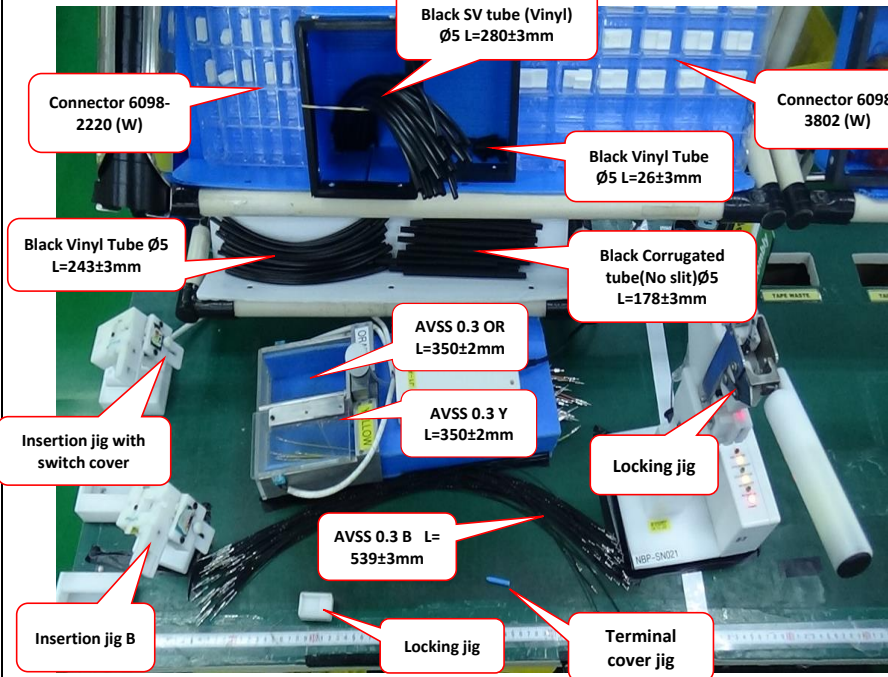
	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>May 29, 2024</b>		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>990B / 7N0142-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-PRUIS</b>	Document No.: <b>WI-ENG-PDE-453A</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		5	Page No.:	1 of 11

<b>PARTS:</b>		1. Connector 6098-2220 (W);Connector 6098-3802 (W) Black SV tube (Vinyl) Ø5 L=280±3mm; Black Vinyl Tube Ø5 L=26±3mm;Black Corrugated tube(No slit)Ø5 L=178±3mm; Black Vinyl Tube Ø5 L=243±3mm;AVSS 0.3 OR-Y L=350±2mm; AVSS 0.3 B L= 539±3mm			JIG:		1. Insertion jig with switch cover 2. Locking jig 3. Terminal cover jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>		<b>5 QUALITY POINTERS</b>	
1	P1  5  Table Lay-out	<div> <div>5</div> <div> <b>Table Lay-out</b>  </div> </div>			<div> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div> <b>Housekeeping</b>            1. Maintain and always practice 5's.            2. Personal things on the workplace is prohibited. Keep it in your locker.         </div> <div> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>		<b>Important reminders/Note/s:</b> <b>1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</b>  1. No missing parts/ tools. 2. No excess parts/ tools.	
Revision History					Prepared by	Reviewed by	Approved by	Noted by
05/29/24	5	Update new template and inclusion of Car mode "TOYOTA-PRUIS". Additional Work procedure/Illustration and notes on page 4-5 as countermeasure for the customer claim(Broken lock of Connector 6098-2220 (W). Split type process transfer to P2 of taping process for SV tube Ø5 L=243±3mm to Corrugated tube (No slit) Ø5 L=178±3mm .			A.Hernandez	C. Villanueva	A.Arañes	n/a
06/16/23	4	Changed Table lay-out; Change Quality Checkpoints; Inclusion of locking process- Connector 6098-2220 (W); Removed and transferred process of Taping 1: COT to wire near terminal to P2 due to new process distribution. Change position of Y-OR wires in switch cover to avoid crisscross.			M.Ariola	J. Loterte	C. Villanueva	A.Arañes
12/17/22	3	Improve Quality pointers; Reminders/notes and references on pages no.1,3,4,5,6,7,8,9,11 and 12 due to document improvement; Improve work procedure/ Illustration on process no.4 and 9 due to process improvement. Inclusion of Quality checkpoints.			M.Ariola	J. Loterte	C. Villanueva	A.Arañes
Eff. Date	Rev. No	Details of Change			Revised	Reviewed	Approved	Noted
					Est. Date:	March 15, 2022		

