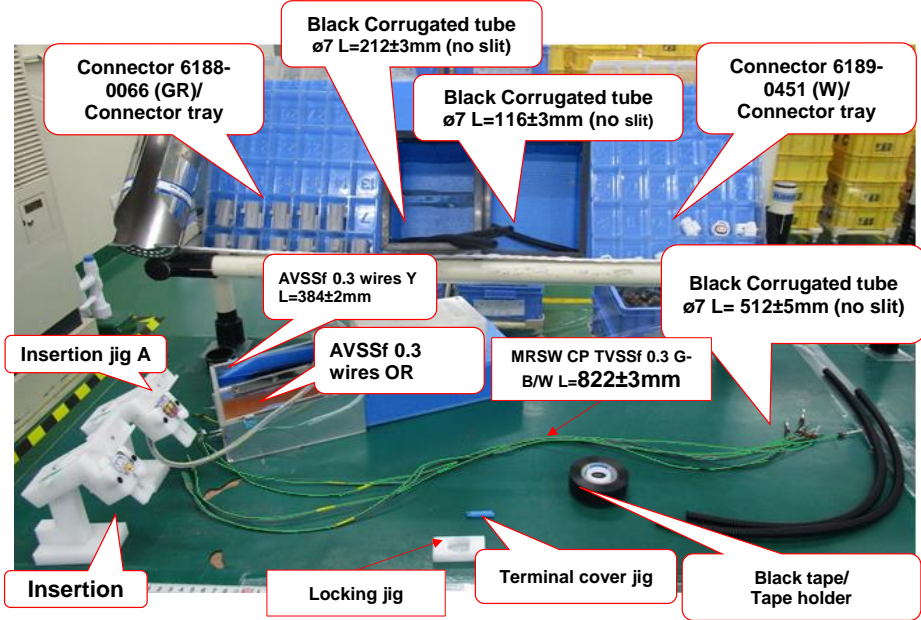



	WORK INSTRUCTION				Effectivity Date:	November 13, 2024		
	TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Process Name/Title:		Model code/Part number: 178D / 7N0129-7021C	Customer: TRJ	Car Model: TOYOTA-COROLLA	Document No.:	WI-ENG-PDE-1162A	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	1	Page No.: 1 of 10

PARTS:	1. All parts: Connector 6188-0066 (GR); AVSSf 0.3 wires Y-OR L=384±2mm; Black Corrugated tube ø7 L=212±3mm (no slit); Black Corrugated tube ø7 L=116±3mm (no slit); Connector 6189-0451 (W); MRSW CP TVSSf 0.3 G-B/W L=822±3mm; Black Corrugated tube ø7 L=512±5mm (no slit); Black tape [1pc.]	JIG:	1. Insertion jig with switch cover 2. Locking jig 3. Terminal cover jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Table Lay-out	<div style="text-align: center;"> Table Lay-out  </div>	<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> 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 solid red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance . 2. Refer to WI-PRO-KIT-005 Wire Taping without Vinyl Tube 1. No missing parts/tools 2. No excess parts/tools

Revision History							Prepared by	Reviewed by	Approved by	Noted by
							 A. Hernandez	 C. Villanueva	 A. Arañes	n/a
11/13/24	1	Change pre-launch to mass pro.	A.Hernandez	C.Villanueva	A. Arañes	N/A				
11/12/24	0	Initial issue.	A.Hernandez	C.Villanueva	A. Arañes	N/A				
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted	Est. Date:	November 12, 2024	

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

178D / 7N0129-7021C

Customer: TRJ

Car Model: TOYOTA-COROLLA

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

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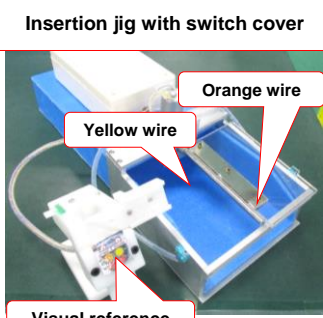
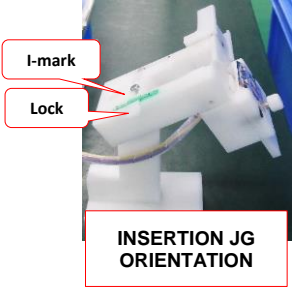

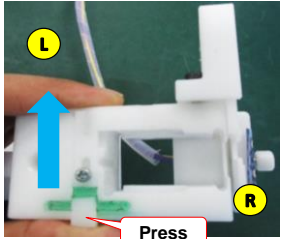
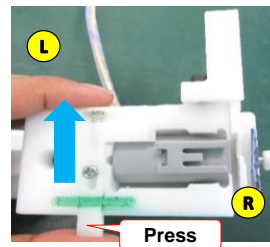
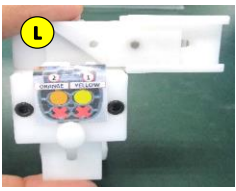
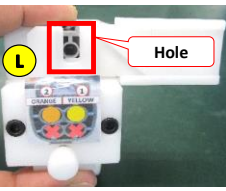
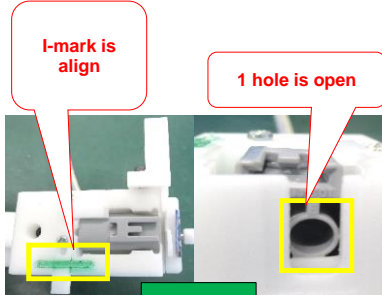
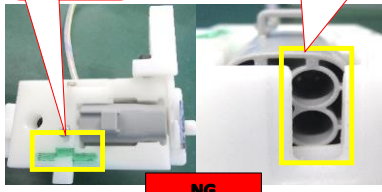
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1

Page No.:

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PARTS:		1. Connector 6188-0066 (GR)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<p>Connector setting to insertion jig 6188-0066 (GR)</p>  <p>Visual reference</p>  <p>INSERTION JG ORIENTATION</p>  <p>CONNECTOR ORIENTATION</p>  <p>Press</p>  <p>Release</p>  <p>Press</p>  <p>Hole</p> <p>1. Press the lock using left thumb.</p> <p>2. Get the connector 6188-0066 (GR) using right hand and insert to insertion jig. Release the lock after insertion. Note: Follow the connector orientation.</p> <p>3. Push the lower wire guide upward using left thumb. Slot for Yellow wire will be opened.</p>		n/a	<p>CONNECTOR ORIENTATION ILLUSTRATION</p>  <p>I-mark is align</p> <p>1 hole is open</p> <p>GOOD</p>  <p>I-mark is not align</p> <p>2 holes are open</p> <p>NG</p> <p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


