



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 22, 2024

Process Name/Title:

Model code/Part number:

310B / 7M0557-7021B

Customer: TRJ

Car Model: TOYOTA RAV4

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1133A

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1. Black Corrugated tube (No slit) $\phi 5$ L=149 \pm 3mm ; Black Sunprene tube $\phi 9$ L=97 \pm 3mm; Assy parts

JIG:

1. Terminal cover jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

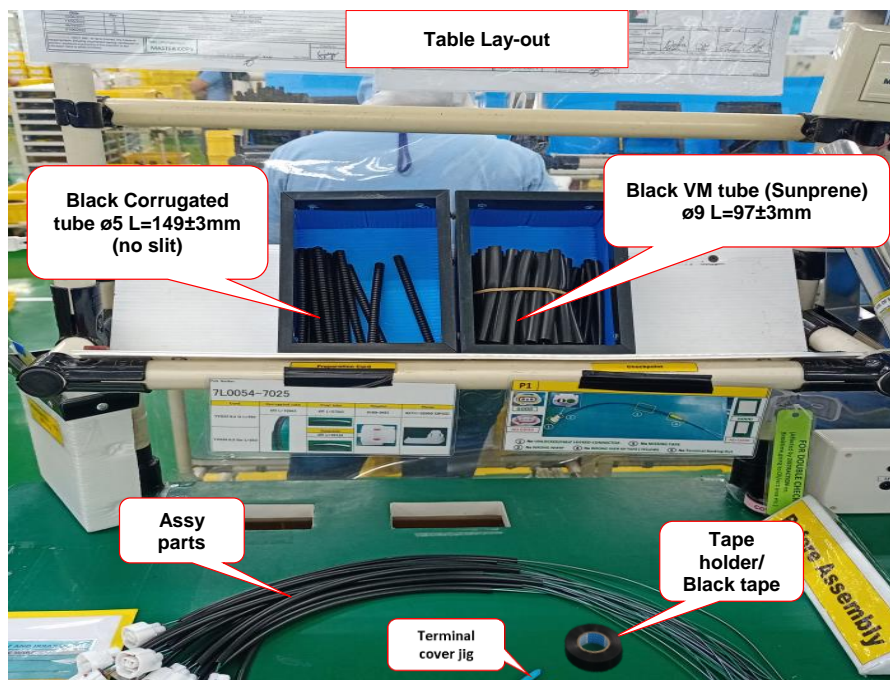
TOOLS/PPE

QUALITY POINTERS

1

P1

Table Lay-out

**Safety Instruction**

Be sure to wear required 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 parts/tools
2. No excess parts/tools

Revision History

Prepared by

Reviewed by

Approved by

Noted by

10/22/24

1

Change pre-launch to mass pro

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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PARTS:		1. Black Corrugated tube $\varnothing 5$ L=149 \pm 3mm (no slit) 2. Assy parts		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1 Wire insertion to Black Corrugated tube $\varnothing 5$ L=149 \pm 3mm (no slit)	<div><div><p>1. Get the terminal cover jig using right hand then insert the G and B/W wires.</p></div><div><p>2. Get the Corrugated $\varnothing 5$ L=203\pm3mm (no slit) using right hand and insert the G and B/W wires</p></div><div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div></div>		<div>Terminal cover jig</div> 	1. No wrong usage of parts 2. No deformed terminal

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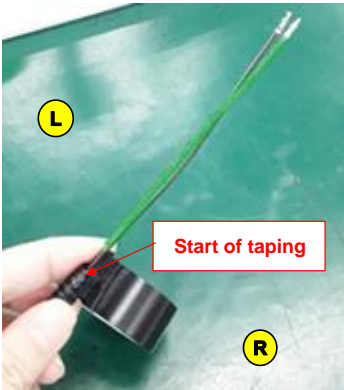
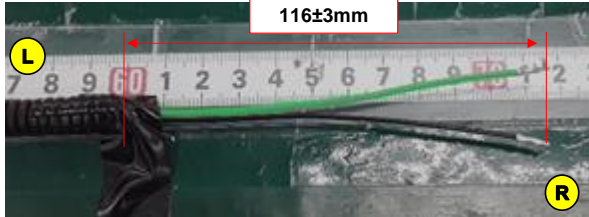
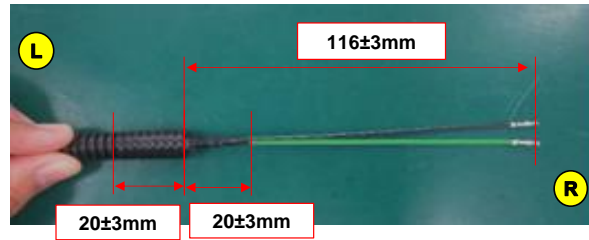

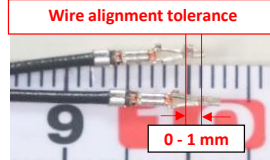
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PARTS:		1. Black tape 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Taping 1 COT to wire near terminal	 <p>1. Hold the assy parts, get the Black tape using right hand then conduct taping process using both hands.</p>  <p>2. Measure the end of COT up to terminal pointed tip $L=116 \pm 3\text{mm}$ then continue the taping process using both hands.</p>  <p>3. After taping, check the dimension, taping condition and wire alignment</p>		<p>MEASURING TAPE</p> 	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</p> <p>Wire alignment tolerance</p> 

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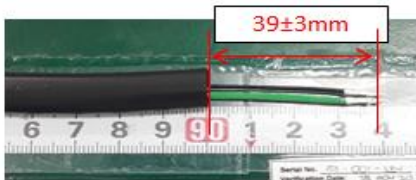



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PARTS:		1. Assy parts 2. Black VM tube (sunprene) $\varnothing 9$ L=97 \pm 3mm		JIG:	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4		Wire insertion to Black VM tube (sunprene) $\varnothing 9$ L=97 \pm 3mm	<div></div> <div>1. Get the Black VM tube (sunprene) $\varnothing 9$ L=97\pm3mm using right hand then insert the Green and Black/White wire using left hand.</div> <div></div> <div>2. Insert the Sunprene to COT 20mm (Tape width) using both hands.</div>	n/a	1. No wrong use of parts 2. No deformed terminal.
5	P1	Taping 2 COT to VM tube (sunprene)	<div></div> <div>1. Hold the COT using left hand and measure the sunprene tube up to terminal tip 39mm using both hands.</div> <div></div> <div>2. Hold the COT using left hand and begin taping using both hands.</div> <div></div> <div>3. After taping, check the dimension and taping condition.</div>	MEASURING TAPE 	1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.

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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P1****7M0557-7021B****① No Missing Tape****② (taping on COT-wire and taping on Sunprene tube)****③ No Missing VM tube (Sunprene)**

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