



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number: 310D / 7N0197-7020

Customer: TRJ

Car Model: TOYOTA-RAV4

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

March 1, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-778B

Revision No.:

1

Page No.:

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PARTS:

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

JIG:

n/a

NO.

PROCESS NAME

1 WORK PROCEDURE/ ILLUSTRATION

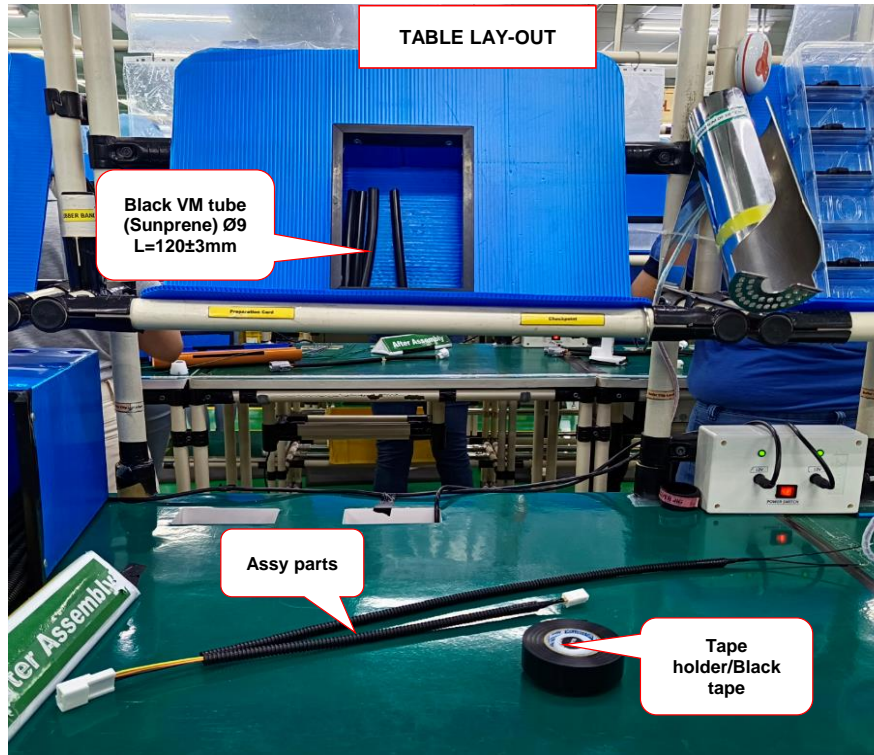
TOOLS/PPE

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.

Document reference/s:
1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

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

Revision History

Prepared by

Reviewed by

Approved by

Noted by

03/01/24 1 Change purpose from pre-launch to Masspro. Additional table lay-out and Inclusion of Quality checkpoints.

M.A. riola

C. Villanueva

A. Arañes

n/a

01/05/24 0 Initial issue

M.A. riola

C. Villanueva

A. Arañes

n/a

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

January 5, 2024

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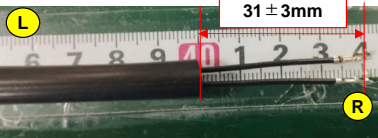

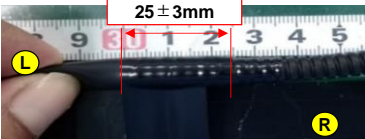

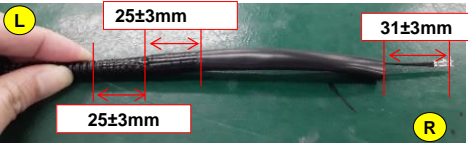


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape 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>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>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>MEASURING TAPE</div> 	<div>Important reminders/Note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> 

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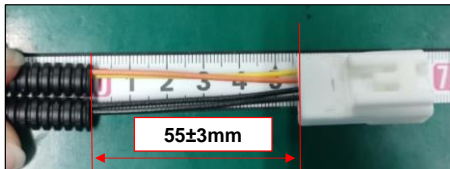
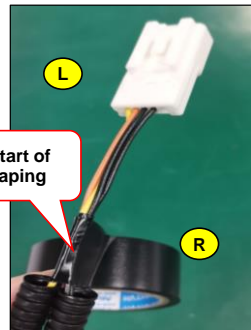
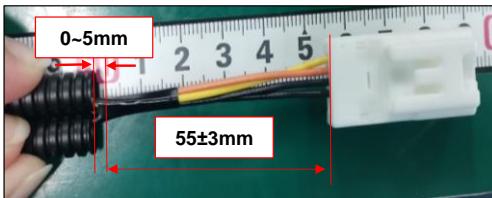
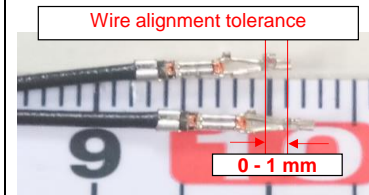

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Spot taping	<div><p>1. Combine the 2 COT and wires. Measure from end of Combined COT up to edge of connector 55±3mm using both hands.</p></div> <div><p>2. Get the Black tape using right hand then conduct 2 windings of tape using both hands.</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>	<div><p>Wire alignment tolerance 0 - 1 mm</p></div> <div><p>MEASURING TAPE</p></div>	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p>

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PROTOTYPE



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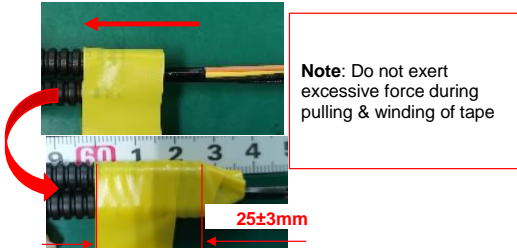
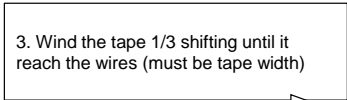
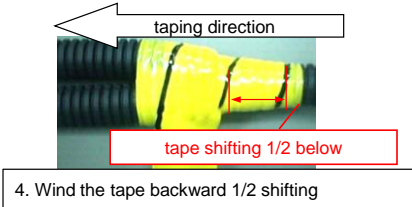
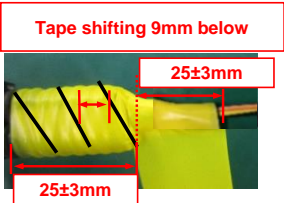


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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2	Y-taping	<div><p>1. Fix the 2 corrugated tube. Follow the correct connector orientation. <i>Note: 2 COT must be aligned.</i></p></div> <div><p>2. Start taping at the middle of combined COT & wires, then wind the tape going to 2 corrugated tubes (2 windings), width must be same with tape (25mm)</p><p><i>Note: Do not exert excessive force during pulling & winding of tape</i></p></div> <div><p>3. Wind the tape 1/3 shifting until it reach the wires (must be tape width)</p></div> <div><p>4. Wind the tape backward 1/2 shifting</p></div> <div><p>5. Wind the tape 1/2 shifting going to spot tape. Cover the spot tape & wire 1/3 shifting. Measure end of COT up to connector 55mm then make 3 windings of tape before cutting of tape.</p></div> <div><p>6. After taping, check the measurement and taping condition.</p></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. Please use calibrated/verified measuring tape when getting the measurement. 2. Used yellow tape to easily visualize the tape shifting but actual should be <u>BLACK TAPE</u></p>

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**QUALITY CHECKPOINTS****P2****7N0197-7020****1 No Missing Tape
(y-taping)****2 No Wrong Used of tape****3 No Deformed terminal**

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