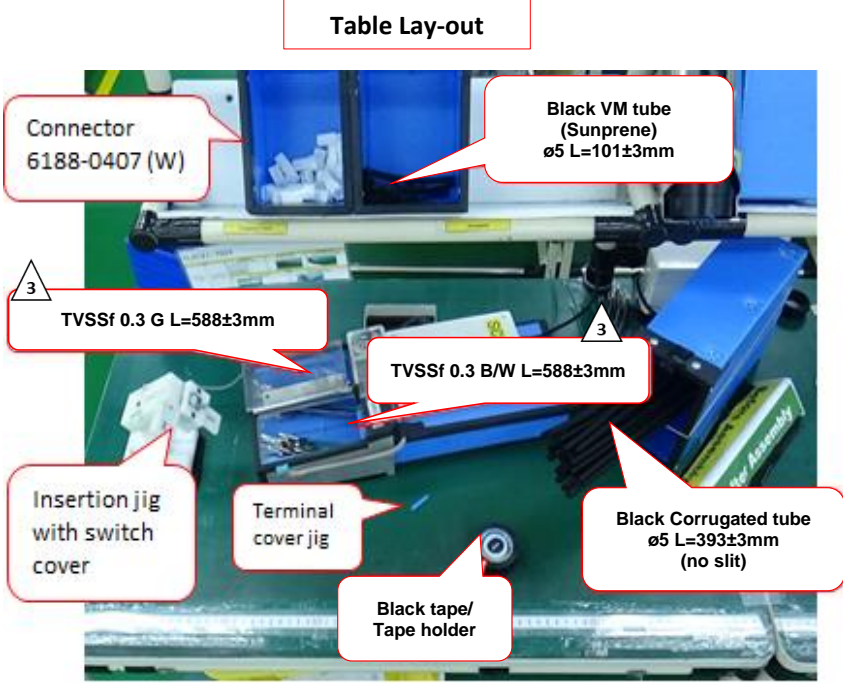


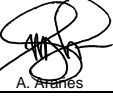

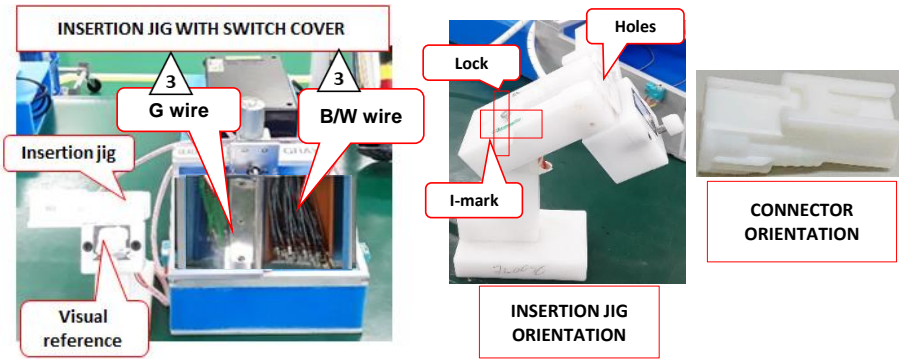
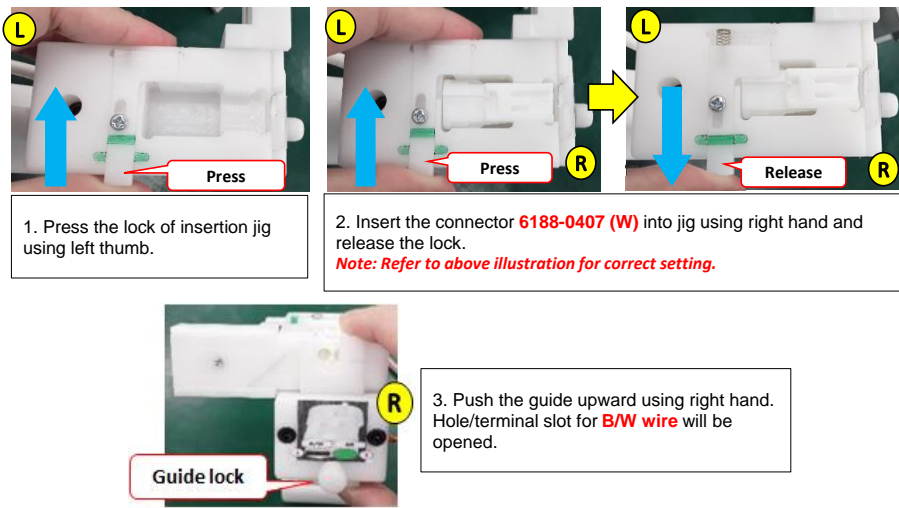
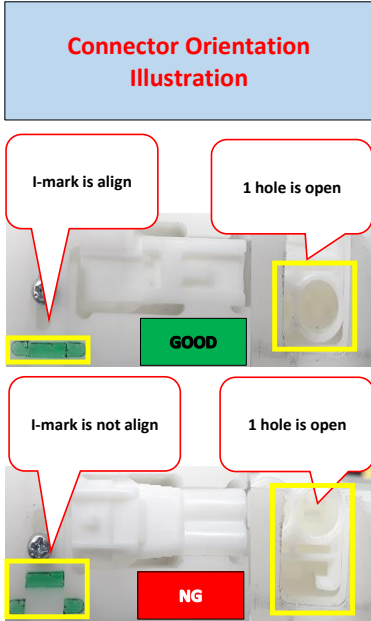
	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date:	June 11, 2024		
	Process Name/Title:				Validity Date:	n/a		
	Model code/Part number: 102D / 7L0121-7024		Customer: TRQSS	Car Model: TOYOTA-RAV4	Document No.:	WI-ENG-PDE-424A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	3	Page No.:	1 of 5

