	WORK INSTRUCTION				Effectivity Date:		November 04, 2024	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 101D / 7N0098-7021C		Customer: TRJ	Car Model: TOYOTA-RAV4		Document No.: WI-ENG-PDE-1118B
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		1	Page No.:	1 of 5	

PARTS:		1. Assy parts; Black VM tube (Sunprene) Ø9 L=97±3mm; Black tape		JIG:		n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1	P2	Table Lay-out		<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		<div>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>	

Revision History				Prepared by		Reviewed by		Approved by		Noted by	
11/04/24	1	Change document purpose from pre-launch to masspro.									
10/16/24	0	Initial issue. Update the Visual Inspections/Quality checkpoints Illustration		M. Ariola	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted	Est. Date:	October 16, 2024		

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☐ PRE-LAUNCH

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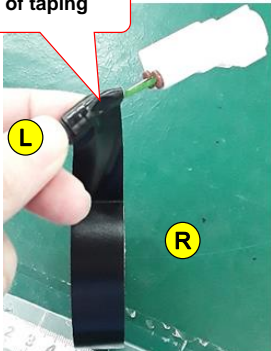
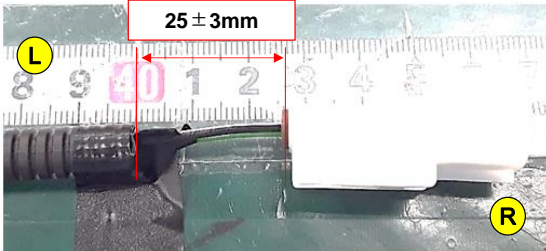
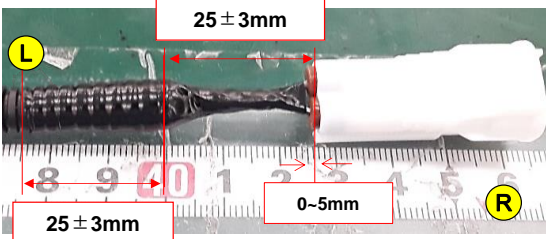

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PARTS:		1. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2	<div><div>Start of taping</div><div>1. Hold the corrugated tube using left hand, get Black tape and start pre-taping using right hand.</div></div> <div><div>25 ± 3mm</div><div>2. Measure from end of corrugated tube up to the edge of connector 25±3mm then continue the taping process using both hands</div></div> <div><div>25 ± 3mm</div><div>0~5mm</div><div>3. After taping, check the measurement and taping condition.</div></div>		<div>MEASURING TAPE</div> 	<p>Important reminders and Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <p>7. No flip-out tape 8. No peel-off tape 9. No loose tape 10. No wrong dimension 11. No wrong use of tape 12. No missing tape</p>

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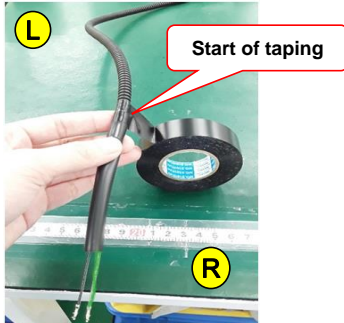


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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) Ø9 L=97±3mm		3. Black tape	JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
3		Wire insertion to Black VM tube (Sunprene) Ø9 L=97±3mm	<div></div> <div>1. Get the Black VM tube (Sunprene) Ø9 L=97±3mm using right hand and insert the G-B/W wires using left hand</div>			n/a	1. No wrong use of parts 2. No deformed terminal
4	P2	Taping 3 Corrugated tube to Black VM tube (Sunprene)	<div></div> <div>1. Hold the COT using left hand and check the dimension from VM tube (Sunprene) to terminal tip 39±3mm using both hands.</div> <div></div> <div>2. Hold the assy parts, get Black tape then start taping process using both hands.</div> <div></div> <div>3. After taping, check the measurement and taping condition.</div>			<div>MEASURING TAPE</div> 	Important reminders and 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 procedure. 1. No peel-off tape 2. No flip-out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape

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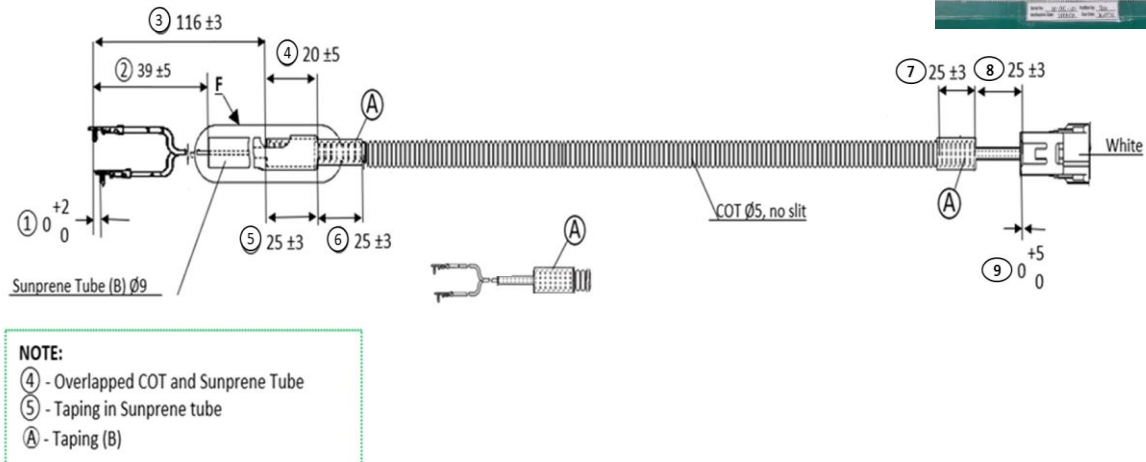

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2	Measurement	<div></div>	<div>MEASURING TAPE</div> 	<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring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

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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P2****7N0098-7021C**

① **No Missing Black VM tube (Sunprene)**

② ③ **No Missing tape (Black tape)**

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