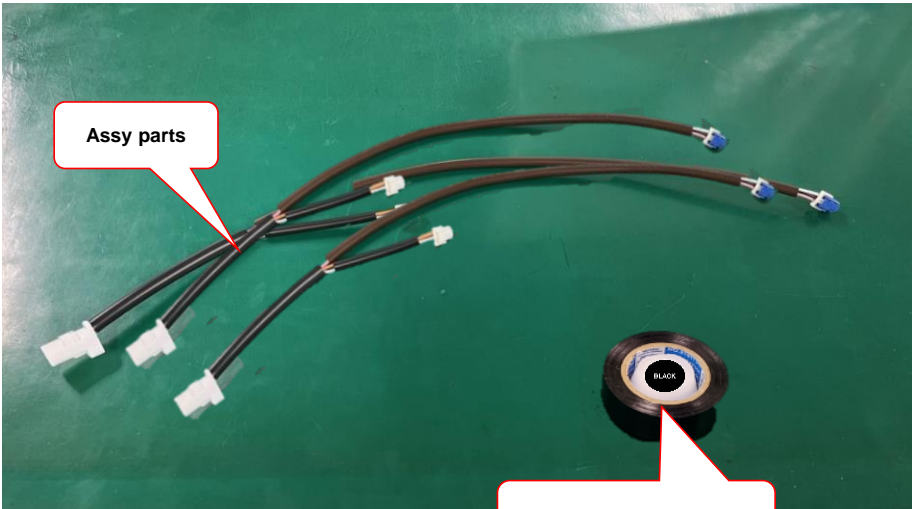
	WORK INSTRUCTION				Effectivity Date:		December 18, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 310D / 628126-0000A		Customer: TRJ	Car Model: TOYOTA-RAV 4	Document No.:		WI-ENG-PDE-1167B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		0	Page No.: 1 of 5




PARTS:		1. Assy parts; Black tape		JIG:		n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1	P2	Table Lay-out		<div><div>Safety Instruction Be sure to wear prescribed 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>		1. No missing parts/tools 2. No excess parts/tools	

TABLE LAY-OUT



Assy parts


Tape holder/ Black tape

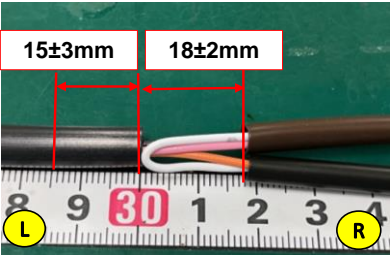
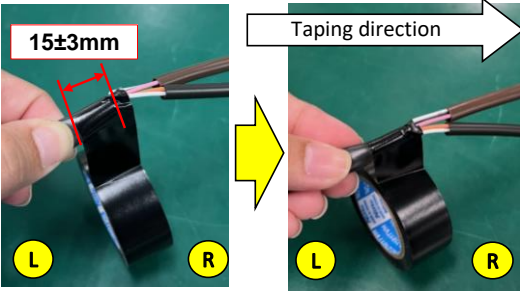
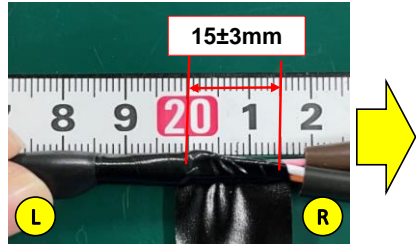
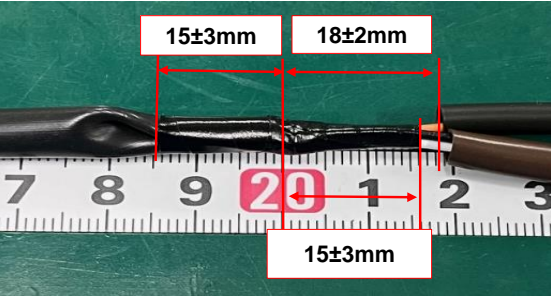

Revision History						Prepared by	Reviewed by	Approved by	Noted by
						 D. Castillo	 C. Villanueva	 A. Arañes	n/a
12/18/24	0	Initial issue.							
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted

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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><p>15±3mm 18±2mm</p><p>1. Hold the assy parts using both hands. Measure from end of VM tube to end of VM tube 18±2mm. Measure VM tube up to end of VM tube 15±3mm for taping.</p></div> <div><p>15±3mm</p><p>Taping direction</p><p>2. Get the Black tape and position the tape to VM tube. Make 2 windings then continue taping. <i>Note: Follow the above illustration.</i></p></div> <div><p>15±3mm</p><p>3. Measure from end of VM tube (Sunprene) up to end of tape (15±3mm) then continue the taping process.</p></div> <div><p>15±3mm 18±2mm</p><p>15±3mm</p><p>4. After taping, Check the measurement and taping condition.</p></div>			<div>MEASURING TAPE</div> 	<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> <p>Important Reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p>		

