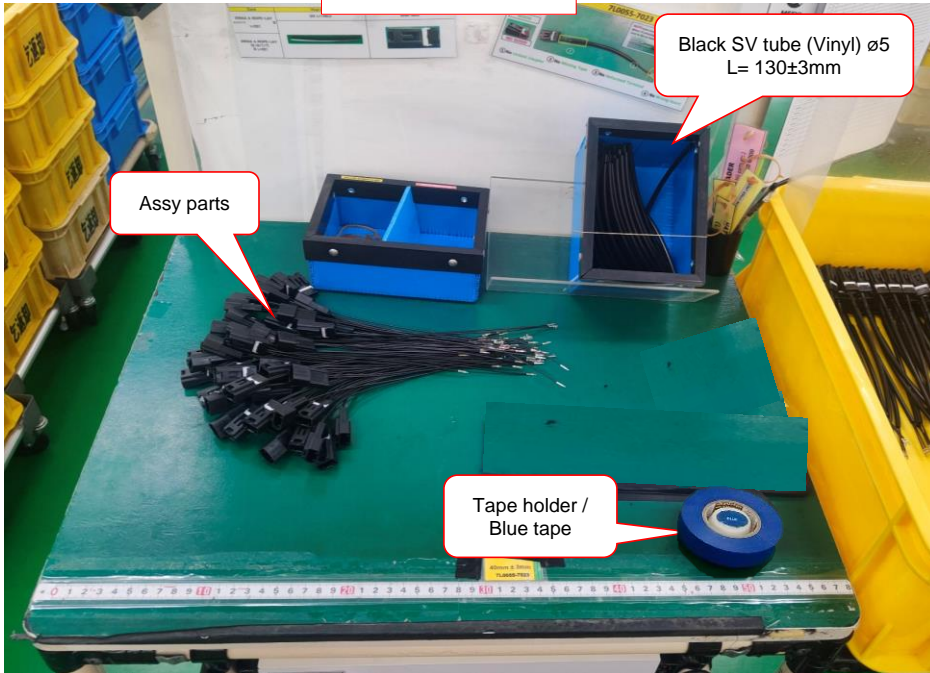





WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	March 15, 2025		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-1204		
Revision No.:	1	Page No.:	1 of 4

Process Name/Title:	TAPING ASSEMBLY PROCESS		
Model code/Part number:	311D / 7L0157-7022	Customer:	TRQSS
Car Model:	TOYOTA RAV4		
Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO

PARTS:		1. Assy Parts 2. Black SV tube (Vinyl) ø5, t=0.5 L=130±3mm; 3. Blue Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1 Table Lay-out	<p>TABLE LAY-OUT</p> 		<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>Document reference/s: 1. Please refer to WI-ENG-PDE-282 Offline Assembly process</p> <p>1. No missing parts/tools 2.No excess parts/tools</p>

Revision History							Prepared by	Checked by	Reviewed by	Approved by
							 A. Hernandez	 J. Loterte	 C. Villanueva	 A. Arañes
03/15/25	1	Change document purpose from pre-launch to mass pro.								
02/24/25	0	Initial issue.	A. Hernandez	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved	Est. Date:	February 24, 2025		

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**WORK INSTRUCTION**

Effectivity Date:

March 15, 2025

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TAPING ASSEMBLY PROCESS

Validity Date:

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311D / 7L0157-7022

Customer:

TRQSS

Car Model:

TOYOTA RAV4

Document No.:

WI-ENG-PDE-1204

Purpose:


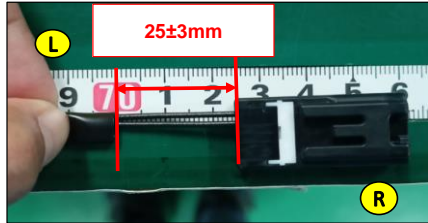
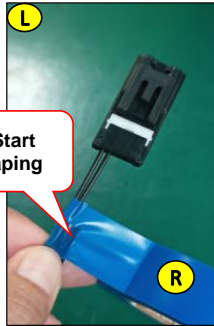

