



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model code/Part number:

311D / 7L0153-7023

Customer:

TRQSS

Car Model:

TOYOTA-RAV4

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

August 28, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-963B

Revision No.:

0

Page No.:

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PARTS:

1. Assy parts; Black VM tube (Sunprene) Ø9 L=112±3mm; Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

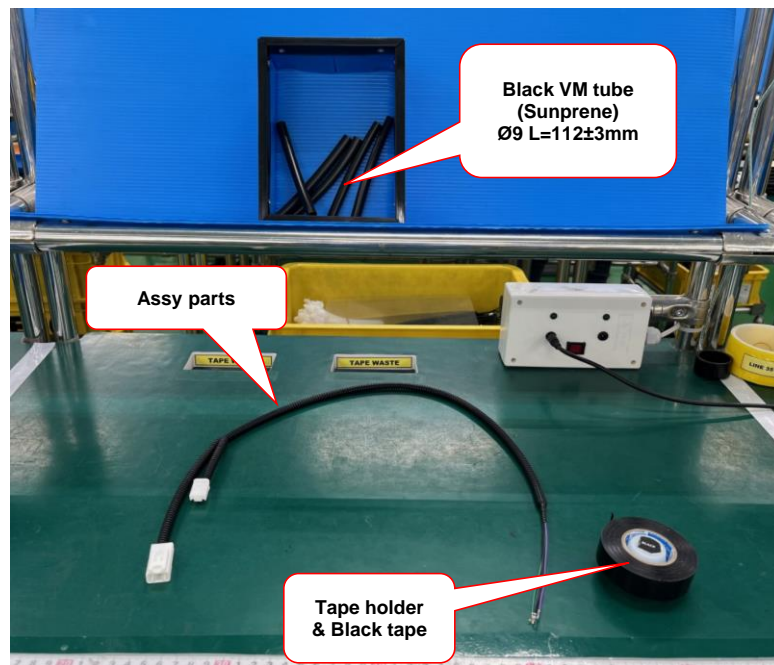
QUALITY POINTERS

1

P2

Table lay-out

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 wrong use of parts/tools
2. No missing parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
08/28/24	0	Initial issue. Separate process from P1.	D. Castillo	C. Villanueva	A. Arañes	n/a	D. Castillo	C. Villanueva	A. Arañes	n/a

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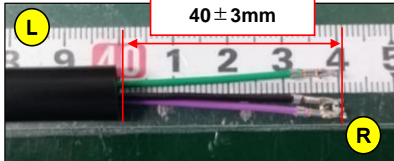

