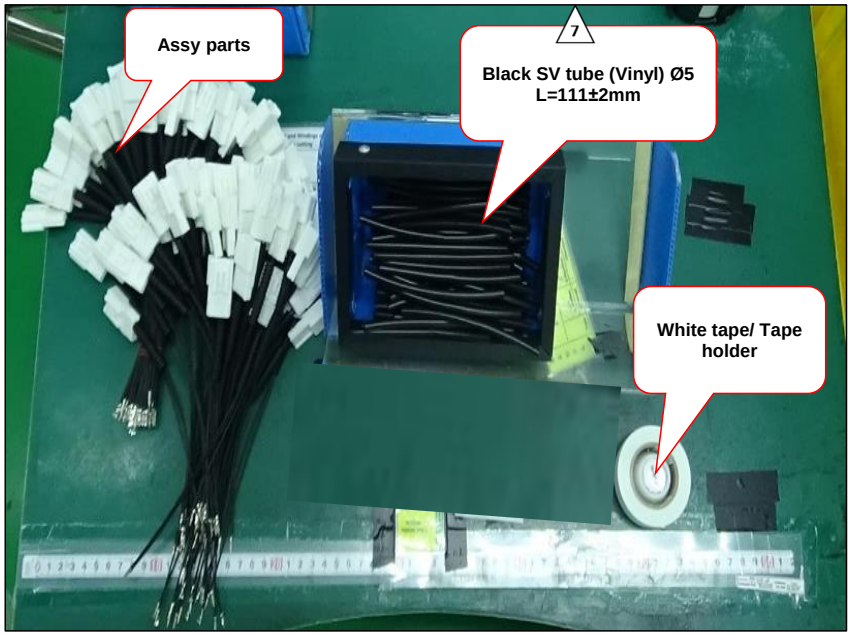
	WORK INSTRUCTION			Effectivity Date:	April 23, 2024		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number:	164B / 7M0546-7020C	Customer: TRJ	Car Model: TOYOTA-AURIS	Document No.:	WI-ENG-PDE-084	
	Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	7	Page No.: 1 of 5

PARTS: 7	1. All parts: Assy parts (Connector 6098-5668 (W); IRRAX A 0.3 B L=192mm [2pcs]; Black Corrugated tube (with slit) Ø5 L=39±2mm); Black SV tube (Vinyl) Ø5 L=111±2mm; White tape [1pc]	JIG:	1.Terminal cover jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	7 P1	Table Lay-out	**TABLE LAY-OUT**  	**Safety Instruction** Be sure to wear prescribed 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 references:*** ***1. Refer to WI-ENG-PDE-083 Offline Assembly Process*** 1.No missing parts/tools 2.No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
04/23/24	7	Inclusion of all improvements (Table lay-out; important reminders and note/s; Document references; By two's inspection and Car model"TOYOTA-AURIS"). Standardized tube description SV tube(vinyl). Transfer Wire insertion to corrugated tube process to Offline assembly process (WI-ENG-PDE-083). Update Measurement and Visual inspection.	D. Castillo	C. Villanueva	A. Arañes	n/a
07//07/21	6	Removal of marking.	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes
02/27/21	5	Remove cycle time; Change connector colors in accordance with color standardization for plastic parts; Put assy parts on pg 2; Change illustrations of wire insertion to connector; Put additional note on taping process Put measuring tape illustrations and instructions on measurement process	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes

Prepared by	Reviewed by	Approved by	Noted by
D. Castillo	C.Villanueva	A. Arañes	n/a
Est. Date:	July 2, 2018		

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PARTS:	1. Assy parts 2. Black SV tube (Vinyl) Ø5 L=111±2mm	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1	7 Wire insertion to Black SV tube(Vinyl) ø5 L=111±2mm	 1. Get the SV tube (Vinyl) ø5 L=111±2mm using right hand then insert the B-B wires. 	n/a	1. No wrong usage of parts 2. No deformed terminal

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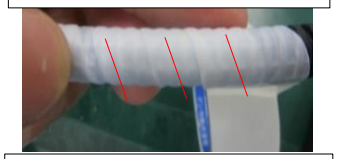
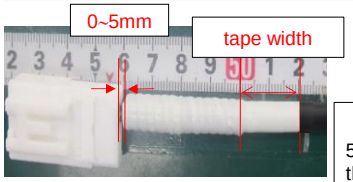
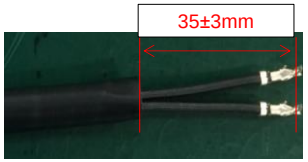
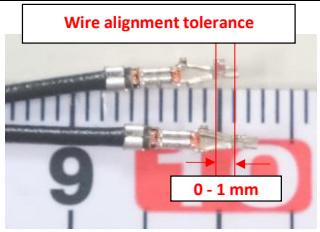
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 164B/ 7M0546-7020C	Customer: TRJ	Car Model: TOYOTA-AURIS	Document No.:	WI-ENG-PDE-084		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	7	Page No.:	3 of 5

