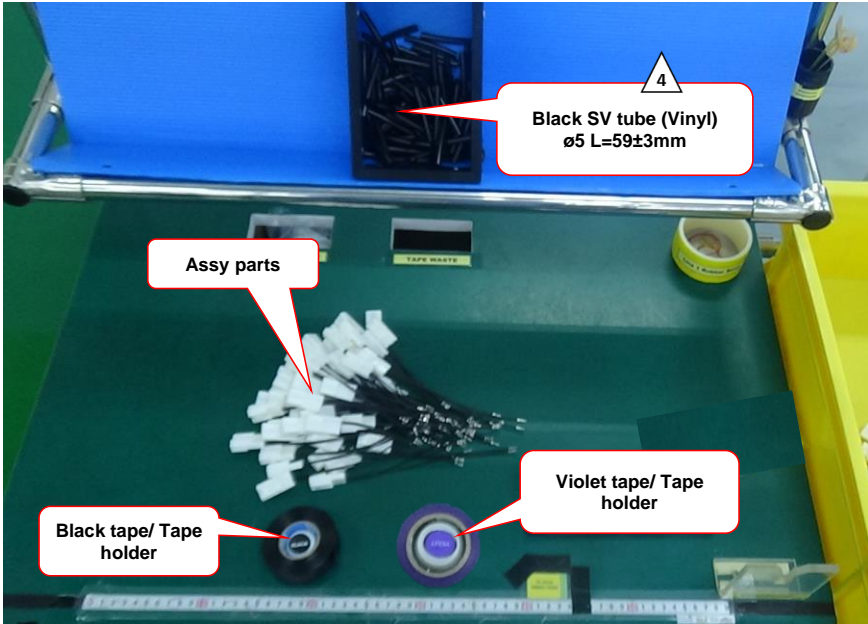




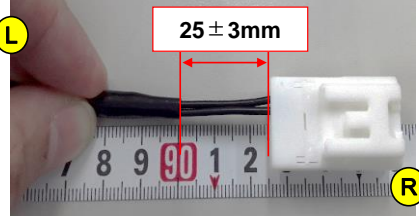

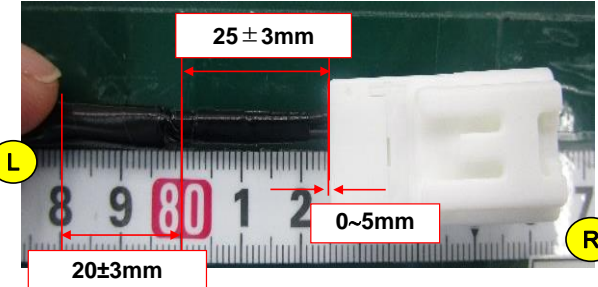
	WORK INSTRUCTION				Effectivity Date:	Mrach 22, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 150B / 7N0002-7020A		Customer: TRMX	Car Model: TOYOTA-COROLLA	Document No.:	WI-ENG-PDE-281		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	4	Page No.:	1 of 5

PARTS:		1. Assy parts (Connector 6098-3802 (W); AVSSf 0.3 wires B L=146mm [2pcs.]); Black SV tube (vinyl) ø5 L=59±3mm; Violet tape: Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
1	P1 Table Lay-out	<div style="text-align: center;"> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;">TABLE LAY-OUT</div>  </div>	<div style="border: 1px dashed 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 dashed 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 dashed 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-ENG-PDE-280 Offline Assembly Process 1.No missing parts/tools 2.No excess parts/tools	

Revision History								Prepared by	Reviewed by	Approved by	Noted by
03/22/24	4	Transfer to new format. Inclusion of Table lay-out. Change term from Vinyl tube to SV tube (Vinyl). Change process sequence due to process improvement. Update work procedure/illustration Process 5. Inclusion of car model "TOYOTA-COROLLA". Remove By two's inspection and change Quality checkpoints to Visual inspection.				D.Castillo	C. Villanueva	A. Arañes	n/a		n/a
07/15/21	3	Removal of marking				J. Loterte	C. Villanueva	A. Shimamura	A. Arañes		
06/11/21	2	Transferred process owner from Production (WI-PRO-ASY-132) to Engineering (WI-ENG-PDE-281); xlmprove process illustration and quality pointers.				J. Loterte	C. Villanueva	A. Shimamura	A. Arañes		
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	October 17, 2018

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	WORK INSTRUCTION			Effectivity Date:	Mrach 22, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 150B / 7N0002-7020A		Customer: TRMX	Car Model: TOYOTA COROLLA	Document No.:	WI-ENG-PDE-281	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	4	Page No.:	2 of 5