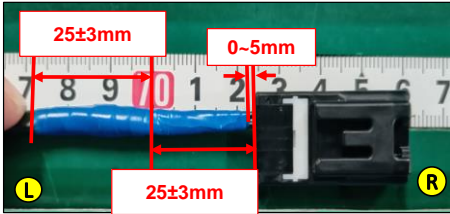
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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PARTS:		1. Assy parts 2. Black SV tube (Vinyl) $\phi 5$, $t=0.5$ L=130 \pm 3mm 3. Blue tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Black SV tube (Vinyl) $\phi 5$, $t=0.5$ L=130 \pm 3mm	 <div>1. Get the Black SV tube (Vinyl) $\phi 5$, $t=0.5$ L=130\pm3mm using right hand then insert the B-B wire using left hand.</div>		n/a	1. No wrong usage of parts. 2. No deformed terminal.
3	P1 Taping 1 Black SV tube to wire near connector	 <div>1. Hold the Black SV tube (Vinyl) using left hand then measure from end of tube up to end of connector L=25\pm3mm using both hands.</div>  <div>2. Hold the harness using left hand, Get the Blue tape using right hand then start taping process using both hands.</div>   <div>3. After taping, check the measurement and taping condition.</div>			Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Use <u>BLUE TAPE</u> only. 1. No flip-out tape 2. No Pell-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension

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TAPING ASSEMBLY PROCESS

Effectivity Date:

March 15, 2025

Model code/Part number:

311D / 7L0157-7022

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TOYOTA RAV4

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:


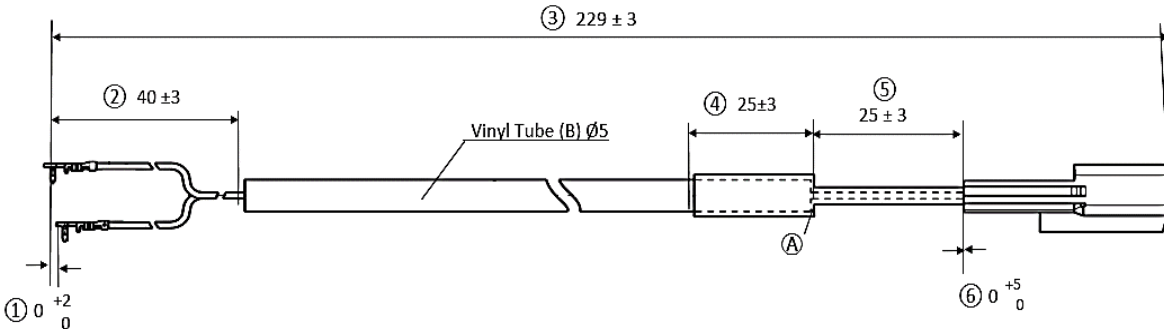
WI-ENG-PDE-1204

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1

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PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	Measurement	<div>MEASURING TAPE</div> 	1. No wrong dimension	
					
<div>Important Reminders/Note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>2. For Hatsumono, Nakamono and Owarimono only</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-ASY-056 for Sub assembly Hatsumono, Nakamono, and Owarimono Inspection.</div>					

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Model code/Part number: 311D / 7L0157-7022		Customer: TRQSS	Car Model: TOYOTA RAV4	Document No.: WI-ENG-PDE-1204		
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.: 4 of 4	

PARTS:	n/a	JIG:	n/a
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VISUAL INSPECTION/QUALITY CHECKPOINTS

P1

7L0157-7022



1 No Unlock connector

3 No Deformed terminal

5 No Terminal Backing Out

2 No Wrong insert

4 No Wrong color of tape (Must be BLUE TAPE only)

6 Check the Alignment

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