PARTS:	1. White tape [1pc] 2. Assy parts	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1	Taping 1 From wire near connector to corrugated tube and from corrugated tube to SV tube (vinyl)	 1. Hold the connector using left hand and tape the wires using right hand, make 3 winds. 2. Hold the connector using left hand and insert the tape into COT ø5 With Slit using right hand. 3. After insertion of tape, Wind the tape 2 times before shifting. Make 1/2 shifting until it covers the COT. 1/2 Shifting visual reference  4. Fix the SV tube (vinyl)beside COT. Continue taping until tape width. Wind 3 times, then cut the tape.  5. After taping, check the condition of tape, measurement and wire alignment.  NOTE: This part is controlled based on the drawing.	MEASURING TAPE 	 1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong use of tape 5. No wrong dimension ***Important reminders/Note/s:*** ***1. Use WHITE TAPE only.*** ***2. Please use calibrated/verified measuring tape when getting the measurement.***

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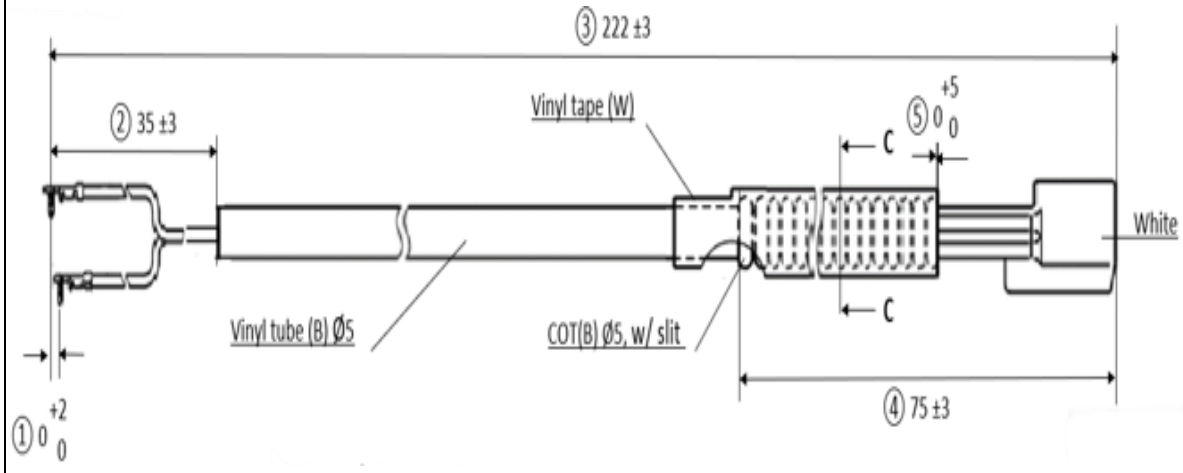
PARTS:	1. Assy parts	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1	Measurement		**Measuring tape**	***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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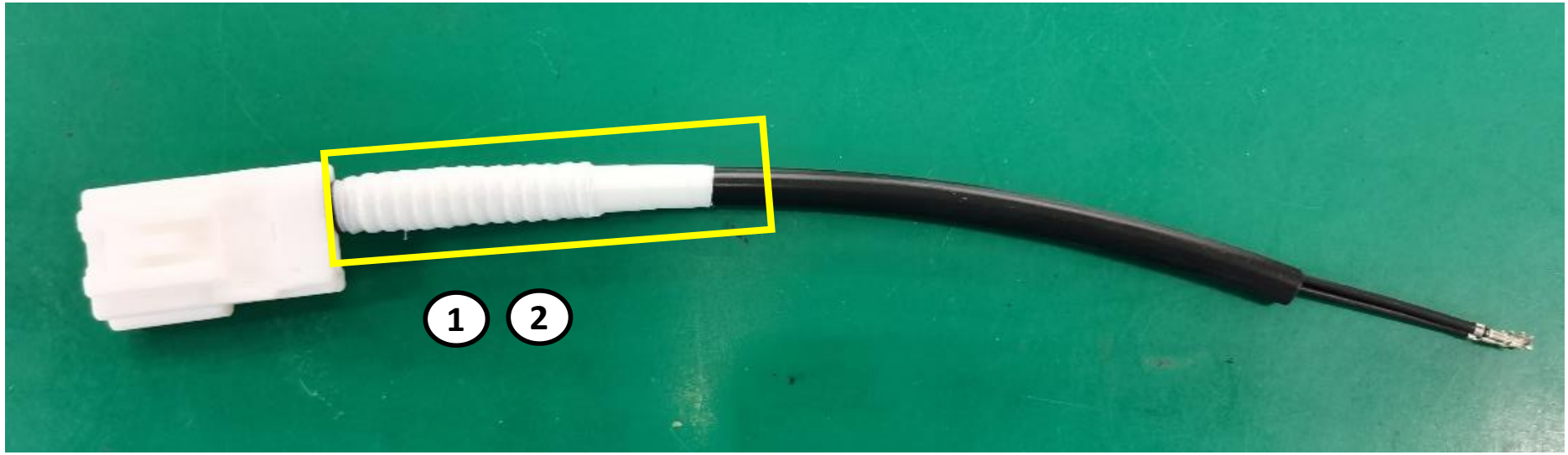
PARTS:	1. Assy parts	JIG:	n/a

7 **VISUAL INSPECTION**

TAPING-P1	7M0546-7020C



1 No Missing Tape

2 No Wrong use of tape

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