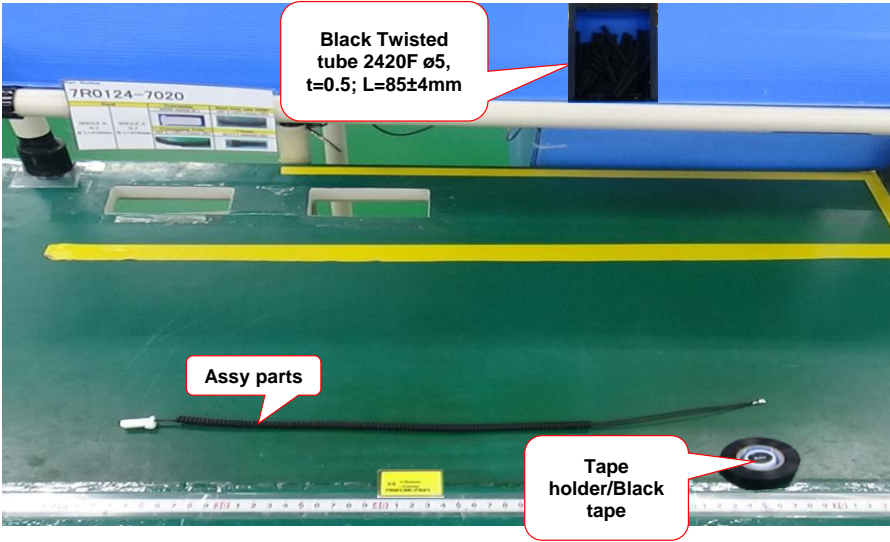
	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>July 10, 2024</b>		
	<b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Process Name/Title:	<b>200D / 7R0124-7020</b>		Customer:	<b>TRMX</b>	Car Model:	<b>TOYOTA-SEQUOIA</b>
	Model code/Part number:			Document No.:	<b>WI-ENG-PDE-449</b>		
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	6	Page No.:	1 of 5

PARTS:	1. Assy parts; Black Twisted tube 2420F ø5, t=0.5; L=85±4mm; Black tape			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	n/a	Table lay-out			<p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>

Revision History						Prepared by	Reviewed by	Approved by	Noted by
07/10/24	6	Improve measurement and visual inspection.	A.Hernandez	C. Villanueva	A. Arañes	n/a			
07/29/23	5	Change MP from P1 to P2; Transfer process of Wire insertion to Connector; Connector lock and Wire insertion to COT from P1 to OFFLINE ASSEMBLY PROCESS; Transfer process of Clamp setting, Clamp assembly Visual/By two's inspection and measurement to CLAMP ASSEMBLY PROCESS due to new process distribution.(Please refer to ENGDRR-132 for Document revision request). Update table lay-out illustration and Quality pointers.	M Ariola	J. Loterte	C. Villanueva	A. Arañes			
01/26/23	4	Merge from P1 to P2 . Inclusion of Table 1 and Table 2 in process name; Quality checkpoints and inclusion of Batching quantity [9pcs] as countermeasure for audit findigns. Change table lay-out. Change process sequence of taping 2 ( Black Corrugated tube to Black twist tube) and clamp setting.	M Ariola	J. Loterte	C. Villanueva	A. Arañes			
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	March 11, 2022	



# WORK INSTRUCTION

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☐ PROTOTYPE

☐ PRE-LAUNCH



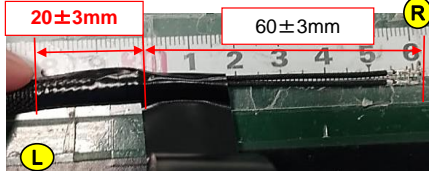
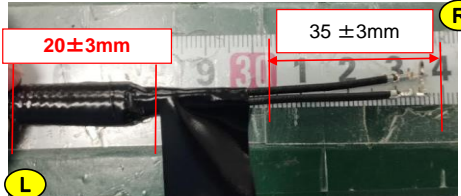
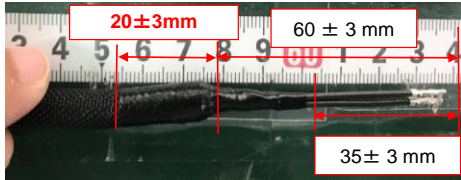

