




Revision History							Prepared by	Reviewed by	Approved by	Noted by
							 A. Hernandez	 C. Villanueva	 A. Arañes	n/a
09/21/24	0	Initial Issue.		A. Hernandez	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change			Revised	Reviewed	Approved	Noted	Est. Date:	September 21, 2024

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**September 21, 2024**

Model code/Part number:

**310B / 7M0529-7020C**Customer: **TRJ**

Car Model:

**TOYOTA-RAV4**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-034B**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

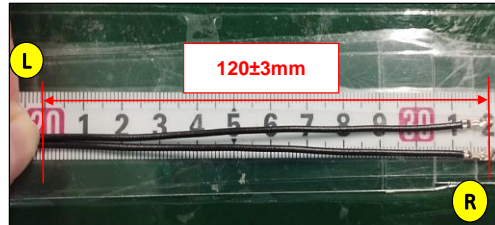
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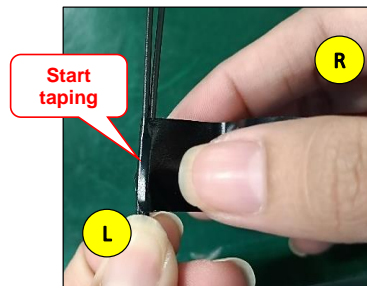
Page No.:

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<b>PARTS:</b>		1. Assy parts 2. Black tape 20mm	JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	P2	Spot taping	n/a	<div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div> <div><b>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></div>



1. Hold the wires using both hands and measure from wire up to terminal pointed tip **120±3mm**.



2. Hold the wires using left hand, get **black tape** then start taping using right hand. Make **2 windings** then cut the tape.



