



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model code/Part number:

311D

/ 7L0154-7022

Customer:

TRJ

Car Model:

TOYOTA-RAV4

Effectivity Date:

September 10, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-942B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

1 of 5

PARTS:

1. Assy parts
2. Black VM tube (Sunprene) $\varnothing 9$, L=97 \pm 3mm
3. Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

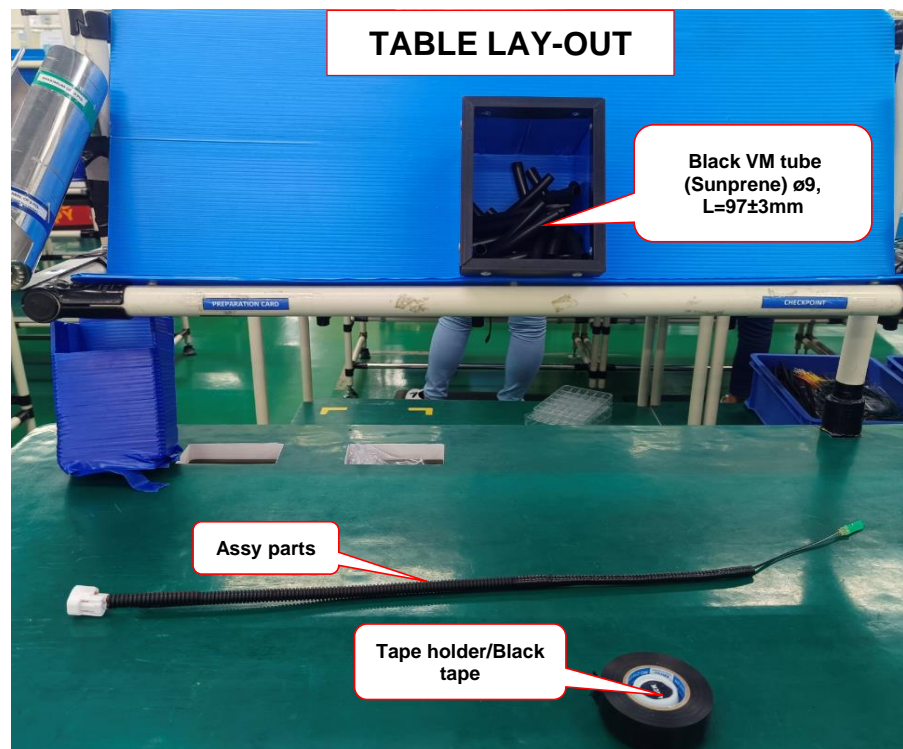
TOOLS/PPE

QUALITY POINTERS

1

P2

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 part/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
9/10/24	0	Initial Issue.					M. Ariola	C. Villanueva	A. Arañes	n/a

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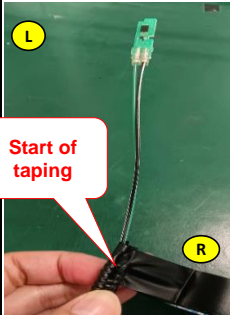
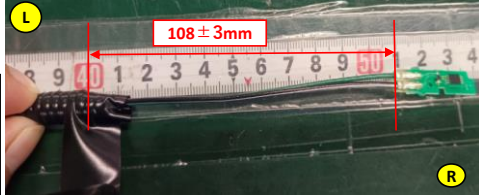
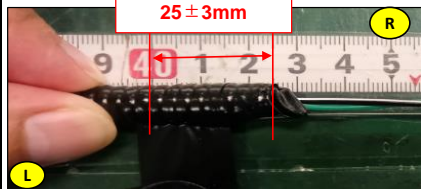
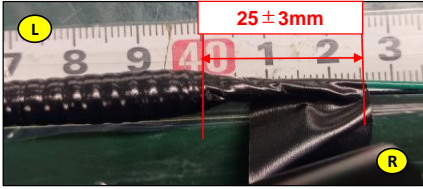
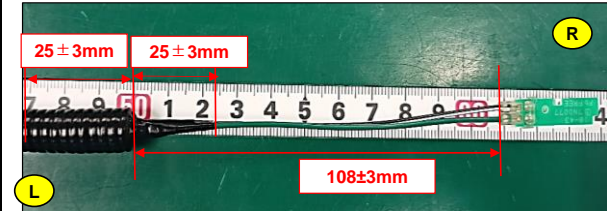