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	3 of 5

PARTS:		1. Assy parts 2. Master sample		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 Visual/By two's Inspection	<div>1. Check the connector lock. Locking of connector is included in Steering Electrical test.</div> <div>2. Check the wire alignment. Must be no tangled wires.</div> <div>3. Check the Terminal if with Backing out (Not fully inserted) or no deformed terminal.</div> <div></div> <div>ACTUAL PRODUCT</div> <div>4. Check the presence and position of retainer (2 connectors).</div> <div>4. Check the orientation of harness.</div> <div>5. Compare to Master sample by tapping</div> <div></div> <div>ASSEMBLED PARTS</div> <div>MASTER SAMPLE</div> <div>MASTER SAMPLE</div>			<div>Document reference/s: 1. Refer to WI-QAD-QAC-252 Steering Electrical Test</div> <div>MASTER SAMPLE</div> <div></div>

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TOYOTA-RAV 4

Document No.:

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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

4

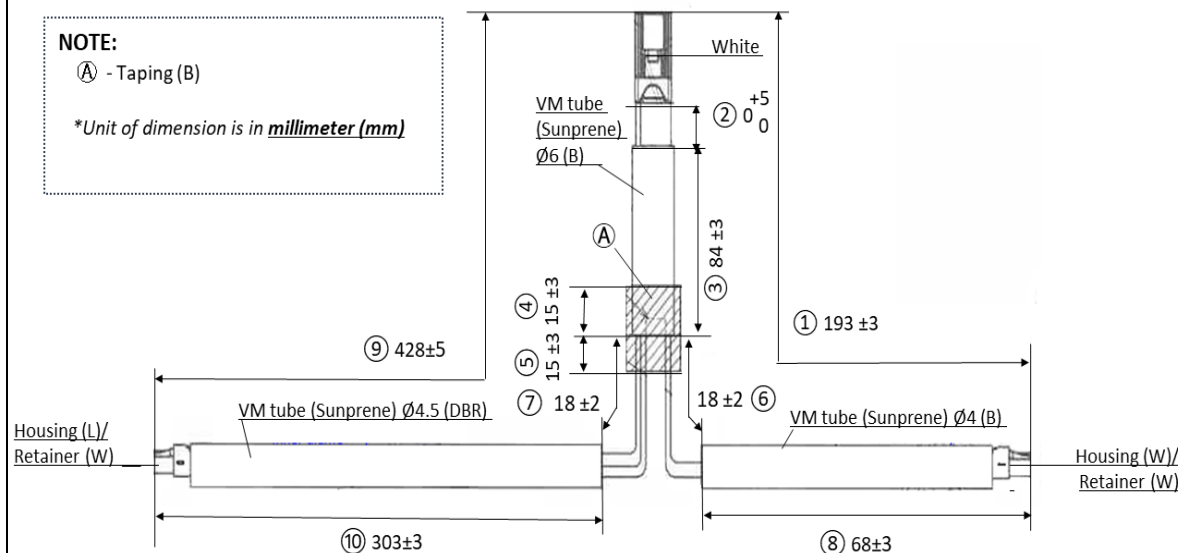
P2

Measurement

NOTE:

Ⓐ - Taping (B)

*Unit of dimension is in millimeter (mm)



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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PROTOTYPE



PRE-LAUNCH



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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

PADDLE SWITCH

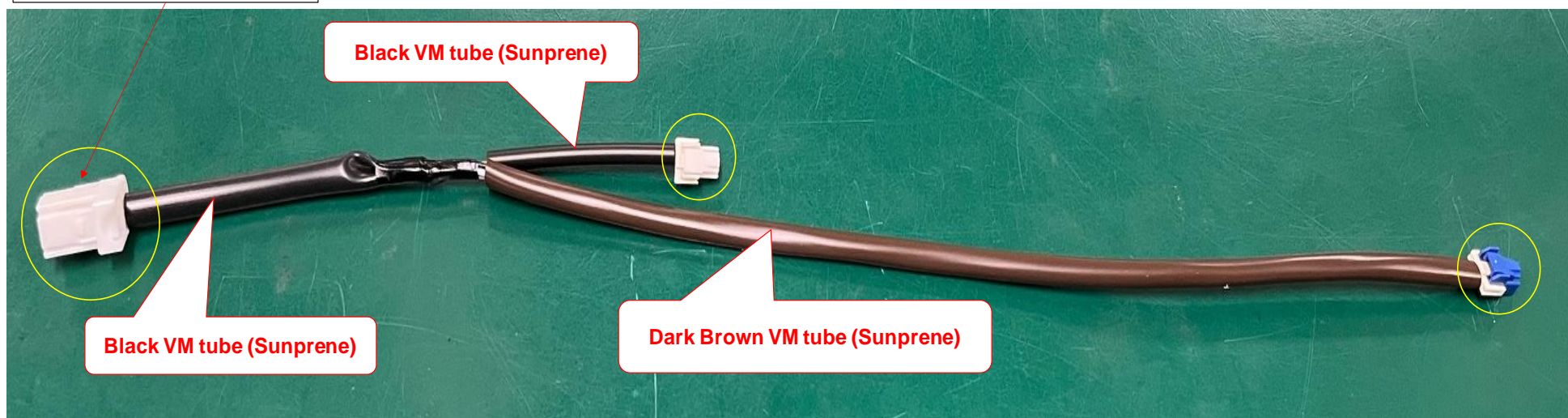
628126-0000A

1. Check the Connector lock, should be unlock.

2. Check the wire alignment. Make sure no tangled wires.

3. Check the terminal if with backing out (not fully inserted) or deformed terminal.

4. Check the orientation of harness.



5. Check if no missing parts. Check the presence and position of retainer (2 connectors).

6. No Missing tape

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