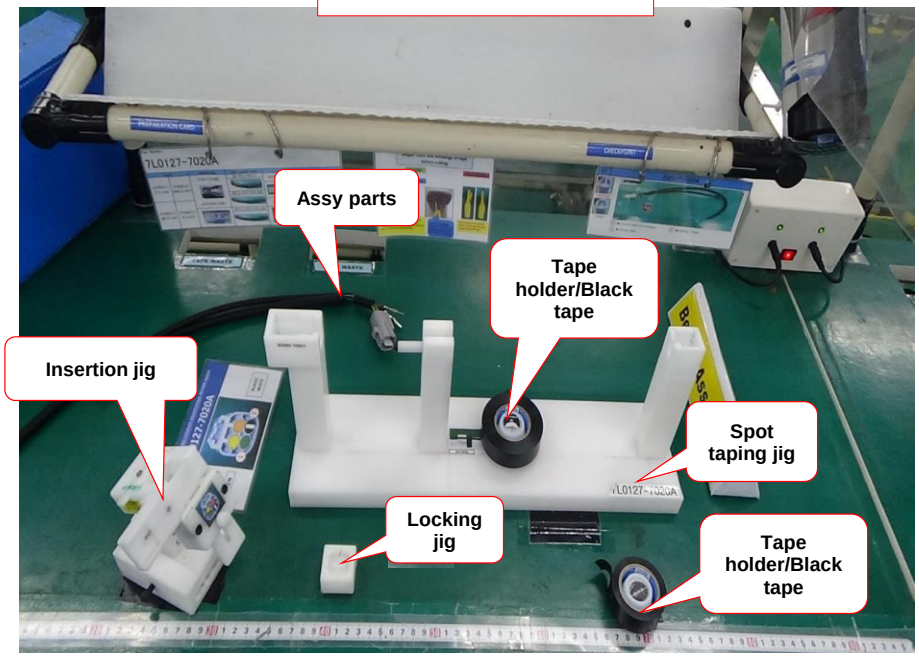
NBC	WORK INSTRUCTION			Effectivity Date:	September 17, 2024	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	-	
	Model code/Part number: 177D / 7L0127-7020B	Customer:	Car Model: TOYOTA-COROLLA	Document No.:	WI-ENG-PDE-1046B	
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	1	Page No.: 1 of 9

PARTS:	1. Assy parts 2. Black tape [2pcs]	JIG:	1. Insertion jig 3. Spot taping jig 2. Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Table lay-out	TABLE LAY-OUT  	**Safety Instruction** Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) **Housekeeping** 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. **Alert level** For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	1. No missing parts/tools 2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
09/17/24	1	Change purpose from Pre-launch to Masspro.	M. Ariola	C. Villanueva	A. Arañes	n/a
09/11/24	0	Initial issue.	M. Ariola	C. Villanueva	A. Arañes	n/a

Prepared by	Reviewed by	Approved by	Noted by
M. Ariola	C. Villanueva	A. Arañes	n/a
Est. Date:	September 11, 2024		

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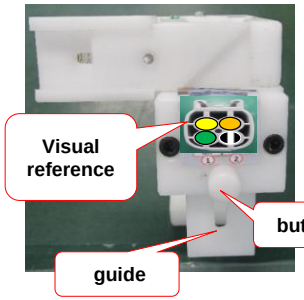
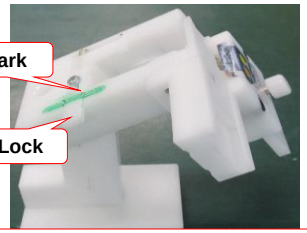
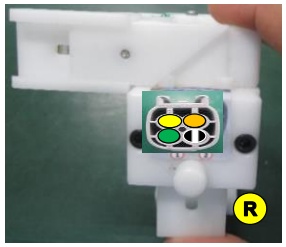
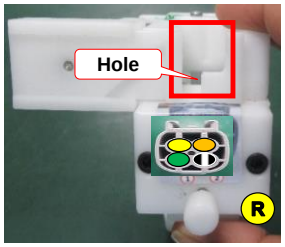
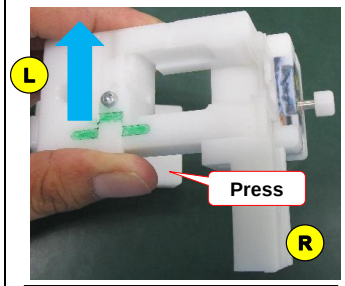
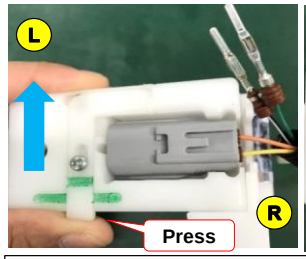
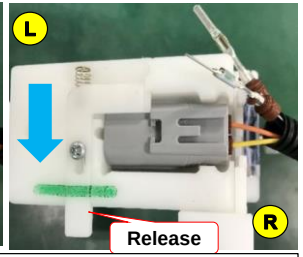
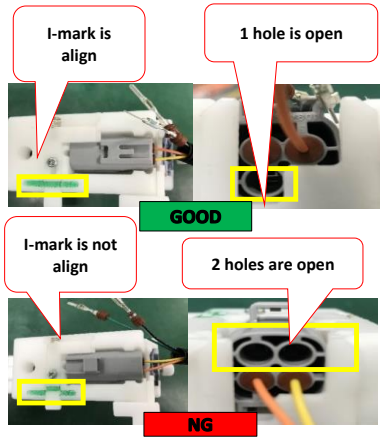
	Model code/Part number:	177D / 7L0127-7020B	Customer: / Car Model: TOYOTA-COROLLA	Document No.:	WI-ENG-PDE-1046B	
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.: 2 of 9

