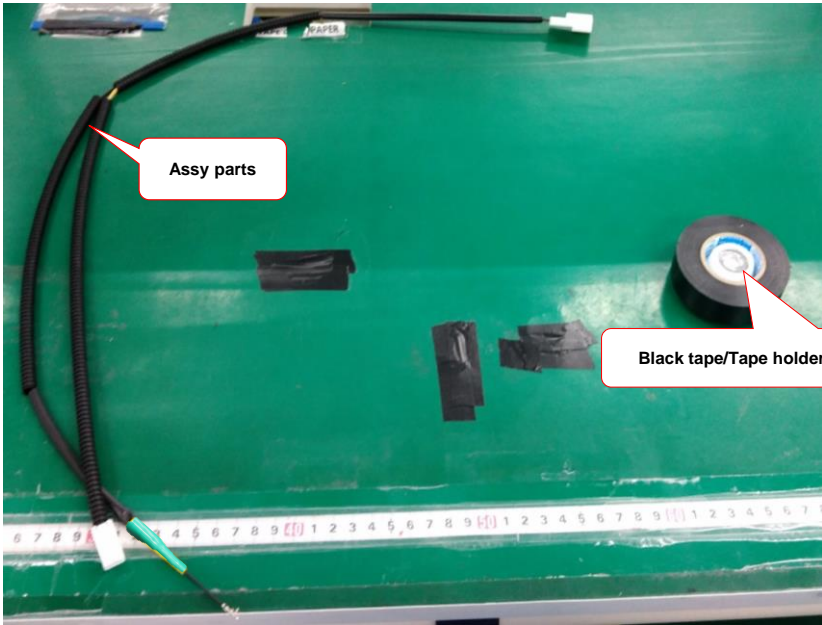




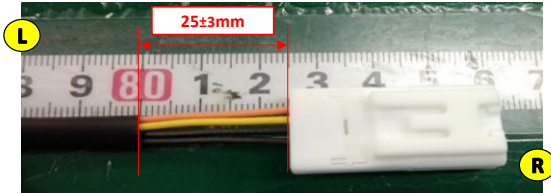
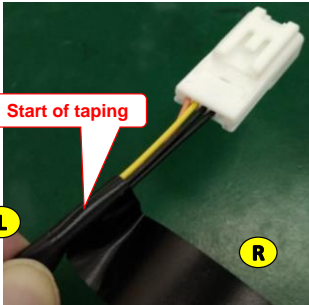
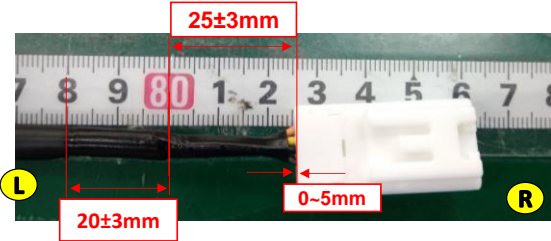

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	Model code/Part number: 096D / 7L0119-7021A		Customer: TRQSS	Car Model: TOYOTA-HIGHLANDER	Document No.:	WI-ENG-PDE-393B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	4	Page No.:	1 of 8

PARTS:	1. Assy parts; Black tape [1pc.]			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P2 4 Table Lay-out	<div style="text-align: center;"> Table Lay-out </div> 		<div style="border: 1px dashed red; padding: 5px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	1. No missing parts/tools 2. No excess parts/tools

Revision History								Prepared by	Reviewed by	Approved by	Noted by		
07/02/24	4	Transfer Taping 2 and Taping 4 from WI-ENG-PDE-393A due to process improvement. Update table lay-out. Improved Measurement and Visual inspection. Separate clamp seating and clamp assembly process to Clamp assembly process.				D.Castillo	C.Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
07/26/23	3	Standardized tube description: VM tube (Sunprene); SV tube (Vinyl) page no.3,10,11 and 13.				M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
04/06/23	2	Align procedure no.4 in process no.5 in actual due to elimination the resetting of alarm from time-to-time by the leader and the process in jig				M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	February 03, 2022		

