



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 04, 2024

Process Name/Title:

Model code/Part number:

310D / 7N0201-7020B

Customer: TRJ

Car Model: TOYOTA RAV4

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1014B

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

0

Page No.:

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PARTS:

1. Assy parts; Black corrugated tube $\phi 5$ L=316 \pm 3mm (no slit); AVSSF 0.3 B-B L=779 \pm 3mm; Black VM tube (Sunprene) $\phi 9$ L=120 \pm 3mm; Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

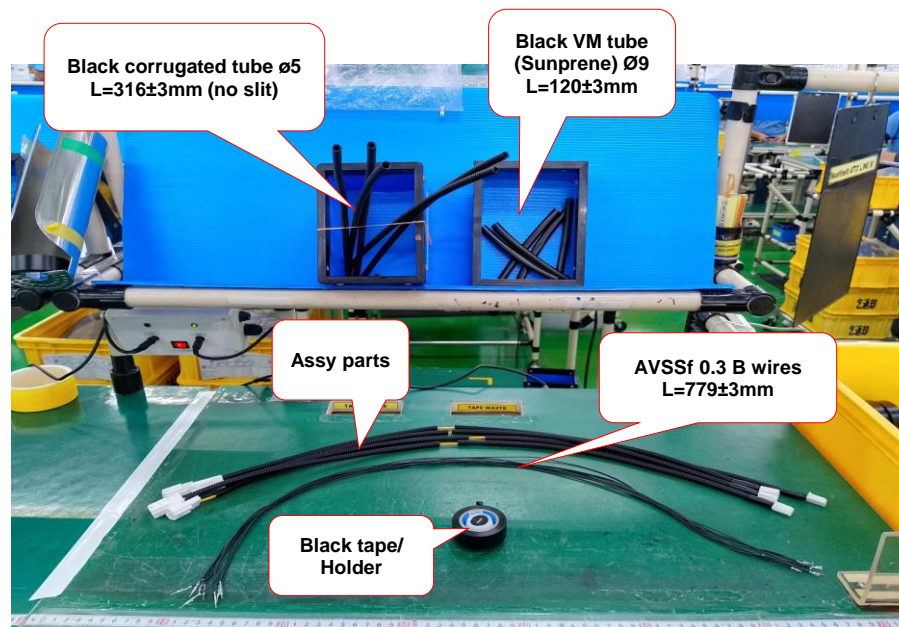
QUALITY POINTERS

1

P2

Table Lay-out

TABLE LAY-OUT



Safety Instruction

Be sure to wear required 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

10/04/24 0 Initial issue.

A.Hernandez C.Villanueva A. Arañes n/a

A.Hernandez

C.Villanueva

A.Arañes

n/a

Eff. Date Rev. No

Details of Change

Revised Reviewed Approved Noted

Est. Date:

October 04, 2024

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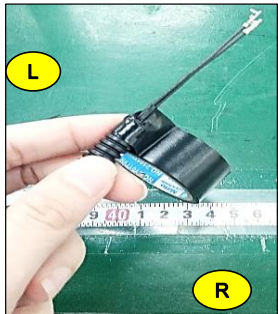
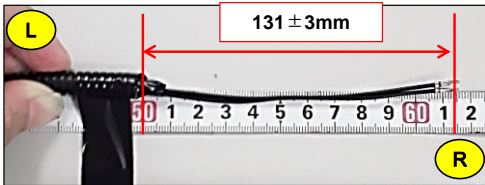
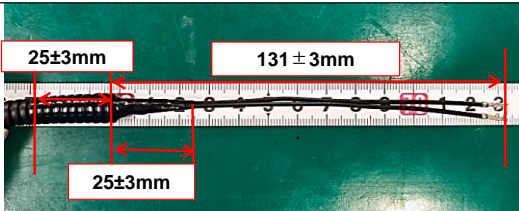

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PARTS:		1. Black corrugated tube $\phi 5$ L=316 \pm 3mm (no slit) 2. AVSSF 0.3 B-B L=779 \pm 3mm 3. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2		<div><div><p>Wire Insertion to Black corrugated tube $\phi 5$ L=316\pm3mm (no slit)</p></div><div><p>1. Get the Black corrugated tube $\phi 5$ L=316\pm4mm (no slit) using left had and get B-B wires using right hand then insert.</p></div></div>		n/a	1. No wrong usage of parts. 2. No deformed terminal
	P2	<div><div><p>Taping 2 Black Corrugated tube to Wire near terminal</p></div><div><p>1. Hold the assy parts using left hand. Get the Black tape using right hand then start taping process using both hands.</p></div><div><p>2. Measure form end of COT up to terminal pointed tip 131\pm3mm then continue the taping process using both hands</p><p>3. After taping, check the measurement and taping condition.</p></div></div>		<div><div>MEASURING TAPE</div></div>	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 Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.

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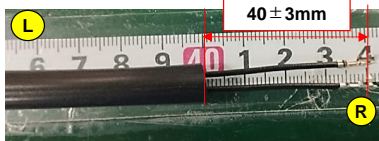

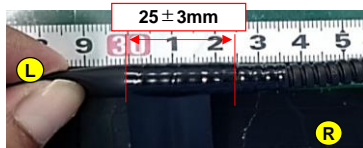
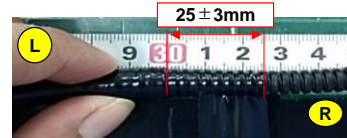
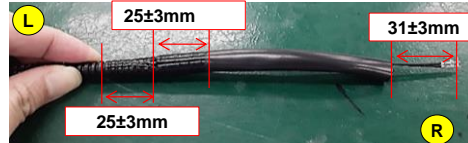