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

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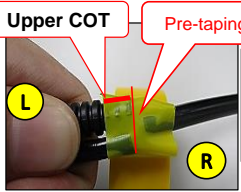
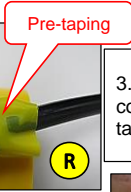
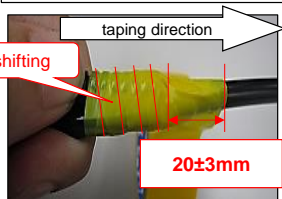
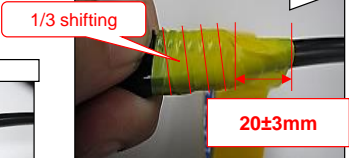
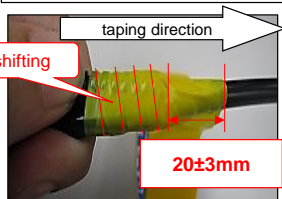
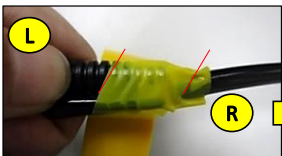
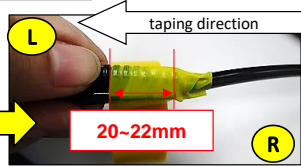
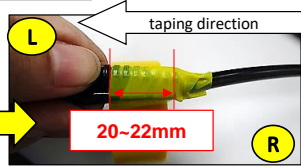
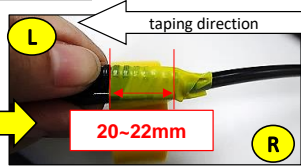
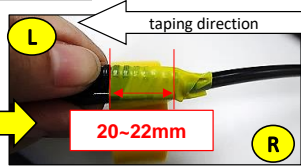
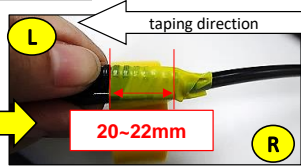
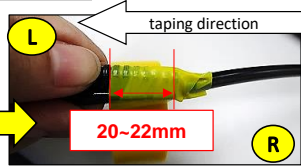
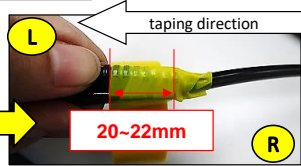
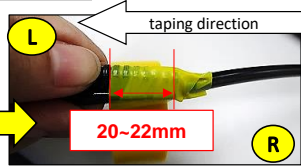
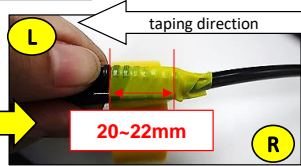
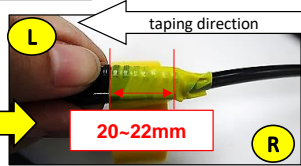
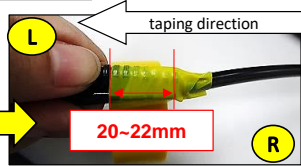
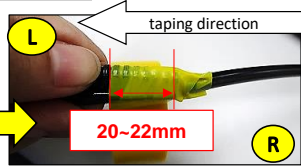
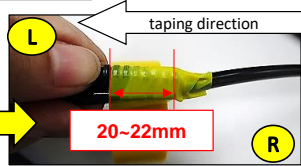
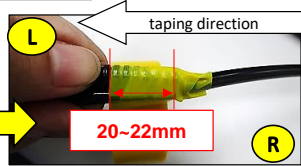
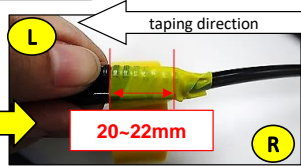
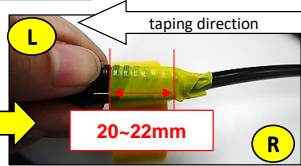
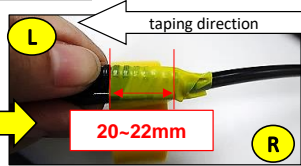
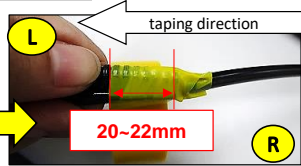
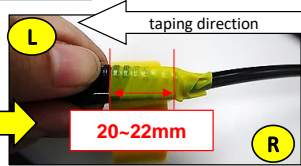
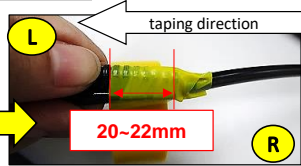
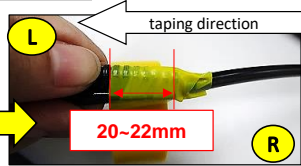
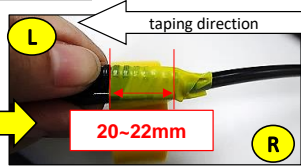
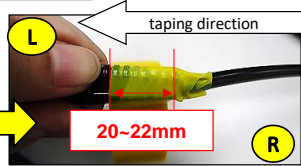
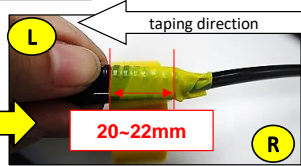
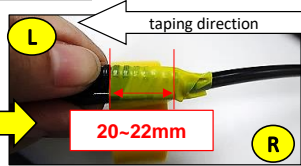
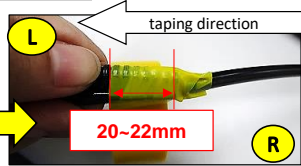
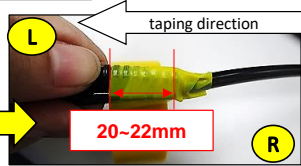
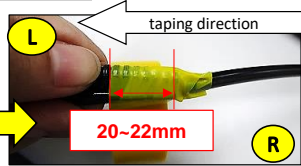
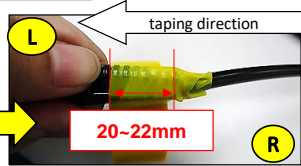
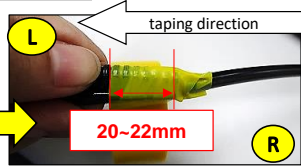
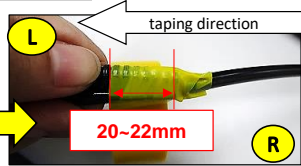