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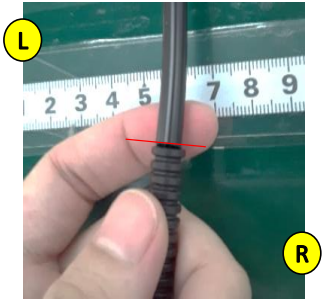
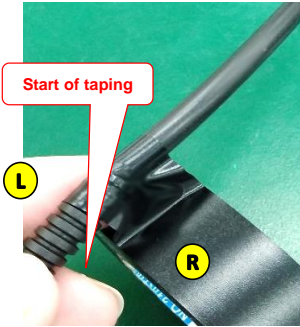
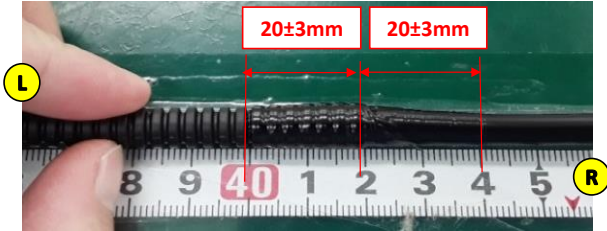

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS		
2	P2 Taping 2 Black SV tube (vinyl) to wire near connector	<div><p>1. Measure from end of SV tube (vinyl) up to end of connector 25±3mm using both hands.</p></div> <div><p>2. Get the Black tape using right hand then start taping process using both hands.</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>	<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p>		

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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 Taping 3 Black Cot to Black SV tube (vinyl) near connector	<div><p>1. Fix the corrugated tube and SV tube (vinyl) using both hands.</p></div> <div><p>2. Get the Black tape and start taping process using both hands.</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>		<div>MEASURING TAPE</div> 	<p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p> <p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p>

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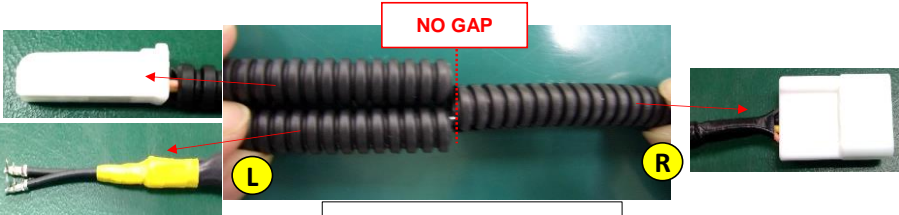
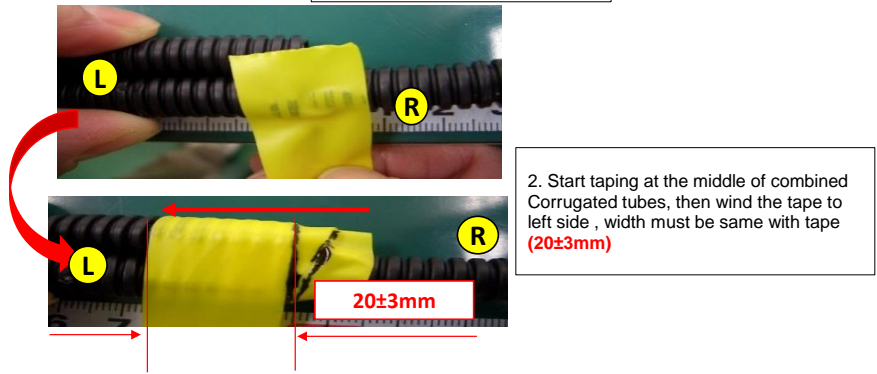
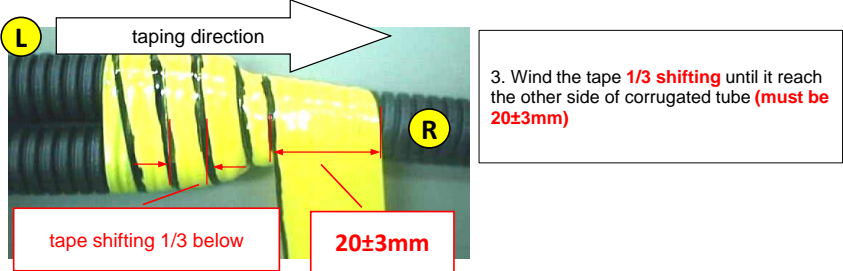
PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2 Taping 4 Black Corrugated tube to Black VM tube (sunprene) near terminal	<div><div><div>L</div><div>176±3mm</div><div>R</div></div><div>1. Measure from end of corrugated tube up to end of terminal pointed tip 176±3mm using both hands.</div></div> <div><div><div>L</div><div>Start of taping</div><div>R</div></div><div>2. Fix the corrugated tube and SV tube (vinyl) using both hands.</div></div> <div><div><div>L</div><div>Start of taping</div><div>R</div></div><div>3. Get the Black tape and start taping process using both hands.</div></div> <div><div><div>L</div><div>176±3mm</div><div>R</div></div><div><div>20±3mm</div><div>20±3mm</div></div><div>4. After taping, check the measurement and taping condition.</div></div>		<div>MEASURING TAPE</div> <div></div>	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p>

