



## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

310D / 7N0197-7020B

Customer: TRJ

Car Model: TOYOTA-RAV4

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

August 29, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-998B

Revision No.:

1

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## PARTS:

1. Assy parts; Black VM tube (Sunprene) Ø9 L=120±3mm; Black tape 20mm

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

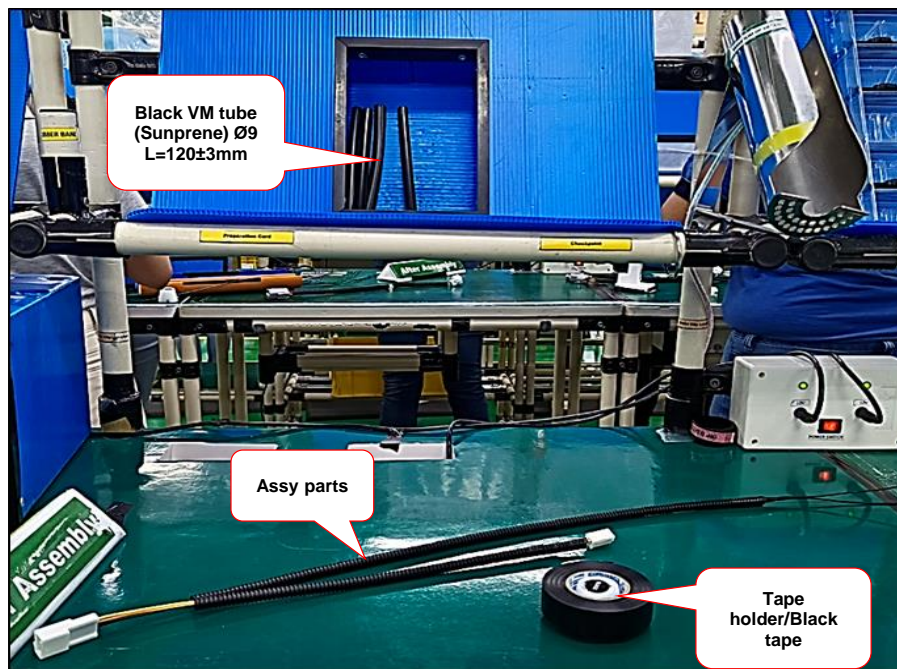
QUALITY POINTERS

1

P2

Table lay-out

## TABLE LAY-OUT

**Safety Instruction**

Be sure to wear 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.

1. No missing parts/tools
2. No excess parts/tools

**Document reference/s:**

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
08/29/24	1	Change from Pre-launch to Masspro	A. Hernandez	C. Villanueva	A. Arañes	n/a	A. Hernandez	C. Villanueva	A. Arañes	n/a
08/06/24	0	Initial Issue	A. Hernandez	C. Villanueva	A. Arañes	n/a	A. Hernandez	C. Villanueva	A. Arañes	n/a

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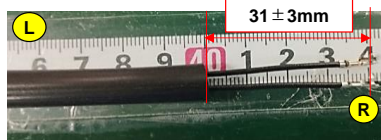

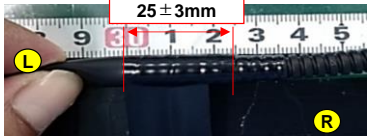
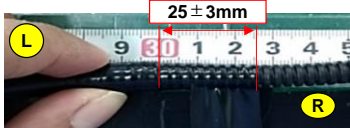



☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape 20mm 3. Black VM tube (Sunprene) Ø9 L=120±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2		Wire insertion to Black VM tube (Sunprene) Ø9 L=120±3mm	<div></div> <div>1. Get the Black VM tube (Sunprene) Ø9 L=120±3mm using right hand then insert the assy parts using left hand.</div>	n/a	1. No wrong use of parts 2. no deformed terminal
3	P2	Taping 3 COT to VM tube (Sunprene)	<div><div><div>1. Measure from end of tube up to terminal pointed tip 31±3mm using both hands.</div></div><div><div>2. Hold the Assy parts using left hand, get the Black tape using right hand then start pre-taping using both hands.</div></div><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><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><div>5. After taping, check the measurement, terminal appearance and taping condition.</div></div></div> <div><div>MEASURING TAPE</div></div>	<div>1. Check the tape from COT to SV tube (Vinyl) (Conduct bending for verification) 2. No flip out tape. 3. No tape peeling. 4. No loose tape</div> <div><b>Important reminders/Note/s:</b> 1. Please use calibrated/verified measuring tape when getting the measurement.</div> 	

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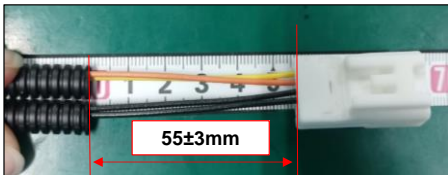
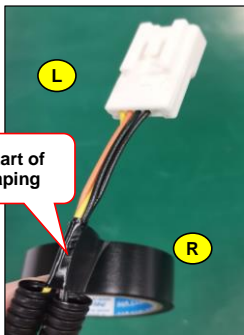
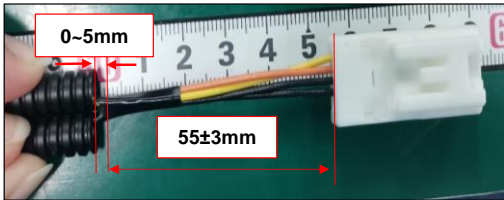