PARTS: <div style="border: 1px solid black; padding: 2px; display: inline-block;">4</div>	1. Assy parts 2. Black SV tube (Vinyl) ø5 L=59±3mm 3. Black tape			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	<div style="border: 1px solid black; padding: 2px; display: inline-block;">4</div> Wire insertion to Black SV tube (vinyl) ø5 L= 59±3mm	 <div style="border: 1px solid black; padding: 5px; margin-top: 5px;"> 1. Get the SV tube (Vinyl) ø5 L= 59±3mm using right hand then insert the B-B wires. </div>		<div style="border: 1px solid red; padding: 2px; display: inline-block;">MEASURING TAPE</div> 	1. No wrong usage of parts 2. No deformed terminal
3	<div style="border: 1px solid black; padding: 2px; display: inline-block;">4</div> P1 Taping 1 SV tube (Vinyl) to wire near connector	<div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  <div style="border: 1px solid black; padding: 5px; margin-top: 5px;"> 1. Measure from end of SV tube(Vinyl) to connector 25±3mm using both hands. </div> </div> <div style="text-align: center;">  <div style="border: 1px solid black; padding: 5px; margin-top: 5px;"> 2. Hold the SV tube (Vinyl) using left hand then start taping using right hand. </div> </div> </div> <div style="text-align: center; margin-top: 20px;">  <div style="border: 1px solid black; padding: 5px; margin-top: 5px;"> 3. After taping, check the measurement and taping condition </div> </div>		n/a	Important remiinders/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 dimension 6. No wrong use of tape

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TAPING ASSEMBLY PROCESS

Effectivity Date:

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Model code/Part number:

150B / 7N0002-7020A

Customer:

TRMX

Car Model:

TOYOTA COROLLA

Document No.:

WI-ENG-PDE-281

Purpose:

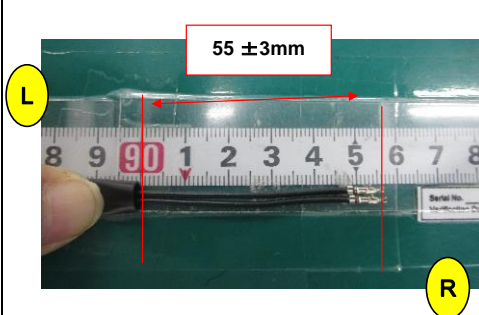
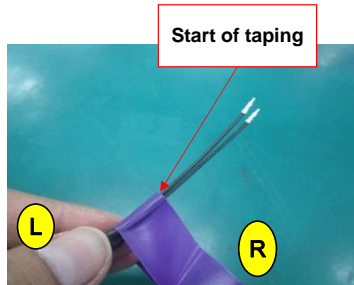
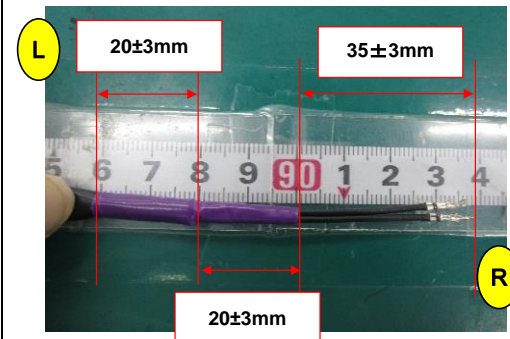

