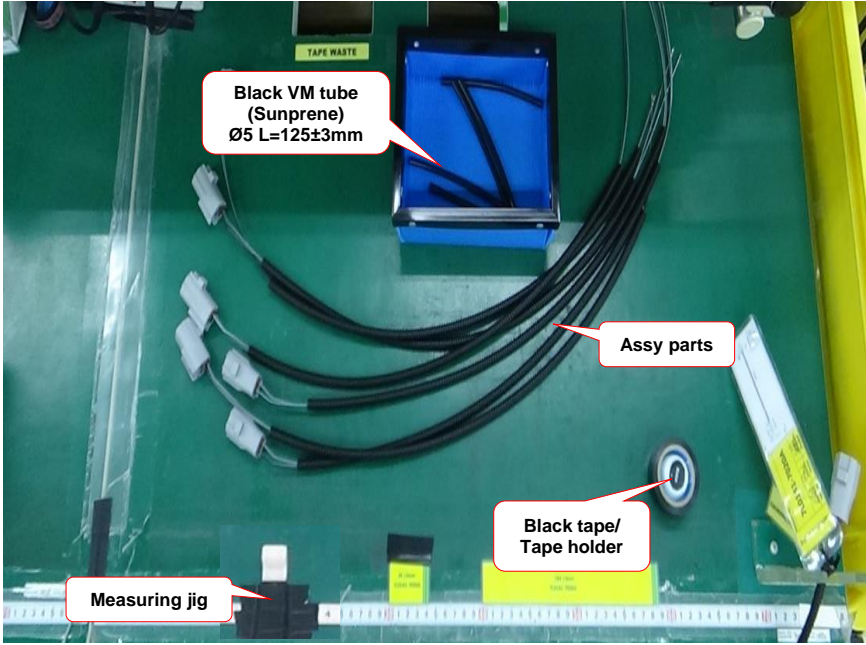
	WORK INSTRUCTION				Effectivity Date:		September 25, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 380D / 7L0139-7020A		Customer: TRQSS	Car Model: TOYOTA CAMRY	Document No.:		WI-ENG-PDE-649	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		2	Page No.: 1 of 6

PARTS:		1. Assy parts; Black VM tube (Sunprene) Ø5 L=125±3mm; Black tape			JIG:		1. Measuring jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE		QUALITY POINTERS	
1	P1	<div>2</div> <div>TABLE LAY-OUT</div> 			<div><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		<div><b>Document reference/s:</b> 1. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length Tolerance. 2. Refer to <b>WI-ENG-PDE-968</b> for Offline assembly process</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>	


Revision History				Prepared by		Reviewed by		Approved by		Noted by	
09/25/24	2	Transfer wire insertion to connector, connector lock and COT insertion process to Offline assembly process. Separate clamp assy to Clamp assembly process due to process improvement. Inclusion of car model "TOYOTA-CAMRY" Improved table lay-out, measurement and visual inspection/quality checkpoints.				D.Castillo	C.Villanueva	A. Arañes	N/A		
04/29/23	1	Change document purpose from pre-launch to masspro. Inclusion of table lay-out (Page 1), Insertion jig (Page 2-3) and Quality pointers (Page 7).				D.Castillo	J.Loterte	C.Villanueva	A. Arañes		
03/10/23	0	Initial issue.				D.Castillo	J.Loterte	C.Villanueva	A. Arañes		
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	March 10, 2023


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	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Model code/Part number: <b>380D / 7L0139-7020A</b>		Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA CAMRY</b>	Document No.:		<b>WI-ENG-PDE-649</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:		2	Page No.: 2 of 6


<b>PARTS:</b>		1. Assy parts 2. Black VM tube (Sunprene) Ø5 L=125±3mm		JIG:	N/A
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	P1	<div><div>Wire insertion to Black VM tube (Sunprene) Ø5 L=125±3mm</div><div></div><div>1. Get the VM tube (Sunprene) Ø5 L=125±3mm using right hand then insert the GR-B/W wires using left hand.</div></div>		N/A	1. No wrong use of parts 2. No deformed terminal