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PARTS:			1. Assy parts 2. Black tape		JIG:	n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
5	P2	Y-Taping	<div><p>1. Fix the 3 corrugated tube .</p></div> <div><p>2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side , width must be same with tape (20±3mm)</p></div> <div><p>3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be 20±3mm)</p></div>			n/a	<div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</div> <div>Important reminders/Note/s: 1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</div>	

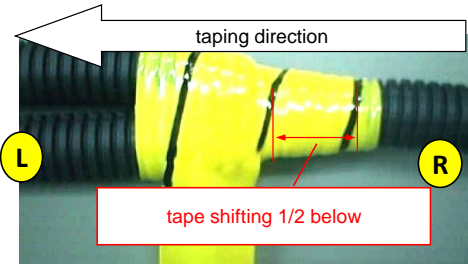
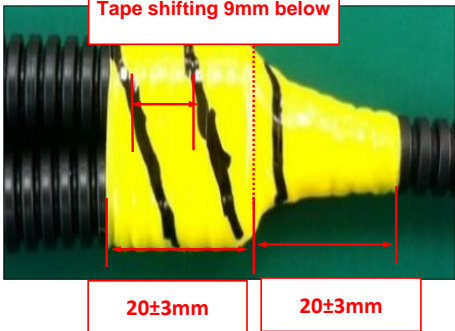

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
5	P2 Y-Taping (Continuation)	<div><p>4. Wind the tape backward 1/2 shifting</p></div> <div><p>5. Wind the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.</p><p>20±3mm 20±3mm</p></div>	<div>MEASURING TAPE</div> 	<p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p> <p>Important reminders/Note/s:</p> <p>1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p>	

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PARTS:

n/a

JIG:

n/a

NO.**PROCESS NAME**

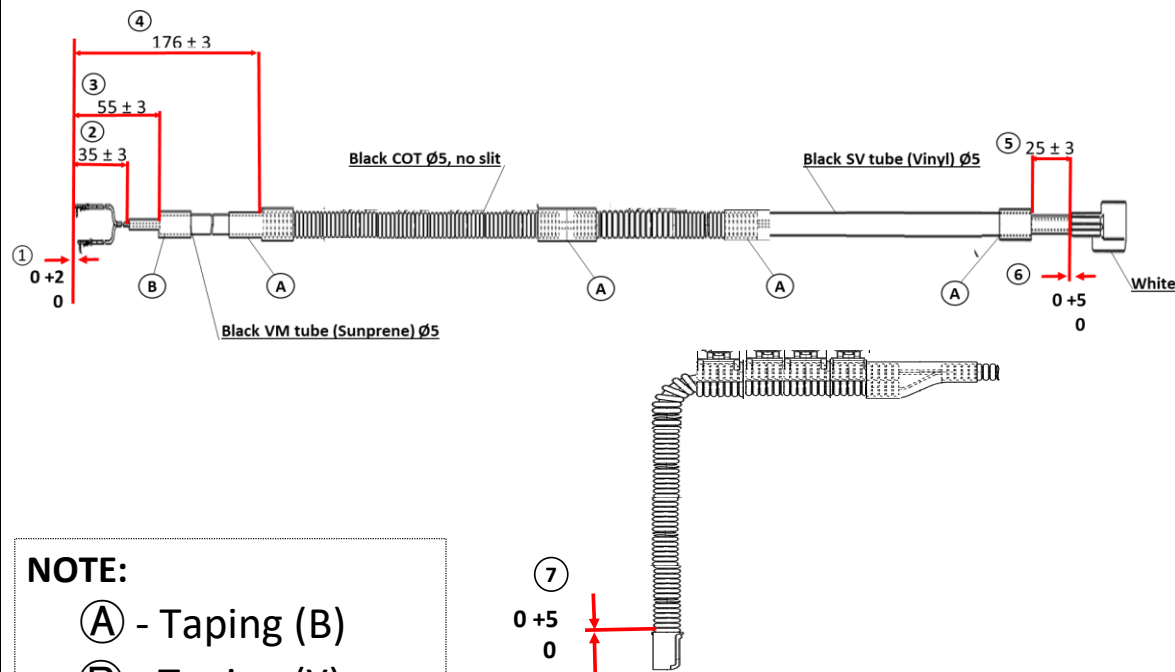
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WORK PROCEDURE/ ILLUSTRATION**TOOLS/PPE****QUALITY POINTERS**

