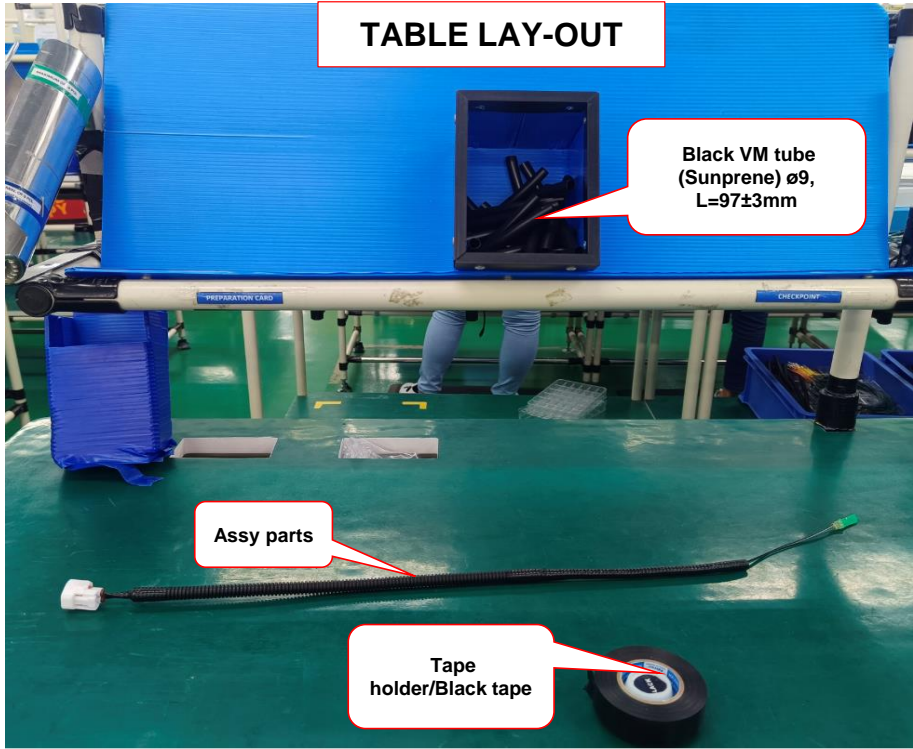
	WORK INSTRUCTION					Effectivity Date:		October 18, 2024		
	TAPING ASSEMBLY PROCESS					Validity Date:		n/a		
	Model code/Part number: 310D / 7N0195-7020E		Customer: TRJ	Car Model: TOYOTA-RAV4		Document No.:		WI-ENG-PDE-1028C		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		1	Page No.:	1 of 5	

PARTS:		1. Assy parts 2. Black VM tube (Sunprene) ø9, L=97±3mm 3. Black tape			JIG:		n/a			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS		
1	P3 Table lay-out					<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		1. No missing part/tools. 2. No excess parts/tools		

Revision History						Prepared by	Reviewed by	Approved by	Noted by
10/18/24	1	Change purpose from Pre-launch to Masspro.				M. Ariola	C. Villanueva	A. Arañes	n/a
9/10/24	0	Initial Issue.				M. Ariola	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

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310D

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Customer:

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n/a

Document No.:

WI-ENG-PDE-1028C

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

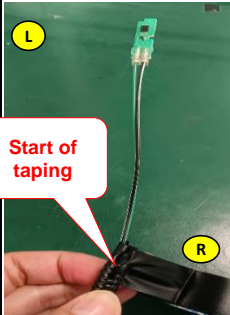
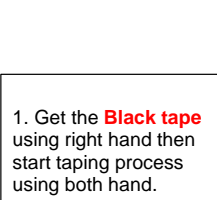
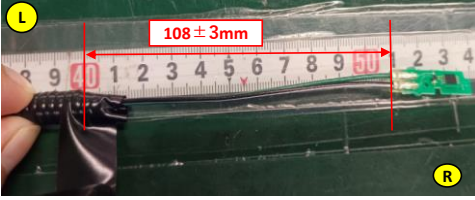
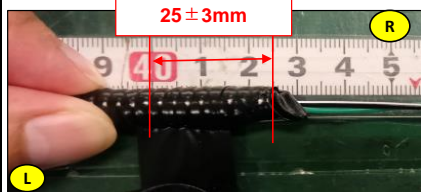
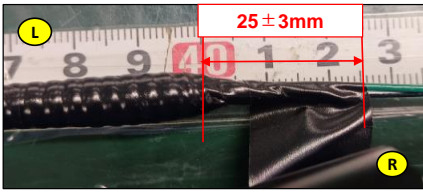
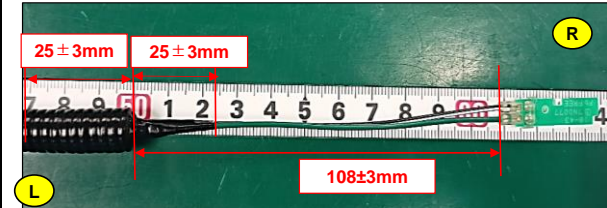

☒ MASSPRO

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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	P3 Taping 2 Black Corrugated tube to Wire near PCB	<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>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>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>5. After taping, check the measurement, wire alignment and taping condition.</p></div>		<div>MEASURING TAPE</div> 	<p>Important reminders/Notes</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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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