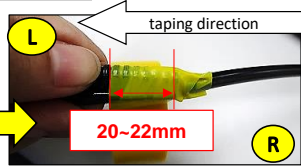
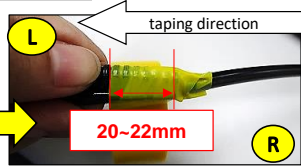
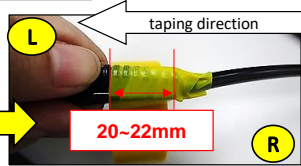
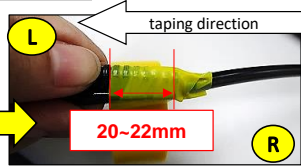
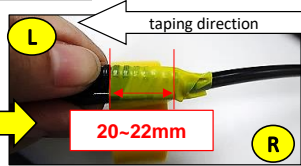
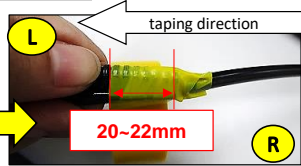
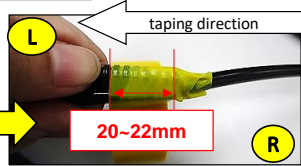
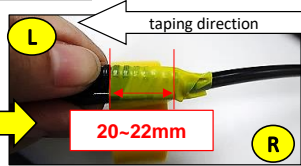
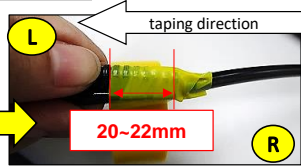
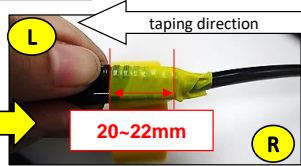
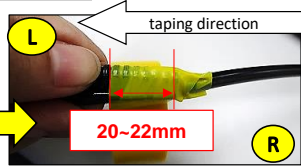
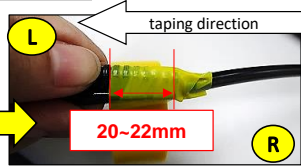
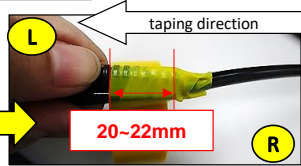
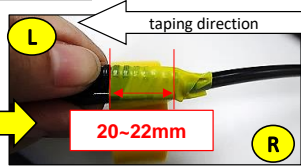
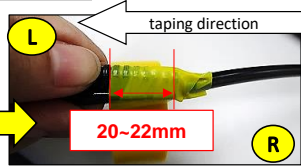
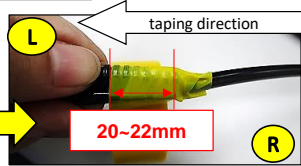
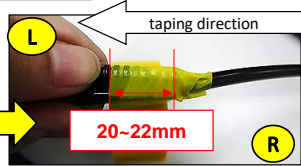
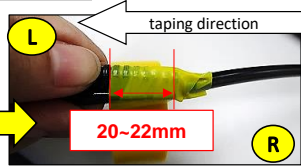
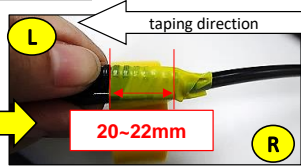
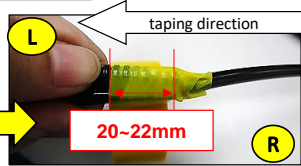
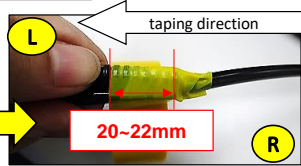
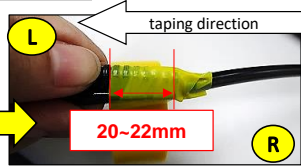
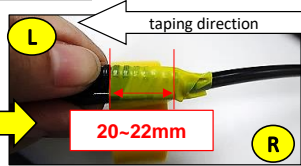
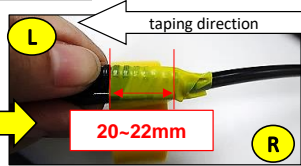
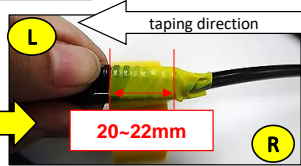
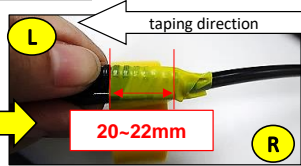
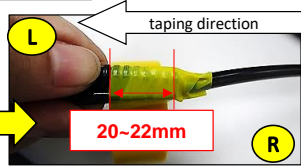
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PARTS:		1. Assy parts 2. Black Corrugated tube (no slit) $\varnothing 5$ L=391 $\pm$ 3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Wire Insertion to Black SV tube (Vinyl) $\varnothing 5$ L=124 $\pm$ 3mm	<div></div> <div>1. Get the <b>Black SV tube (Vinyl) <math>\varnothing 5</math> L=124<math>\pm</math>3mm</b> using right hand then insert the B-B wires.</div>		n/a	1. No wrong use of parts
4	P2  Y-Taping	<div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div></div>			