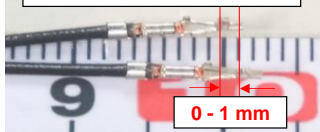
☒ MASSPRO

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PARTS:		1. Assy parts 2. Black Twisted tube 2420F ø5, t=0.5; L=85±4mm		3. Black tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Black Twisted tube 2420F ø5, t=0.5; L=85±4mm	<div><div><div>L</div><div>R</div></div><div>Get the Wire insertion <b>Black Twisted tube 2420F ø5, t=0.5; L=85±4mm</b> using right hand and insert to black wires</div></div>			n/a	1. No wrong usage of parts 2. No deformed terminal
3	n/a  Taping 1 Twisted tube to wire near terminal	<div><div><div>L</div><div>R</div></div><div>1. Hold the black twisted tube using left hand, get the <b>Black tape</b> then start the taping process using both hands.</div></div> <div><div><div>20±3mm</div><div>60±3mm</div><div>R</div></div><div>L</div><div>2. Hold the black twisted tube using left hand. Measure from twisted tube up to terminal pointed tip <b>60±3mm</b>.</div></div> <div><div><div>20±3mm</div><div>35 ±3mm</div><div>R</div></div><div>L</div><div>3. Hold the black twisted tube using left hand. Measure from twisted tube up to terminal pointed tip <b>35±3mm</b>.</div></div> <div><div><div>20±3mm</div><div>60 ± 3 mm</div><div>35± 3 mm</div></div><div>4. After taping check the measurement, wire alignment and taping condition.</div></div>			<div>MEASURING TAPE</div>  <div><b>Important reminders/Note/s:</b>  <b>1. Please use calibrated/ verified measuring tape when gerring the measurement.</b>  <div>Wire alignment tolerance</div><div>0 - 1 mm</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

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☐ PROTOTYPE

☐ PRE-LAUNCH

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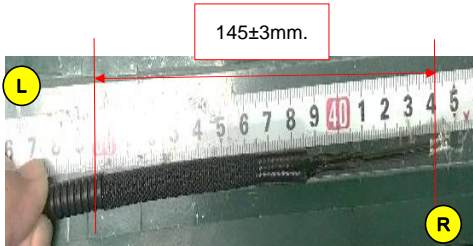

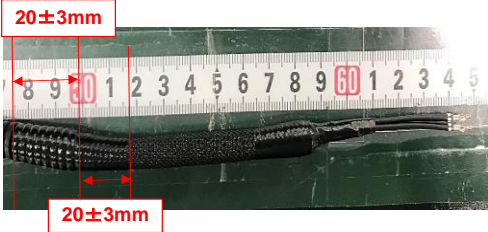

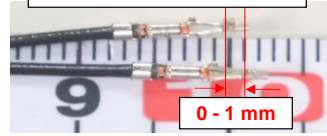
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PARTS:		1. Assy parts 2. Black tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	n/a	<p>Wire insertion to Black Corrugated tube to Black Twisted tube</p>  <p>1. Measure from end of COT up to terminal pointed tip <b>145±3mm</b>.</p>  <p>2. Hold the Assy part using left hand and get <b>Black tape</b> using right hand and start the taping process.</p>  <p>3. After taping, check the measurement and taping condition.</p>	<p><b>MEASURING TAPE</b></p> 	<p>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</p> <p><b>Important reminders/Note/s:</b></p> <p><b>1. Please use calibrated/ verified measuring tape when gerring the measurement.</b></p> <p><b>Wire alignment tolerance</b></p> 