PARTS:	1. Assy parts 2. Connector: 6188-0066 (GR)	JIG:	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2	Connector setting to insertion jig 6188-0066 (GR) (Assy parts)	  INSERTION JIG ORIENTATION CONNECTOR ORIENTATION 1. Push the lower wire guide upward using right thumb. Slot for **Green wire** will be opened.      2. Press the lock of insertion jig using left thumb. 3. Get the connector **6188-0066 (GR)** using right hand and insert to insertion jig. Release the lock after insertion.		1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector CONNECTOR ORIENTATION ILLUSTRATION 

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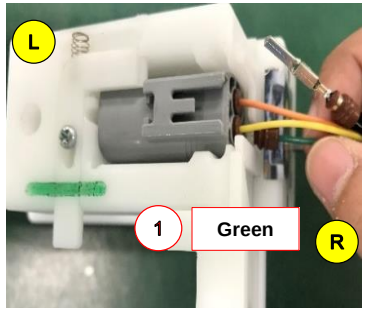
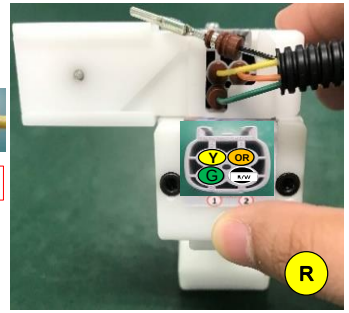
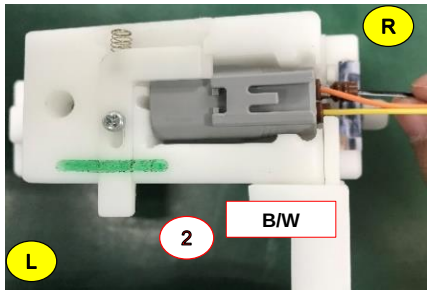
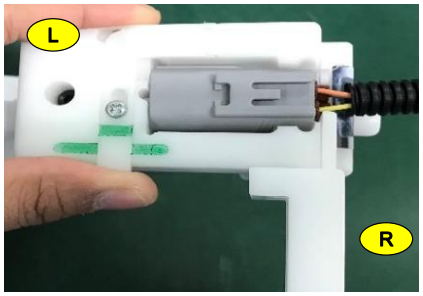
	WORK INSTRUCTION			Effectivity Date:	September 17, 2024	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	-	
	Model code/Part number: 177D / 7L0127-7020B	Customer:	Car Model: TOYOTA-COROLLA	Document No.:	WI-ENG-PDE-1046B	
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	1	Page No.: 3 of 9

PARTS:	1. Assy parts	JIG:	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2	Wire insertion to connector 6188-0066 (GR) (Assy parts)	 1 Hold the **G wire** then insert to terminal slot **1** using right hand. WIRE FACING  2. Press the button using right thumb. The slot for **B/W wire** will be opened.  3. Hold the **B/W wire** then insert to terminal slot **2** using right hand.  4. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand. A	n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing ***Important reminders/Notes:*** *1. Please hold the wire near terminal .* *2. Make sure wires are properly inserted.* *Conduct **Pull-Push-Pull-Push** after insertion.* *Do not exert extra force.* ***Document reference/s:*** *1. Please refer to GL-PRO-ASY-029 for Pull-Push-Pull-Push procedure.*