PARTS:	1. All parts: Connector 6188-0407 (W); TVSSf 0.3 G-B/W wires L=588±3mm; Black VM tube (Sunprene) ø5 L=101±3mm; Black Corrugated tube ø5 L=393±3mm (no slit); Black tape				JIG:	1. Insertion jig with switch cover 2. Terminal cover jig	
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 dashed red; padding: 5px;"> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px;"> 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 dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance. 1. No missing parts/tools 2. No excess parts/tools

Revision History						Prepared by	Reviewed by	Approved by	Noted by	
06/11/24	3	Separate Connector lock, Black VM tube (Sunprene) to wire near terminal taping, Black COT to VM tube (Sunprene), Clamp setting, clamp assembly and By two's inspection to WI-ENG-PDE-424B due to process improvement. Update table lay-out and quality pointers. Change the wire color location from B/W-G to G-B/W.	D. Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
02/24/23	2	Work instruction improvement: Change MP from 2MP to 1MP. Inclusion of batching. Change term of Sunprene tube to VM tube (Sunprene). Update table lay-out and Quality Checkpoints (Page 12).	D. Castillo	C. Villanueva	C. Villanueva	A. Arañes				
12/16/23	1	Improve quality pointers in all process. Inclusion of quality checkpoints.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	Februaty 24, 2022		

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	WORK INSTRUCTION			Effectivity Date:	June 11, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 102D / 7L0121-7024		Customer: TRQSS	Car Model: TOYOTA-RAV4	Document No.: WI-ENG-PDE-424A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	3	Page No.:	2 of 5

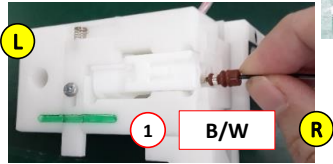
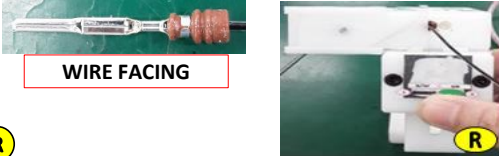






PARTS:		1. Connector 6188-0407 (W)		JIG:	1. Insertion jig with switch cover	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS		
2	P1 Connector setting to insertion jig 6188-0407 (W)	<div></div> <div></div>	n/a	<div></div> <div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div>		

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	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 102D / 7L0121-7024		Customer: TRQSS		Car Model: TOYOTA-RAV4	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.:		Revision No.:		3	Page No.:


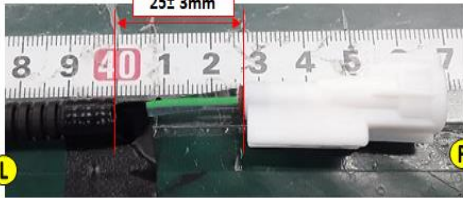
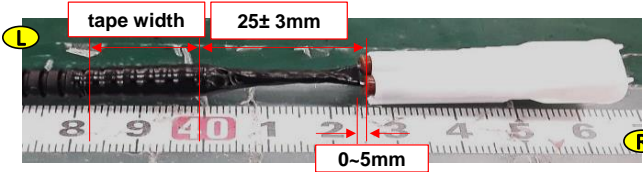