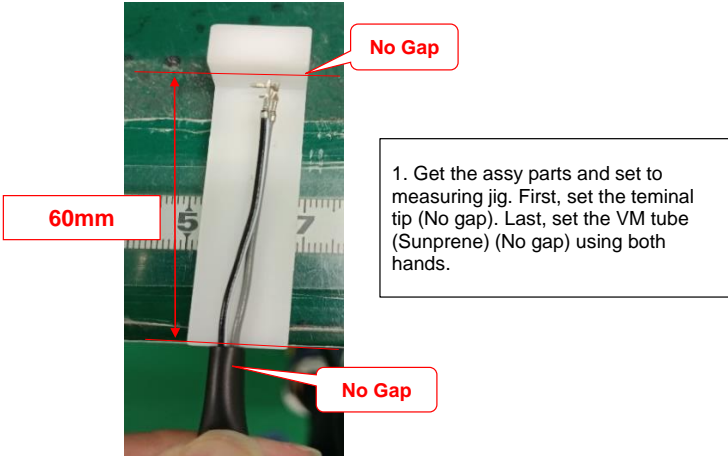
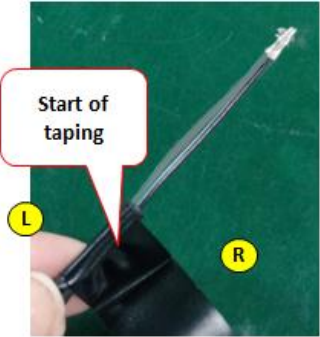
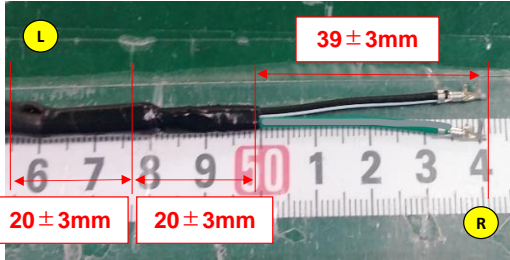


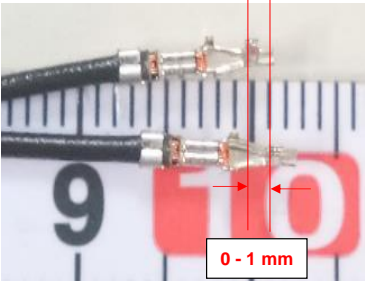
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	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>380D / 7L0139-7020A</b>		Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA CAMRY</b>	Document No.: <b>WI-ENG-PDE-649</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	2	Page No.:	3 of 6

<b>PARTS:</b>	1. Assy parts 2. Black tape			JIG:	1. Measuring jig			
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
3	P1 Taping 1 Black sunprene tube to wire near terminal	<div></div> <div></div> <div></div> <div>2. Hold the tube using left hand, get the <b>Black tape</b> using right hand then start taping process using both hands.</div> <div>3. After taping, check the taping condition, measurement and wire alignment.</div>			<div><b>MEASURING JIG</b></div> <div><b>MEASURING TAPE</b></div>	<div><b>Wire alignment tolerance</b> <b>0 - 1 mm</b></div> <div><b>Important reminders and Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></div> <div><b>Document reference/s:</b> <b>1. Refer to WI-PRO-ASY-001 for taping procedure.</b></div>		

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Model code/Part number:

380D / 7L0139-7020A

Customer:

TRQSS

Car Model:

TOYOTA CAMRY

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

September 25, 2024

Validity Date:

n/a

Document No.:

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Revision No.:

2

Page No.:

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### PARTS:

1. Assy parts
2. Black tape

JIG:

N/A

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

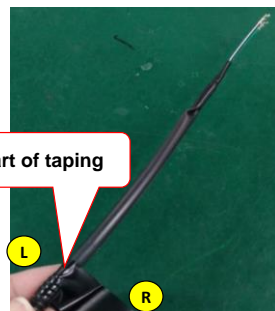
P1

Taping 2  
Black COT to Black VM  
tube (Sunprene)



1. Measure from end of corrugated tube up to terminal pointed tip  $184 \pm 3\text{mm}$  using both hands.

Start of taping



2. Hold the corrugated tube and sunprene tube using left hand, get the **Black tape** then start taping process using both hands.