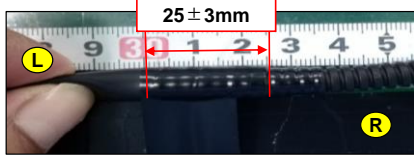



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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) Ø9 L=112±3mm		3. Black tape	JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2		Wire insertion to Black VM tube (Sunprene) Ø9 L=112±3mm	<div></div> <div>1. Get the Black VM tube (Sunprene) Ø9 L=112±3mm using right hand then insert the B-G-V wires.</div>		n/a	1. No wrong usage of parts. 2. No deformed terminal
3	P1	Taping 2 Black Corrugated tube to Balck VM tube (Sunprene)	<div><div><div>40 ± 3mm</div></div><div>1. Measure from end of VM tube (Sunprene) up to terminal pointed tip 40±3mm using both hands.</div><div><div>Start of taping</div><div>2. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.</div><div><div>25 ± 3mm</div><div>3. Confirm measurement of 25±3mm from end of tape up to end of tube then continue the taping process using both hands.</div><div><div>25 ± 3mm</div><div>4. Confirm measurement of 25±3mm from end of tube up to end of tape then continue the taping process using both hands.</div><div><div>25 ± 3mm</div><div>40 ± 3mm</div><div>25 ± 3mm</div><div>5. After taping, check the measurement, terminal appearance and taping condition.</div></div></div></div></div></div>		<div>MEASURING TAPE</div> <div></div>	1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension Important reminders and 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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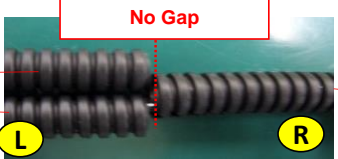
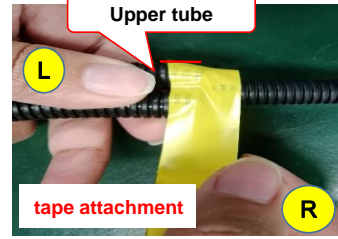
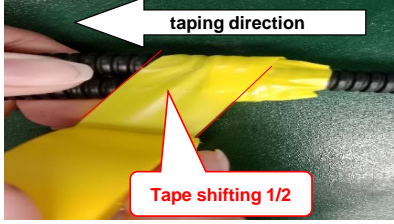
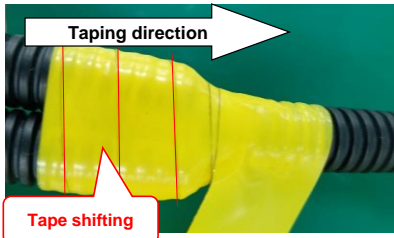
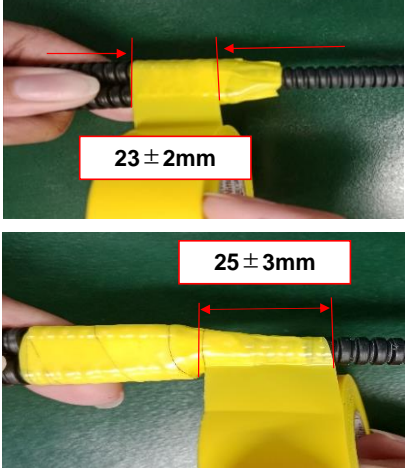
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PARTS:	1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2 Y-taping	<div></div> <div></div> <div><p>1. Fix the 3 corrugated tube .</p></div> <div></div> <div></div> <div><p>3. Winding the tape 1/2 shifting going to the left side.</p></div> <div></div> <div><p>5. Winding the tape 1/3 shifting going to the right side until reach the other side of tube.</p></div> <div></div> <div><p>2. Start taping at the middle of combined tubes, attach the tape on the upper tube. Then make pre-tape 2 windings. Note: Do not exert excessive force during pulling & winding of tape.</p></div> <div><p>4. Make 2 windings, width must be 23±2mm.</p></div> <div><p>6. Make 2 windings, width must be 25±3mm.</p></div>		<p>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>Important reminders/Note/s: 1. Use yellow tape for easy visualization of tape shifting, but actual should be <u>BLACK TAPE</u>. 2. Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none">1. No loose tape2. No flip-out tape3. No peel-off tape4. No wrong use of tape5. No wrong dimension-out tape6. No exposed wire7. No gap between tubes

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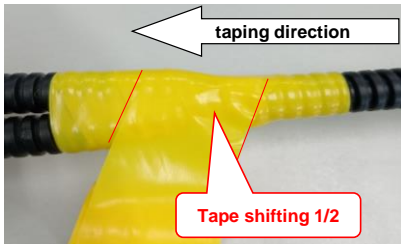
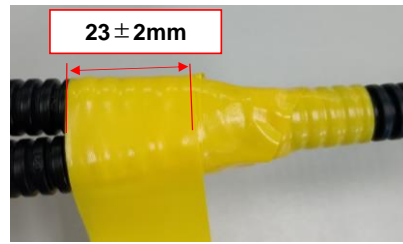
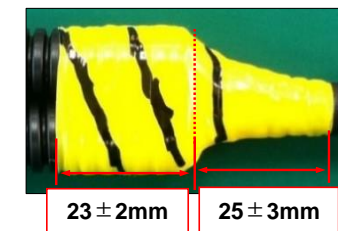
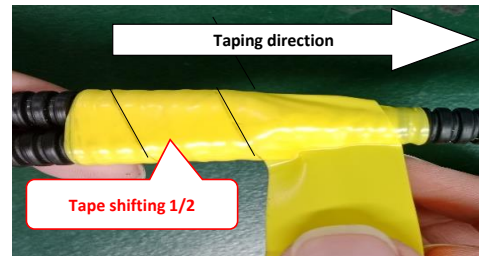
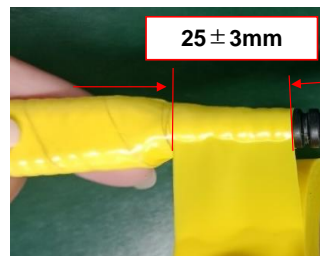

