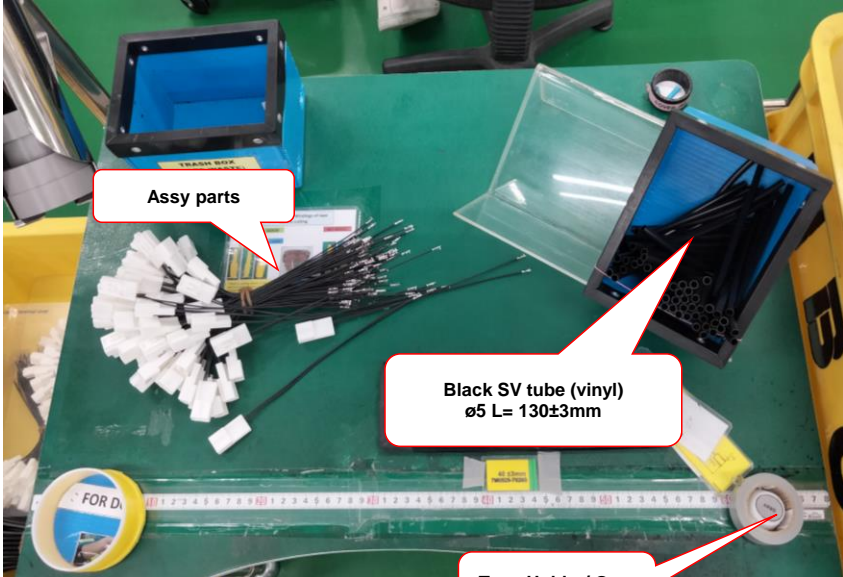
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	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 310B / 7M0525-7020B		Customer: TRJ	Car Model: TOYOTA-RAV 4		Document No.: WI-ENG-PDE-030
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.: 8		Page No.: 8	1 of 5


PARTS:		1. Assy parts; Black SV tube (Vinyl) ø5 L=130±3mm			JIG:		n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS
1	P1	<div>TABLE LAY OUT</div>  <div>Assy parts</div> <div>Black SV tube (vinyl) ø5 L= 130±3mm</div> <div>Tape Holder/ Gray tape</div>				<div>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		<div>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to WI-ENG-PDE-104 for Offline assembly process</div> <div>1.No missing parts/tools 2.No excess parts/tools</div>


Revision History							Prepared by	Reviewed by	Approved by	Noted by
07/02/24	8	Inclusion of Car model "TOYOTA-RAY 4". Improved Measurement and Visual inspection/Quality checkpoint.				D.Castillo	C.Villanueva	A. Arañes	N/A	
05/17/23	7	Inclusion of table lay-out and quality checkpoints; improvement of important reminders/Note/s and document references; improvement of by two's inspection; standardize term of SV tube (Vinyl)				J. Loterte	C. Villanueva	A. Shimamura	A. Arañes	
06/25/21	6	Removal of Marking.				J. Loterte	C. Villanueva	A. Shimamura	A. Arañes	
04/26/21	5	Add instruction on taping process; Change connector color in accordance with color standardization for plastic parts. Refer to GL-COM-003.				J. Loterte	R. Peñalosa	A. Shimamura	A. Arañes	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date: November 21, 2018

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	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:		8	Page No.:


PARTS:		1. Assy parts 2. Black SV tube (Vinyl) ø5 L=130±3mm				JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS
2	P1	<div></div> <div>1. Get the Black SV tube (Vinyl) ø5 L=130±3mm using right hand then insert the B-B wires.</div>				N/A	1. No wrong usage of parts 2. No deformed terminal

