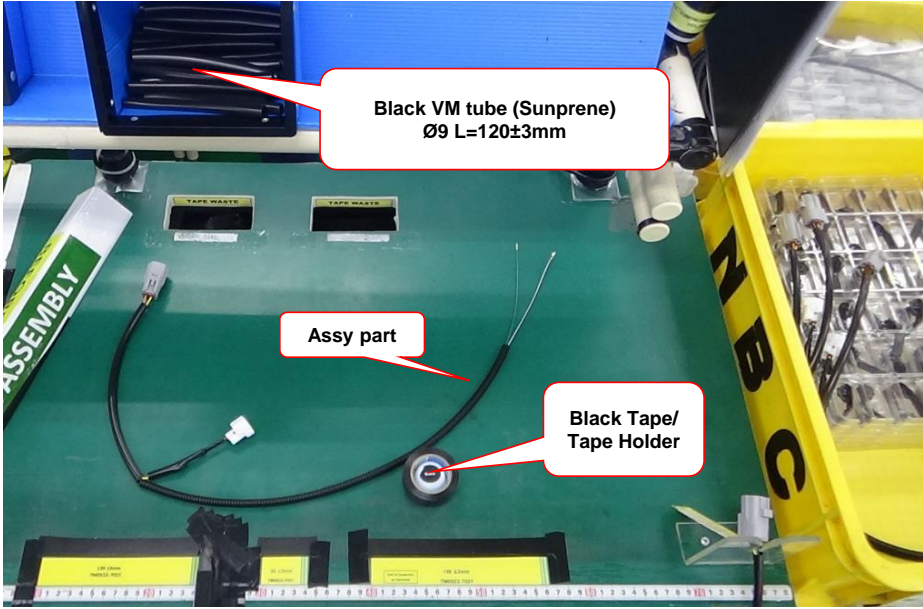
	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>October 22, 2024</b>		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>310B / 7M0522-7021B</b>	Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-RAV 4</b>	Document No.:	<b>WI-ENG-PDE-1130B</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	1 of 6

<b>PARTS:</b>		1. Assy part; Black VM tube (Sunprene) Ø9 L=120±3mm ; Black Tape		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
1	P2	<div> <div>Table Lay-out</div>  </div>		<div> <p><b>Safety Instruction</b></p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b></p> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b></p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>	1. No missing parts/tools 2. No excess parts/tools

Revision History						Prepared by	Reviewed by	Approved by	Noted by
10/22/24	1	Change from Pre-launch to Masspro. Add "No Wrong facing of Y-taping in Visual Inspection and Quality Checkpoints.				A. Hernandez	C. Villanueva	A. Arañes	n/a
10/17/24	0	Initial Issue				A. Hernandez	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted
						Est. Date:	October 17, 2024		

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# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

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Model code/Part number:

310B / 7M0522-7021B

Customer: TRJ

Car Model: TOYOTA-RAV 4

Validity Date:

n/a

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

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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

Y-taping


**No Gap**



1. Fix the two (2) SV tubes (Vinyl) and COT using both hands.

**Note: Connector facing and position of two (2) SV tube (Vinyl) must be same with the illustration.**

**Connector facing and Y-taping facing**



**Top of tube**

**taping direction**

**tape shifting 1/2**

2. Start taping at the middle of combined tubes, attach the tape on the top of tube. Then make pre-tape **2 windings**. Winding the tape **1/2 shifting** going to the left side. Make **2 windings**, width must be **20±3mm**. **Note: Do not exert excessive force during pulling & winding of tape.**

**3. Winding the tape 1/3 shifting** going to the right side until reach the other side of tube. Make **2 windings**, width must be **20±3mm**.

**4. Winding the tape 1/2 shifting** going to the left side. Make **2 windings**, width must be **20±3mm**.

**5. Winding the tape 1/2 shifting** going to the right side until it reach the other side of tube. Make **3 winds**, width must be **20±3mm**. Then cut the tape.

**tape shifting 1/3**

**20±3mm**

**taping direction**

### Document reference/s:

1. Refer to WI-PRO-ASY-001C for taping procedure (special).

### Important reminders/Note/s:

1. Use **YELLOW TAPE** for easy visualization of shifting lines, but actual should be **BLACK TAPE**.
2. Please use calibrated/verified measuring tape when getting the measurement.

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

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Car Model:

TOYOTA-RAV 4

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n/a

Document No.:

WI-ENG-PDE-1130B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

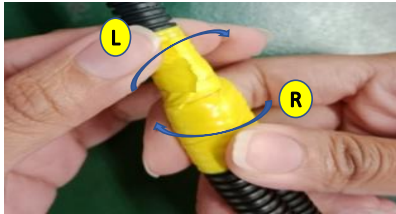

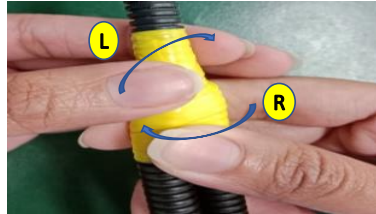
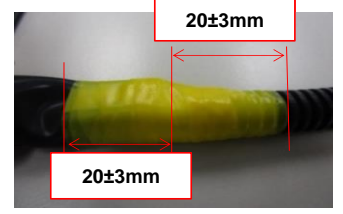
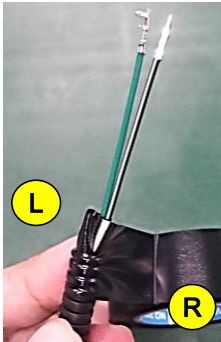
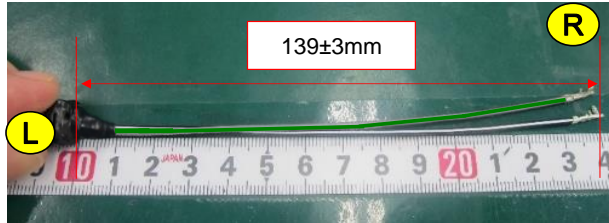
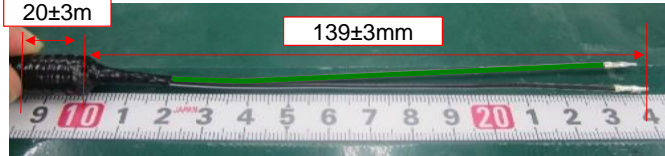
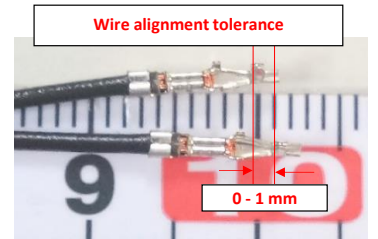

☒ MASSPRO

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PARTS:		1. Assy parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Y-taping (Continuation)				
3	P2 Taping 2 COT to wire near terminal				 <b>MEASURING TAPE</b>  <b>Important reminders and Note/s:</b> 1. Please use calibrated/verified measuring tape when getting the measurement. <b>Document reference/s:</b> 1. Refer to WI-PRO-ASY-001 for taping procedure.

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# WORK INSTRUCTION

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Car Model: TOYOTA-RAV 4

Validity Date:

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WI-ENG-PDE-1130B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

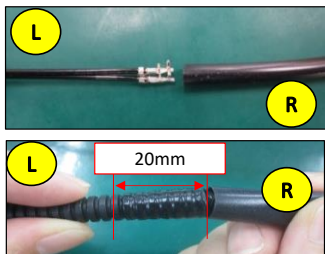
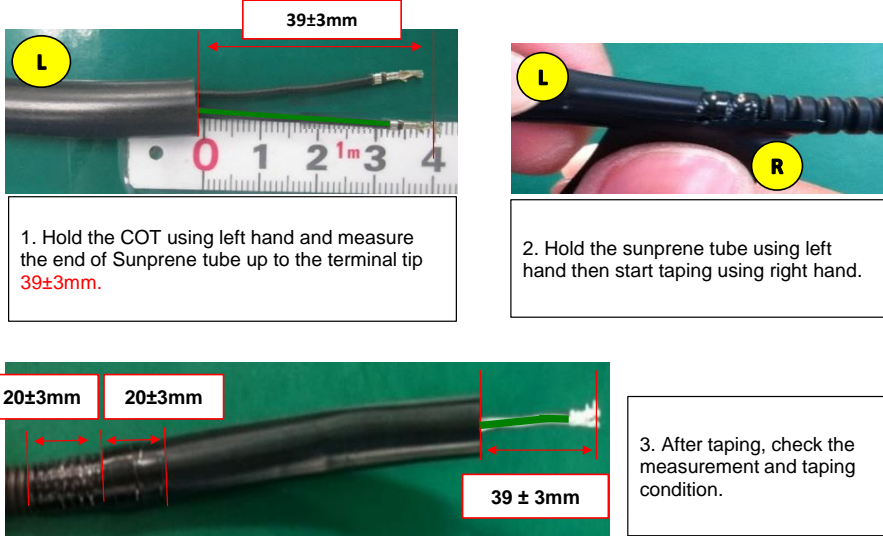

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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) Ø9 L=120±3mm 3. Black Tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Wire insertion to Black VM tube (Sunprene) Ø9 L=120±3mm	 <p>1. Hold the Black wires using left hand and insert the <b>Black VM tube (Sunprene) Ø9 L=120±3mm</b> using right hand.</p> <p>2. Insert the Sunprene tube to COT <b>20mm</b> (Tape width).</p>	n/a	1. No wrong use of parts
5	P2 Taping 3 Corrugated tube to VM tube (Sunprene)	 <p>1. Hold the COT using left hand and measure the end of Sunprene tube up to the terminal tip <b>39±3mm</b>.</p> <p>2. Hold the sunprene tube using left hand then start taping using right hand.</p> <p>3. After taping, check the measurement and taping condition.</p>	<b>Measuring tape</b> 	<b>Important reminders/Note/s:</b> 1. Please use calibrated/verified measuring tape when getting the measurement.  <b>Document reference/s:</b> 1. Please refer to WI-PRO-ASY-001 for taping procedure  1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape

