



WORK INSTRUCTION

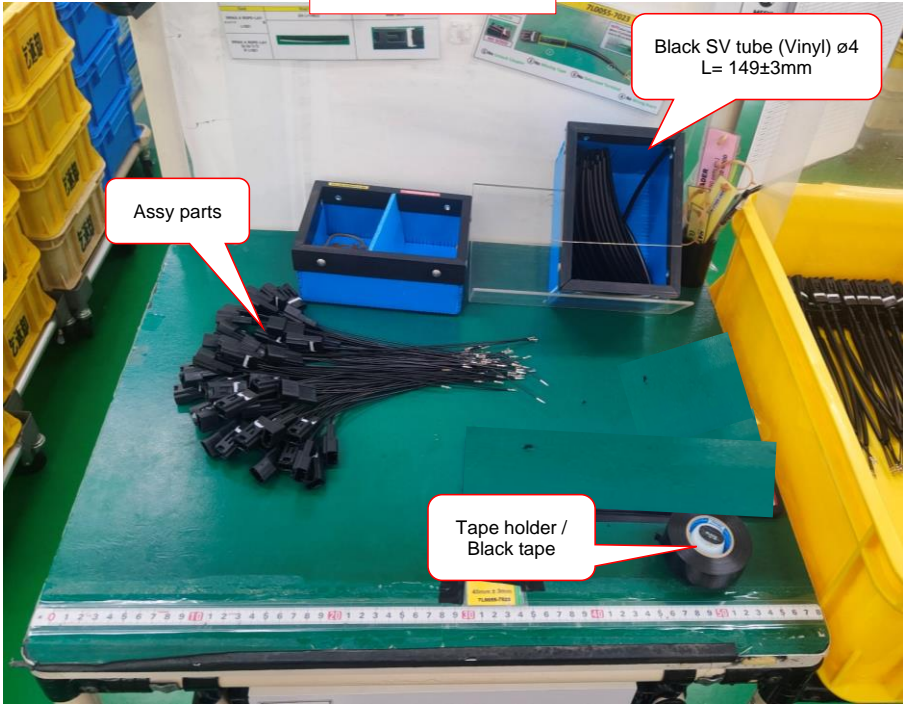
Process Name/Title: **TAPING ASSEMBLY PROCESS**
Model code/Part number: **320B / 7L0055-7023** Customer: **TRQSS** Car Model: **TOYOTA-RAV4**
Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Effectivity Date: **May 22, 2024**
Validity Date: **n/a**
Document No.: **WI-ENG-PDE-283**
Revision No.: **4** Page No.: **1 of 4**

PARTS: 1. Pre-assy parts: Connector 6098-3803 (B); AVSSf 0.3 wires B L= 221±2mm [2pcs]; Black SV tube (Vinyl) ø4 L= 149±3mm; Black tape

JIG:

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	Table Lay-out 	<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 work place 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


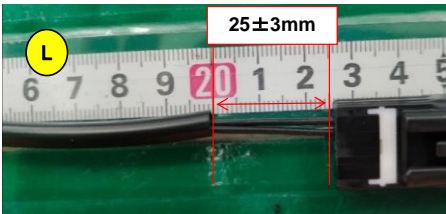
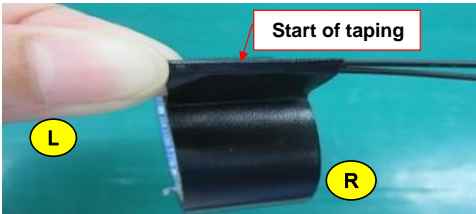


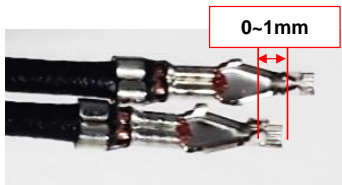
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/22/24	4	Improved Measurement and Visual inspection.	D.Castillo	C. Villanueva	A. Arañes	n/a				
06/30/23	3	Inclusion of table lay-out and quality checkpoints; improve by two's inspection, important reminders/note/s and document references and work procedure and illustration; standardize term of SV tube (Vinyl); update template, include car model.	J. Loterte	C. Villanueva	A. Arañes	n/a				
06/11/21	2	Transfer process owner from Production WI (WI-PRO-ASY-129) To Engineering WI (WI-ENG-PDE-283) Improve process illustration and quality pointers; removal of marking	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	November 27, 2018		

