



WORK INSTRUCTION

Process Name/Title: TAPING ASSEMBLY PROCESS

Effectivity Date:

July 05, 2024

Model code/Part number: 310D / 7M0527-7020B

Customer: TRJ

Car Model: TOYOTA RAV4

Validity Date:

n/a

Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-032

Revision No.:

8

Page No.:

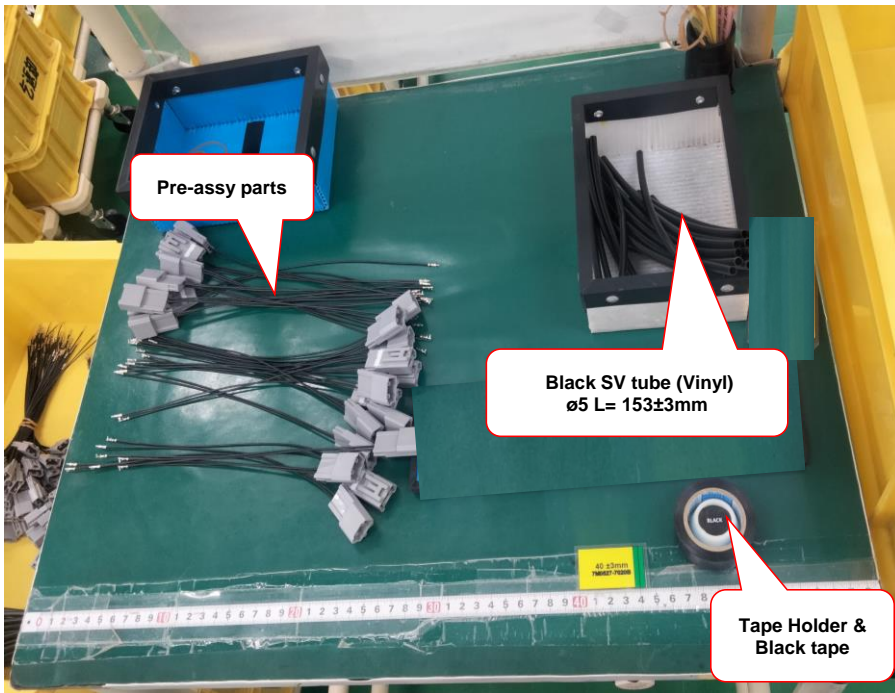
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PARTS:



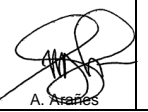
1. Pre-assy parts from kitting: Connector 6098-5673 [GR]; AVSSf wires B L= 224±2mm; Black SV tube (Vinyl) ø5 L=153±3mm; Black tape

JIG:

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	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.	Document reference/s: 1. Please refer to WI-ENG-PDE-106 for insertion process. 1.No missing parts/tools 2.No excess parts/tools


Revision History


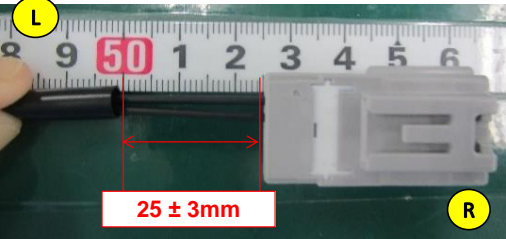
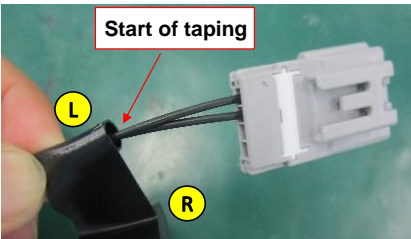


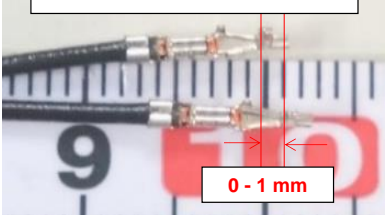
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
07/05/24	8	Inclusion of Car model "TOYOTA-RAV 4" Improved Measurement and Visual inspection/Quality checkpoints.	D. Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
5/19/23	7	Inclusion of all improvements (Table lay-out; Quality checkpoints; Important reminders and note/s; Document references;) Standardized tube description SV tube (vinyl).	J. Loterte	C. Villanueva	A. Arañes	n/a				
06/25/21	6	Removal of marking.	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes				

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	8	Page No.:	2 of 4

PARTS:	1. Assy parts 2. Black SV tube (Vinyl) ø5 L= 153±3mm 3. Black tape			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to SV tube (Vinyl) ø5 L=±153mm	 <div>1 Get the SV tube (Vinyl) ø5 L= 153±3mm using right hand then insert the 2 Black wires.</div>		n/a	1. No wrong usage of parts 2. No deformed terminal
3	P1 Taping 1 SV tube (Vinyl) to wire near connector	<div><div>1. Measure the end of the SV tube (vinyl) up to edge of connector 25mm.</div></div> <div><div>2. Get Black tape, hold the SV tube (vinyl) (ø5 L=153±3mm) using left hand then fold the vinyl tube and start taping using right hand.</div></div> <div><div>Note: This part is controlled based on the drawing</div></div> <div>3. After taping, check the wire alignment, measurement and tape condition.</div>		<div>Measuring tape</div>  <div>Wire alignment tolerance</div> 	Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.

