



## WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Model code/Part number:

311D

/

7N0195-7020Ea

Customer:

TRJ

Car Model:

TOYOTA-RAV4

Effectivity Date:

June 27, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-919C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

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## PARTS:

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

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

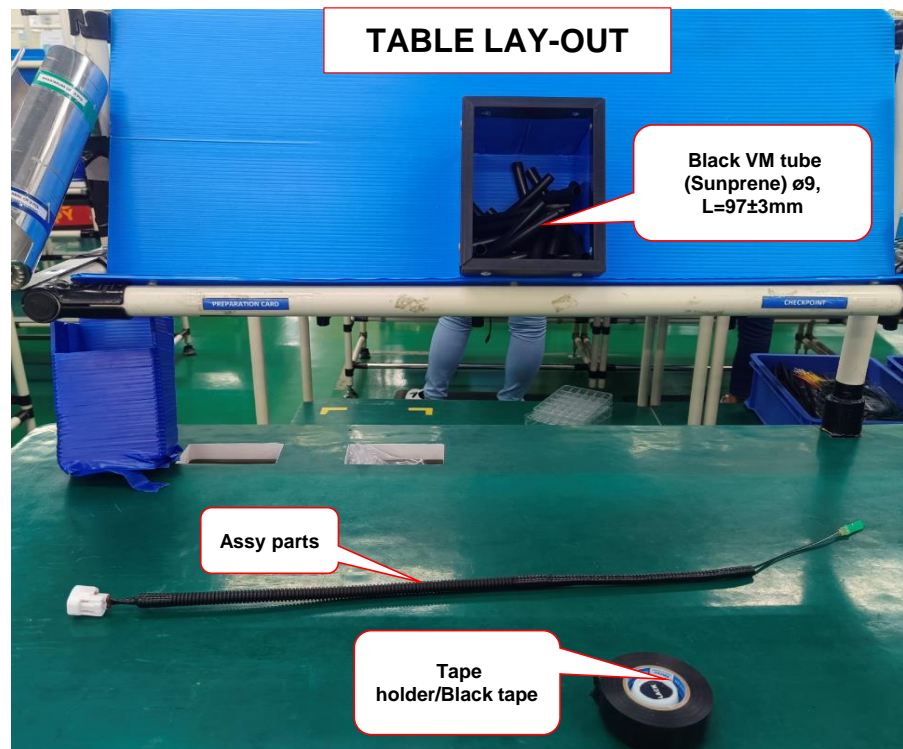
TOOLS/PPE

QUALITY POINTERS

1

P3

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.

1. No missing part/tools.
2. No excess parts/tools

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
6/27/24	0	Initial Issue.					M. Ariola	C. Villanueva	A. Arañes	n/a

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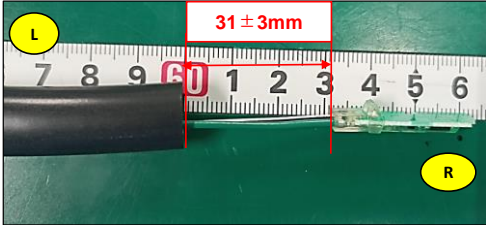

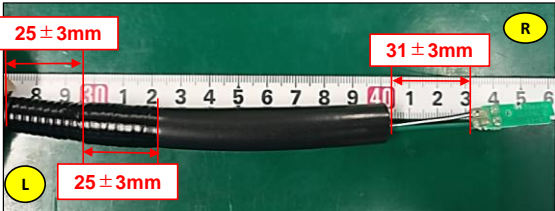

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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) $\varnothing 9$ , L=97 $\pm$ 3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2		Wire insertion to Black VM tube (Sunprene) $\varnothing 9$ , L=97 $\pm$ 3mm	<div></div> <div>1. Get the Black VM tube (Sunprene) <math>\varnothing 9</math>, <b>L=97<math>\pm</math>3mm</b> using right hand then insert the hotmelted wires (B/W-G) using left hand.</div>	n/a	1. No wrong use of parts.
3	P3  Taping 3 Black Corrugated tube to VM tube (Sunprene)	<div></div> <div>1. Measure the end of VM tube (Sunprene) up to hotmelted wires <b>L=31<math>\pm</math>3mm</b>.</div> <div></div> <div>2. Hold the VM tube (Sunprene) using left hand, get the <b>Black tape</b> then start taping using right hand.</div> <div></div> <div>3. After taping, check the measurement and taping condition.</div>		<div>MEASURING TAPE</div> 	<p><b>Important reminders/Notes</b></p> <p>1. Please use calibrated/verified measuring tape when fetting the measurement.</p> <p>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</p>