PARTS:	1. TVSSf 0.3 G-B/W wires L=588±3mm 2. Black corrugated tube (no slit) Ø5 L=393±3mm (no slit)			JIG:	1. Insertion jig 2. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to connector 6188-0407 (W) P1	<div><p>1. Get the B/W wire then insert to terminal slot 1 using right hand.</p></div> <div><p>2. Push the button after insertion. Hole for G wire will be opened.</p></div> <div><p>3. Get the G wire then insert to terminal slot 2 using right hand.</p></div> <div><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	<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: 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.</div> <div>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</div>
4	Wire Insertion to Black Corrugated tube Ø5 L=393±3mm (no slit)	<div><p>1. Get the terminal cover jig using right hand then insert the G-B/W wires using left hand.</p></div> <div><p>2. Get the corrugated tube (no slit) Ø5 L=393±3mm using right hand and then insert the G-B/W wires using left hand.</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div>		<div>TERMINAL COVER JIG</div> 	<div>1. No wrong use of parts 2. No deformed terminal</div>

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	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 102D / 7L0121-7024		Customer: TRQSS	Car Model: TOYOTA-RAV4	Document No.:	WI-ENG-PDE-424A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	3	Page No.:	4 of 5

PARTS:	1. Assy parts 2. Black tape 3. Black VM tube (Sunprene) Ø5 L=101±3mm			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1 Taping 1 Black corrugated tube to wire near connector	<div><p>Start of taping</p><p>1. Hold the corrugated tube using left hand, get the Black tape then start pre-taping at the middle of COT and wires using both hands.</p></div> <div><p>25± 3mm</p><p>2. Measure from end of corrugated tube up to end of connector 25mm then continue the taping process using both hands.</p></div> <div><p>tape width 25± 3mm</p><p>3. After taping, check the measurement and taping condition.</p><p>0~5mm</p></div>		<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p>
6	Wire insertion to Black VM tube (Sunprene) Ø5 L=101±3mm	<div><p>1. Get the VM tube (Sunprene) Ø5 L=101±3mm using right hand then insert the G-B/W wires using left hand.</p></div>		n/a	<p>1. No wrong use of parts 2. No deformed terminal</p>

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**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**

Effectivity Date:

June 11, 2024Model code/Part number: **102D / 7L0121-7024**Customer: **TRQSS**Car Model: **TOYOTA-RAV4**

Validity Date:

n/a

Document No.:

WI-ENG-PDE-424A

Purpose:

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Revision No.:

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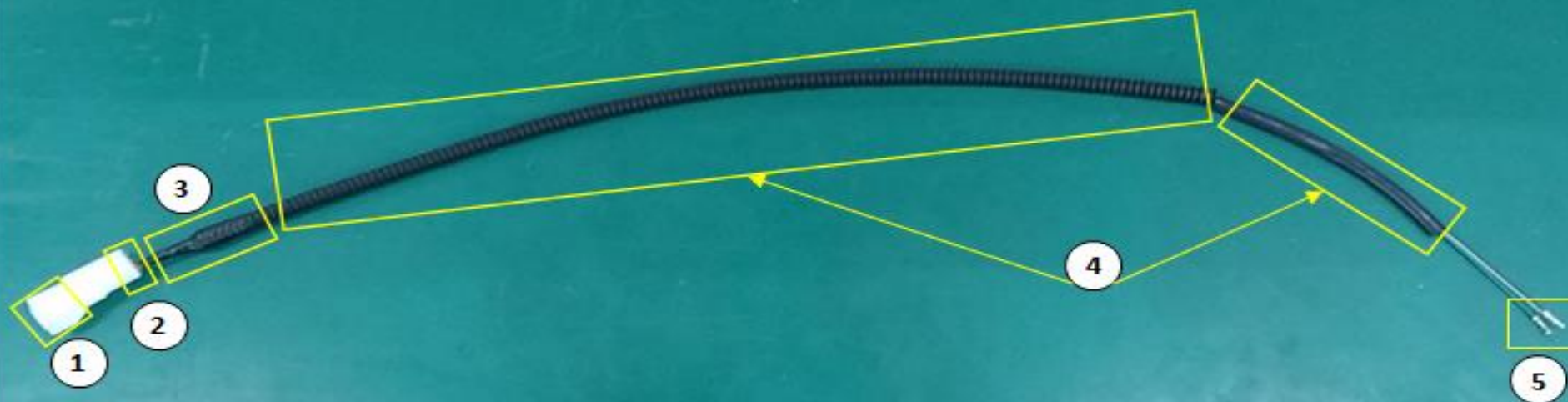
Page No.:

5 of 5**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P1****7L0121-7024****1 No Unlock/Halflock Connector****3 No Missing tape
(COT to wire near Connector)****5 No Deformed terminal****2 No Wrong insert /
Terminal Backing Out****4 No Missing COT and Sunprene
tube**

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