6

P2

Measurement



1. No wrong dimension

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

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PARTS:

n/a

JIG:

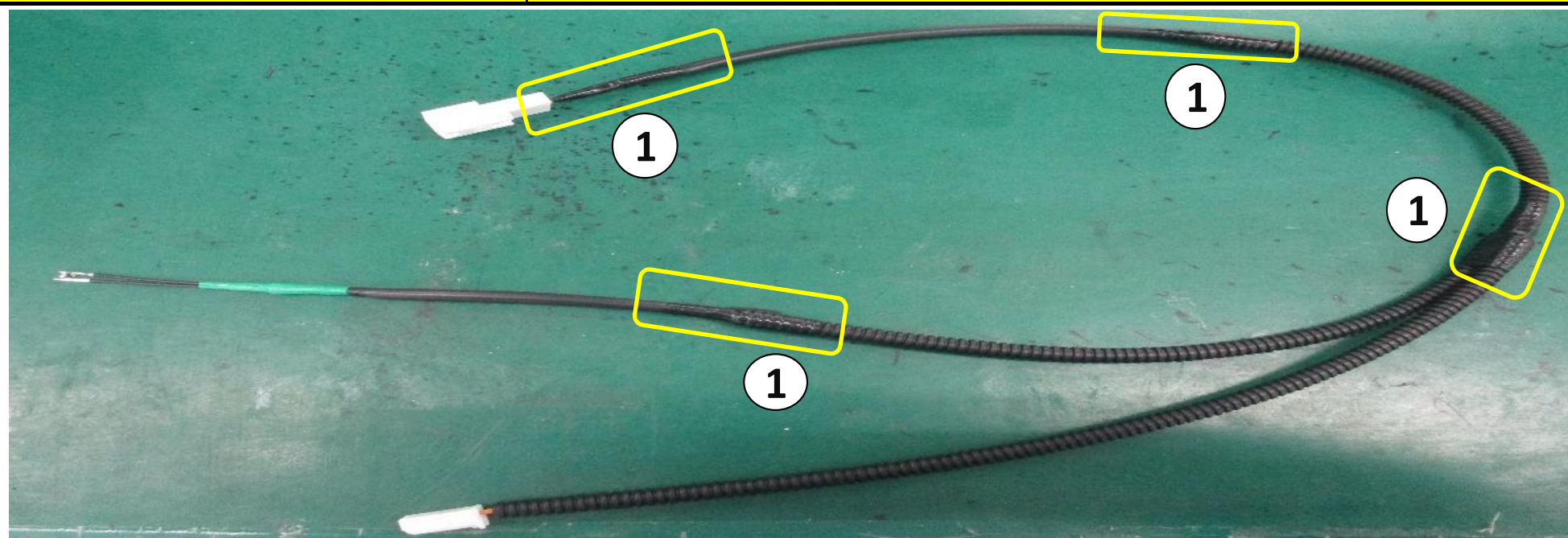
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VISUAL INSPECTION

TAPING - P2

7L0119-7021A



1 No Missing Tape

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