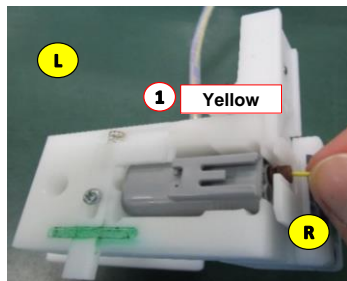
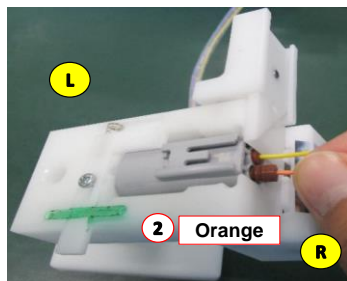
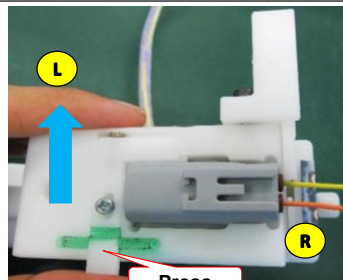
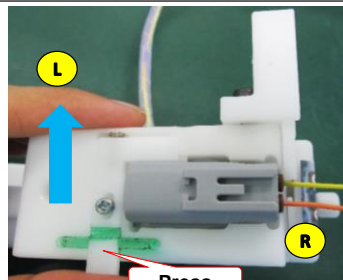
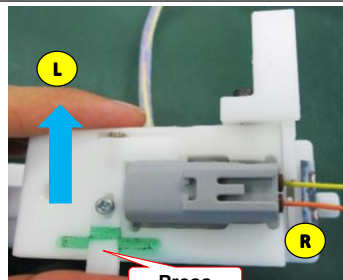
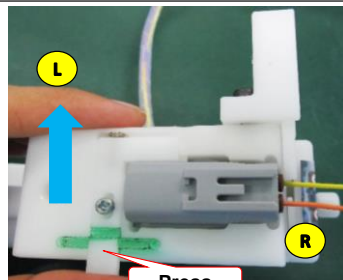
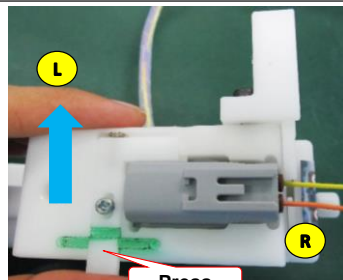
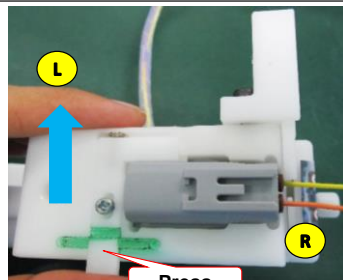
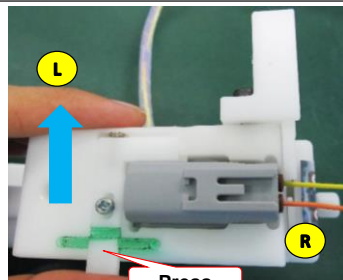
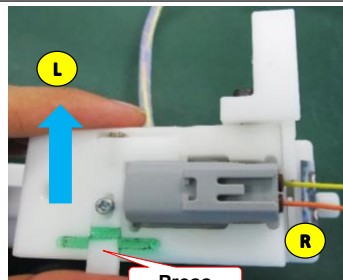
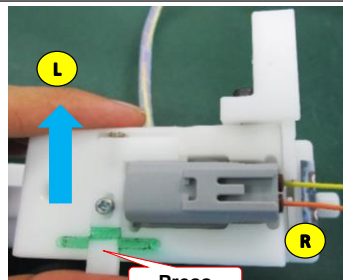
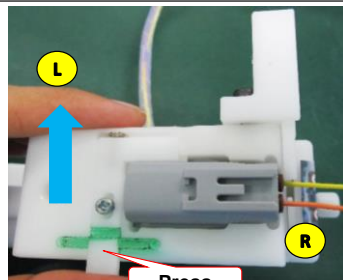
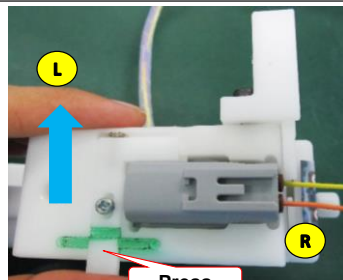
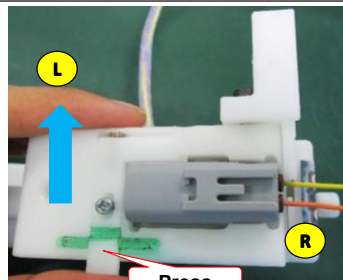
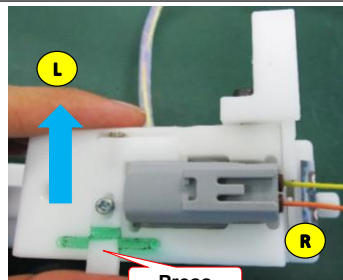
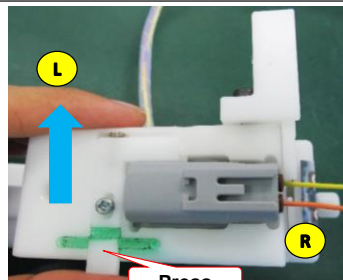
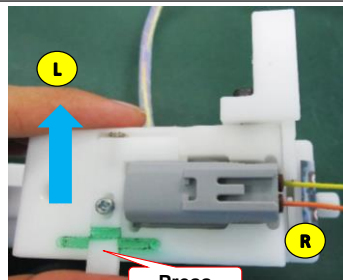
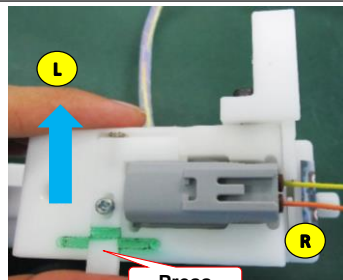
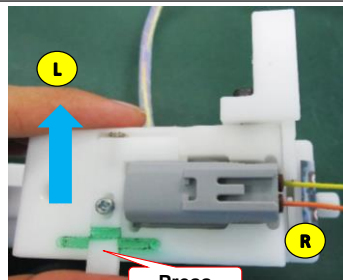
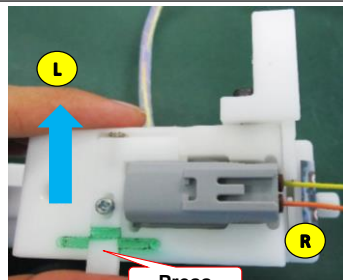
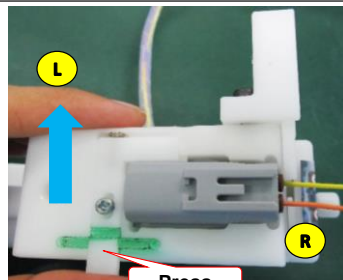
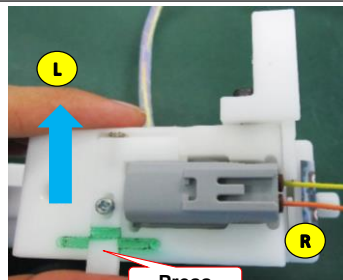
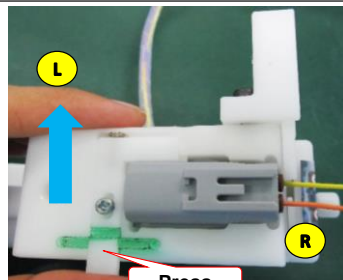
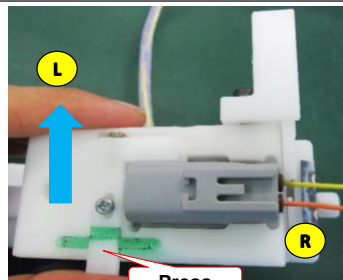
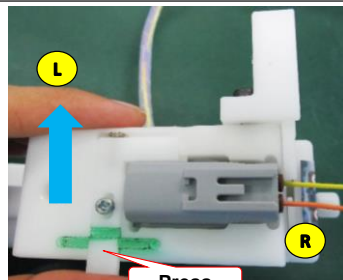
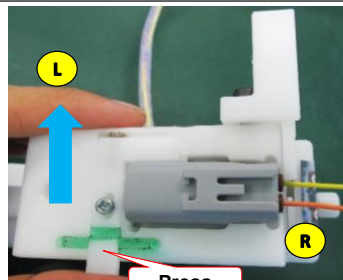
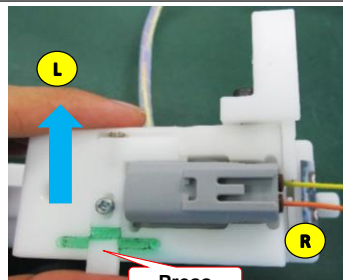
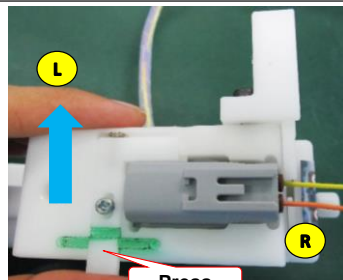
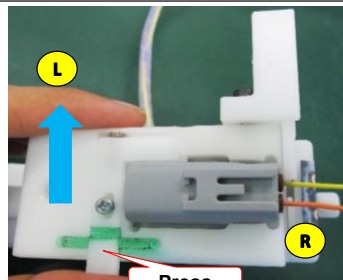
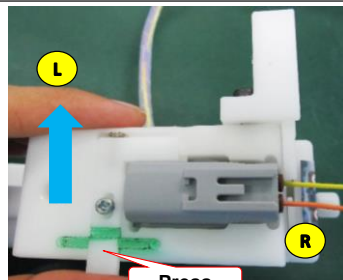
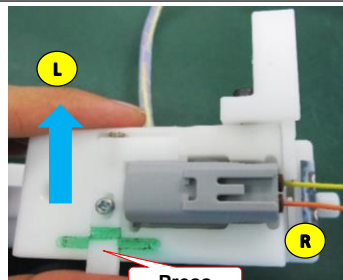
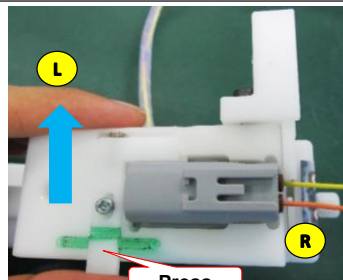
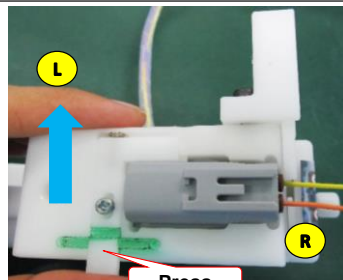
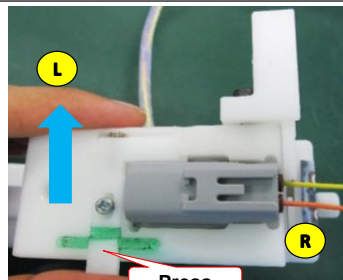
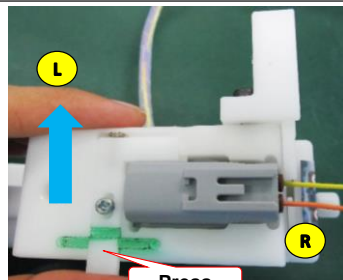
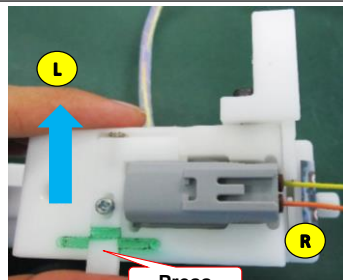
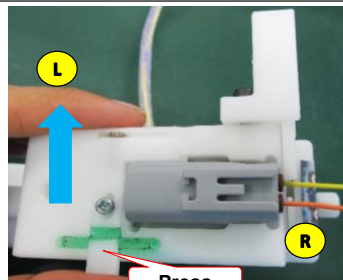
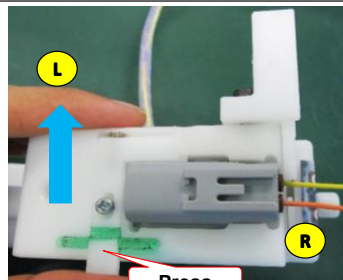
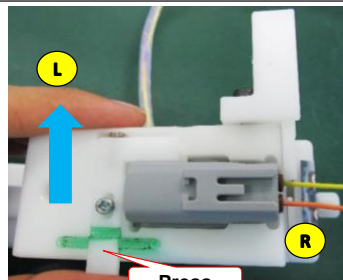
