



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

January 22, 2025

Model code/Part number:

311D

/

7L0154-7023

Customer:

TRQSS

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-1026B

Purpose:

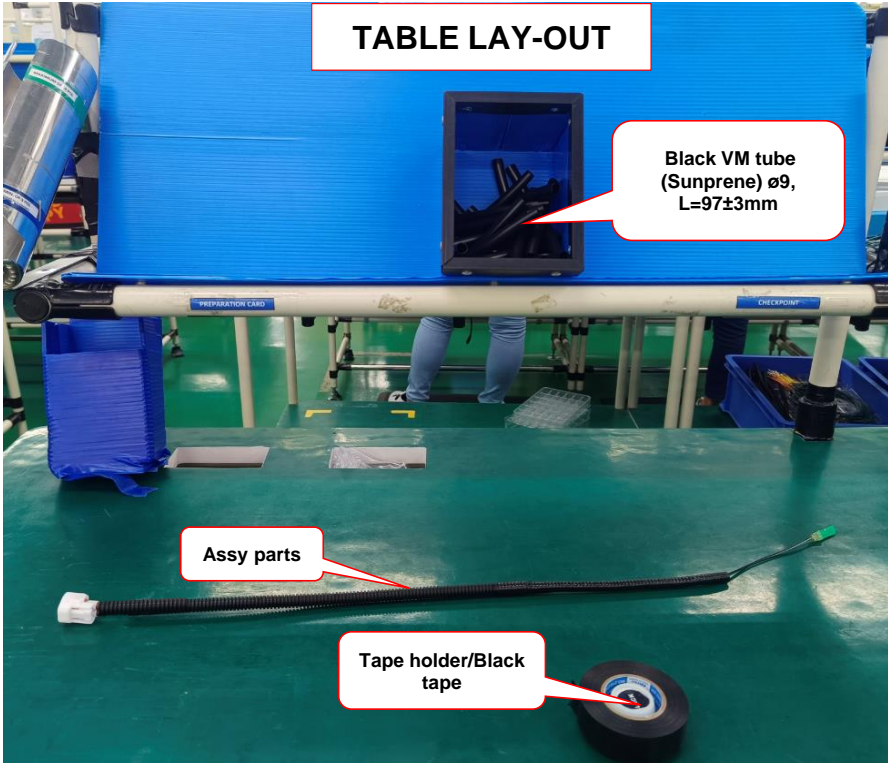

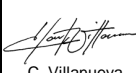

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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Page No.:

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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					<p>Safety Instruction</p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping</p> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>		1. No missing part/tools. 2. No excess parts/tools					
Revision History														
01/22/25	2	Additional Quality pointers "No insufficient tape" and add document references (Page 2-3) as countermeasure to customer claim.				D. Castillo	C. Villanueva	A. Arañes	n/a	Prepared by  D. Castillo	Reviewed by  C. Villanueva	Approved by  A. Arañes	Noted by n/a	
10/02/24	1	Change purpose from Pre-launch to Masspro.				M. Ariola	C. Villanueva	A. Arañes	n/a					
09/10/24	0	Initial issue.				M. Ariola	C. Villanueva	A. Arañes	n/a					
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	September 10, 2024			

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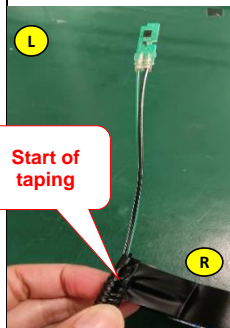

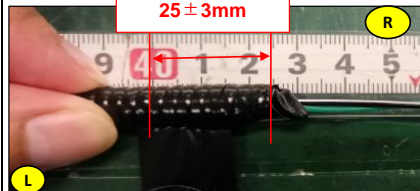
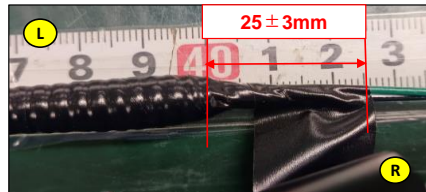
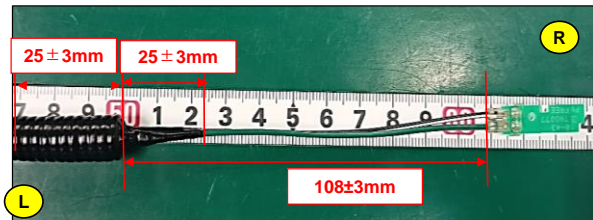

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Revision No.:

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 2 Black Corrugated tube to Wire near PCB	<div><div><p>Start of taping</p></div><div><p>1. Get the Black tape using right hand then start taping process using both hand.</p></div><div><p>108 ± 3mm</p></div><div><p>2. Measure from end of COT up to Hotmelted wires L=108±3mm then continue the taping process using both hands.</p></div><div><p>25 ± 3mm</p></div><div><p>25 ± 3mm</p></div><div><p>3. Confirm measurement from end of tape up to end of COT 25±3mm then continue the taping process using both hands.</p></div><div><p>4. Confirm measurement from end of COT up to end of tape 25±3mm then continue the taping process using both hands.</p></div><div><p>25 ± 3mm 25 ± 3mm 108 ± 3mm</p></div><div><p>5. After taping, check the measurement, wire alignment and taping condition.</p></div></div> <div><div>MEASURING TAPE</div></div> <div><p>Important reminders/Note/s:</p><p>1. Please use calibrated/verified measuring tape when getting the measurement.</p><p>Document references:</p><p>1. Refer to WI-PRO-ASY-001A for Taping process</p><div><p>2</p><p>2</p></div><ol style="list-style-type: none">1. No flip-out tape2.No peel-off tape3. No loose tape4. No wrong dimension5. No wrong use of tape6. No missing tape7. No insufficient tape</div>			

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PARTS:

1. Assy parts
2. Black VM tube (Sunprene) $\varnothing 9$, L=97 \pm 3mm

JIG:

n/a

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

3

Wire insertion to Black VM tube (Sunprene) $\varnothing 9$, L=97 \pm 3mm



1. Get the Black VM tube (Sunprene) $\varnothing 9$, **L=97 \pm 3mm** using right hand then insert the hotmelted wires (B/W-G) using left hand.

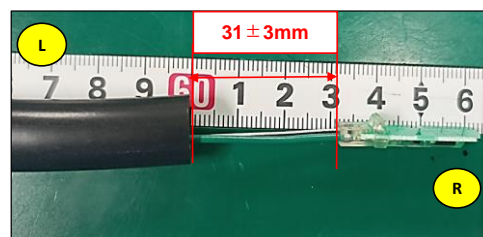
n/a

1. No wrong use of parts.

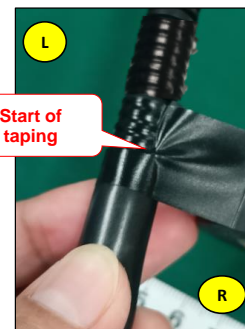
4

P2

Taping 3 Black Corrugated tube to VM tube (Sunprene)

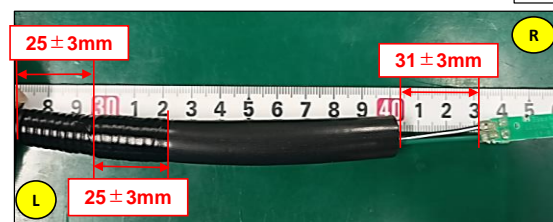


1. Measure the end of VM tube (Sunprene) up to hotmelted wires **L=31 \pm 3mm**.



Start of taping

2. Hold the VM tube (Sunprene) using left hand, get the **Black tape** then start taping using right hand.



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

MEASURING TAPE

Important reminders/Note/s:
1. Please use calibrated/verified measuring tape when getting the measurement.

2

Document references:

1. Refer to **WI-PRO-ASY-001B** for Taping process

2

1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No wrong dimension
5. No wrong use of tape
6. No missing tape
7. No insufficient tape

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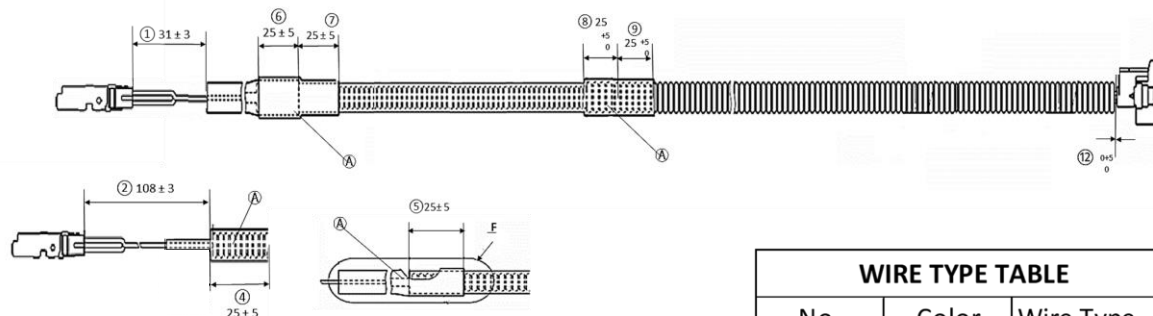
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4 of 5**PARTS:**

n/a

JIG:

n/a

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****5****P2****Measurement**

NOTE:
A - Taping (B)
C - dimension of overlapped Sunprene and COT

WIRE TYPE TABLE

No.	Color	Wire Type
1	G	AVSS 0.3 f
2	BW	AVSS 0.3 f

MEASURING TAPE

1. No wrong dimension

Important reminders/Notes

1. Please use calibrated/verified measuring tape when fetting the measurement.
2. For Hatsumono, Nakamono and Owarimono

Document reference/s:

1. Please refer to WI-PRO-ASY-056 for Sub-Assy Hatsumono, Nakamono and Owarimono inspection.

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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**TAPING - P2****7L0154-7023****1****No MISSING VM tube (Sunprene)****2****3****No MISSING TAPE**

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