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# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

May 29, 2024

Process Name/Title:

Model code/Part number:

990B / 7N0142-7020A

Customer: TRJ

Car Model: TOYOTA-PRIUS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-453A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

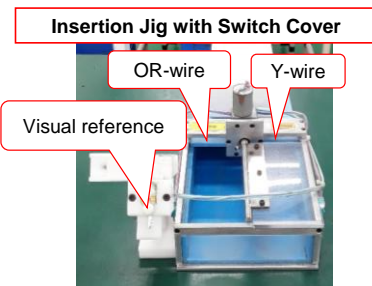

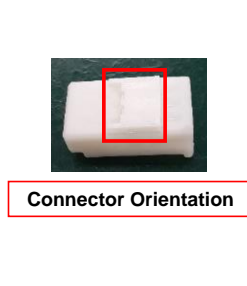
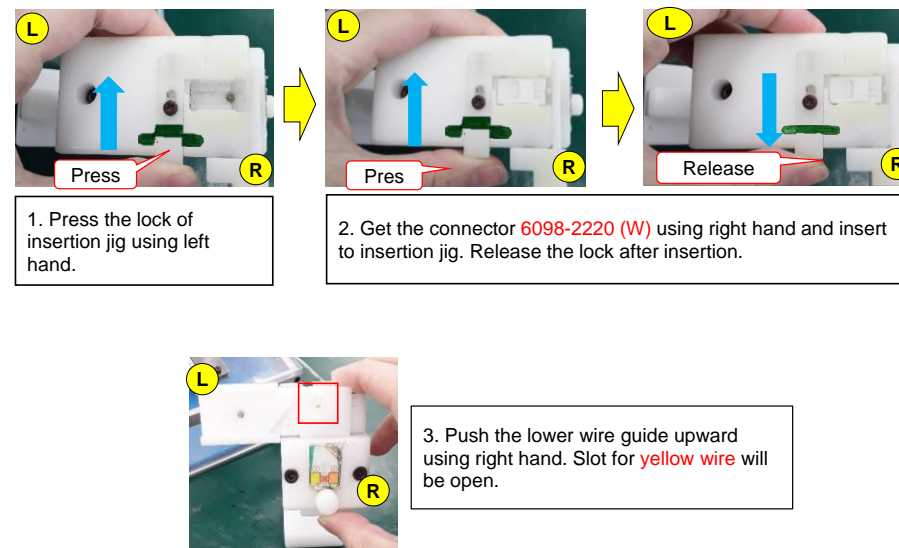
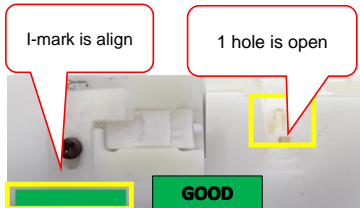
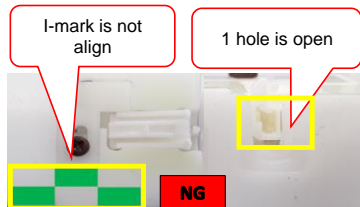
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Revision No.:

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PARTS:		1. Connector 6098-2220 (W)		JIG:	1. Insertion jig w/ switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<p>Connector setting to insertion jig 6098-2220 (W)</p>     <p>1. Press the lock of insertion jig using left hand.</p> <p>2. Get the connector 6098-2220 (W) using right hand and insert to insertion jig. Release the lock after insertion.</p> <p>3. Push the lower wire guide upward using right hand. Slot for yellow wire will be open.</p>		n/a	<p><b>CONNECTOR ORIENTATION ILLUSTRATION</b></p>   <p>1. Use the provided jig per model</p> <p>2. No wrong orientation of connector</p>

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# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

May 29, 2024

Process Name/Title:

Model code/Part number:

990B / 7N0142-7020A

Customer: TRJ

Car Model: TOYOTA-PRIUS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-453A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


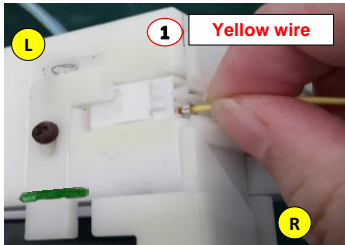
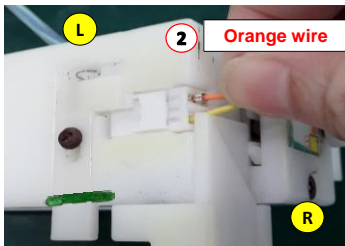
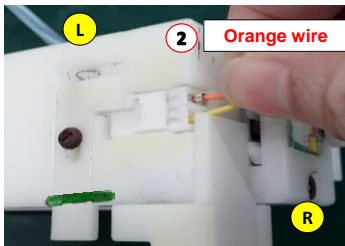
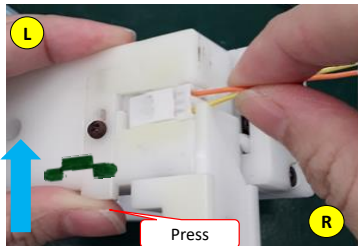
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PARTS:		1. Connector 6098-2220 (W) 2. AVSS 0.3 OR L=350±2mm; AVSS 0.3 Y L=350±2mm		JIG:	1. Insertion jig w/ Switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1  Wire Insertion to Connector 6098-2220 (W)	<div><div><div>Wire facing</div></div><div><div><div>1 Yellow wire</div></div><div><div>2 Orange wire</div></div></div><div><div><div>3</div></div><div><div>Press</div></div></div></div>		n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>Important reminders/Note/s:</div> <div>1. Please hold the wire near terminal during insertion. 2. Insertion of wire must be from left to right. 3. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>

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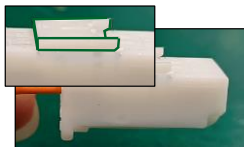
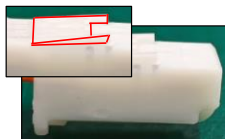
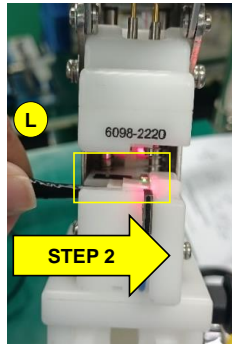
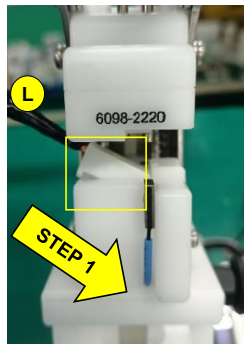
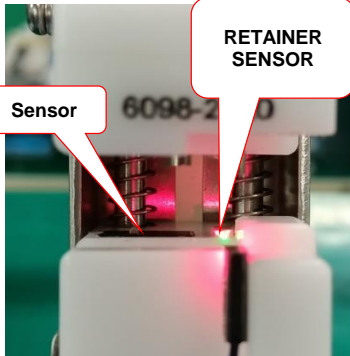
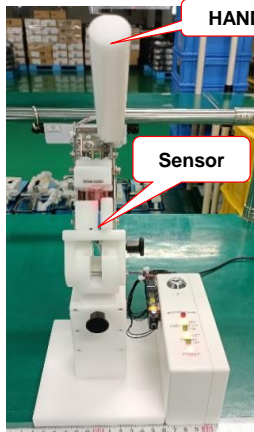
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WORK INSTRUCTION  
TAPING ASSEMBLY PROCESS

