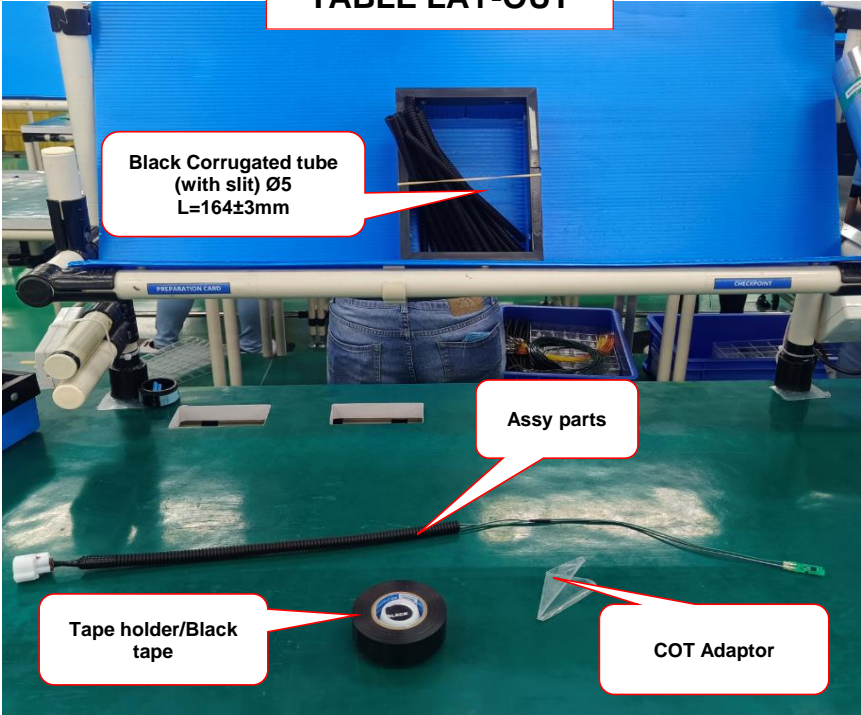


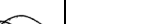
	<b>WORK INSTRUCTION</b>				Effectivity Date:	October 18, 2024	
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a	
	Process Name/Title:		Model code/Part number: <b>310D / 7N0195-7020E</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-RAV4</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.: <b>WI-ENG-PDE-1028B</b>		Revision No.: <b>1</b>		Page No.: <b>1 of 5</b>

PARTS:		1. Assy parts 2. Black Corrugated tube (with slit) Ø5 L=164±3mm		3. Black tape		JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
1	P2	Table lay-out	<div><div>TABLE LAY-OUT</div><div></div></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 part/tools. 2. No excess parts/tools

Revision History							Prepared by	Reviewed by	Approved by	Noted by
							 M. Ariola	 C. Villanueva	 A. Arañes	
10/18/24	1	Change purpose from Pre-launch to Masspro. Update the Visual Inspection/Quality Checkpoints.	M. Ariola	C. Villanueva	A. Arañes	n/a				
9/10/24	0	Initial issue.	M. Ariola	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change			Revised	Reviewed	Approved	Noted	Est. Date:	September 10, 2024

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

Process Name/Title:

Model code/Part number:

**310D****/****7N0195-7020E**

Customer:

**TRJ**

Car Model:

**TOYOTA-RAV4**

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Effectivity Date:

**October 18, 2024**

Validity Date:

**n/a**

Document No.:

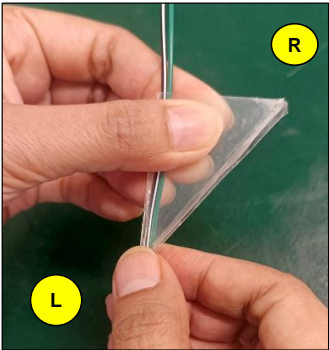
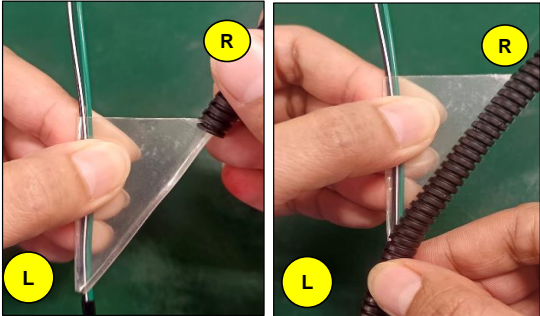