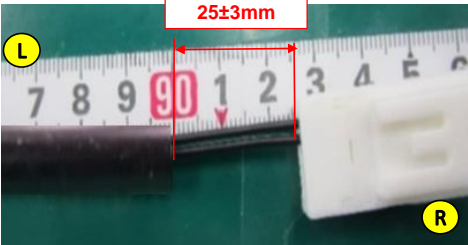
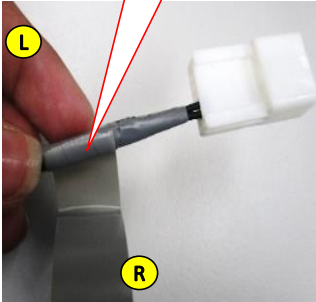
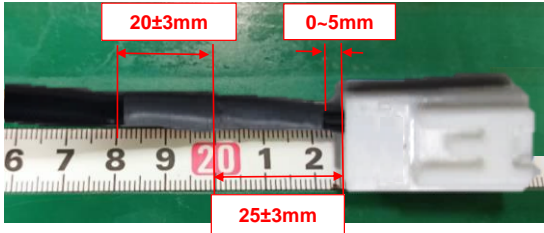
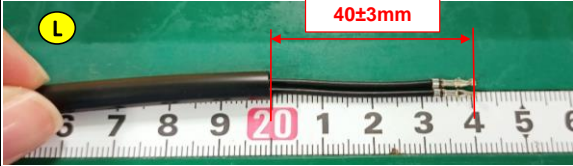

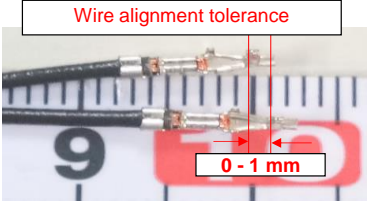
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	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		8	Page No.:	3 of 5			

PARTS:		1. Assy parts 2. Gray tape [1pc]		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
3	P1 Taping 1 SV tube (Vinyl) to wire near Connector	<div><p>25±3mm</p></div> <div>1. Hold the Black SV tube (Vinyl) using left hand and measure from end of vinyl tube up to connector 25±3mm.</div> <div><p>Start taping</p></div> <div>2. Get the Gray tape using right hand then start taping process using both hands.</div> <div><p>20±3mm 0~5mm 25±3mm</p></div> <div>3. After taping, check the measurement, taping condition and wire alignment.</div> <div><p>40±3mm</p></div>		<div>MEASURING TAPE</div> 	<div>1. No flip-out tape 2.No peel-off tape 3. No loose tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape</div> <div>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</div> <div><p>Wire alignment tolerance 0 - 1 mm</p></div>	

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PARTS:

1. Assy parts

JIG:

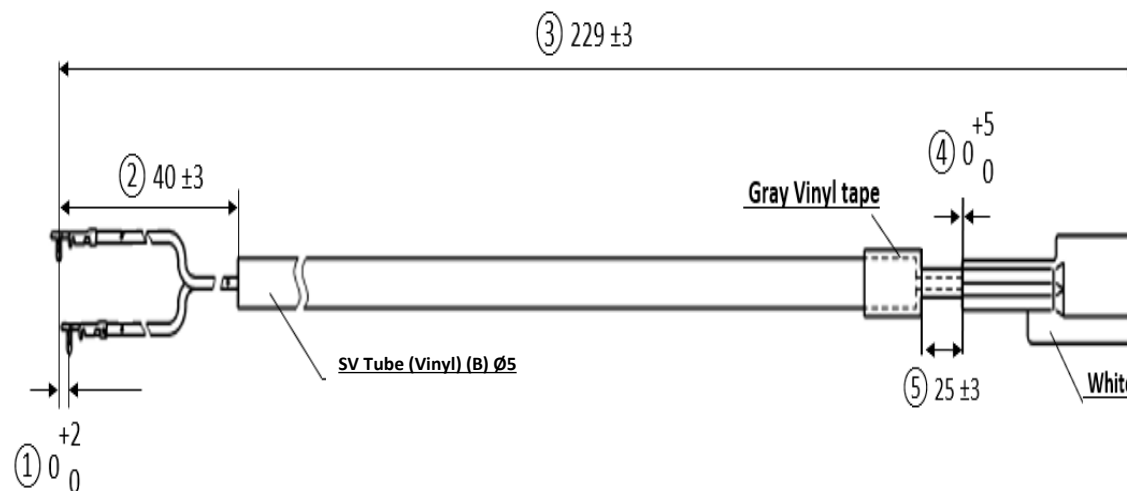
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NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