Effectivity Date:	May 29, 2024		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-453A		
Revision No.:	5	Page No.:	4 of 11

Process Name/Title:	TAPING ASSEMBLY PROCESS		
Model code/Part number:	990B / 7N0142-7020A	Customer:	TRJ
Car Model:	TOYOTA-PRIUS		
Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO

PARTS:	1. Assy parts			JIG:	1. Locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION 5			TOOLS/PPE	5 QUALITY POINTERS
4	P1	Connector lock	<div><div>CONNECTOR RETAINER ILLUSTRATION SIDE VIEW</div><div><div></div><div></div></div><div><p>1. Check the Retainer lock of connector before insertion to locking jig. <i>Note: Must be <b>NO</b> half-locked condition prior connector locking.</i></p></div></div> <div><div></div><div><p>2. Hold the assy parts using left hand and insert into connector locking jig based on the direction of arrow. Make sure the connector touch the sensor. Sound will be heard if properly lock. <i>NOTE: CONNECTOR LOCKING JIG WILL NOT FUNCTION IF CONNECTOR NOT REACH THE SENSOR.</i></p></div></div>			<div><p>1. Please ensure that Connector lock/retaine will not touch or hit by any object prior insertion into locking jig to avoid half-lock connector.</p><p>2. Maintain 10mm proper holding of wire to connector</p><p>3. Connector must be fully inserted to connector slot.</p><p>4. Make sure no offset setting before locking process.</p><p>5. No wrong setting of connector.</p><p>6. No damaged connector lock</p><p>7. No unlocked/ half-locked connector.</p></div> <div><p><b>Important reminders/Note/s:</b></p><p>1. <i>Incomplete locking process will alarm the jig.</i></p><p>2. <i>No retainer in connector cannot proceed.</i></p><p>3. <i>If encountered abnormality, <b>STOP</b> and immediately <b>CALL</b> the attention of the leader. <b>WAIT</b> for further instruction and continue the process.</i></p></div>

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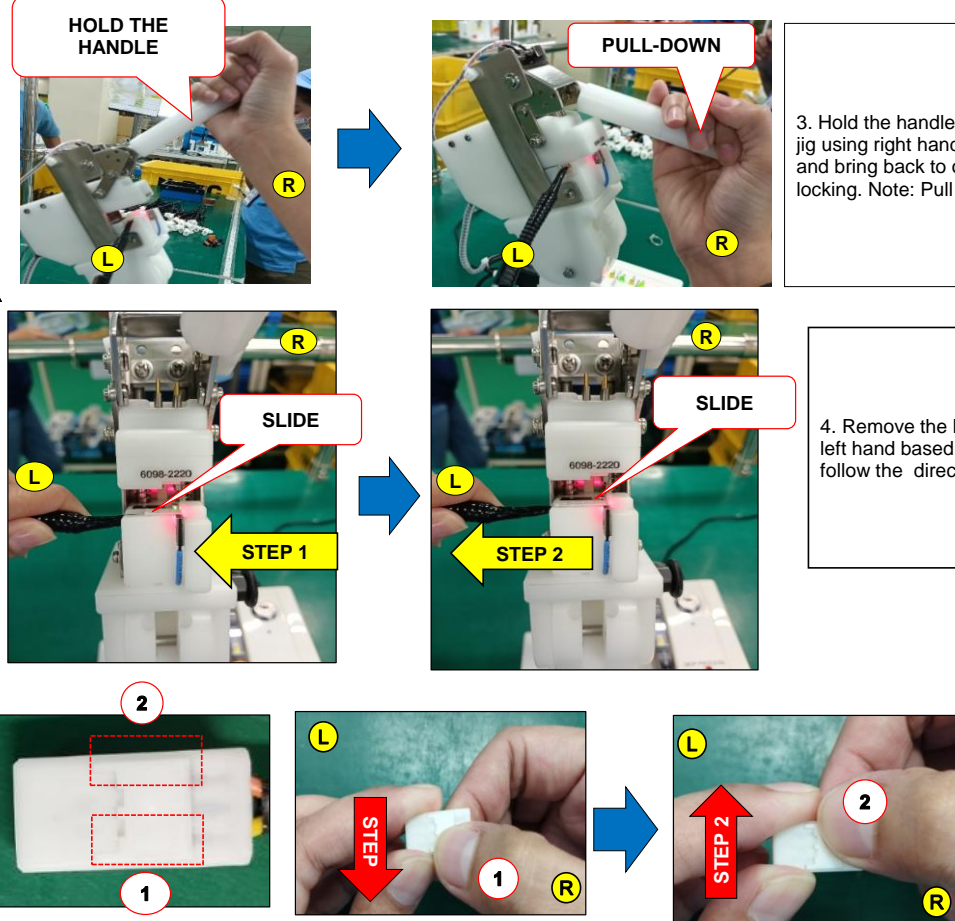