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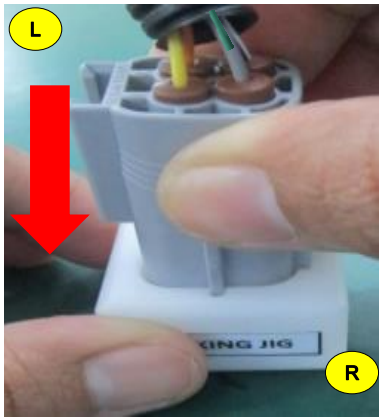
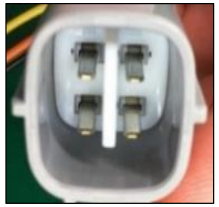
	Model code/Part number:	177D / 7L0127-7020B	Customer: / Car Model: TOYOTA-COROLLA	Document No.:	WI-ENG-PDE-1046B		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.:	4 of 9

PARTS:	1. Assy parts	JIG:	1. Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2	Connector lock	 1. Put the connector into locking jig using both hands and then conduct **2x** pressing. Check the connector if properly locked. Before pressing  After pressing A	LOCKING JIG 	1. Use the provided locking jig per model 2. No unlock/half-locked connector 3. No damaged lock ***Important reminders/Notes:*** *1. Manual locking may cause damaged connector lock.*

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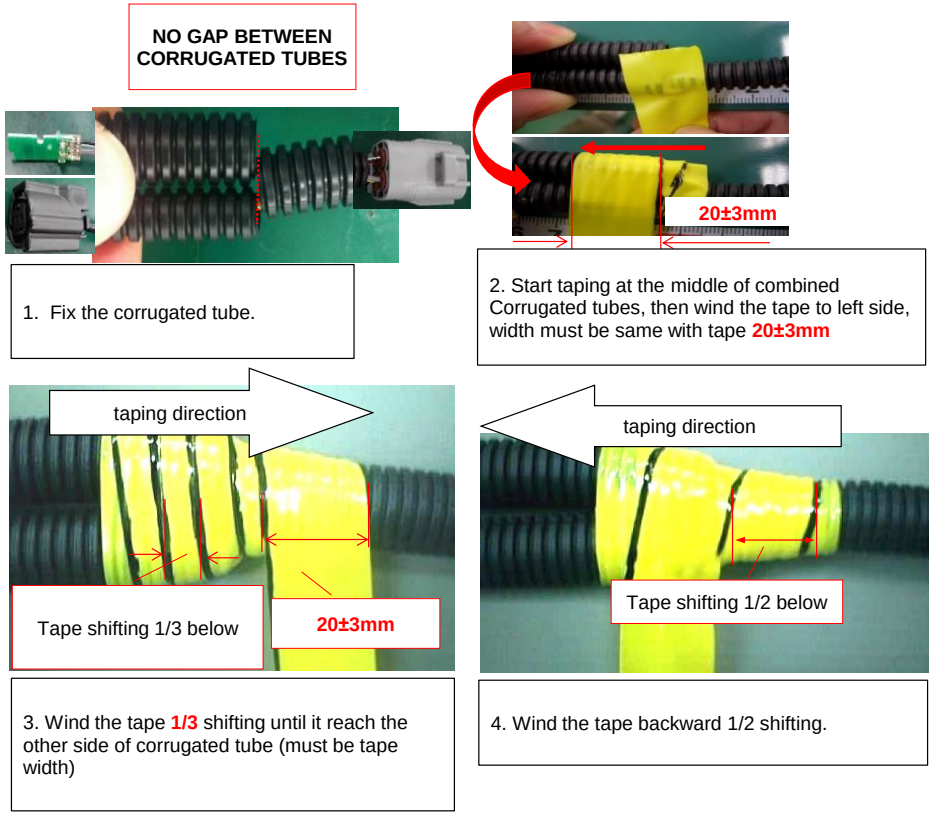
	Model code/Part number: 177D / 7L0127-7020B	Customer:	Car Model: TOYOTA-COROLLA	Document No.:	WI-ENG-PDE-1046B	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 5 of 9