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PARTS:

1. Assy parts

JIG:

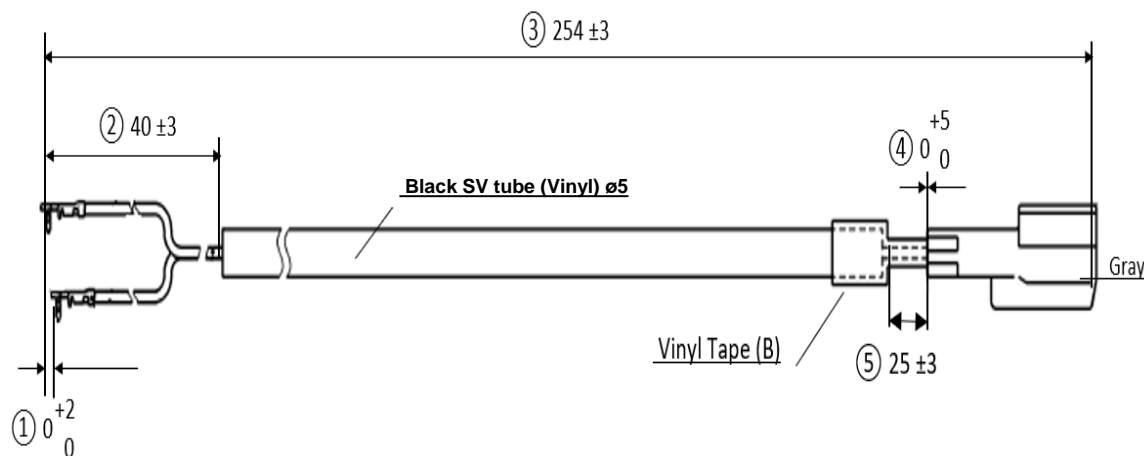
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NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

4

P1

Measurement

**MEASURING
TAPE****Important reminders and note/s:**

1. Please use calibrated/verified measuring tape when getting the measurement.

2. For Hatsumono, Nakamono and Owarimono.

Document reference/s:

1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection

1. No wrong dimension

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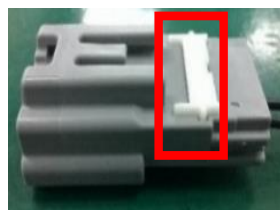
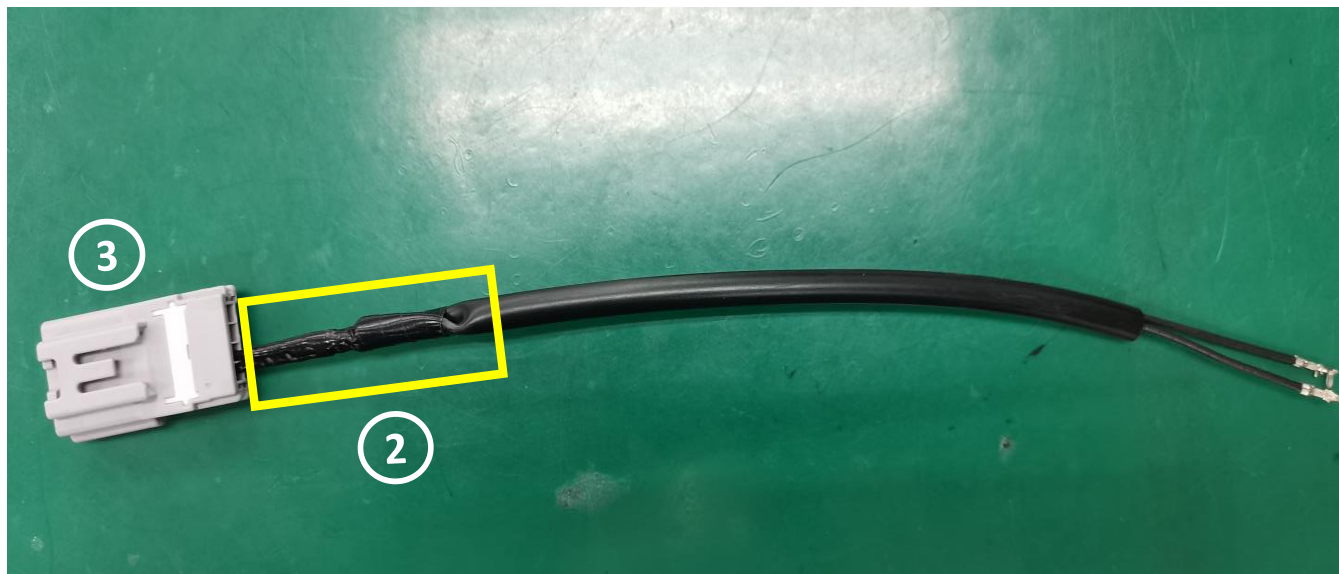
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P1****7M0527-7020B****GOOD****NO GOOD****GOOD****NO GOOD****① No Unlocked/Half-locked connector****② No Wrong Insert****③ No Deformed Terminal****④ No Missing Tape**

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