WORK INSTRUCTION  
TAPING ASSEMBLY PROCESS

Effectivity Date:	May 29, 2024		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-453A		
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Process Name/Title:	TAPING ASSEMBLY PROCESS		
Model code/Part number:	990B / 7N0142-7020A	Customer:	TRJ
Car Model:	TOYOTA-PRIUS		
Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO

PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1 Connector lock (Continuation)	<p><b>5</b></p> 	<p>3. Hold the handle of the connector locking jig using right hand then gently pull down and bring back to original position after locking. Note: Pull down one time only.</p> <p>4. Remove the locked connector using left hand based on the illustration, follow the direction of arrow.</p> <p>5. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p>	<p>1. Please ensure that Connector lock/retainer will not touch or hit by any object prior insertion into locking jig to avoid half-lock connector.</p> <p>2. Maintain 10mm proper holding of wire to connector</p> <p>3. Connector must be fully inserted to connector slot.</p> <p>4. Make sure no offset setting before locking process.</p> <p>5. No wrong setting of connector.</p> <p>6. No damaged connector lock</p> <p>7. No unlocked/ half-locked connector</p> <p><b>Important reminders/Note/s:</b></p> <p>1. <i>Incomplete locking process will alarm the jig.</i></p> <p>2. <i>No retainer in connector cannot proceed.</i></p> <p>3. <i>If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</i></p>

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Effectivity Date:

May 29, 2024

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Validity Date:

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Model code/Part number:

990B / 7N0142-7020A

Customer: TRJ

Car Model: TOYOTA-PRIUS

Document No.:

WI-ENG-PDE-453A

Purpose:


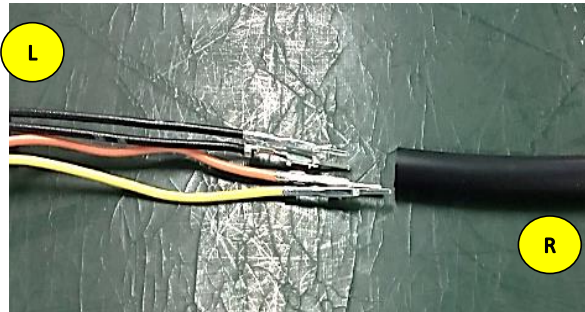
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<b>PARTS:</b>		1. Assy parts	3. Black SV tube (Vinyl ) Ø5 L=26±3mm	JIG:	n/a
		2. Black SV tube (Vinyl ) Ø5 L=280±3mm			
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
5	P1	Wire Insertion to black SV tube (Vinyl ) Ø5 L=280±3mm and Ø5 L=26±3mm		n/a	1. No wrong use of parts.
6		Wire Insertion to black Vinyl tube Ø5 L=26±3mm		n/a	<b>Document reference/s:</b>  1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.  1. No wrong use of parts.