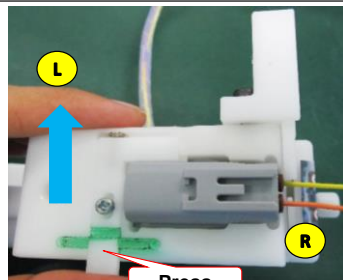
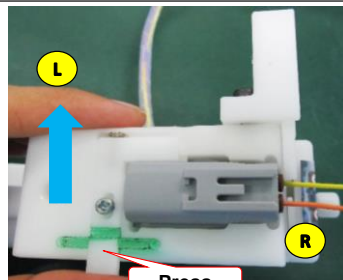
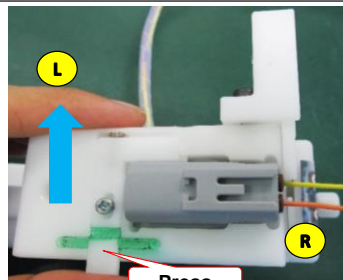
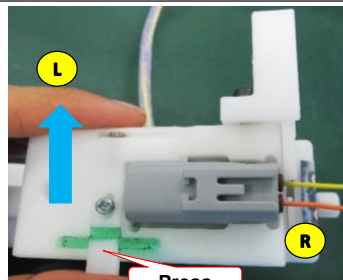
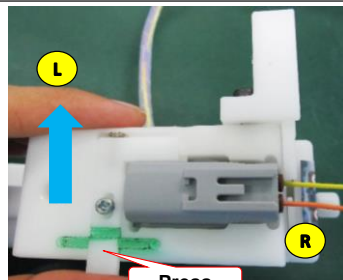
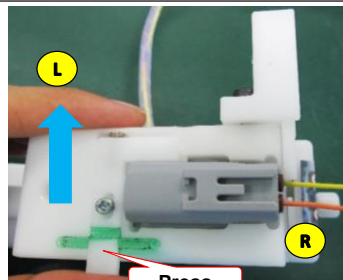
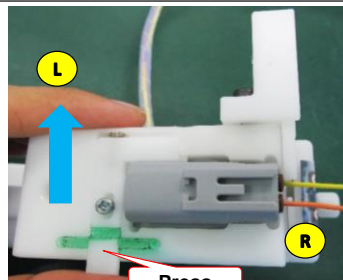
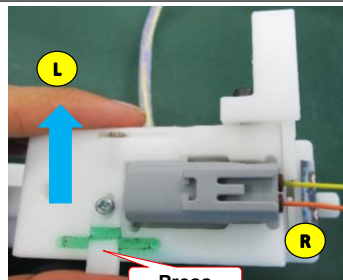
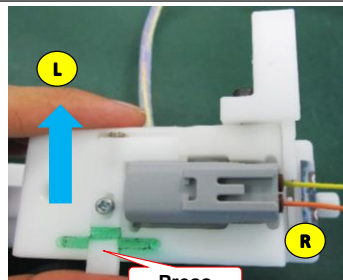
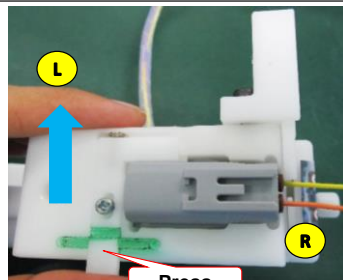
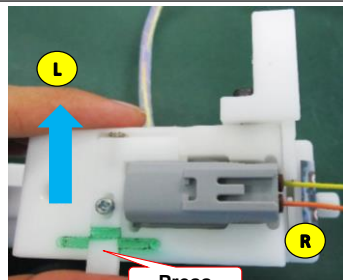
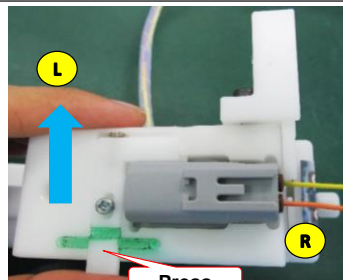
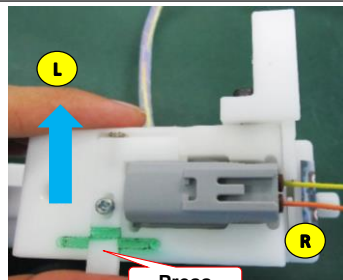
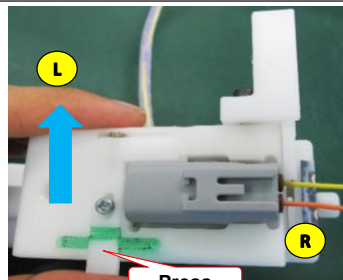
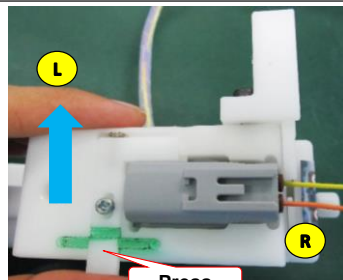
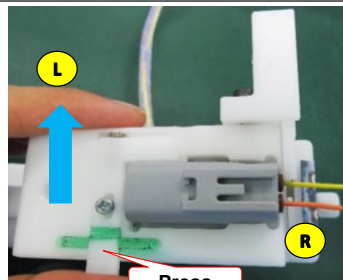
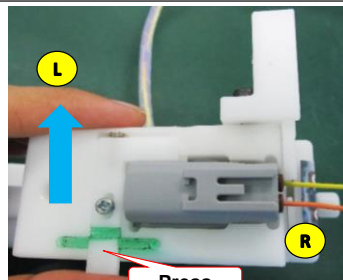
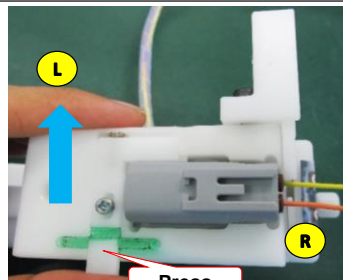
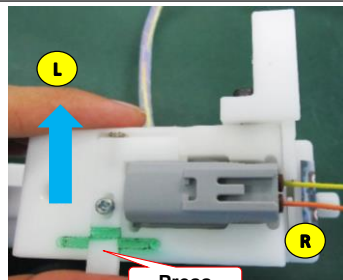
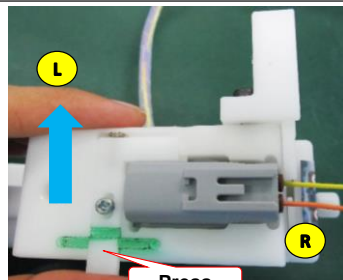
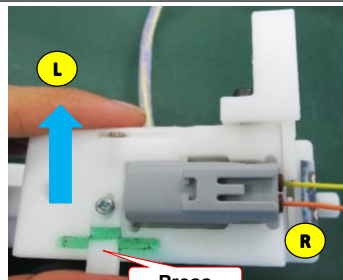
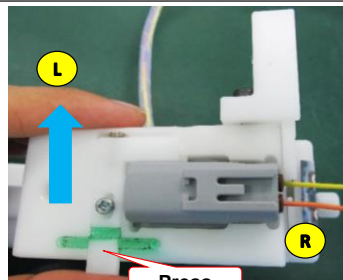
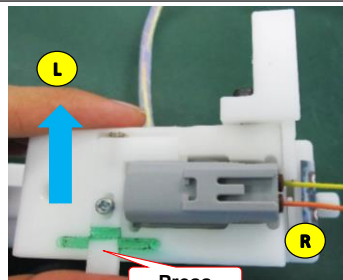
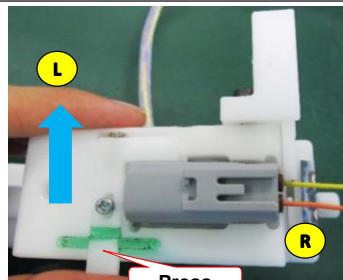
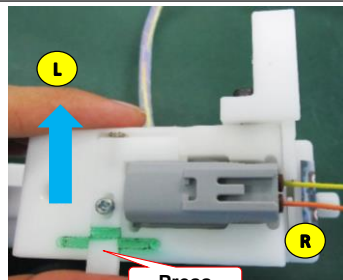
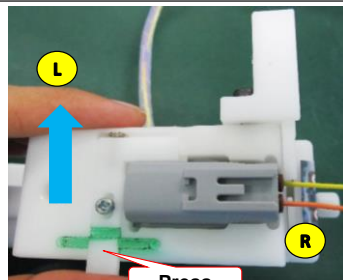
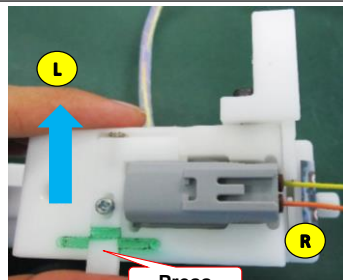
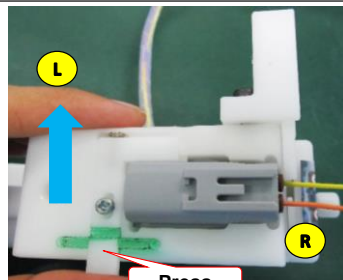
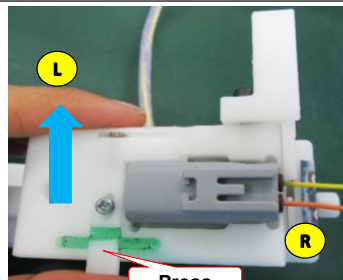
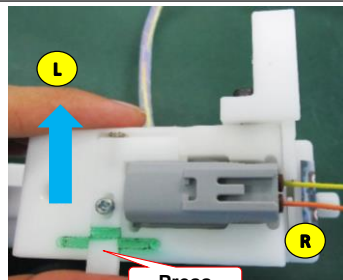
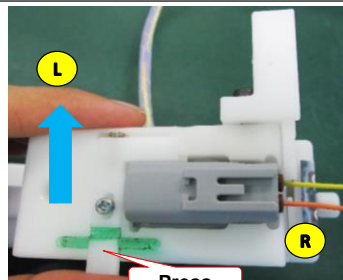
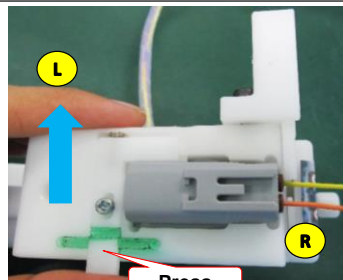
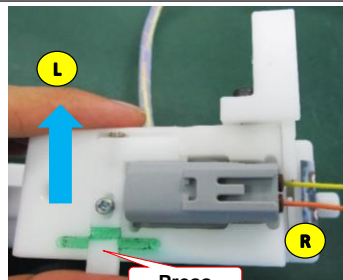
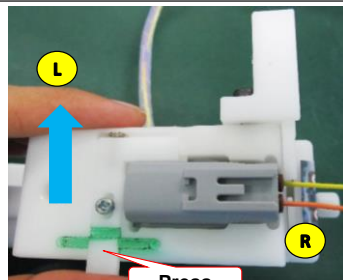
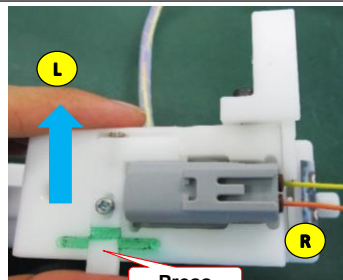
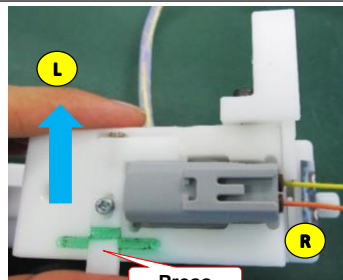
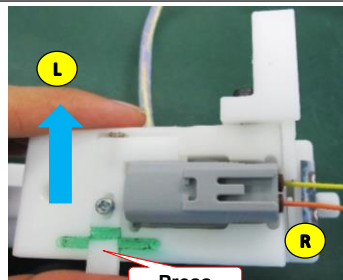
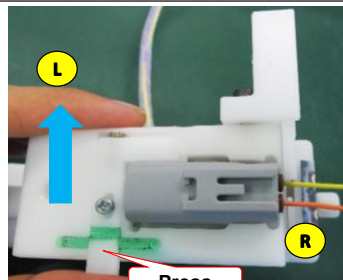