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PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2  Wire insertion to Black Corrugated tube (with slit) Ø5 L=164±3mm	<div><div>1. Hold the COT Adaptor using left hand. Insert the wires using right hand.</div></div> <div><div>2. Hold the COT Adaptor with wires using left hand, get the <b>Black Corrugated tube (w/ slit) Ø5 L=164±3mm</b> using right hand then insert to COT adaptor. Hold the COT adaptor and push the COT (same timing) using both hands. Make sure all wires are inserted.</div></div>		<div>COT Adaptor</div> 	<b>Important reminders/Notes</b> <b>1. Please use calibrated/verified measuring tape when fetting the measurement.</b>  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

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## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

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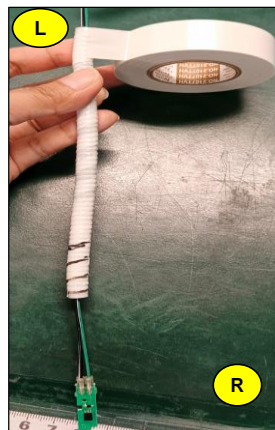
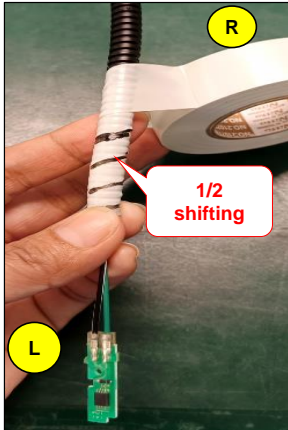
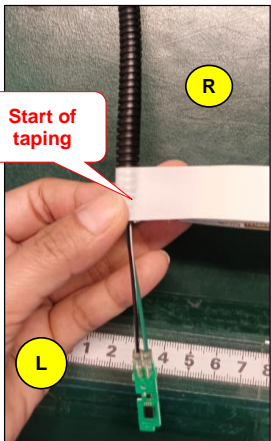
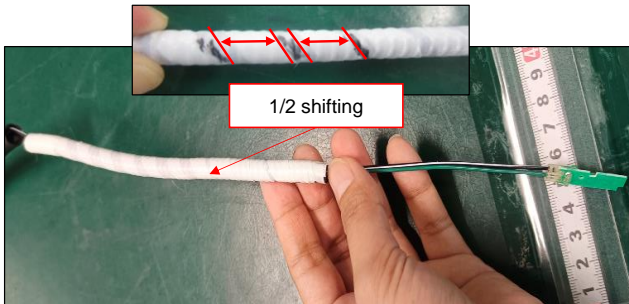

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	Half-wrap Taping	<div><p>1. Hold the <b>corrugated tube (w/slit)</b> using left hand. Get the black tape using right hand. Conduct <b>2 windings</b> of tape before shifting using both hands.</p><p>2. Make <b>1/2 shifting</b>. Repeat the process until the end of corrugated tube. Make <b>3 windings</b> of tape then cut the tape.</p><p>3. Check the taping condition.</p></div>	<div><b>MEASURING TAPE</b></div> 	<p><b>Important reminders/Notes</b></p> <ol style="list-style-type: none"><li>1. Please use calibrated/verified measuring tape when getting the measurement.</li><li>2. Used <b>WHITE TAPE</b> to easily visualize the tape shifting, but actual should be <b>BLACK TAPE</b>.</li><li>3. Internal tolerance for halfwrap taping shifting should be 0~14mm only.</li></ol> <ol style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong use of tape</li></ol>

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# WORK INSTRUCTION

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310D

/

7N0195-7020E

Customer:

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Car Model:

TOYOTA-RAV4

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

October 18, 2024

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n/a

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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  Taping 2 Black Corrugated tube (No slit) to Corrugated tube (w/ slit)	<div><p>272 ± 3mm</p><p>1. Measure from end of the Corrugated tube (No slit) up to end of hotmelted wire <b>272mm</b> using both hands.</p></div> <div><p>25 ± 3mm</p><p>2. Fix the <b>Corrugated tube (No slit)</b> and the <b>Corrugated tube (w/slit)</b> using both hands.</p></div> <div><p>25 ± 3mm</p><p>3. Get the black tape and start taping process using both hands.</p></div> <div><p>25 ± 3mm</p><p>4. Measure from end of tape up to end of Corrugated tube (No slit) <b>25±3mm</b>.</p></div> <div><p>25 ± 3mm</p><p>5. Measure from end of Corrugated tube (No slit) to end of tape <b>25±3mm</b>.</p></div> <div><p>25 ± 3mm</p><p>6. After taping, check the measurement and taping condition.</p></div>		<div><p><b>MEASURING TAPE</b></p></div>	<p><b>Important reminders/Notes</b></p> <p><b>1. Please use calibrated/verified measuring tape when fetting the measurement.</b></p> <ol style="list-style-type: none"><li>1. No peel-off tape</li><li>2. No flip out tape</li><li>3. No loose tape</li><li>4. No wrong use of tape</li><li>5. No wrong dimension</li><li>6. No missing tape</li></ol>

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PARTS:

n/a

JIG:

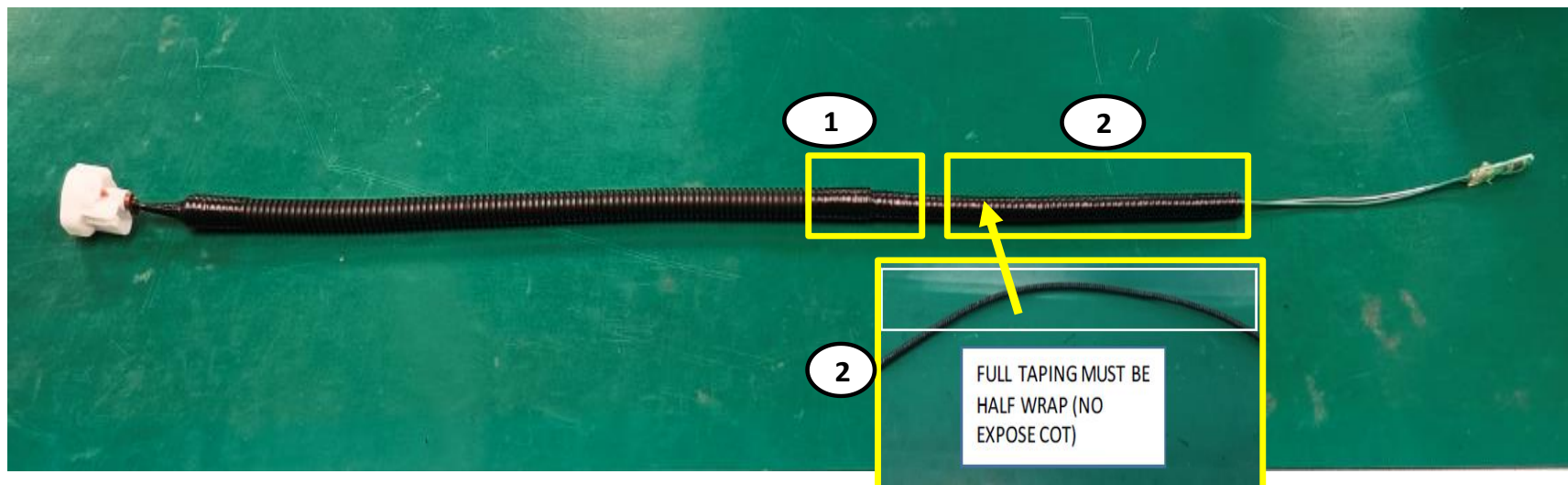
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### QUALITY CHECKPOINTS

## TAPING - P2

## 7N0195-7020E



1

No MISSING TAPE

2

No EXPOSED COT

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