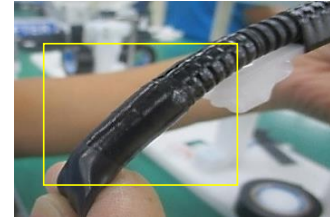
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PARTS:		1. Assy parts 2. Black tape 3. Black VM tube (Sunprene) Ø9 L=120±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3		<div><div></div><div><p>1. Get the Black VM tube (Sunprene) Ø9 L=120±3mm using right hand then insert the assy parts using left hand.</p></div></div>		n/a	1. No wrong use of parts 2. no deformed terminal
	P2	<div><div><div><p>1. Measure from end of tube up to terminal pointed tip 31±3mm using both hands.</p></div><div><p>2. Hold the Assy parts using left hand, get the Black tape using right hand then start pre-taping using both hands.</p></div><div><div><p>3. Confirm measurement of 25±3mm from end of tape up to end of tube then continue the taping process using both hands.</p></div><div><div><p>4. Confirm measurement of 25±3mm from end of tube up to end of tape then continue the taping process using both hands.</p></div><div><div><p>5. After taping, check the measurement, terminal appearance and taping condition.</p></div></div></div></div><div><div>MEASURING TAPE</div></div><div></div></div></div>		1. Check the tape from COT to SV tube (Vinyl) (Conduct bending for verification) 2. No flip out tape. 3. No tape peeling. 4. No loose tape Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.	

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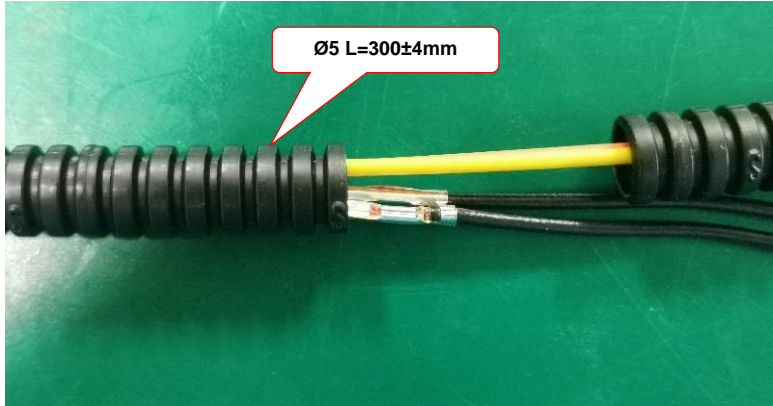
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PARTS:	1. Assy Parts			JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2	Wire insertion to Assy parts	<div></div> <div>1.Hold the corrugated tube (no slit) Ø5 L=300±4mm using left hand then insert the B-B wire using right hand.</div>	n/a	1. No wrong use of parts 2. No deformed terminal 3. No wrong use of insertion

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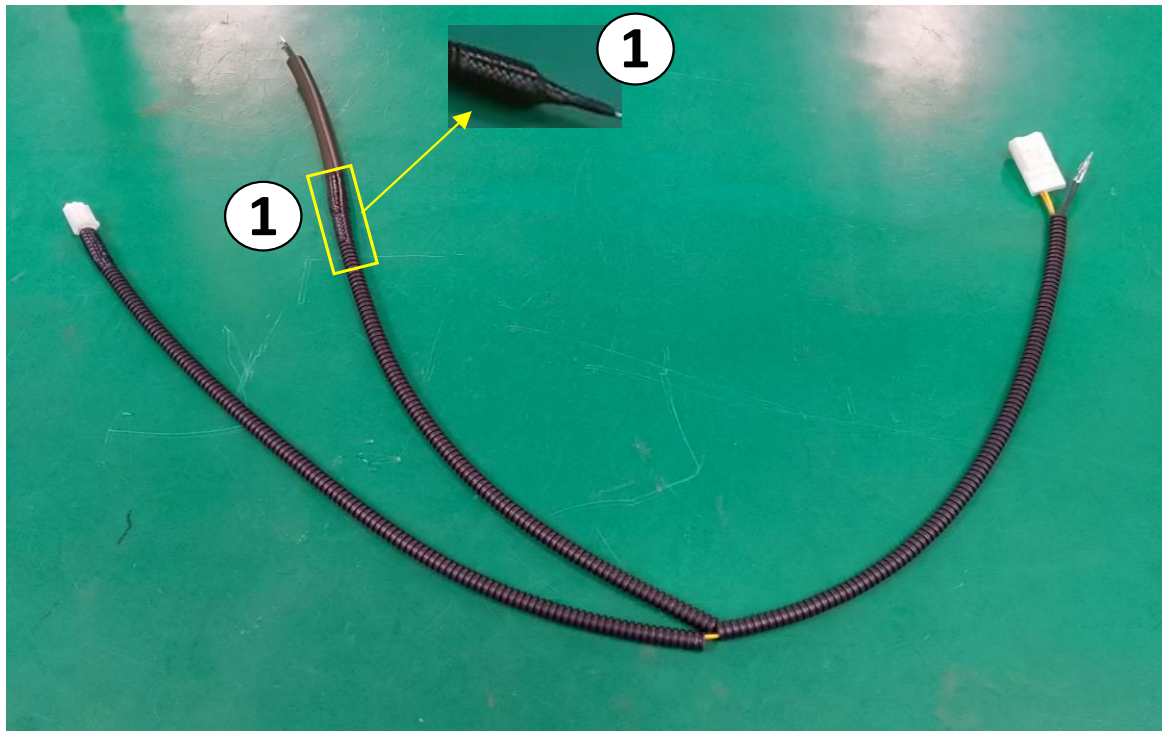
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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P2****7N0201-7020B****1 No Missing tape****2 No Deformed Terminal**

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