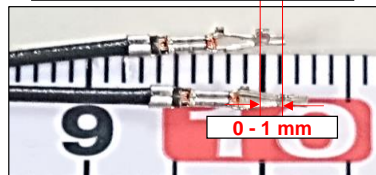
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape 20mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Spot taping	<div></div> <div></div> <div></div> <div><p>1. Combine the 2 COT and wires. Measure from end of Combined COT up to edge of connector <b>55±3mm</b> using both hands.</p><p>2. Get the <b>Black tape</b> using right hand then conduct <b>2 windings of tape</b> using both hands.</p><p>3. After taping, check the measurement and taping condition.</p></div>	<div></div> <div></div>	<div><p>1. No flip-out tape</p><p>2. No peel-off tape</p><p>3. No loose tape</p><p>4. No missing tape</p><p>5. No wrong use of tape</p><p>6. No wrong dimension</p></div> <div><p><b>Important reminders/Note/s:</b></p><p><b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></p></div>

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PARTS:		1. Assy parts 2. Black tape 20mm	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2	Y-taping	<div>MEASURING TAPE</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> <div>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Used yellow tape to easily visualize the tape shifting but actual should be <b>BLACK TAPE</b></div>

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### PARTS:

1. Assy parts
2. Black tape 20mm

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

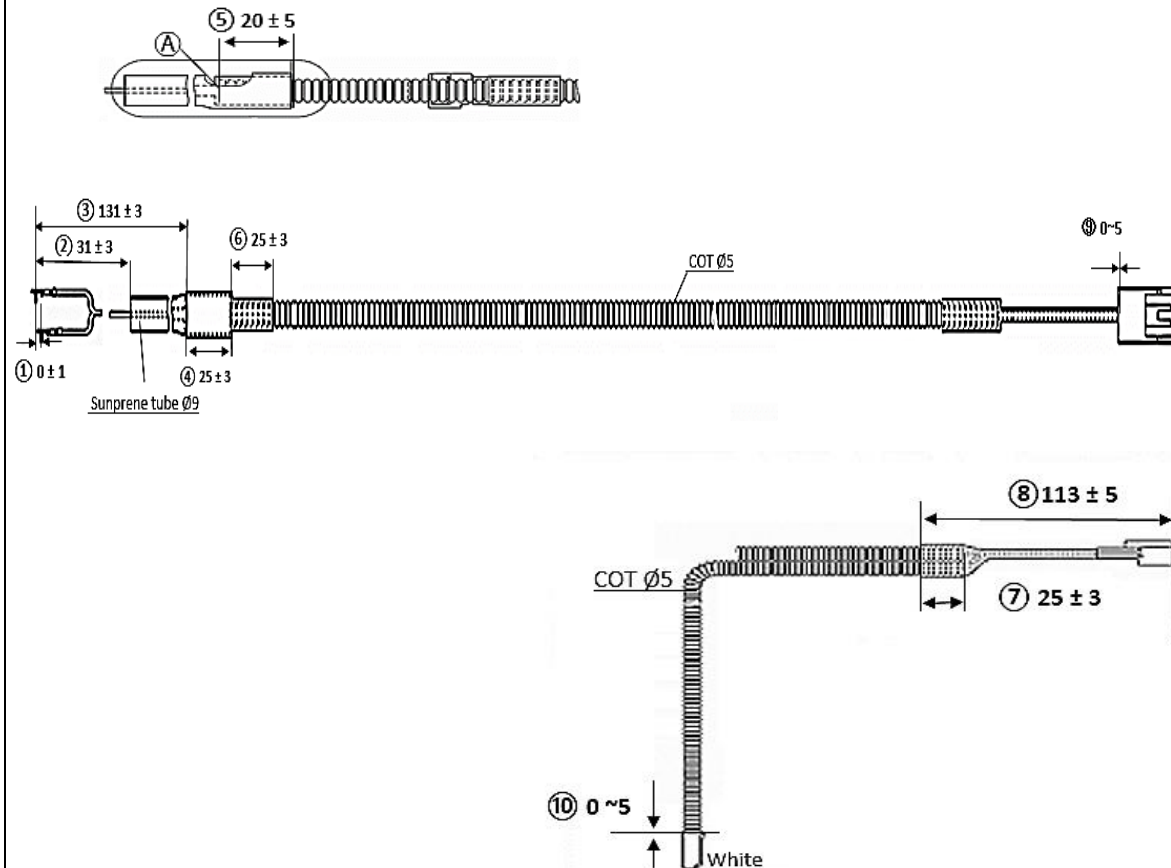
TOOLS/PPE

QUALITY POINTERS

6

P2

Measurement



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.
2. For Hatsumono and Owarimono.

### Document reference/s:

1. Refer to WI-PRO-ASY-056 for Sub assembly Hatsomono, Nakamono, and Owarimono Inspection.

### MEASURING TAPE



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PARTS:

n/a

JIG:

n/a

**VISUAL INSPECTION/QUALITY CHECKPOINTS****P2****7N0197-7020B**

1

**No Missing Tape**

3

**Check the Tape Appearance**

2

**No Missing parts**

4

**No Wrong Dimension**

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