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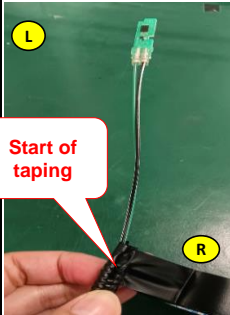
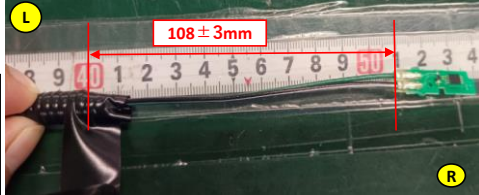
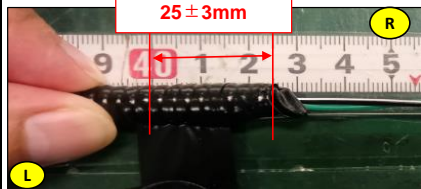
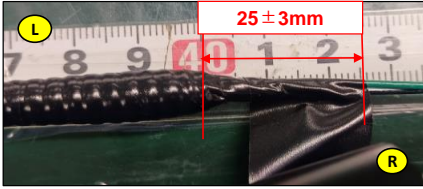
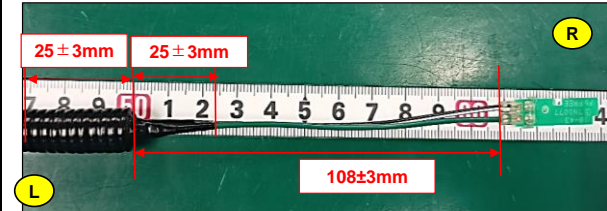

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PARTS:		1. Assy parts 2. Black tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P3 Taping 2 Black Corrugated tube to Wire near PCB	<div><p>1. Get the <b>Black tape</b> using right hand then start taping process using both hand.</p></div> <div><p>2. Measure from end of COT up to Hotmelted wires <b>L=108±3mm</b> then continue the taping process using both hands.</p></div> <div><p>3. Confirm measurement from end of tape up to end of COT <b>25±3mm</b> then continue the taping process using both hands.</p></div> <div><p>4. Confirm measurement from end of COT up to end of tape <b>25±3mm</b> then continue the taping process using both hands.</p></div> <div><p>5. After taping, check the measurement, wire alignment and taping condition.</p></div>	<div><b>MEASURING TAPE</b></div> 	<p><b>Important reminders/Notes</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>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</p>

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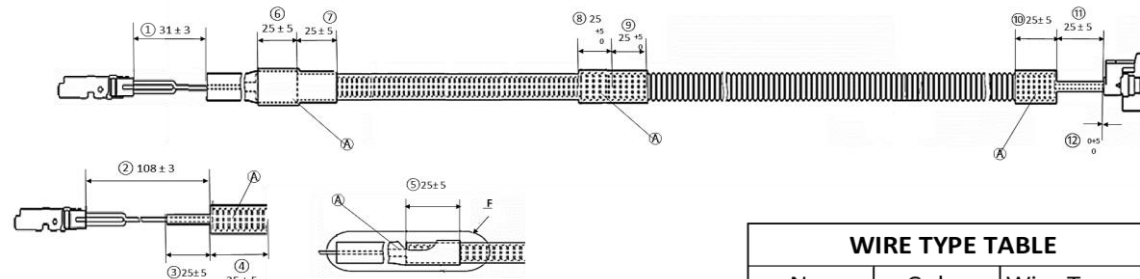
TOOLS/PPE

QUALITY POINTERS

5

P3

Measurement



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

### WIRE TYPE TABLE

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

**QUALITY CHECKPOINTS****P3****7N0195-7020Ea**

①

**No MISSING VM tube  
(Sunprene)**

②

③

**No MISSING TAPE**

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