3. After taping, check the taping condition, measurement and wire alignment.

### MEASURING TAPE



**Important reminders and Note/s:**  
1. Please use calibrated/verified measuring tape when getting the measurement.


**Document reference/s:**  
1. Refer to WI-PRO-ASY-001 for taping procedure.

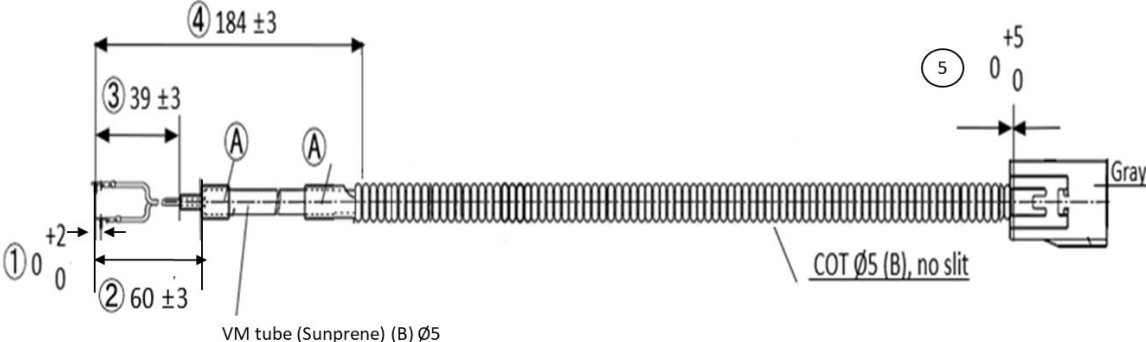

1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong use of tape
6. No wrong dimension

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	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>September 25, 2024</b>		
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>380D / 7L0139-7020A</b>		Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA CAMRY</b>	Document No.:	<b>WI-ENG-PDE-649</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.:	5 of 6

<b>PARTS:</b>	1. Assy parts			JIG:	n/a		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>2</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
4	P1	Measurement	<div><div><b>NOTE:</b> A - Taping (B)</div></div>	<div><b>MEASURING TAPE</b></div> 	<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>		

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**WORK INSTRUCTION**

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**TAPING ASSEMBLY PROCESS**

Effectivity Date:

September 25, 2024

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**380D / 7L0139-7020A**

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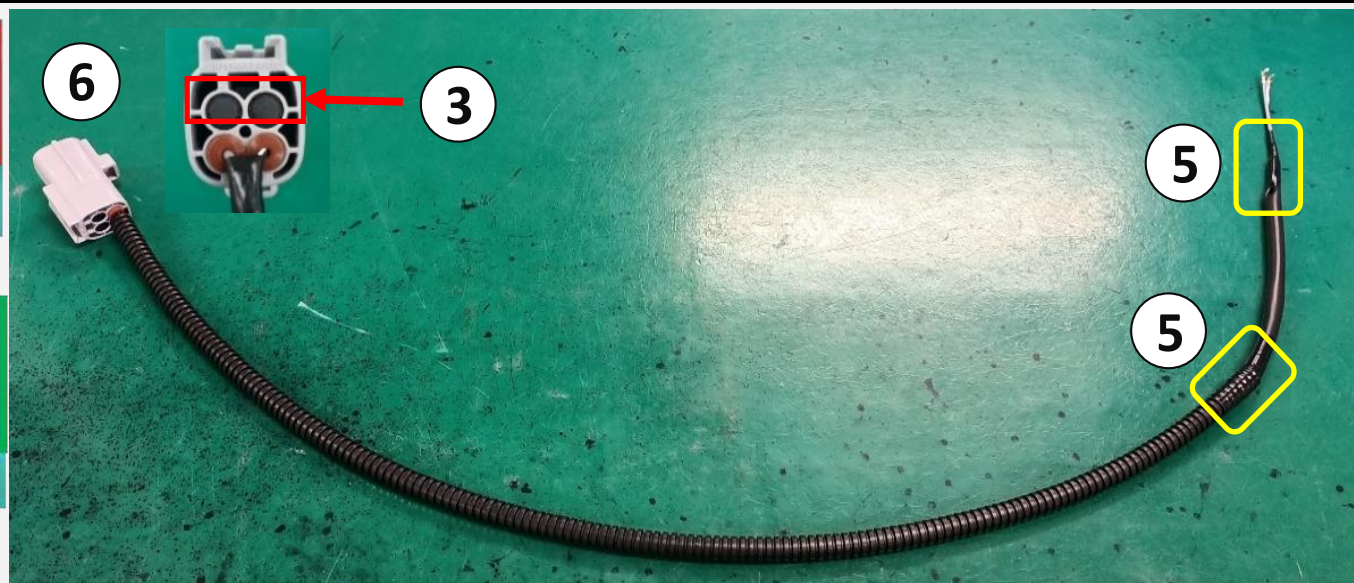
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**PARTS:**

1. Assy parts

JIG:

N/A

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P1****7L0139-7020A****NO GOOD****GOOD****GOOD****GOOD****NO GOOD****NO GOOD****1****No Unlock/ Half Lock Connector****4****No Terminal Backing out****2****No Wrong Insert****5****No Missing Tape****3****No Missing Dummy Seal****6****No Deformed Terminal**

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