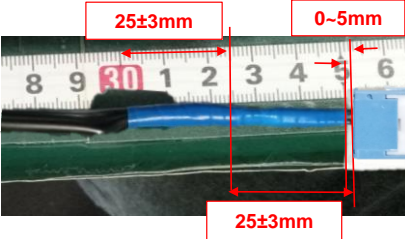
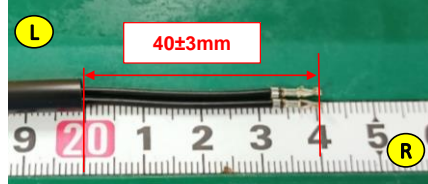
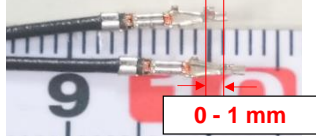
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PARTS:		1. Assy parts 2. Blue tape [1pc]		3. Black SV tube (Vinyl) $\phi 5$ L=130 \pm 3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
3		Wire Insertion to Black SV tube (Vinyl) $\phi 5$ L=130 \pm 3mm		1. Get the Black SV tube (Vinyl) $\phi 5$ L=130 \pm 3mm using right hand then insert the B-B wires.	n/a	1. No wrong usage of parts 2. No deformed terminal	
4	P1	Taping 1 SV tube (Vinyl) to wire near Connector	 1. Get the Blue tape using right hand then start taping process using both hands.	 2. Hold the COT using left hand and measure from end of COT up to connector 25±3mm .	 3. After taping, check the measurement, taping condition and wire alignment.	 Measuring tape	 Wire alignment tolerance 0 - 1 mm 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 reminders/note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping

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PROTOTYPE



PRE-LAUNCH



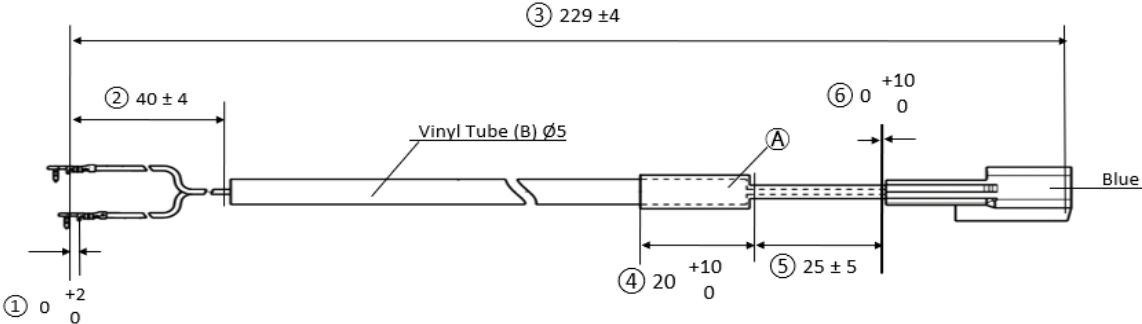

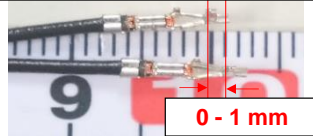
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PARTS:	1.Assy Parts		JIG:	n/a												
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS												
3	P1	Measurement	<div><div><p>NOTE: Ⓐ - Taping (L) *UNIT OF DIMENSION: millimeter (mm) *MEASURING TOOL: measuring tape</p></div><table><tr><th colspan="3">WIRE TYPE TABLE</th></tr><tr><td>No.</td><td>Color</td><td>Wire Type</td></tr><tr><td>1</td><td>B</td><td>AVSS 0.3 f</td></tr><tr><td>2</td><td>B</td><td>AVSS 0.3 f</td></tr></table><div><p>MEASURING TAPE</p></div></div>	WIRE TYPE TABLE			No.	Color	Wire Type	1	B	AVSS 0.3 f	2	B	AVSS 0.3 f	<div><p>1. No wrong usage of parts 2. No deformed terminal</p></div> <div><p>Wire alignment tolerance</p></div> <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></div> <div><p>Important reminders/note/s: 1.Please use calibrated/verified measuring tape when getting the measurement.</p></div> <div><p>Document reference/s: 1.Refer to WI-PRO-ASY-001 for taping</p></div>
WIRE TYPE TABLE																
No.	Color	Wire Type														
1	B	AVSS 0.3 f														
2	B	AVSS 0.3 f														

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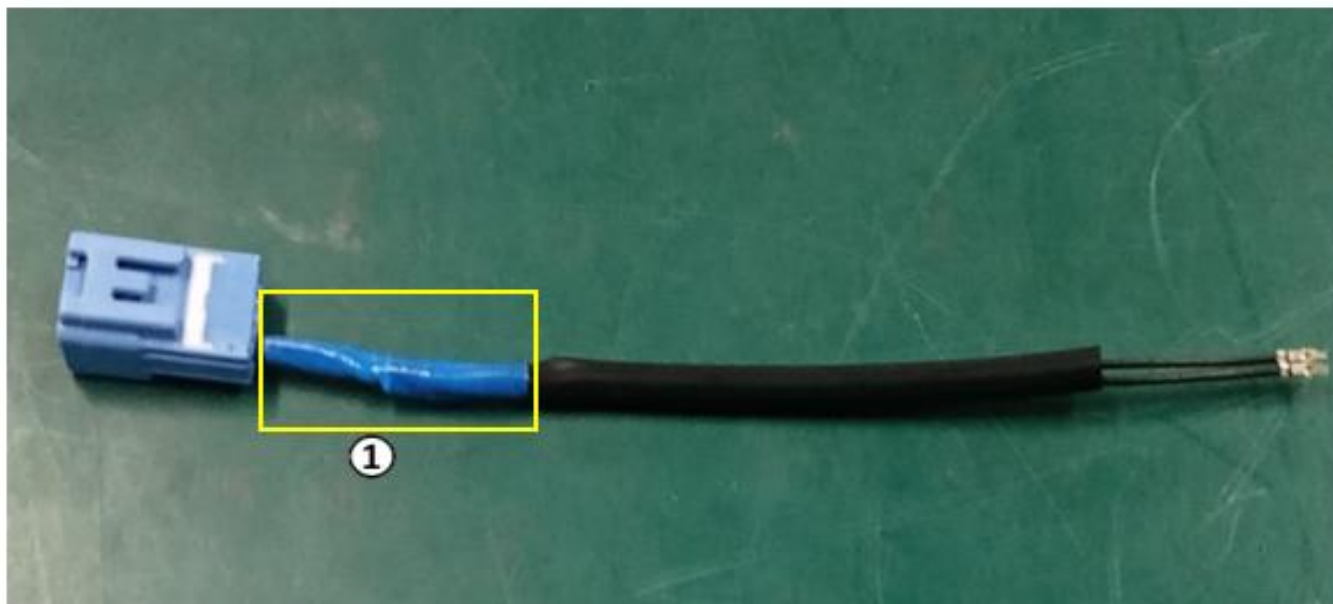
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PARTS:

1.Assy Parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING P-1****7N0246-7020**

① **No Missing and No Wrong
used of tape**

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