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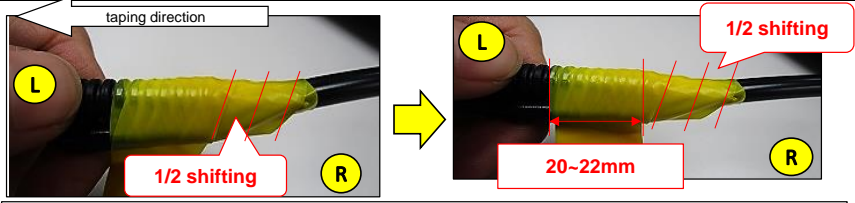
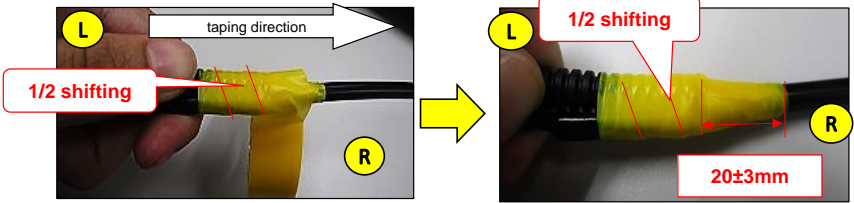
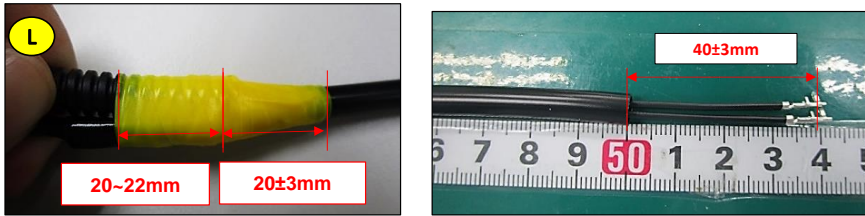