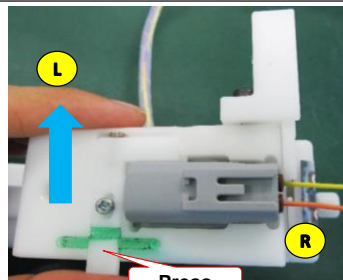
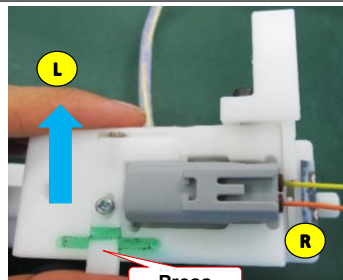
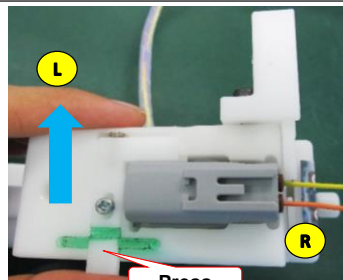
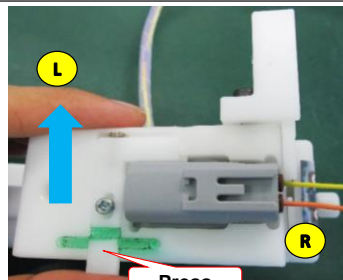
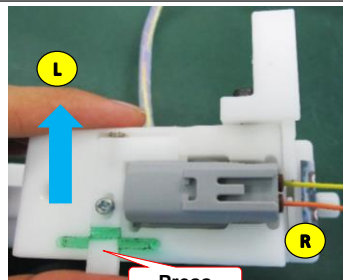
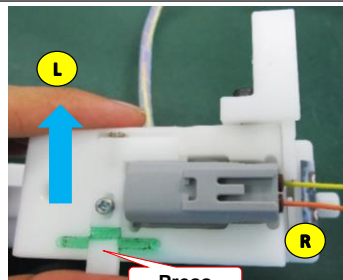
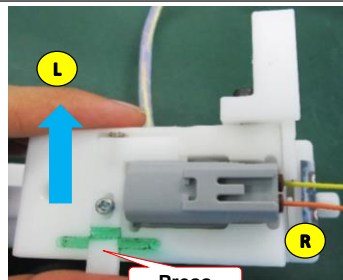
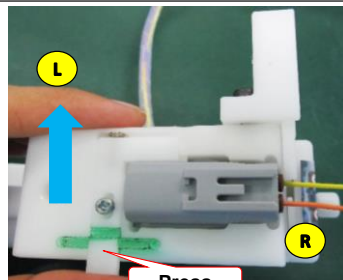
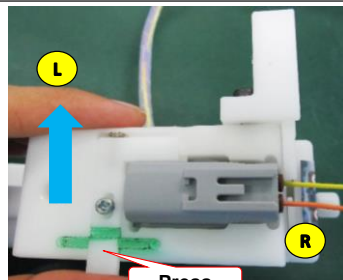
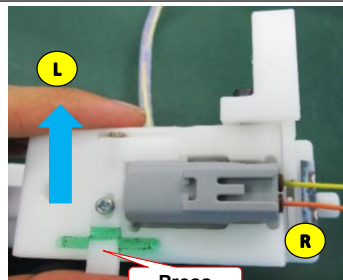
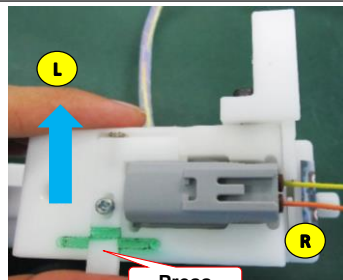
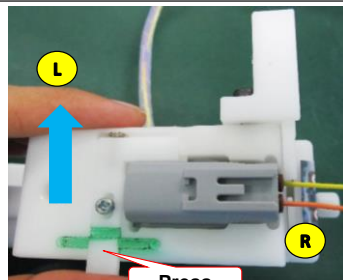
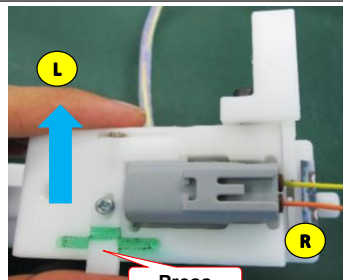
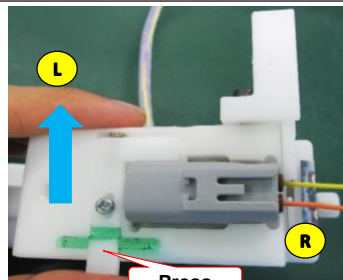
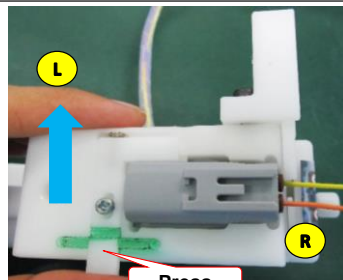
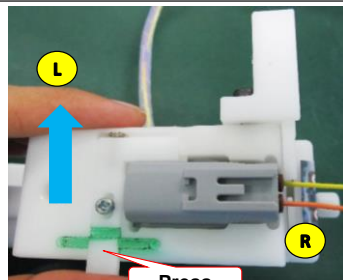
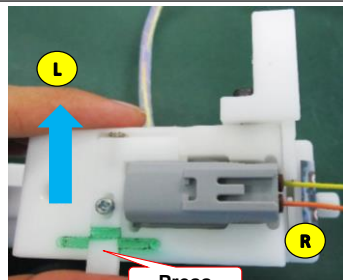
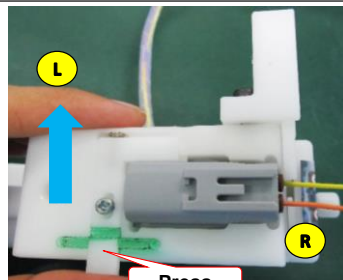
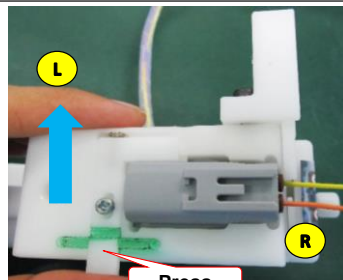
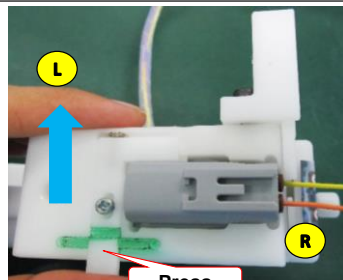
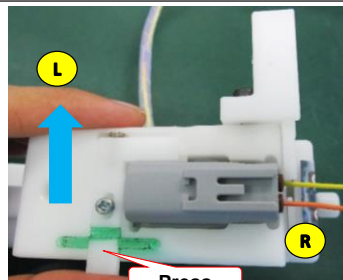
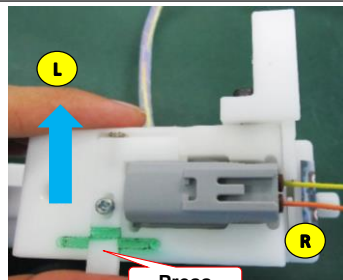
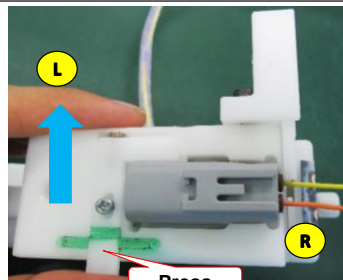
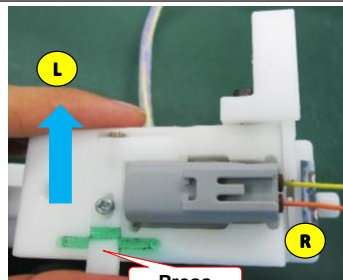
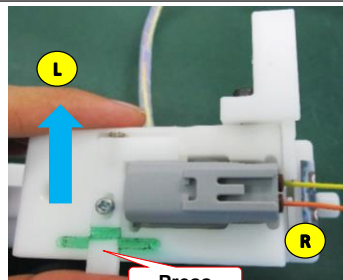
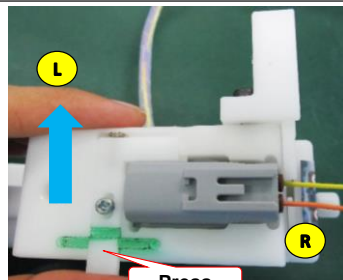
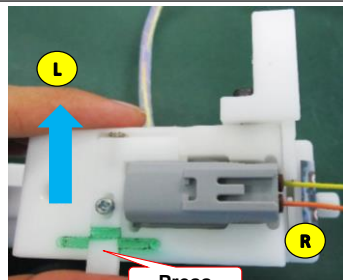
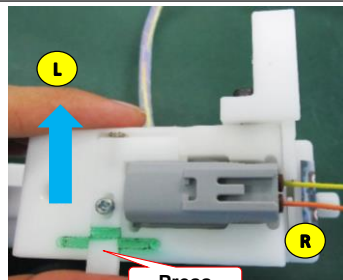
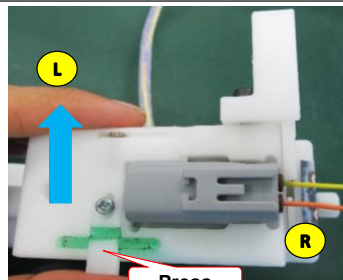
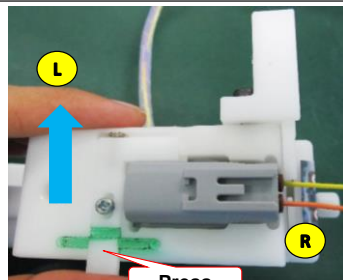
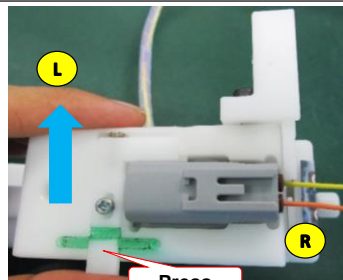
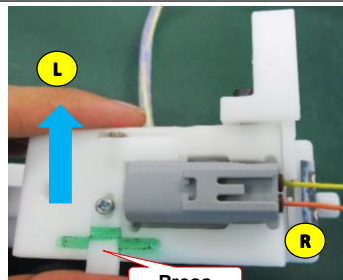
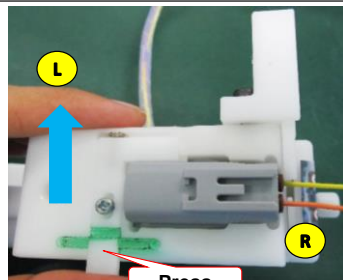
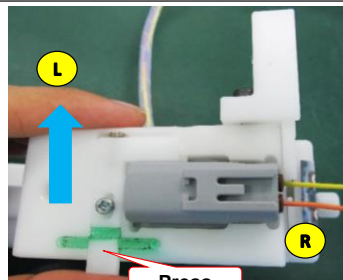
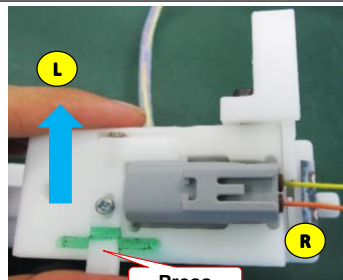
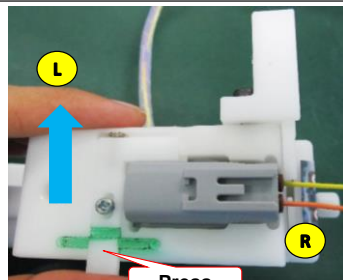
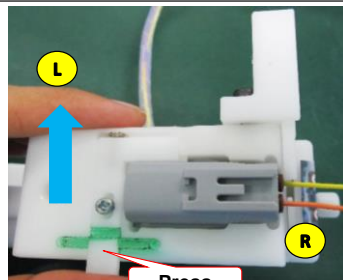
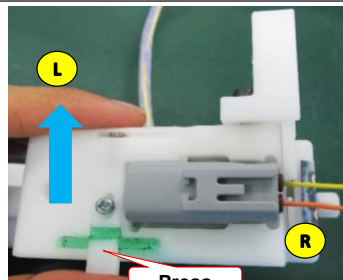
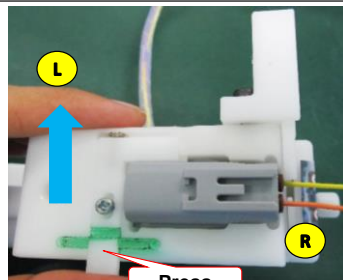