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Purpose:

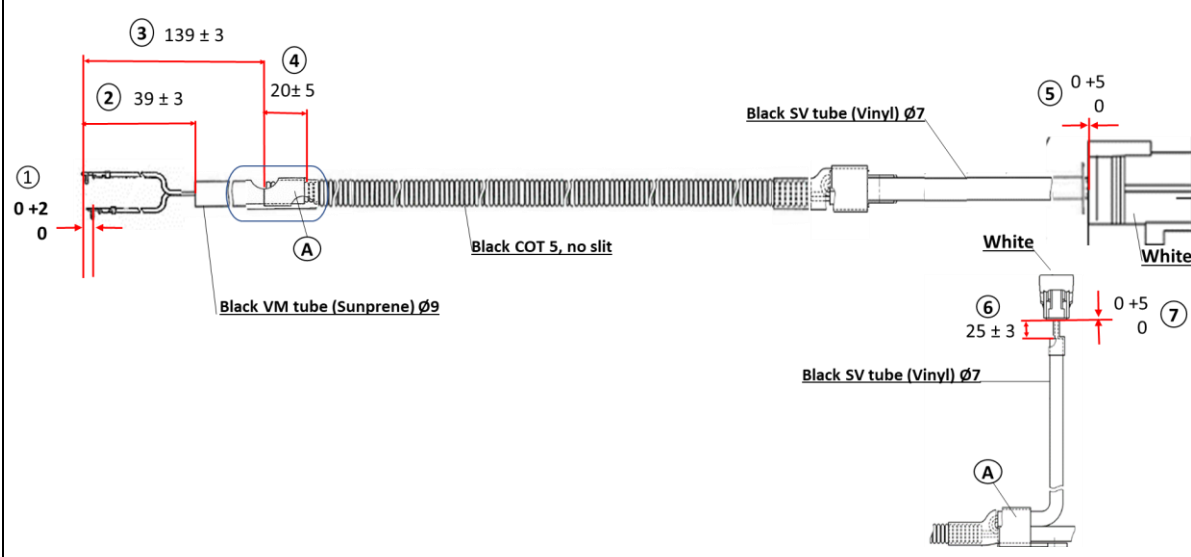

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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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>MEASURING TAPE</div> 	<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>

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☐ PROTOTYPE

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PARTS:

1. Assy parts

JIG:

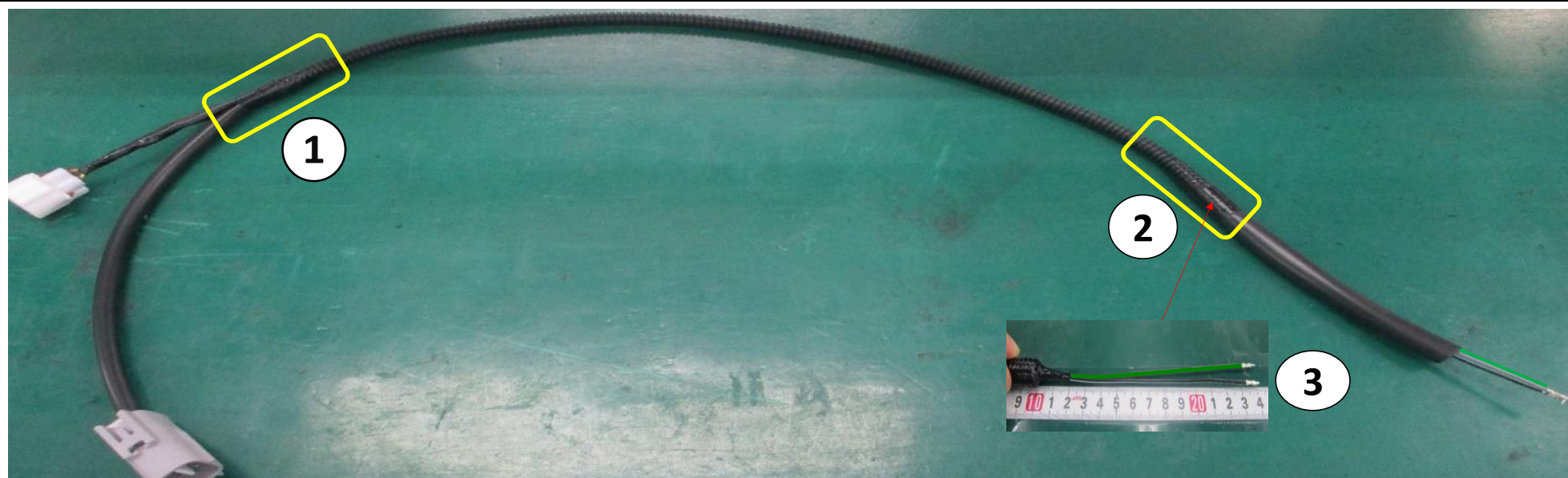
n/a



## VISUAL INSPECTION / QUALITY CHECKPOINTS

P2

7M0522-7021B



1

No Wrong facing of Y-taping

1

2

3

No Missing Tape(Black Tape)

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