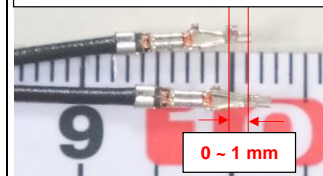
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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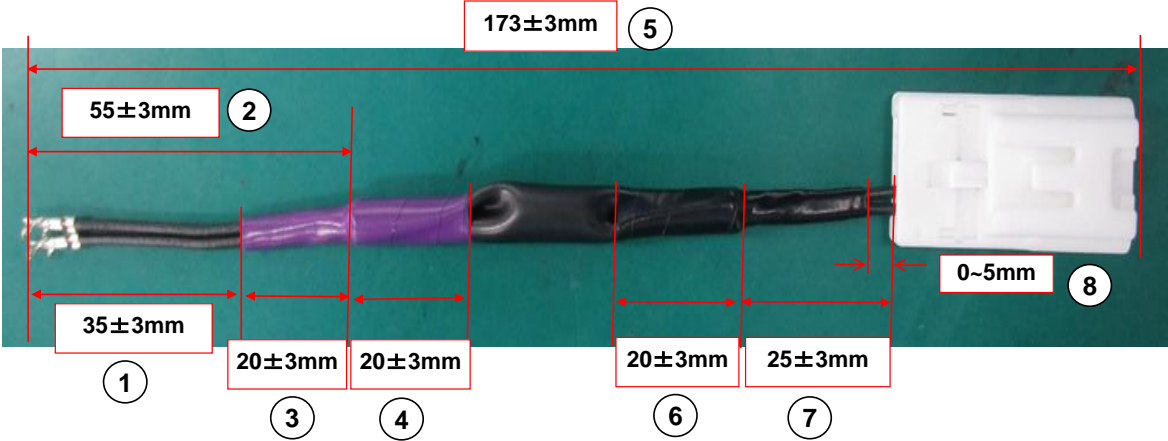
PARTS:		1. Assy parts 2. Violet tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 Taping 2 SV tube (Vinyl) to wires near terminal	<div><div></div><div><p>1. Measure from end of the SV tube (Vinyl) up to the terminal tip 55 ± 3mm using both hands.</p></div><div><div></div><div><p>2. Hold the SV tube (Vinyl) using left hand, get the Violet tape then start taping using right hand.</p></div><div><div></div><div><p>3. After taping, check the condition of tape, measurement and wire alignment.</p></div></div></div><div><div></div><div>MEASURING TAPE</div></div></div>		<p>Important reminders/Note/s;</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s;</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <p>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</p> <div><div>Wire alignment tolerance</div><div></div></div>	

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	WORK INSTRUCTION				Effectivity Date:	Mrach 22, 2024					
	TAPING ASSEMBLY PROCESS				Validity Date:	n/a					
	Process Name/Title:		Model code/Part number: 150B / 7N0002-7020A		Customer: TRMX	Car Model: TOYOTA COROLLA		Document No.:	WI-ENG-PDE-281		
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO		Revision No.:	4	Page No.:	4 of 5

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

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**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

Mrach 22, 2024

Model code/Part number:

150B / 7N0002-7020A

Customer:

TRMX

Car Model:

TOYOTA-COROLLA

Document No.:

WI-ENG-PDE-281

Purpose:

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Revision No.:

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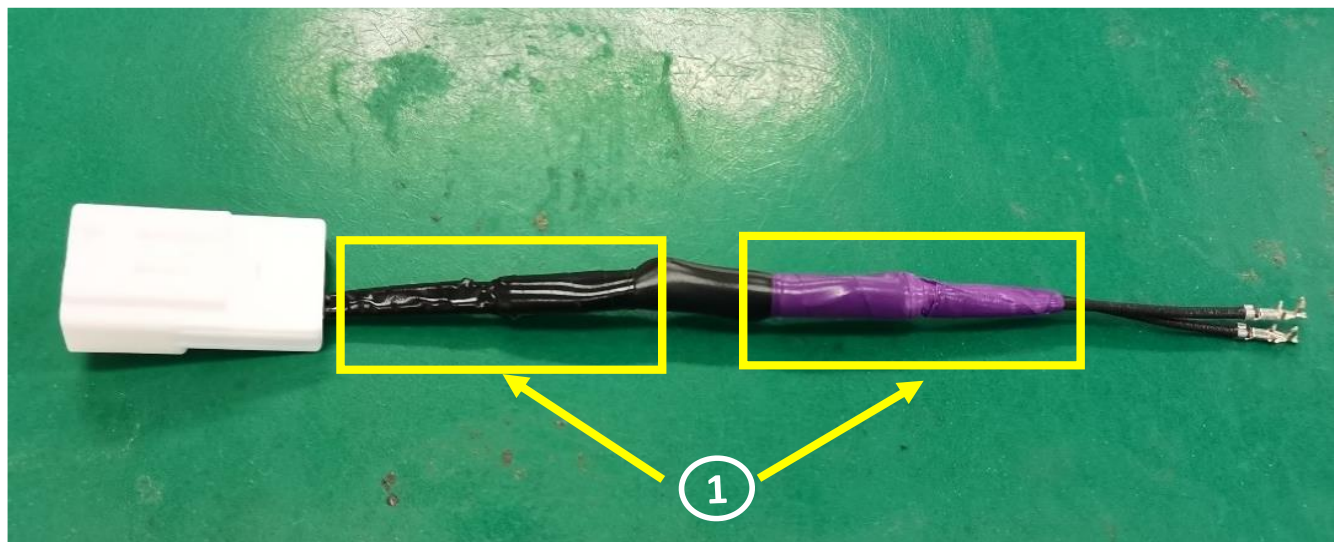
Page No.:

5 of 5**PARTS:**

n/a

JIG:

n/a

**VISUAL INSPECTION****TAPING - P1****7N0002-7020A****1****No Missing Tape and
No Wrong use of tape (violet tape)**

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