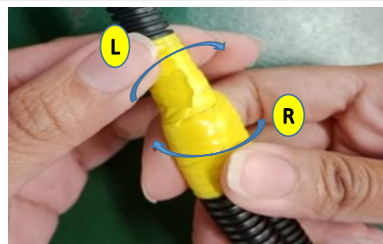

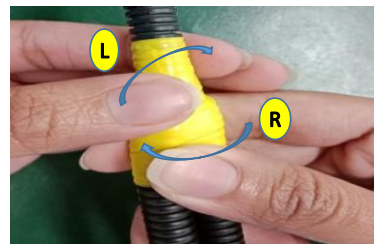
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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Y-taping (Continuation)	<div></div> <div>7. Winding the tape 1/2 shifting going to the left side.</div> <div></div> <div>8. Make 2 windings, width must be 23±2mm.</div>		<p>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>Important reminders/Note/s: 1. Use <u>yellow tape</u> for easy visualization of tape shifting, but actual should be <u>BLACK TAPE</u>. 2. Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none">1. No loose tape2. No flip-out tape3. No peel-off tape4. No wrong use of tape5. No wrong dimension-out tape6. No exposed wire7. No gap between tubes <div></div> <div>14. Check the Measurement and condition of tape.</div>
			<div></div> <div>9. Winding the tape 1/2 shifting going to the right side until it reach the other side of tube</div> <div></div> <div></div> <div>10. Make 3 winds, width must be 25±3mm. Then cut the tape.</div>		
			<div></div> <div>11. conduct proper pressing of end tape using left hand (top part)</div> <div></div> <div>12. conduct proper pressing of end tape using left hand (Middle part)</div> <div></div> <div>13. conduct proper pressing of end tape using left hand (bottom part)</div>		

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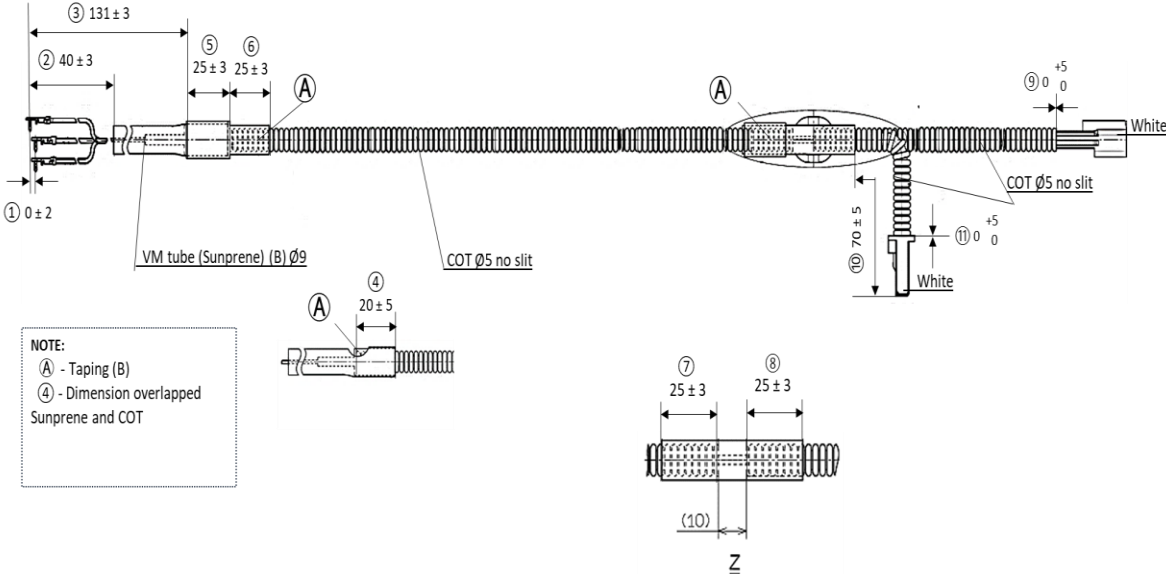
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2	Measurement	<div>Measuring tape</div>   <div>NOTE: A - Taping (B) ④ - Dimension overlapped Sunprene and COT</div>	<div>Important reminders and note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension</div>

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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P2****7L0153-7023**

① ② No Missing tape

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