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Revision No.:

0

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PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2 Y-Taping (Continuation)	 <p>6. Wind the tape backward <b>1/2 shifting</b> until it reach the COT. Then wind the tape, width must be <b>20~22mm (2 winds)</b>.</p>  <p>7. Wind the tape <b>1/2 shifting</b> going to other side of Black SV Tube (Vinyl). Then wind the tape, width must be <b>20±3mm (2 winds)</b> and cut the tape.</p>  <p>8. After taping, check the condition of tape and measurement from SV tube up to terminal pointed <b>40±3mm</b> and taping condition.</p>			<ul style="list-style-type: none"><li>1. No loose tape</li><li>2. No flip-out tape</li><li>3. No peel-off tape</li><li>4. No wrong use of tape</li><li>5. No wrong dimension</li><li>6. No wide interval between the COT</li><li>7. No exposed wire</li></ul> <p><b>Important reminders/Note/s:</b></p> <ul style="list-style-type: none"><li>1. Please use <b>calibrated/verified</b> measuring tape when getting the measurement.</li><li>2. Use <b>YELLOW</b> tape to easily visualize the tape shifting. But actual should be <b>BLUE TAPE</b>.</li></ul>

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**September 21, 2024**

Model code/Part number:

**310B / 7M0529-7020C**Customer: **TRJ**Car Model: **TOYOTA-RAV4**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

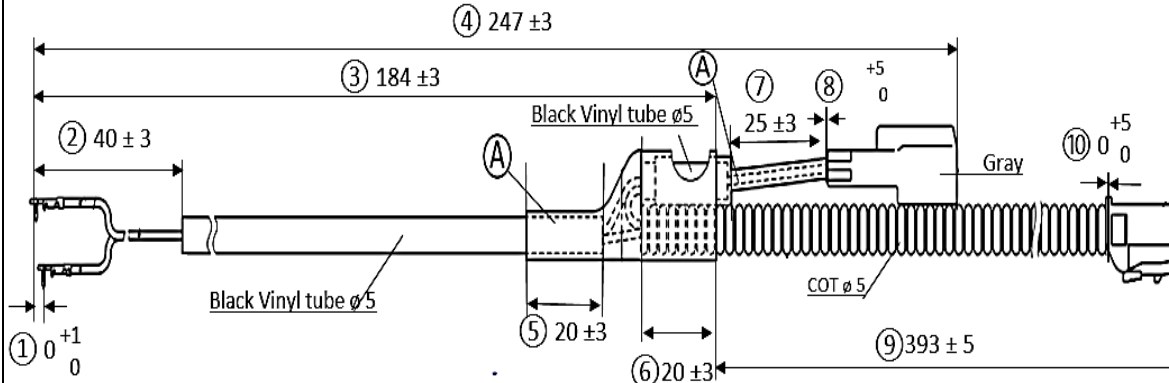

**WI-ENG-PDE-034B**

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2	Measurement			<p><b>Important reminders/Note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono and Owarimono.</p>

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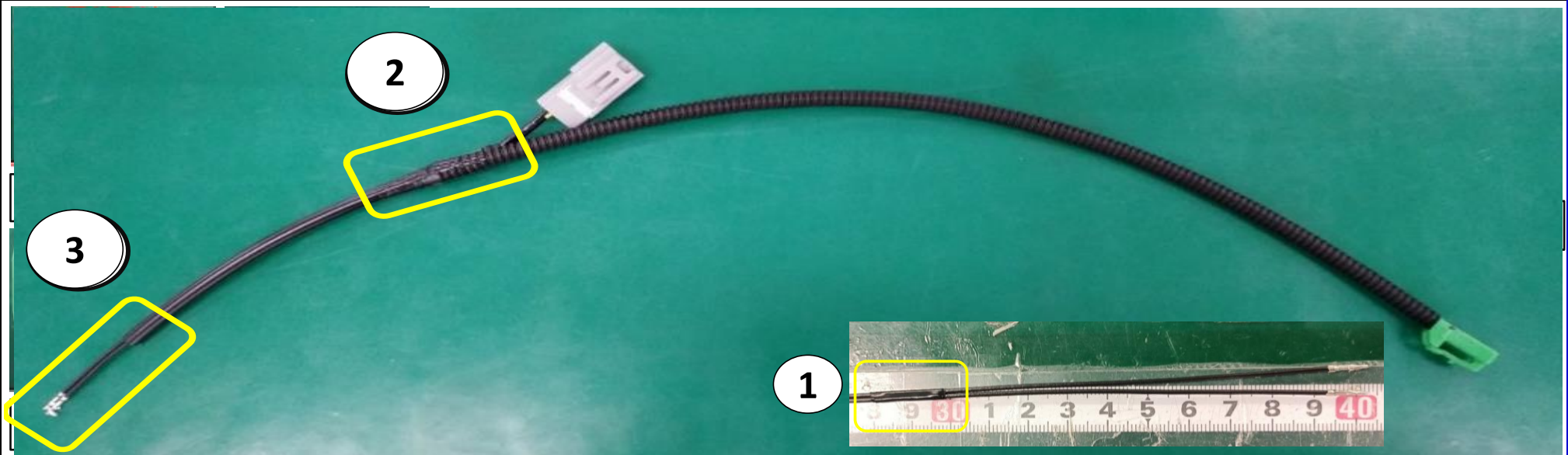
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PARTS:

n/a

JIG:

n/a

**VISUAL INSPECTION QUALITY CHECKPOINTS****P2****7M0529-7020C****1****No Spot Tape  
( Black Tape )****2****No Missing Tape  
( Black Tape )****3****No Deformed Terminal**

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