PARTS:	1. Assy parts 2. Black tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2	Y-taping	 1. Fix the corrugated tube. 2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side, width must be same with tape **20±3mm** 3. Wind the tape **1/3** shifting until it reach the other side of corrugated tube (must be tape width) 4. Wind the tape backward 1/2 shifting. A	MEASURING TAPE 	1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension-out tape 6. No exposed wire 7. No gap between tubes ***Important reminders/Notes:*** ***1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE*** ***2. Please use calibrated/ verified measuring tape when getting the measurement.*** ***3. Do not exert excessive force during pulling & winding of tape*** ***4. Must be no gap between Corrugated tubes*** **Y-TAPING ORIENTATION**

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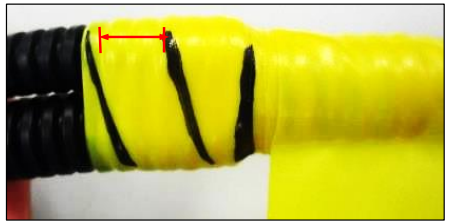
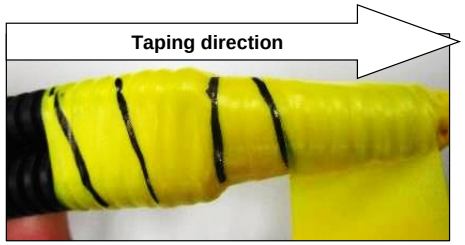
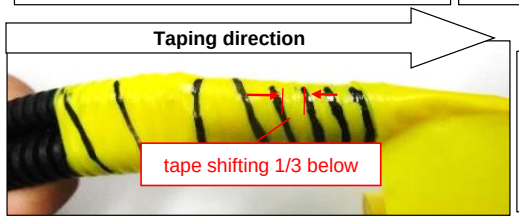
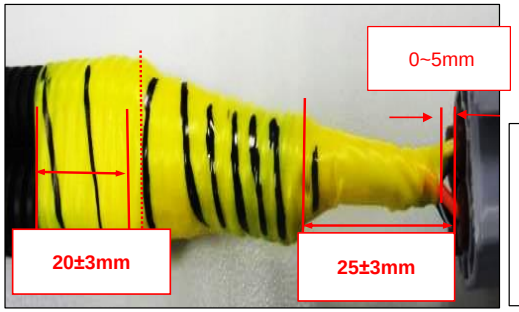
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.:	6 of 9

PARTS:	1. Assy parts 2. Black tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2	Y-taping (Continuation)	 5. Wind the tape 1/2 shifting going to other side of corrugated tube.  6. Make the half of tape outside the COT then wind it 2-3 times as Pre-Taping.  7.Wind the tape 1/3 shifting until it reach the wire , make 3 winds to wires then cut.  8. After taping, check the measurement and taping condition. A	MEASURING TAPE 	1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape ***Important reminders/Notes:*** ***1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE*** ***2. Please use calibrated/ verified measuring tape when getting the measurement.*** ***3. Do not exert excessive force during pulling & winding of tape*** ***4. Must be no gap between Corrugated tubes***

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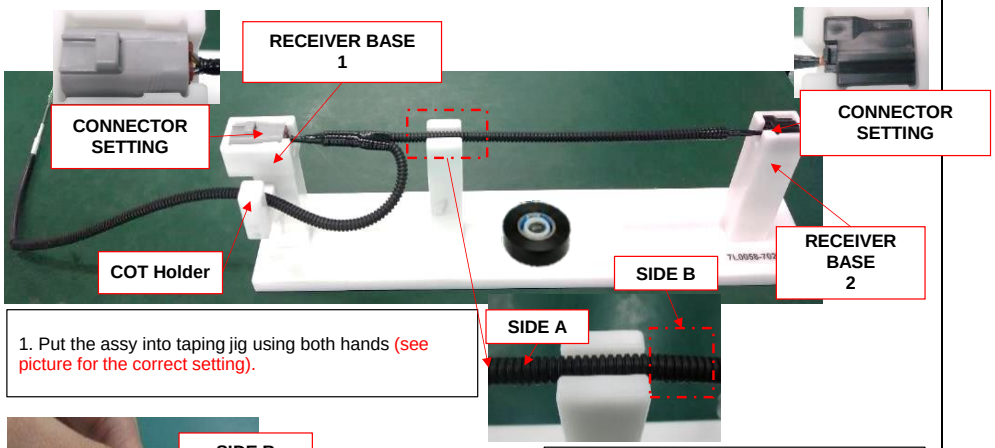
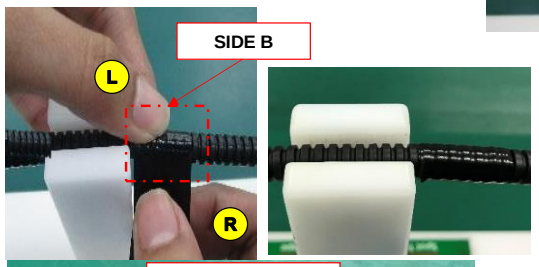
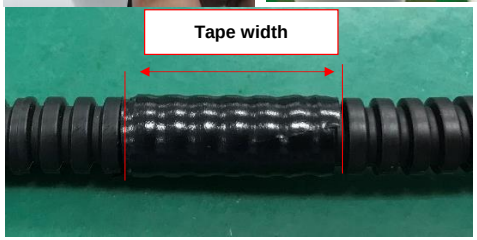
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	1	Page No.: 7 of 9