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	TAPING ASSEMBLY PROCESS				Validity Date:	n/a				
	Process Name/Title:		Model code/Part number: 320B / 7L0055-7023		Customer: TRQSS	Car Model: TOYOTA-RAV4		Document No.:	WI-ENG-PDE-283	
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO		Revision No.:	4	Page No.:

PARTS:	1. Pre-assy parts: Connector 6098-3803 (B); AVSSf wires B L= 221±2mm [2pcs]				2. Black SV tube (Vinyl) ø4 L= 149±3mm		JIG:	n/a
3. Black tape								
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS	
2	Wire insertion to Black SV tube (Vinyl) ø4 L= 149±3mm	<div></div> <div>1. Get the Black SV tube (Vinyl) ø4 L= 149±3mm using right hand then insert the Black wires.</div>				n/a	1. No wrong usage of parts 2. No deformed terminal	
3	P1 Taping Vinyl tube to wire near connector	<div></div> <div>1. Hold the SV tube (Vinyl) and measure the end of the vinyl tube up to connector 25mm.</div> <div></div> <div>2. Get the BLACK TAPE and start taping using both hands.</div> <div></div> <div>3. After taping, check the measurement, wire alignment and tape condition.</div> <div>Note: This part is controlled based on the drawing.</div>				MEASURING TAPE 	<div></div> <div>Wire alignment tolerance 0~1mm</div> <div>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document reference/s: 1. Please refer to WI-PRO-ASY-001 for taping procedure.</div> <div>1.No flip out tape. 2.No tape peeling. 3.No loose tape 4. No wrong use of tape</div>	

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☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

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PARTS:

1. Assy parts

JIG:

n/a

NO.

PROCESS NAME

4

WORK PROCEDURE/ ILLUSTRATION

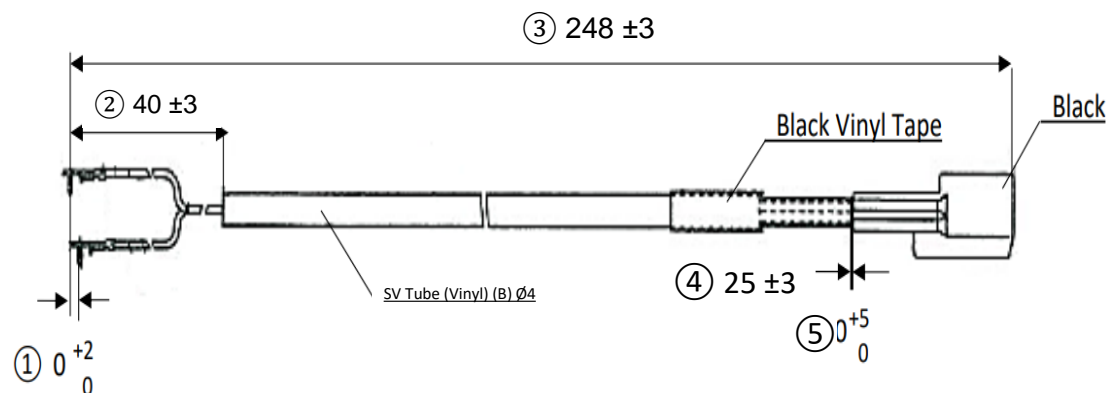
TOOLS/PPE

QUALITY POINTERS

4

P1

Measurement



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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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P1****7L0055-7023****GOOD****NO GOOD****GOOD****NO GOOD**

- ① No Unlock Connector ② No Missing Tape ③ No Deformed Terminal ④ No Wrong Insert

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