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

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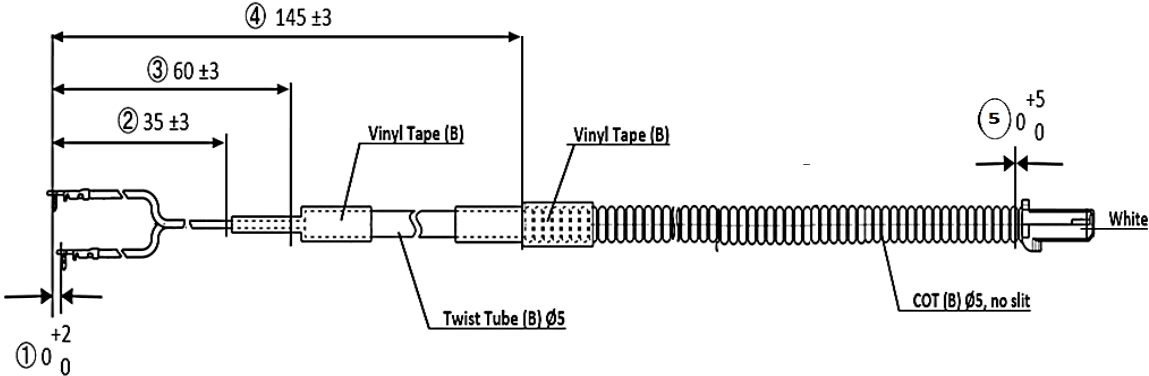
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	6 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	6 QUALITY POINTERS
5	n/a	Measurement		<div>MEASURING TAPE</div>  	<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated /verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection.</p> <p>1.No wrong dimension</p>

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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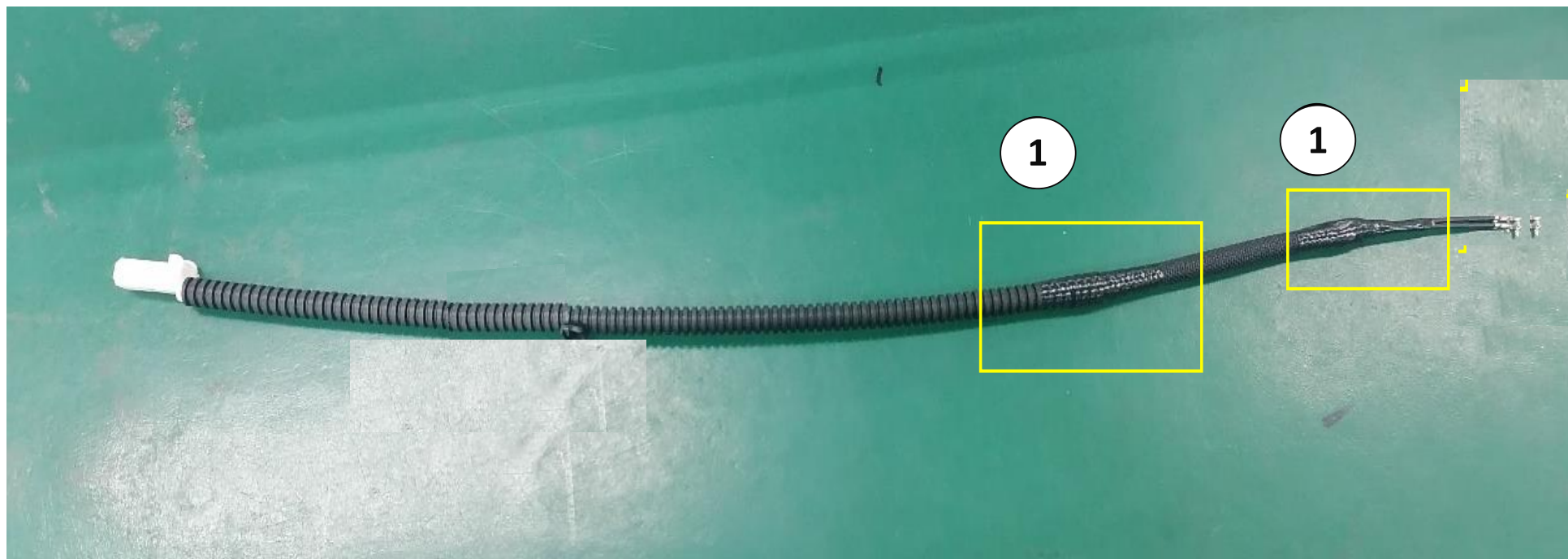
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PARTS:

n/a

JIG:

n/a

**VISUAL/QUALITY POINTERS****P1****7R0124-7020****No Missing Tape**

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