



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 21, 2024

Model code/Part number:

373D / 7N0174-7020B

Customer: TRJ

Car Model:

TOYOTA-RAV4

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-924B

Revision No.:

1

Page No.:

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PARTS:

1. Assy parts: Black SV tube (Vinyl) Ø5 L=108±3mm; Blue tape (19mm)

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

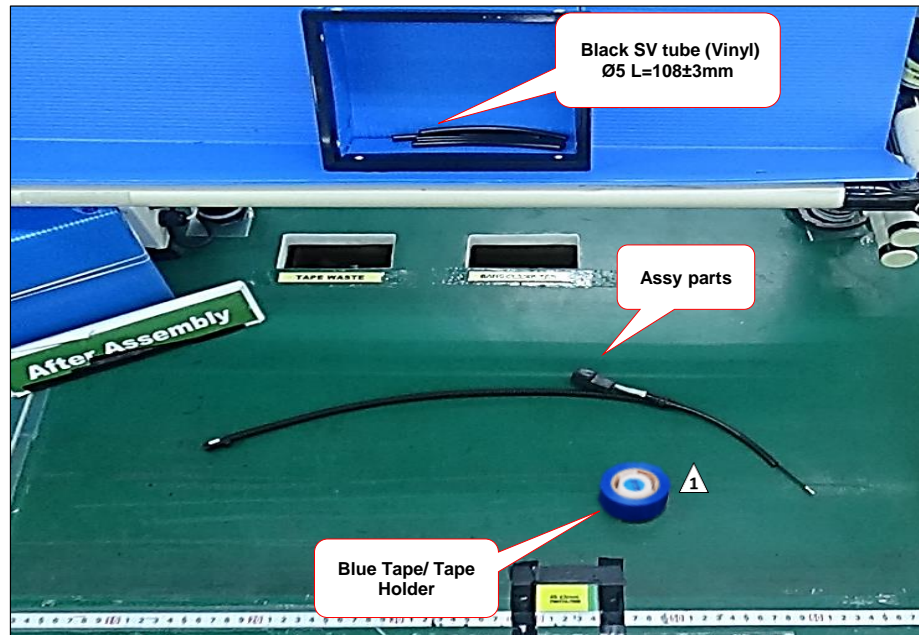
TOOLS/PPE

QUALITY POINTERS

1

P2

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

06/21/24 1 Change from Pre-launch to Masspro. Add Spot taping and change color from Gray tape to Blue tape. Split Clamp Assembly process. Improved the Visual Inspection/Quality Checkpoint

A. Hernandez

C. Villanueva

A. Arañes

n/a

06/18/24 0 Initial issue

A. Hernandez

C. Villanueva

A. Arañes

n/a

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

June 18, 2024

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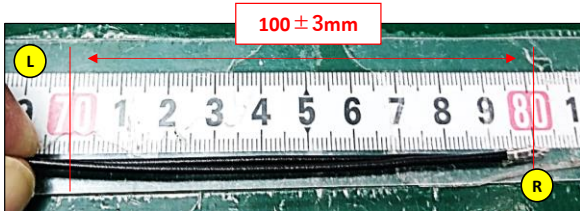
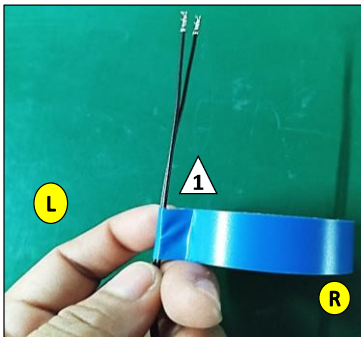
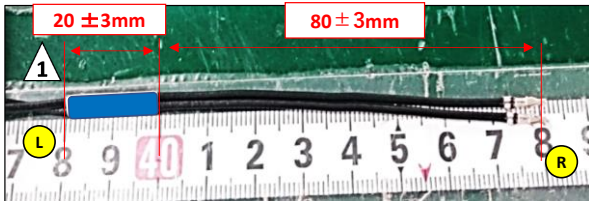

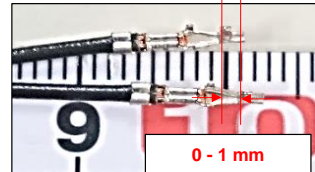
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PARTS:		1. Assy parts 2. Blue tape (19mm)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2	Spot taping 1	<div><p>1. Hold the wires using left hand and measure from wire up to terminal pointed tip 100±3mm.</p></div> <div><p>2. Get the Black tape and start taping on the Black wires. Conduct 2x windings of tape before cutting using both hands.</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>	<div>MEASURING TAPE</div> 	<div>Wire alignment tolerance</div>  <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>Important reminders/Note/s: 1. Use BLACK TAPE only 2. Please use calibrated/verified measuring tape when getting the measurement.</p>

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☐ PROTOTYPE

☐ PRE-LAUNCH





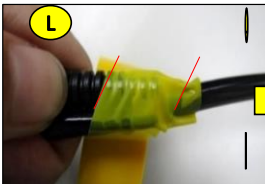
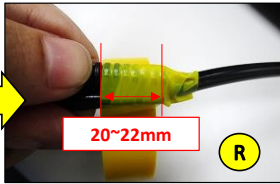