4

P1

Measurement

**MEASURING
TAPE****Important reminders and note/s:**

1. Please use calibrated/verified measuring tape when getting the measurement.

2. For Hatsumono, Nakamono and Owarimono.

Document reference/s:

1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection

1. No wrong dimension

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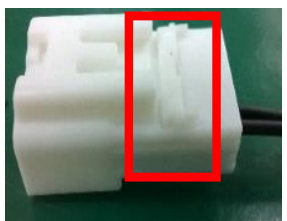
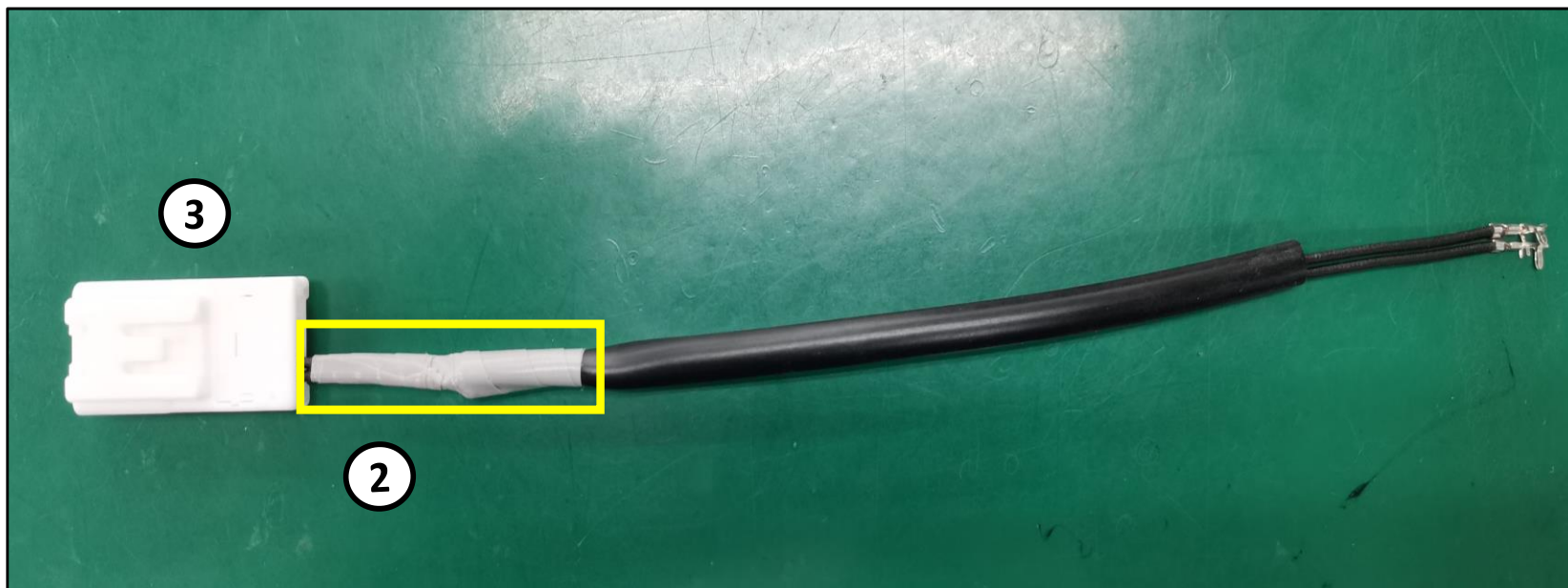
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PARTS:

1. Assy parts

JIG:

N/A

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P1****7M0525-7020B****GOOD****NO GOOD****① No Unlocked/ Half-locked Connector****② No Missing Tape****③ No Deformed Terminal**

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