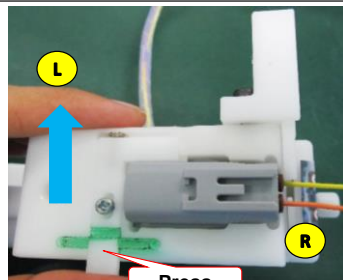
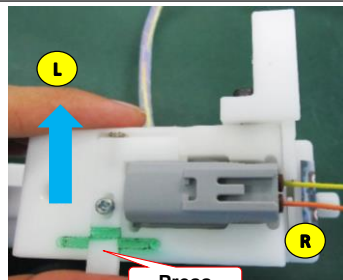
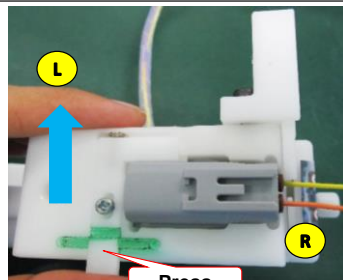
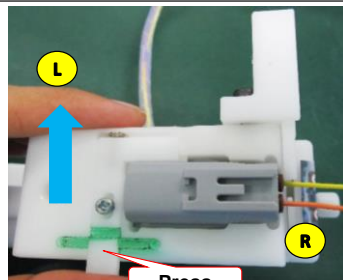
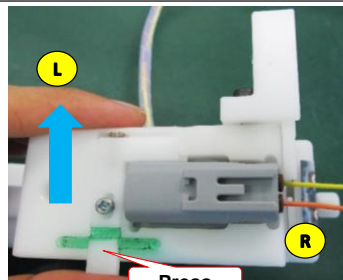
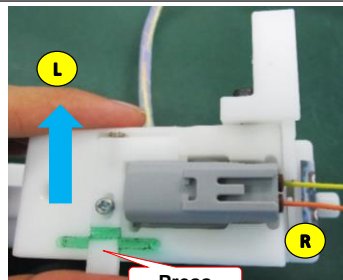
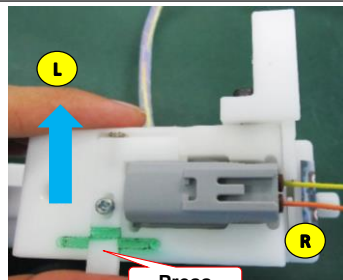
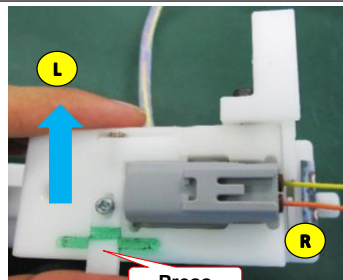
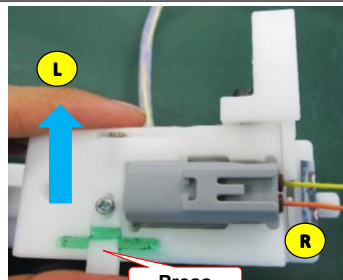
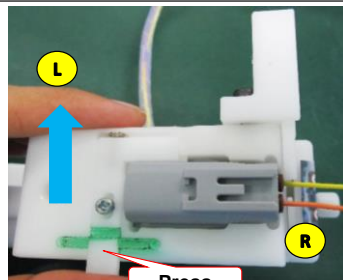
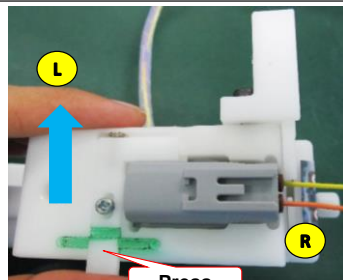
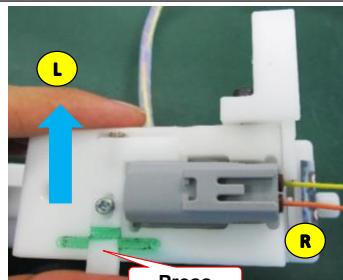
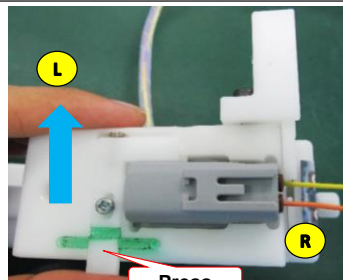
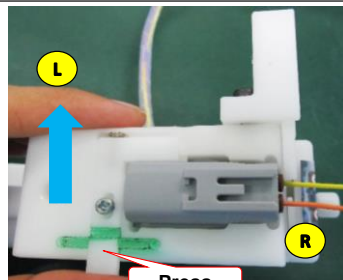
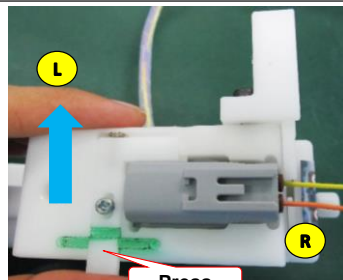
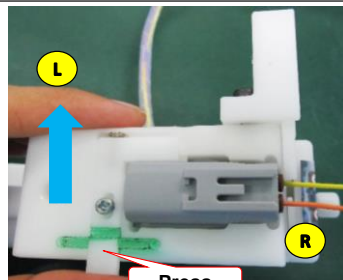
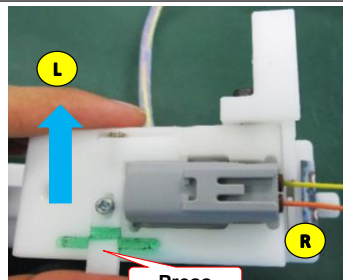
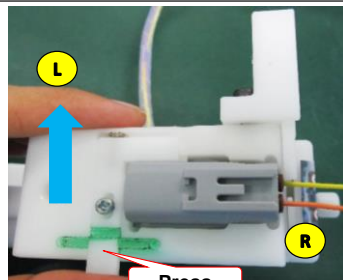
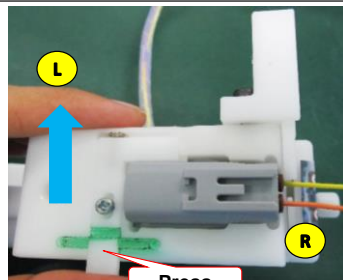
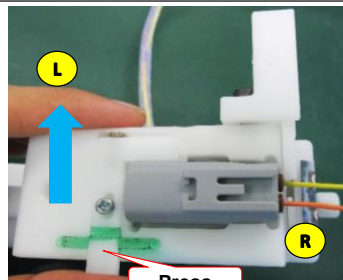
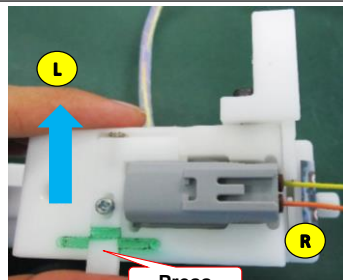
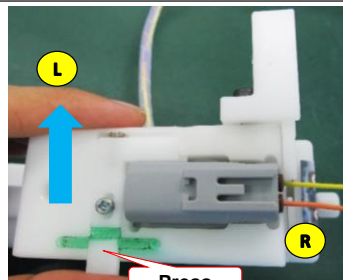
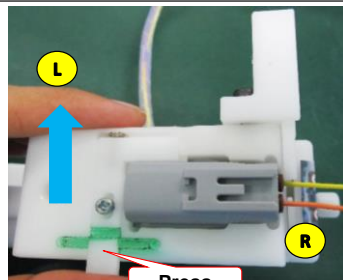
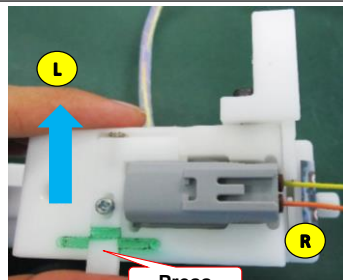
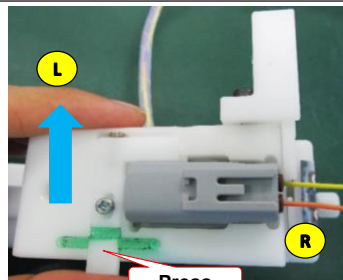
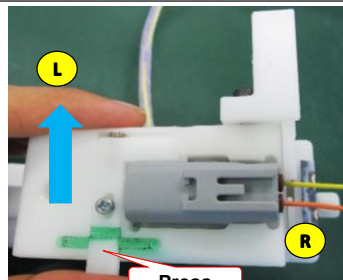
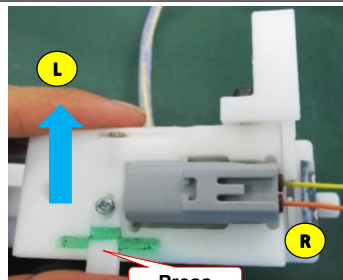
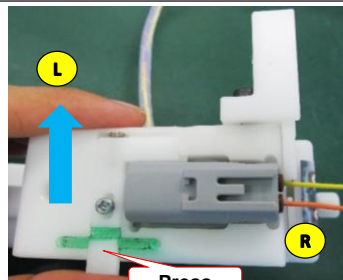
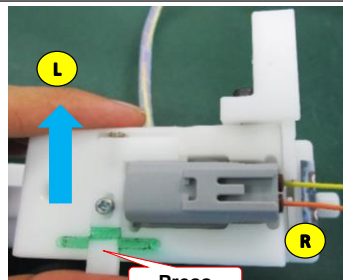
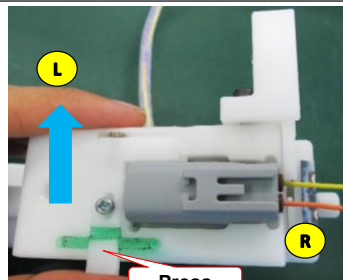
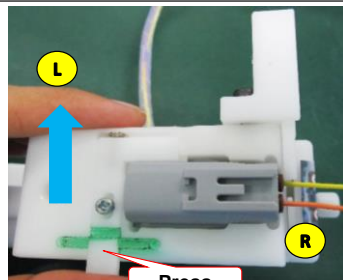
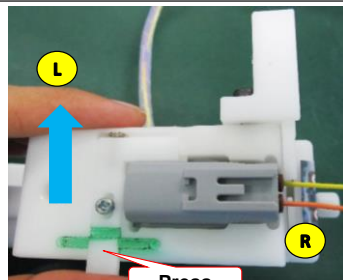
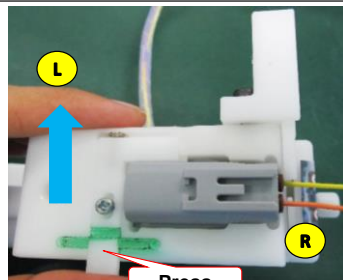
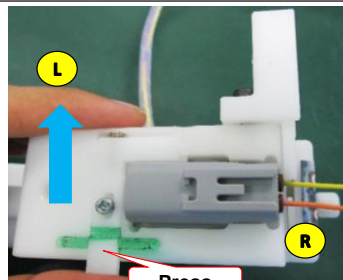
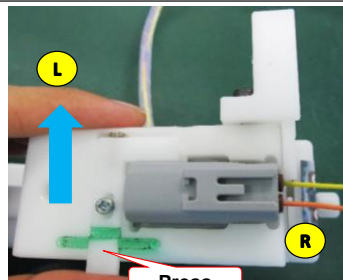
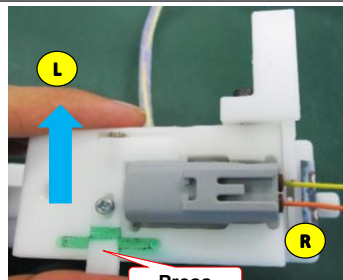
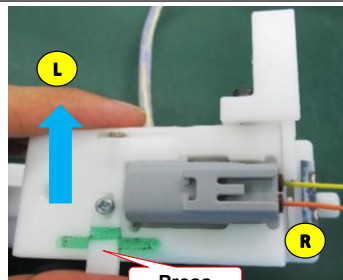
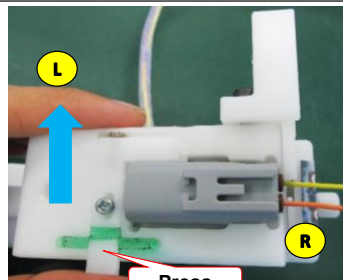
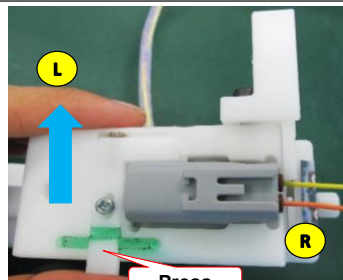