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**WORK INSTRUCTION**

Effectivity Date:

May 29, 2024

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Validity Date:

n/a

Model code/Part number:

900B/910B / 7N0147-7020A

Customer: TRJ

Car Model: TOYOTA-PRIUS

Document No.:

WI-ENG-PDE-453A

Purpose:


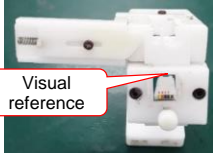
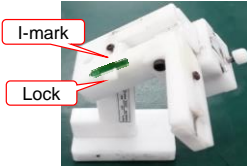



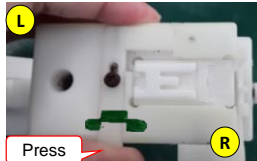
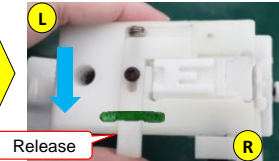
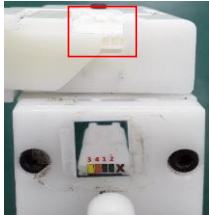

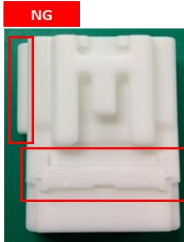
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PARTS:	1. Connector 6098-3802(W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1  Connector setting to insertion jig 6098-3802 (W)	<div><div>Wire facing</div></div> <div><div><div>Insertion Jig</div><div>Visual reference</div></div><div><div>I-mark</div><div>Lock</div></div><div><div>Connector Orientation</div></div><div><div>Insertion Jig Orientation</div></div></div> <div><div><div>L</div><div>R</div><div>Press</div></div><div><div>L</div><div>R</div><div>Press</div></div><div><div>L</div><div>R</div><div>Release</div></div></div> <div><div>1. Press the Lock of insertion jig using left hand.</div><div>2. Get the connector 6098-3802 (W) using right hand and insert to insertion jig. Release the lock after insertion.</div></div> <div><div><div>3. Do not push the lower wire guide upward. Slot for 2 Black wires must be open.</div></div></div>	n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div><div>CONNECTOR ILLUSTRATION</div><div><div><div>GOOD</div><div>6098-3802 (W)</div></div><div><div>NG</div><div>6098-5668 (W)</div></div></div></div>

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## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number: 900B/910B / 7N0147-7020A

Customer: TRJ

Car Model: TOYOTA-PRIUS

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

May 29, 2024

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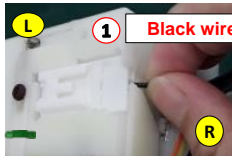
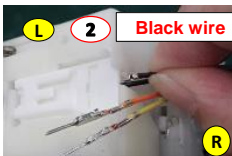
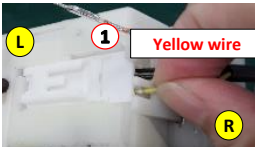
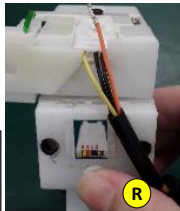


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PARTS:		1. AVSS 0.3 B L= 539±3mm; AVSS 0.3 Y L=350±2mm; AVSS 0.3 OR L=350±2mm (Assy Parts)		JIG:	1. Insertion Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1  Wire insertion to Connector 6098-3802 (W)	<div><div>Wire facing</div></div> <div><div>1. Hold the insertion jig using left hand. Insert the 2 Black wires one by one to connector using right hand.</div></div> <div><div>2. Press the lower wire guide using right thumb. Slot for Yellow wire will be open.</div></div> <div><div>3. Get the Yellow wire then insert to terminal slot 1 using right hand.</div></div> <div><div>4. Press the button using right thumb. Slot for Orange wire will be open.</div></div> <div><div>5. Get the Orange wire then insert to terminal slot 2 using right hand.</div></div> <div><div>6. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</div></div>		n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div><b>Important reminders/Note/s:</b>  <i>1. Please hold the wire near terminal during insertion.</i> <i>2. Insertion of wire must be from left to right.</i> <i>3. Make sure wires are properly inserted.</i> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b></div> <div><b>Document reference/s:</b>  <i>1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</i> <i>2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i></div>