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n/a

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7N0195-7020E

Customer: TRJ

Car Model: TOYOTA-RAV4

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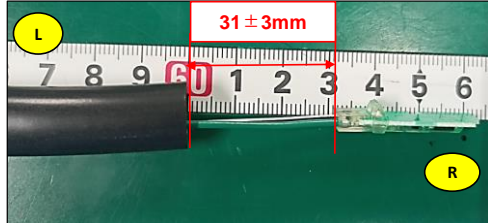

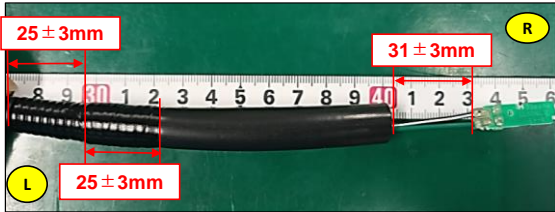

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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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	<div></div> <div>1. Get the Black VM tube (Sunprene) $\varnothing 9$, L=97\pm3mm using right hand then insert the hotmelted wires (B/W-G) using left hand.</div>	n/a	1. No wrong use of parts.
4	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 L=31\pm3mm.</div> <div></div> <div>2. Hold the VM tube (Sunprene) using left hand, get the Black tape then start taping using right hand.</div> <div></div> <div>3. After taping, check the measurement and taping condition.</div>		<div>MEASURING TAPE</div> 	Important reminders/Notes 1. Please use calibrated/verified measuring tape when fetting the measurement. 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

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PARTS:

n/a

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

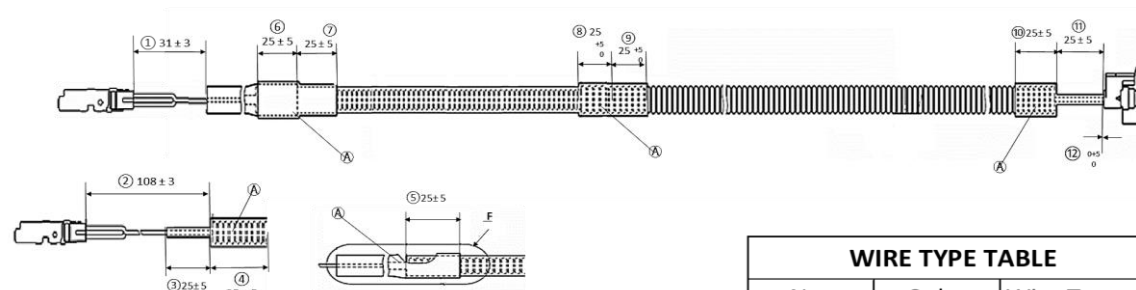
TOOLS/PPE

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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**WORK INSTRUCTION**

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7N0195-7020ECustomer: **TRJ**

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-1028C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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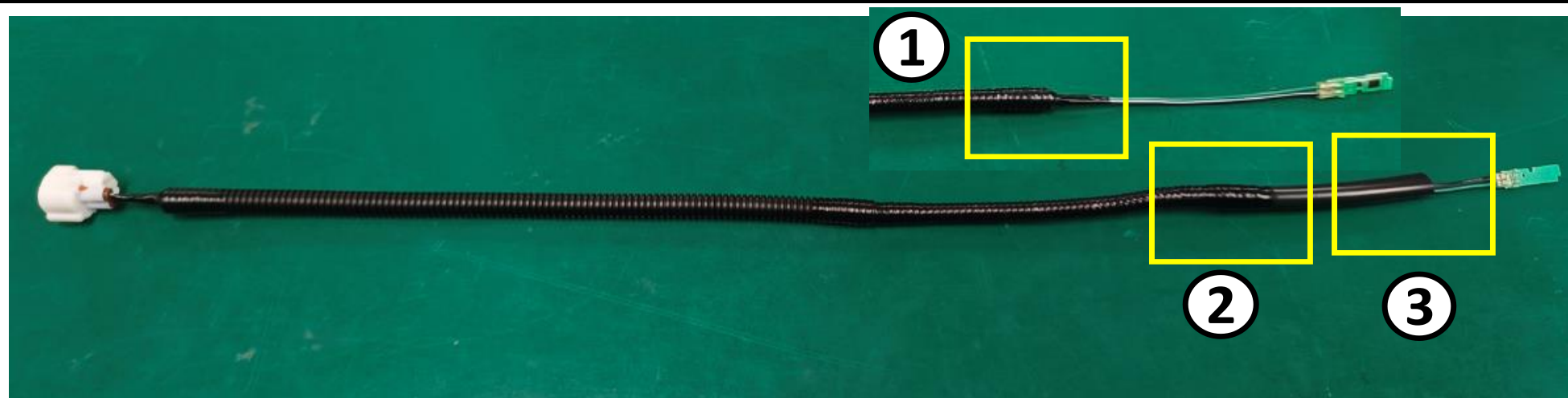
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PARTS:

n/a

JIG:

n/a

**QUALITY CHECKPOINTS****TAPING - P3****7N0195-7020E****1****2****No MISSING TAPE****3****No MISSING VM tube
(Sunprene)**

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