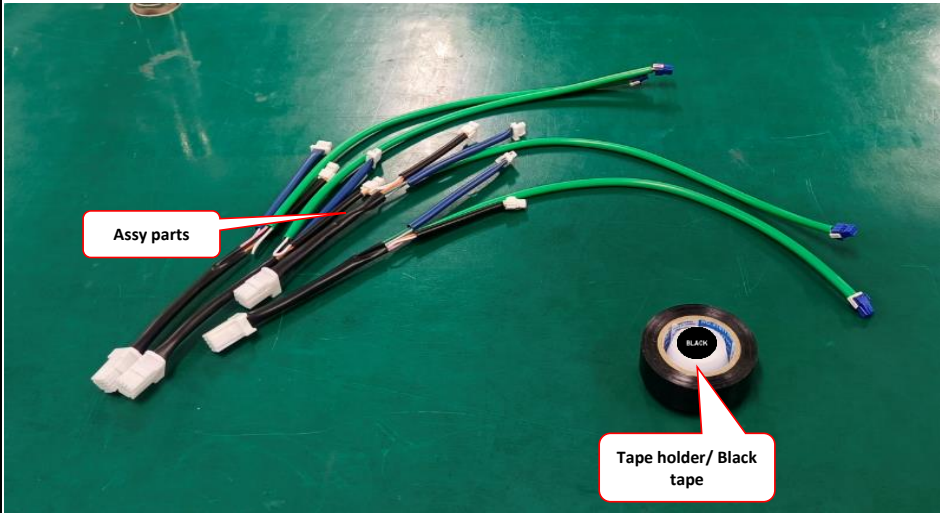
	<b>WORK INSTRUCTION</b>				Effectivity Date:		<b>November 28, 2024</b>	
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: <b>310D / 628125-0001</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-RAV4</b>	Document No.: <b>WI-ENG-PDE-1155B</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO		Revision No.: 0      Page No.:      1 of 5	

<b>PARTS:</b>	1. Assy part; Black tape			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
1	P2	Table lay-out	<div><div>TABLE LAY-OUT</div><div>Assy parts</div><div>Tape holder/ Black tape</div></div>	<div><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	<div>1. No missing parts/tools 2. No excess parts/tools</div> <div><b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal.</b> <b>2. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b></div> <div><b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b> <b>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b></div>

Revision History							Prepared by	Reviewed by	Approved by	Noted by
11/28/24	0	Initial issue. Excluded process from WI-ENG-PDE-1155A due to new process change; Additional Table lay-out; Inclusion of Visual Inspections/Quality checkpoints				M. Ariola	C. Villanueva	A.Arañes	n/a	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:
						November 28, 2024				



## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

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310D / 628125-0001

Customer: TRJ

Car Model: TOYOTA-RAV4

Document No.:

WI-ENG-PDE-1155B

Purpose:



PROTOTYPE



PRE-LAUNCH



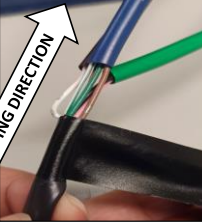
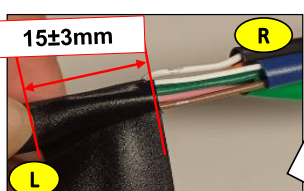
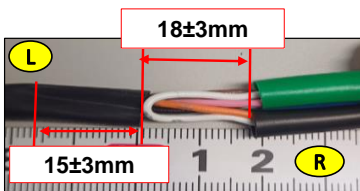
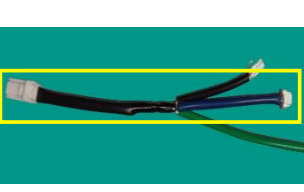
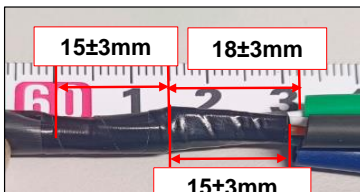
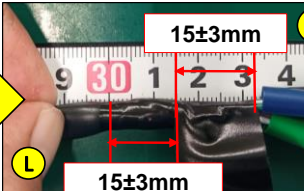
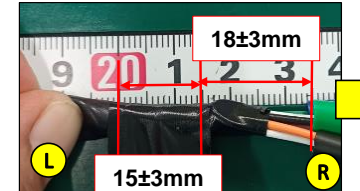

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 1 Black VM tube (Sunprene) to Wire	<div></div> <div><p>1. Hold the assy parts using both hands. Measure from end of Combined tubes to end of Black VM tube (Sunprene) <b>18±3mm</b>. Measure VM tube up to VM tube <b>15±3mm</b>.</p><p>2. Get the <b>Black tape</b> and position the tape to VM tube (Sunprene). Make <b>2 windings</b> of tape then continue the taping process. <b>Note: Follow the above illustration.</b></p></div> <div></div> <p>3. Measure from end of VM tube (Sunprene) up to end of tape (<b>15±3mm</b>) then continue the taping process.</p> <p>4. After taping, Check the measurement, taping condition.</p>		<div>MEASURING TAPE</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> <div><b>Important Reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></div>

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# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

310D / 628125-0001

Customer: TRJ

Car Model: TOYOTA-RAV4

Purpose:



PROTOTYPE



PRE-LAUNCH



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### PARTS:

1. Assembled parts
2. Master sample

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

P2

Visual/By two's  
Inspection

1. Check the connector lock.  
Locking of connector is included  
in Steering Electrical test.

2. Check the wire alignment.  
Must be no tangled wires.

3. Check the Terminal if with  
Backing out (Not fully inserted)  
or no deformed terminal.

BLACK VM TUBE  
(SUNPRENE) Ø6

BLACK VM TUBE  
(SUNPRENE) dia. Ø4

BLUE VM TUBE  
(SUNPRENE) Ø4.5

GREEN VM TUBE  
(SUNPRENE) Ø4.5

4. Check the orientation of  
harness.

5. Compare to **Master sample** by  
tapping

MASTER SAMPLE

ASSEMBLED PARTS

n/a

1. No skip process during inspection.

### Document reference/s:

1. Refer to WI-QAD-QAC-252 Steering  
Electrical Test

MASTER SAMPLE



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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Process Name/Title:

Model code/Part number:

**310D / 628125-0001**Customer: **TRJ**Car Model: **TOYOTA-RAV4**

Purpose:



PROTOTYPE



PRE-LAUNCH



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**PARTS:**

1. Assy parts

JIG:

n/a

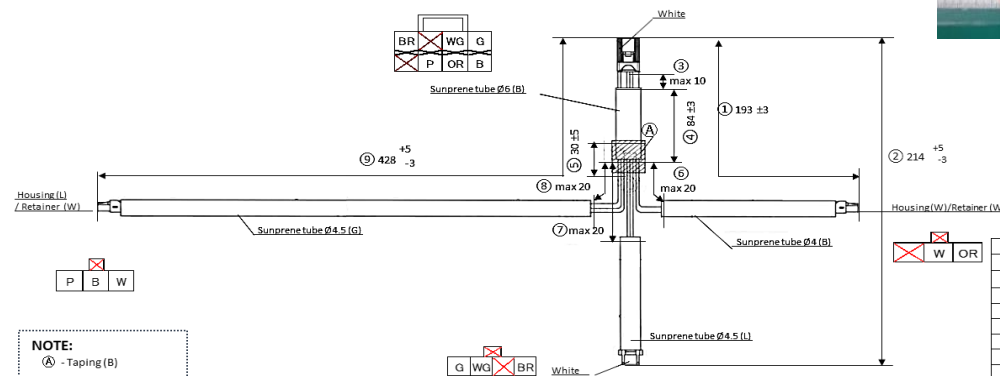
**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****MEASURING TAPE**

1. No wrong dimension

**Important Reminder/s and Note/s:****1. Please use calibrated measuring tape when getting the measurement.****2. For Hatsumono, Nakamono and Owarimono.****Document reference/s:****1. Refer to WI-PRO-ASY-056 For assembly Hatsumono, Nakamono and Owarimono Inspection.****NOTE:**

Ⓐ - Taping (B)

\*Unit of dimension is in millimeter (mm)

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# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

310D / 628125-0001

Customer: TRJ

Car Model: TOYOTA-RAV4

Purpose:



PROTOTYPE



PRE-LAUNCH



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PARTS:

n/a

JIG:

n/a

### VISUAL INSPECTION/ QUALITY CHECKPOINTS

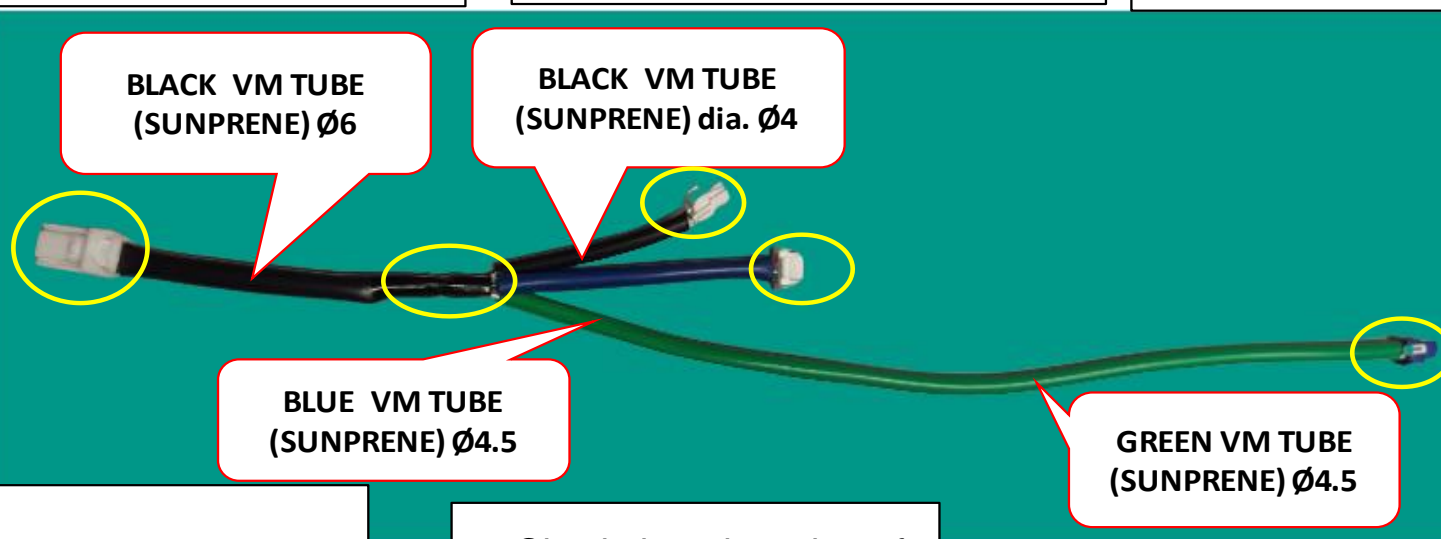
## PADDLE SWITCH

# 628125-0001

1. Check the connector lock. Locking of connector is included in Steering

2. Check the wire alignment. Must be no tangled wires.

3. Check the Terminal if with Backing out (Not fully inserted) or no deformed terminal.



6. Compare to Master sample by tapping

4. No missing tape (Black tape)

5. Check the orientation of harness.

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