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

Effectivity Date:

May 29, 2024

Process Name/Title:

Model code/Part number:

990B / 7N0142-7020A

Customer: TRJ

Car Model: TOYOTA-PRIUS

Validity Date:

n/a

Document No.:

WI-ENG-PDE-453A

Purpose:






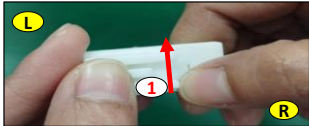
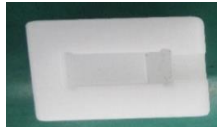
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1	Connector Lock	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div> <div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div> <div><p>Right thumb-Lower Left thumb-middle</p><p>3. Press the lower parts of connector using right hand while left hand holding the middle.</p></div> <div><p>Right thumb-upper Left thumb-middle</p><p>4. Press the upper part of connector using right hand while left hand holding the middle.</p></div> <div><p>Right thumb-middle Left thumb-middle</p><p>5. Lift then press the connector in the middle using left and right hand.</p></div> <div><p>6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div>	<div><b>LOCKING JIG</b></div> 	<b>Important reminders/Note/s:</b> <b>1.MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR LOCK.</b>  1. Use the provided locking jig per model 2. No unlock/half-lock connector

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

Effectivity Date:

May 29, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

990B / 7N0142-7020A

Customer: TRJ

Car Model: TOYOTA-PRIUS

Document No.:

WI-ENG-PDE-453A

Purpose:

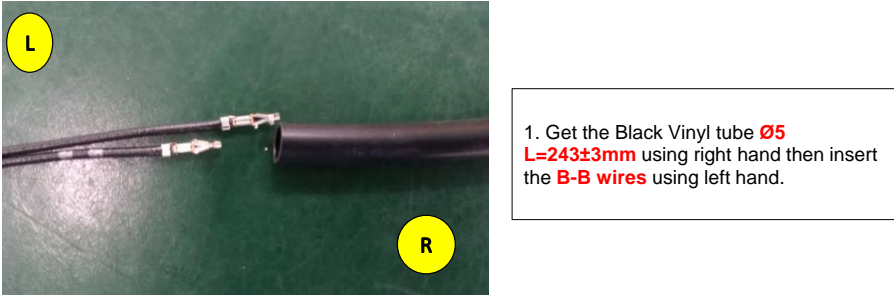
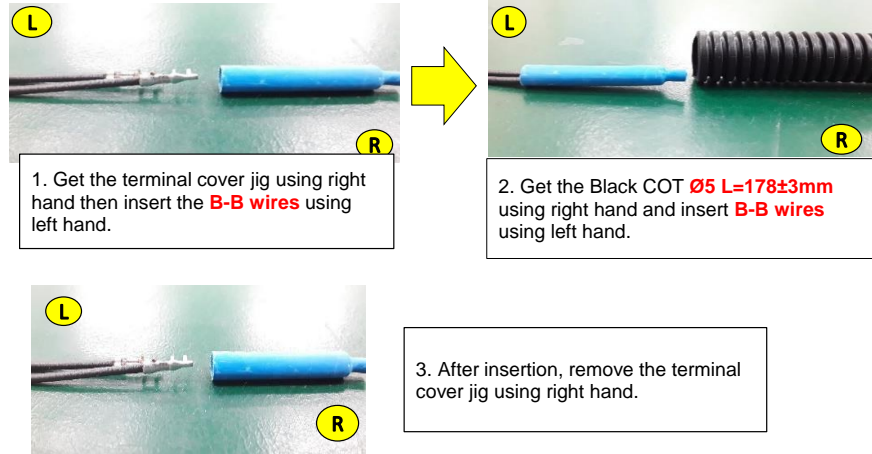