WI-ENG-PDE-942B

Revision No.:

0

Page No.:

2 of 5

PARTS:		1. Assy parts 2. Black tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 2 Black Corrugated tube to Wire near PCB	<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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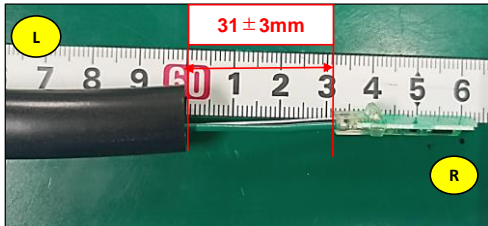

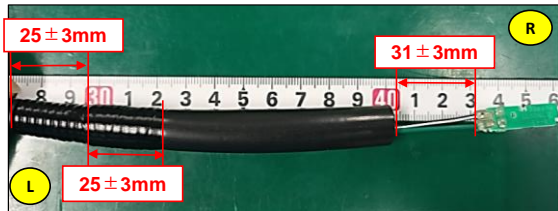

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Revision No.:

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Page No.:

3 of 5

PARTS:		1. Assy parts 2. Black VM tube (Sunprene) ø9, L=97±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3		Wire insertion to Black VM tube (Sunprene) ø9, L=97±3mm	<div></div> <div>1. Get the Black VM tube (Sunprene) ø9, L=97±3mm using right hand then insert the hotmelted wires (B/W-G) using left hand.</div>	n/a	1. No wrong use of parts.
4	P2	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±3mm.</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> 	<div>Important reminders/Notes</div> <div>1. Please use calibrated/verified measuring tape when fetting the measurement.</div> <div>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</div>

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4 of 5

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JIG:

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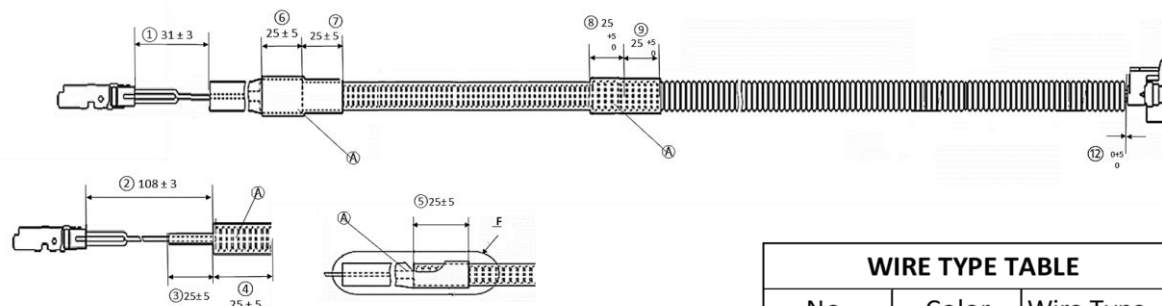
TOOLS/PPE

QUALITY POINTERS

5

P2

Measurement



NOTE:
(A) - Taping (B)
(5) - dimension of overlapped Sunprene and COT

WIRE TYPE TABLE

No.	Color	Wire Type
1	G	AVSS 0.3 f
2	BW	AVSS 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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5 of 5

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QUALITY CHECKPOINTS**P2****7L0154-7022**

① **No MISSING VM tube
(Sunprene)**

② ③ **No MISSING TAPE**

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