☒ MASSPRO

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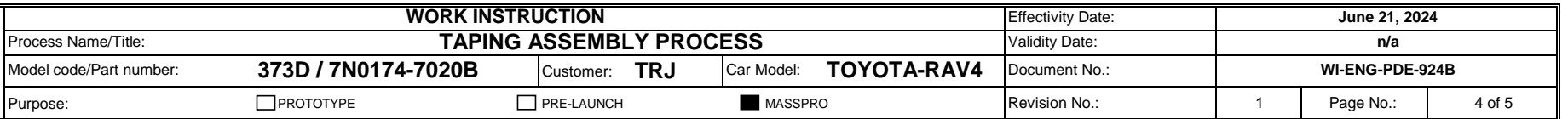
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PARTS:		1. Assy parts 2. Blue tape (19mm)		3. Black SV tube (Vinyl) Ø5 L=108±3mm	JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Black SV tube (Vinyl) Ø5 L=108±3mm		<div></div> <div>1. Get the Black SV tube (Vinyl) Ø5 L=108±3mm using right hand then insert the B-B wire using left hand.</div>		n/a	1. No wrong use of parts
3	P2	Y-taping	<div><div></div><div>No gap between tubes</div><div></div><div>40±3mm</div><div>1. Fix the COT and SV tube (Vinyl). Make sure no gap in between.</div><div>2. Measurement from end of SV tube (Vinyl) up to terminal tip. Must be 40±3mm.</div><div><div></div><div>Pre-taping</div><div></div><div></div><div>20~22mm</div><div>3. Get the tape and fix the COT to SV tube (Vinyl). Make 1 wind pre-taping before shifting.</div><div>4. Make 1 shifting to the left until tape width then wind the tape 2x.</div></div><div><div>Measuring Tape</div></div></div>		<div>Important reminders/Note/s: 1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>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</div>	

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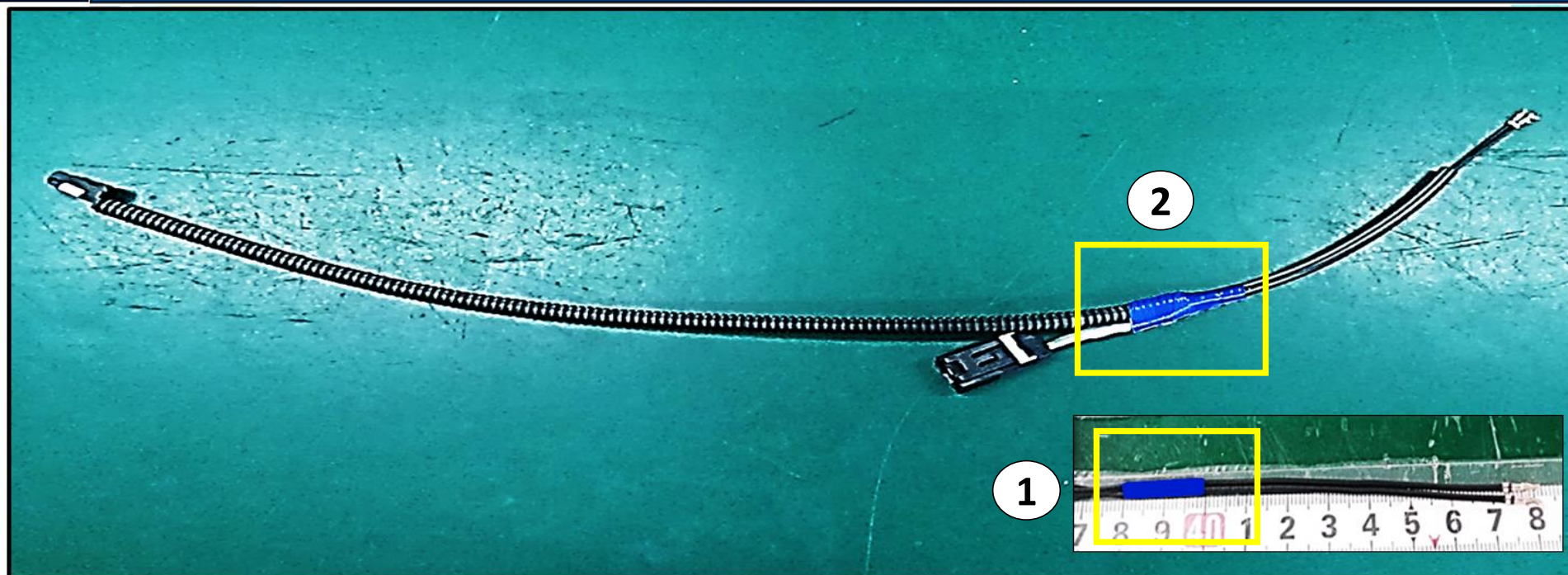
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PARTS:

n/a

JIG:

n/a

**VISUAL INSPECTIONS/QUALITY CHECKPOINTS****P2****7N0174-7020B**

- ① **No Missing BLUE Spot Tape** ② **No Missing BLUE Tape (Y-Taping)**

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