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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<b>PARTS:</b>	1. Assy parts 2. Black Vinyl Tube Ø5 L=243±3mm 3. Black Corrugated tube (No slit) Ø5 L=178±3mm		JIG:	1. Terminal cover jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
10	Wire Insertion to Black Vinyl Tube Ø5 L=243±3mm		n/a	1. No wrong use of parts.
11	P1 Wire insertion to Black Corrugated tube (No slit) Ø5 L=178±3mm			1. No wrong use of parts 2. No deformed terminal

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

May 29, 2024

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n/a

Model code/Part number:

**990B / 7N0142-7020A**Customer: **TRJ**Car Model: **TOYOTA-PRIUS**

Document No.:

**WI-ENG-PDE-453A**

Purpose:

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Revision No.:

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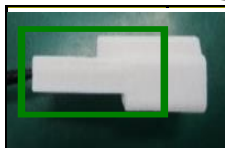
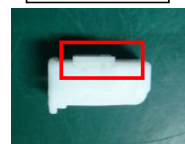
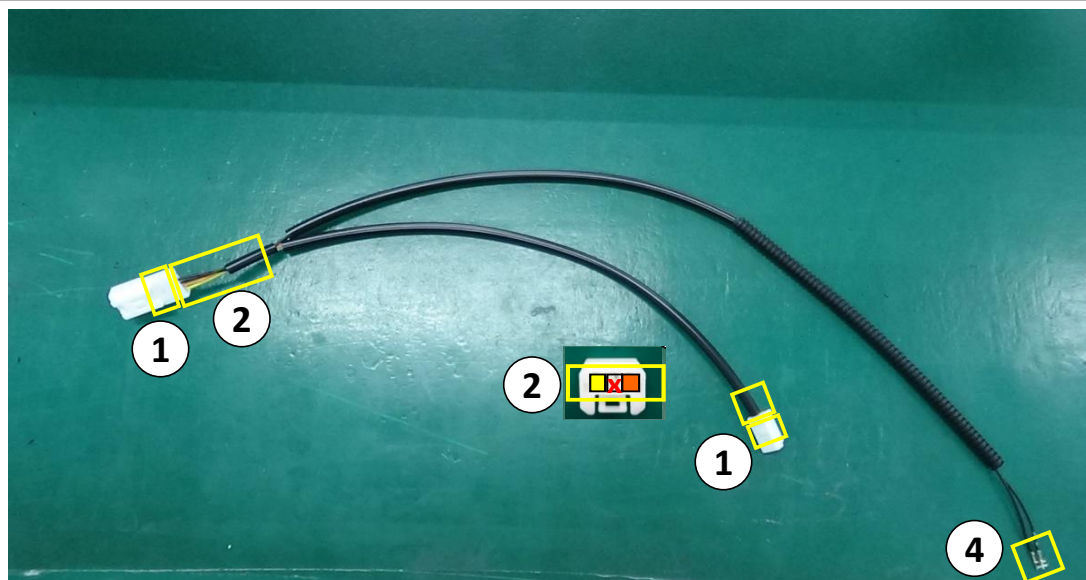
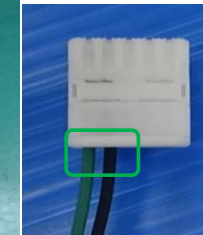
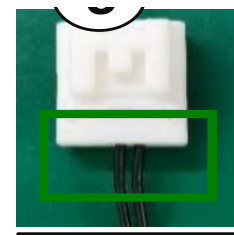
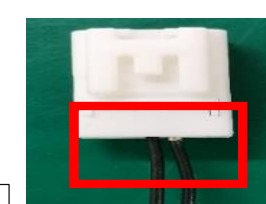
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PARTS:

n/a

JIG:

n/a

**VISUAL INSPECTION/QUALITY CHECKPOINTS****P1****7N0142-7020A****1****GOOD****GOOD****NO GOOD****NO GOOD****5****GOOD****GOOD****NO GOOD****NO GOOD****1** No **Unlock/ Halflock Connector****4** No **Deformed Terminal****2** No **Wrong Insert****5** No **Terminal Backing Out**

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