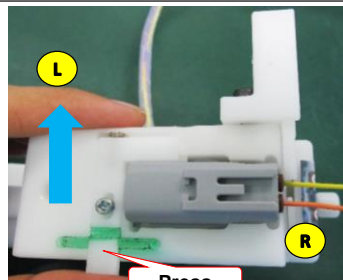
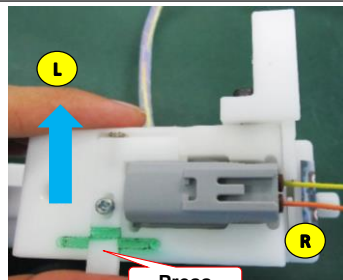
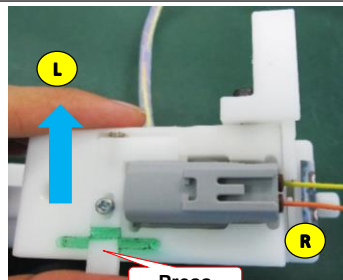
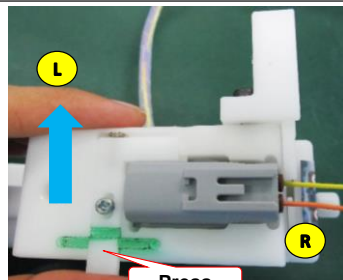
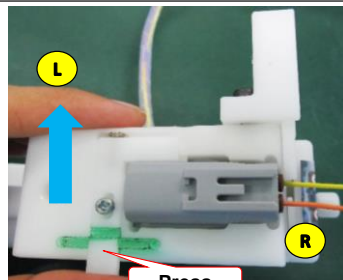
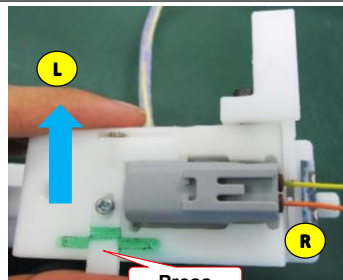
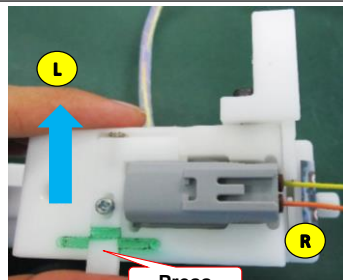
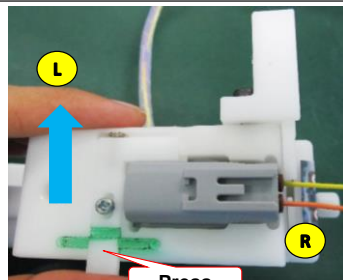
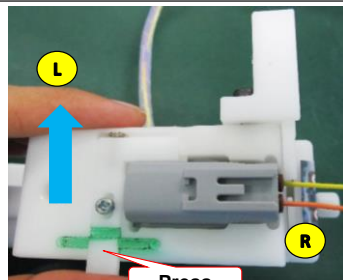
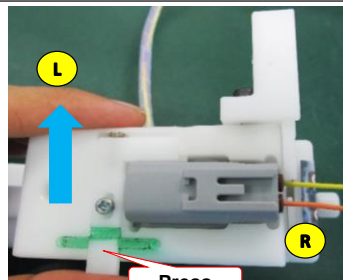
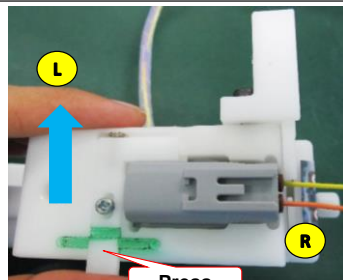
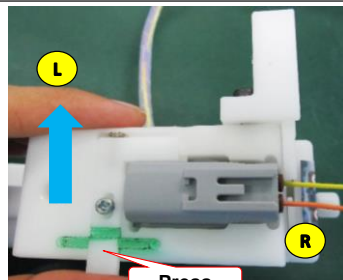
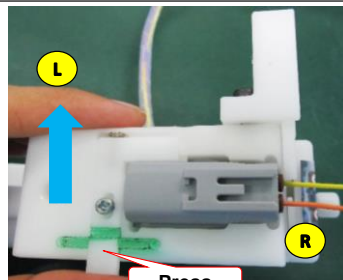
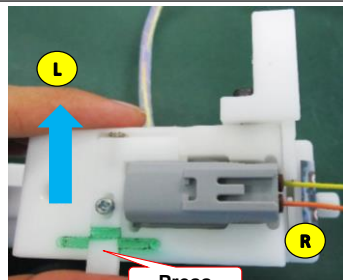
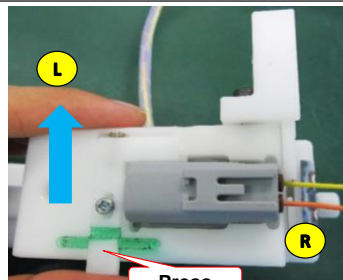
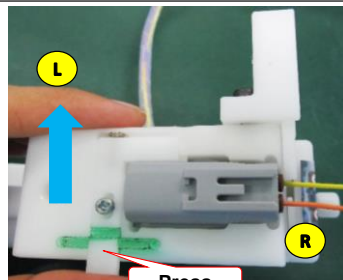
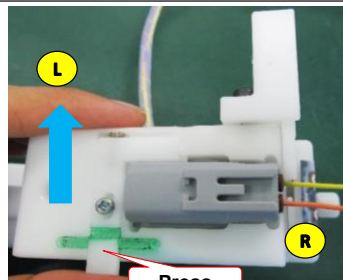
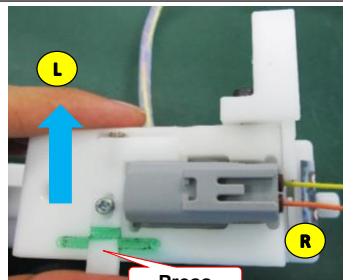
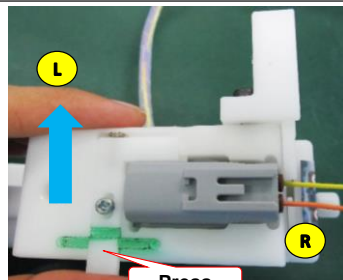
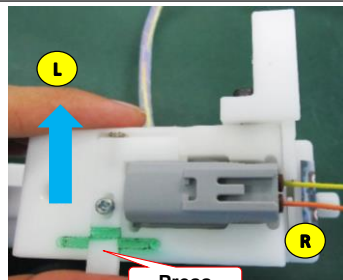
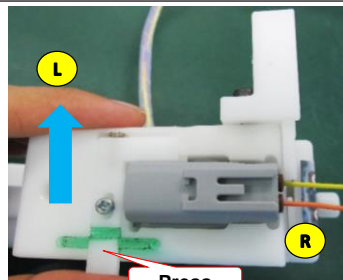
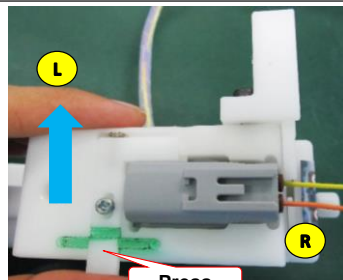
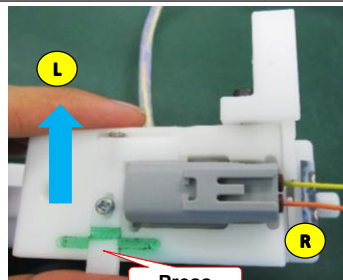
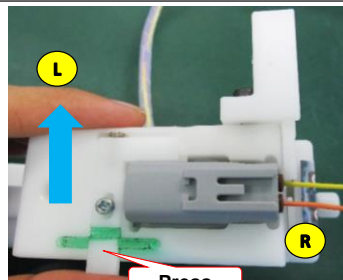
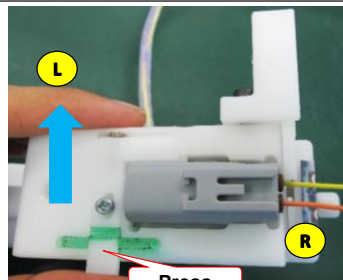
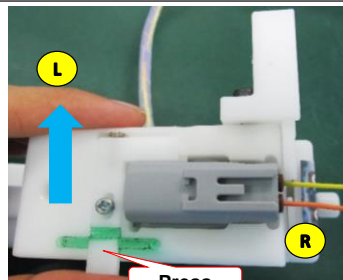
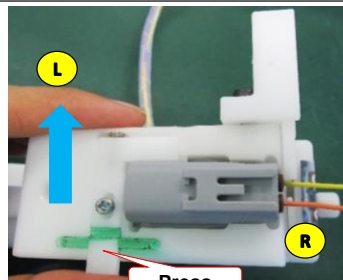
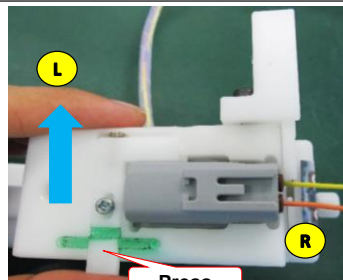
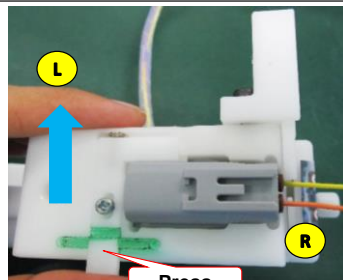
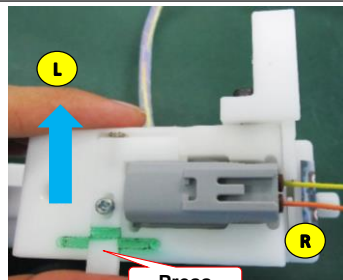
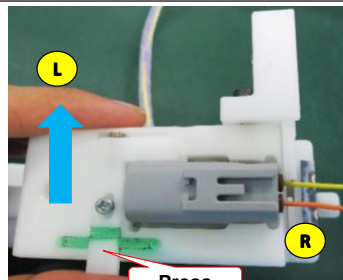
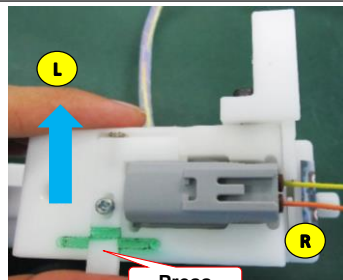
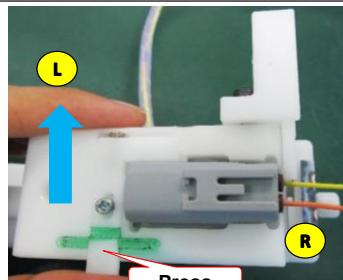
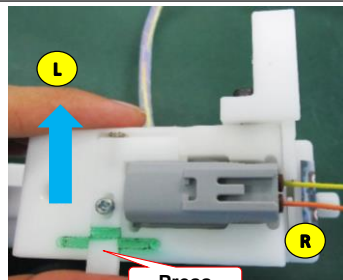
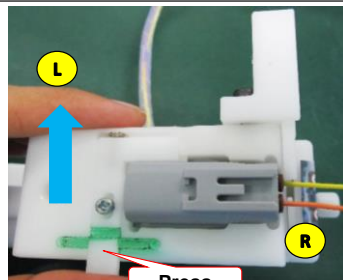
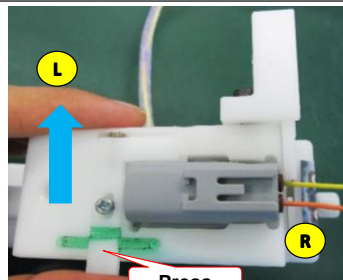
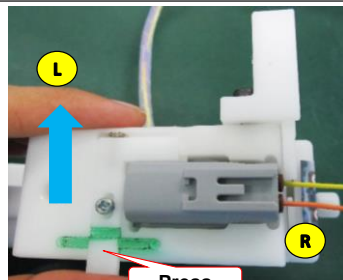
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Revision No.:

1

Page No.:

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PARTS:		1. AVSSf 0.3 wires Y-OR L=384±2mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1	<div><div><div>WIRE FACING</div></div><div><div><div><div>L</div><div>1 Yellow</div><div>R</div></div></div><div><div><div><div>L</div><div>2 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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Process Name/Title:

Model code/Part number:

178D / 7N0129-7021CCustomer: **TRJ**Car Model: **TOYOTA-COROLLA**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

November 13, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1162A

Revision No.:

1

Page No.:

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PARTS:		1. Black Corrugated tube $\varnothing 7$ L= 212 \pm 3mm (no slit) 2. Black Corrugated tube $\varnothing 7$ L= 116 \pm 3mm (no slit) 3. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	<div><p>1. Hold the wires using left hand. Get the Corrugated tube (no slit) $\varnothing 7$ L=212\pm3mm using right hand then insert the Y-OR wires using left hand.</p></div> <div><p>2. Hold the wires using left hand. Get the Corrugated tube (no slit) $\varnothing 7$ L=116\pm3mm using right hand then insert the Y-OR wires using left hand.</p></div>		n/a	1. No wrong use of parts 2. No deformed terminal
5		<div><p>Connector setting to insertion jig 6189-0451 (W)</p></div> <div><p>INSERTION JIG ORIENTATION</p></div> <div><p>CONNECTOR ORIENTATTON</p></div>		n/a	1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector

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TAPING ASSEMBLY PROCESS

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178D / 7N0129-7021C

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Effectivity Date:

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Document No.:

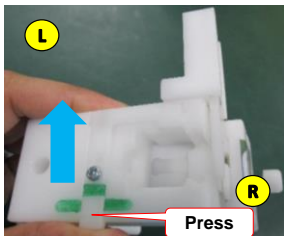
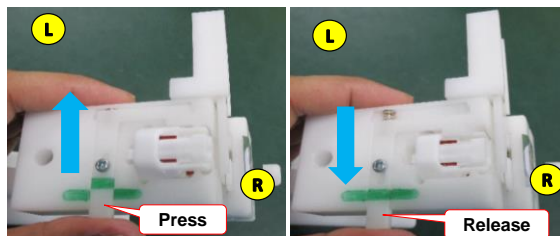
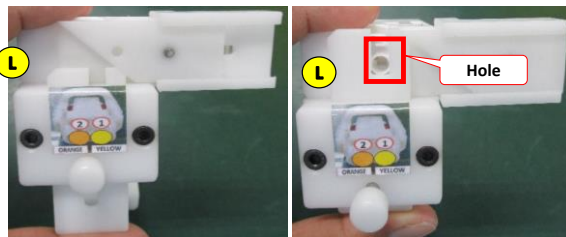

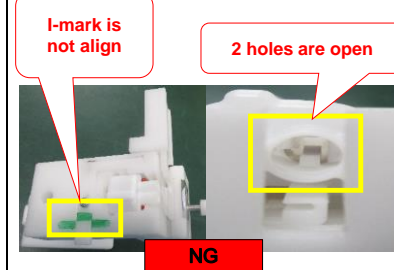
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PARTS:		1. Connector 6189-0451 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1 Connector setting to insertion jig 6189-0451 (W) (Continuation)	<div><p>1. Press the lock using left thumb.</p></div> <div><p>2. Get the connector 6189-0451 (W) using right hand and insert to insertion jig. Release the lock after insertion. <i>Note: Follow the connector orientation.</i></p></div> <div><p>3. Push the lower wire guide upward using left thumb. Slot for Yellow wire will be opened.</p></div>		n/a	<div><h3>CONNECTOR ORIENTATION ILLUSTRATION</h3><div><p>I-mark is align 1 hole is open GOOD</p></div><div><p>I-mark is not align 2 holes are open NG</p></div></div> <p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

178D / 7N0129-7021C

Customer: TRJ

Car Model: TOYOTA-COROLLA

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

November 13, 2024

Validity Date:

n/a

Document No.:

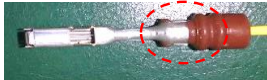
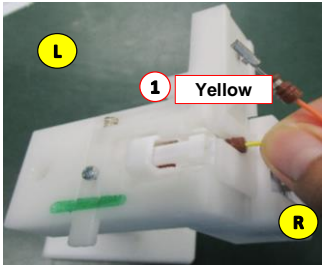
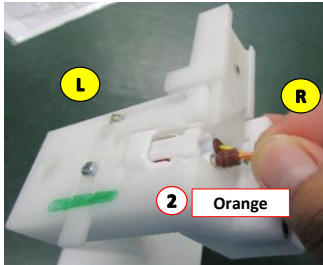
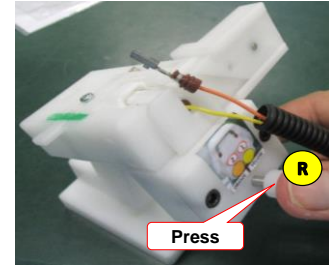
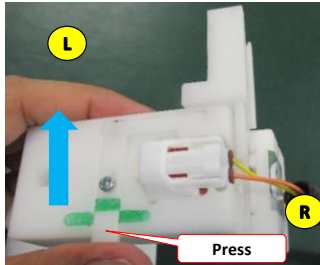
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PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1	<div><p>WIRE FACING</p></div> <div><p>1 Yellow</p></div> <div><p>2 Orange</p></div> <div><p>Press</p></div> <div><p>Press</p></div> <div><p>1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot 1 using right hand.</p><p>2. Press the button using right thumb. The slot for Orange wire will be opened.</p><p>3. Get the Orange wire then insert to terminal slot 2 using right hand.</p><p>4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal.</p> <p>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>

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

Effectivity Date:

November 13, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

178D / 7N0129-7021CCustomer: **TRJ**Car Model: **TOYOTA-COROLLA**

Document No.:

WI-ENG-PDE-1162A

Purpose:

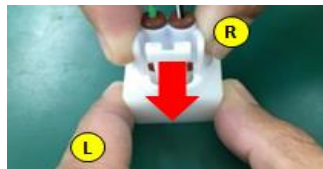



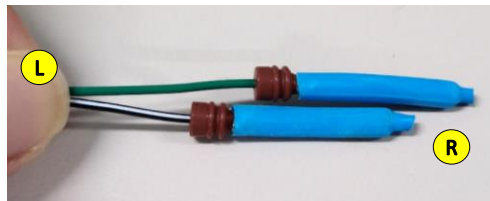

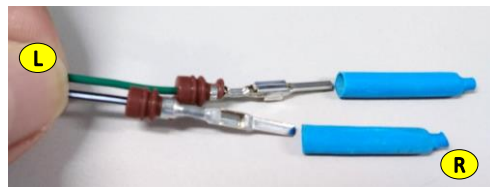

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PARTS:		1. Assy parts 2. MRSW CP TVSSf 0.3 G-B/W L=822±3mm		3. Black Corrugated tube ø7 L=512±5mm (no slit)		JIG:	1. Locking jig 2. Terminal cover jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
7	P1	Connector lock	<div></div> <div>1. Put the connector into locking jig using right hand then press 2x. Touch the connector lock if properly locked.</div> <div>Before pressing</div> <div>After pressing</div>			<div>LOCKING JIG</div> 	1. Use the provided locking jig per model 2. No unlock/half-locked connector 3. No damaged lock Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR
8		Wire insertion to Black Corrugated tube (no slit) ø7 L=512±5mm	<div></div> <div>1. Get the terminal cover jig using right hand then insert to both terminals (G-B/W wires) using right hand.</div> <div></div> <div>2. Get the corrugated tube ø7 L=512±5mm using right hand then insert the G-B/W wires using left hand.</div> <div></div> <div>3. After insertion, remove the cover jig using right hand.</div>			<div>TERMINAL COVER JIG</div> 	1. No wrong usage of parts 2. No damaged rubber seal Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance .

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178D / 7N0129-7021C

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Purpose:

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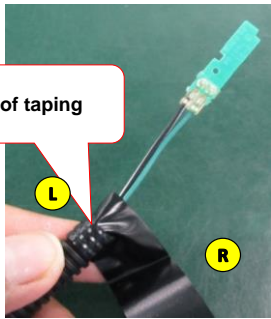
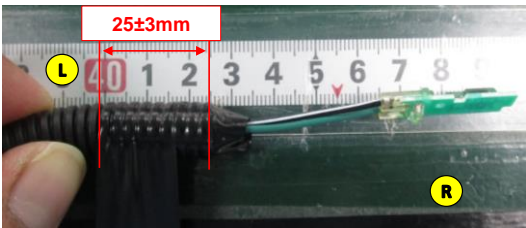
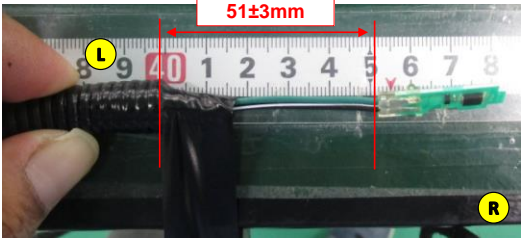

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1 Taping 1 Black corrugated tube to wire near PCB	<div><p>Start of taping</p><p>1. Hold the assy parts using left hand, get Black tape then conduct pre-taping using both hands.</p></div> <div><p>25±3mm</p><p>2. Confirm measurement of 25±3mm from end of tape up to end of COT then continue the taping process using both hands.</p></div> <div><p>51±3mm</p><p>3. Measure from end of COT up to edge of hotmelted wires 51±3mm then continue the taping process using both hands.</p></div>		<div><p>Measuring tape</p></div>	<p>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <ul style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape

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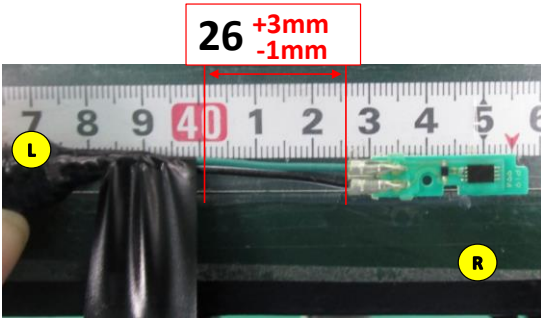
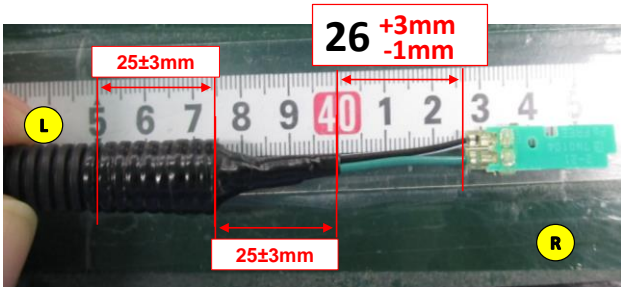

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1 Taping 1 Black corrugated tube to wire near PCB (Continuation)	<div><p>4. Confirm measurement of 26+3mm/-1mm from end of tape up to edge of PCB then continue the taping process using both hands.</p></div> <div><p>5. After taping, check the measurement and taping condition.</p></div>		<div>Measuring tape</div> 	<p>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <ul style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number: 178D / 7N0129-7021C

Customer: TRJ

Car Model: TOYOTA-COROLLA

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

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n/a

Document No.:

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PARTS:

1. Assy parts

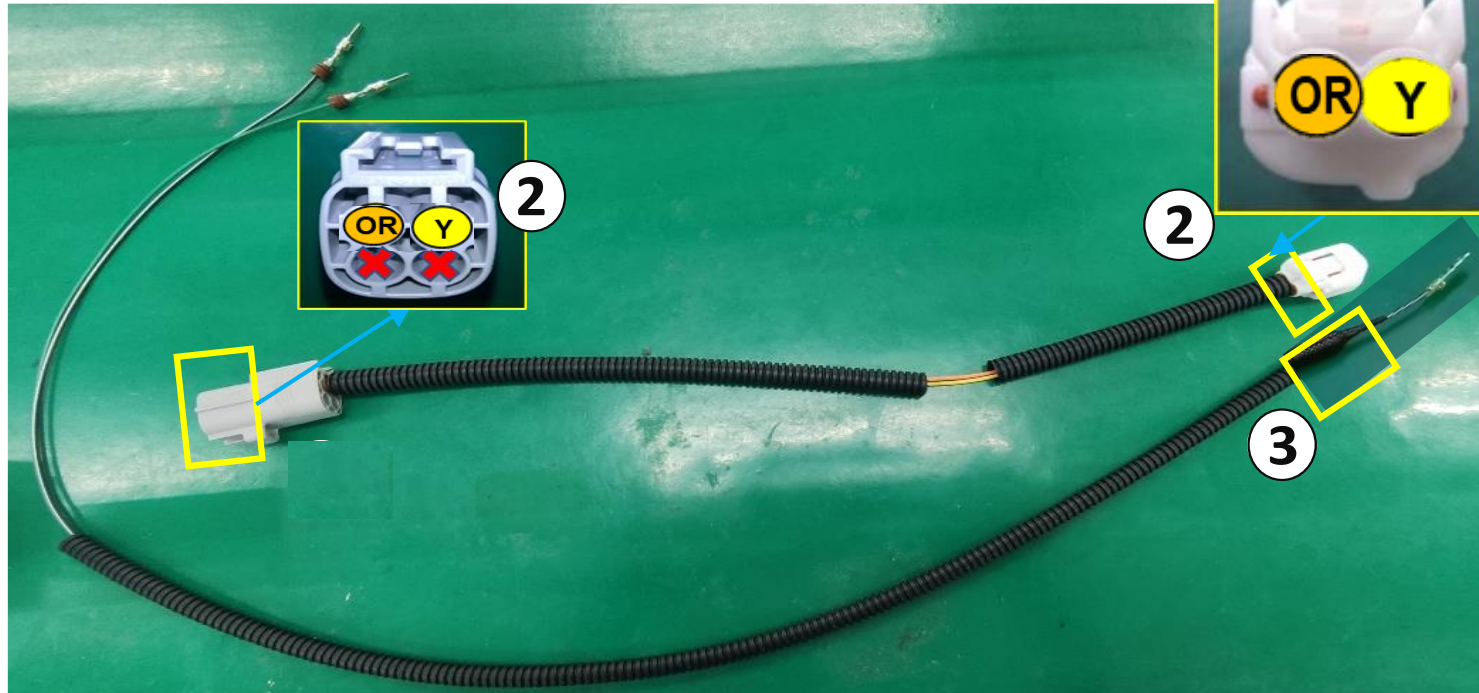
JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING - P1

7N0129-7021C



- 1 No Unlock/Half-locked Connector
- 2 No Wrong Insert
- 3 No Missing Tape
- 4 No Missing COT
- 5 No Deformed terminal
- 6 No Terminal Backing Out

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