PARTS:	1. Assy parts 2. Black tape	JIG:	1. Spot taping jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P2	Spot taping	 1. Put the assy into taping jig using both hands (see picture for the correct setting).  2. Hold the assy parts using left hand, get the **Black tape** then conduct **2 windings** of tape on **SIDE B** then cut using both hands.  3. Check the taping condition. A	n/a	1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape

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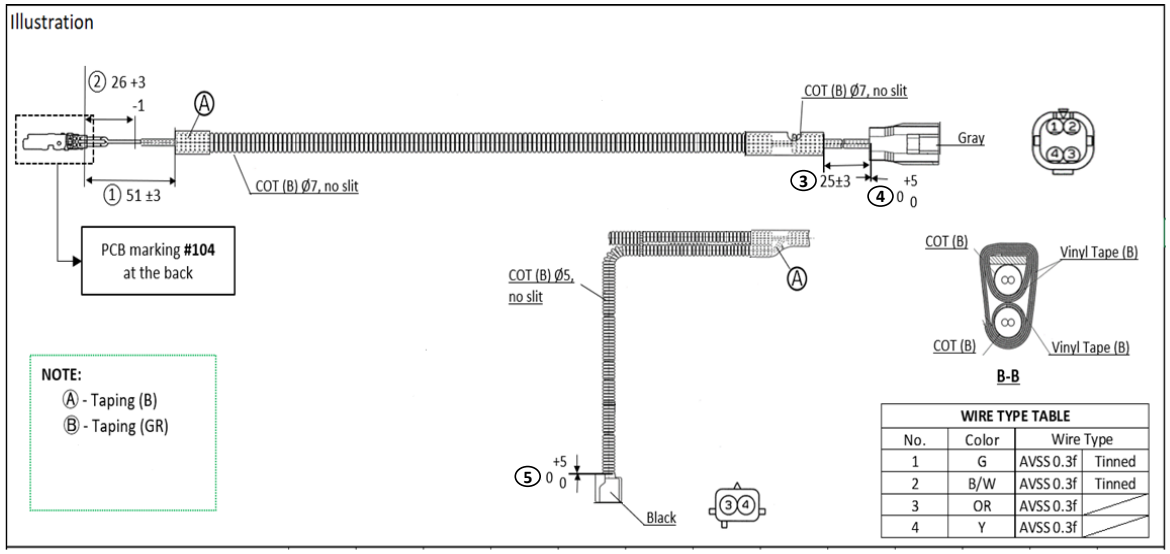
PARTS:	n/a	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P2	Measurement			1. No wrong dimension ***Important reminders/Notes:*** ***1. Please use calibrated/ verified measuring tape when getting the measurement .*** ***2. For Hatsumono, Nakamono and Owarimono.*** ***Document reference/s:*** ***1. Refer to WI-PRO-ASY--056 for Sub-assy Hatsumono, Nakamono and Owarimono Inspection.***

WIRE TYPE TABLE

No.	Color	Wire Type	
1	G	AVSS 0.3f	Tinned
2	B/W	AVSS 0.3f	Tinned
3	OR	AVSS 0.3f	
4	Y	AVSS 0.3f	

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PARTS:	n/a	JIG:	n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING - P2	**7L0127-7020B**

1 2 **No Missing tape**

3 **No Missing spot tape**

4 **No Wrong Facing of Connector (Y-taping)**

A

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