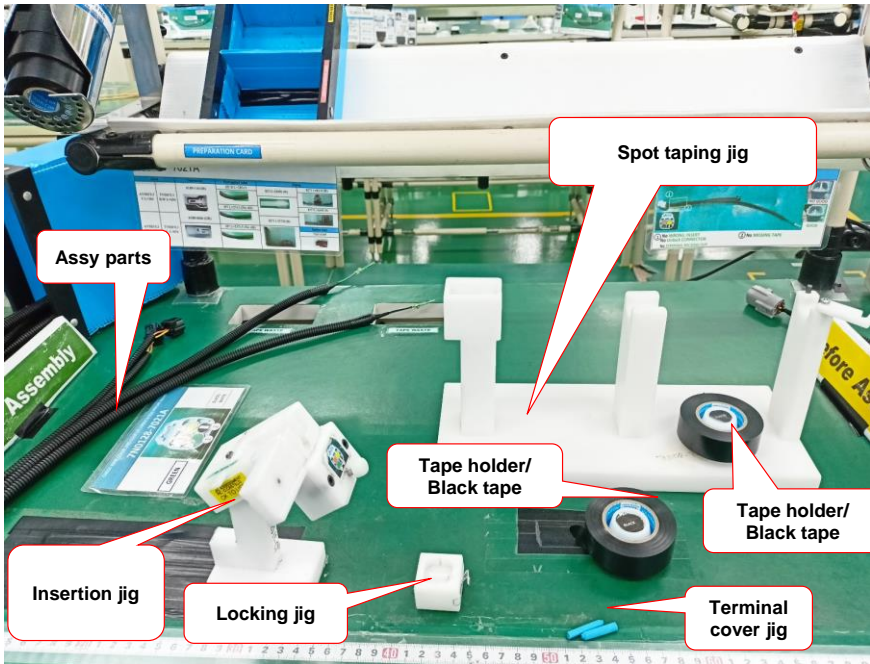

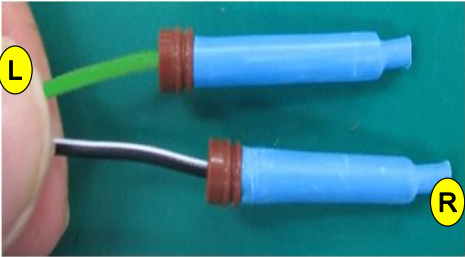
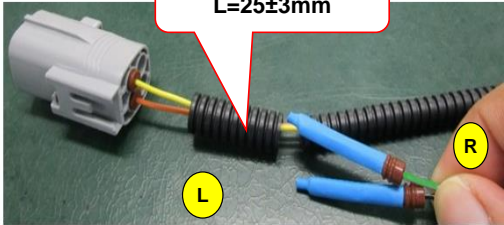
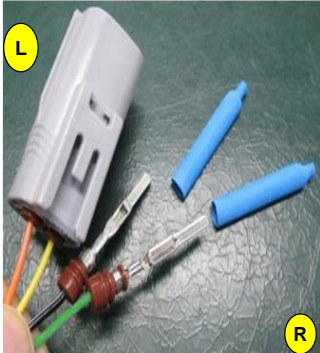

	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>July 4, 2024</b>		
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>178D / 7N0128-7021A</b>		Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA-COROLLA</b>	Document No.:	<b>WI-ENG-PDE-419B</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		5	Page No.:	1 of 10	

<b>PARTS:</b>		1. Assy parts; Black tape [2pcs]				<b>JIG:</b>		1. Insertion jig 2. Locking jig 3. Terminal cover jig 4. Spot Taping jig					
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>				<b>TOOLS/PPE</b>		<b>QUALITY POINTERS</b>					
1	P2	<p style="text-align: center;"><b>Table Lay-out</b></p> 				<p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>		<p>1. No missing parts/tools 2. No excess parts/tools</p>					
Revision History						Prepared by		Reviewed by		Approved by		Noted by	
07/04/24	5	Inclusion of car model "TOYOTA-COROLLA" and Measurement.				D.Castillo	C.Villanueva	A. Arañes	n/a				
02/08/23	4	Inclusion of quality checkpoints on page no. 8 as Document process improvements.				M.Ariola	J. Loterte	C. Villanueva	A. Arañes				
10/28/22	3	Change of measurement from end of tape up to connector from 25±3mm to 28±2mm as countermeasure of encountered NG dimension and peel-off tape.				M.Ariola	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	February 19, 2022		

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	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.:		<b>WI-ENG-PDE-419B</b>			
				Revision No.:		5		Page No.:	2 of 10	

<b>PARTS:</b>		1. Assy parts		<b>JIG:</b>		1. Insertion jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>		<b>QUALITY POINTERS</b>	
2	P2 Wire insertion to assy parts	<div><p>1. Get the <b>MRSW CP G-B/W wires L=655±3mm</b> using both hands then insert the terminal cover jig using right hand.</p></div> <div><p>2. Get the assy parts then hold the COT (no slit) <b>Ø7 L=25±3mm</b> using left hand then insert the <b>MRSW CP G-B/W wires L=655±3mm</b> using right hand.</p></div> <div><p>3. After insertion, remove the cover jig using right hand.</p></div>		<div><p><b>TERMINAL COVER JIG</b></p></div>		1. No wrong usage of parts 2. No damaged rubber seal 3. No exposed rubber seal during insertion	

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# WORK INSTRUCTION

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## TAPING ASSEMBLY PROCESS

Effectivity Date:

July 4, 2024

Validity Date:

n/a

Model code/Part number:

178D / 7N0128-7021A

Customer:

TRQSS

Car Model:

TOYOTA-COROLLA

Document No.:

WI-ENG-PDE-419B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

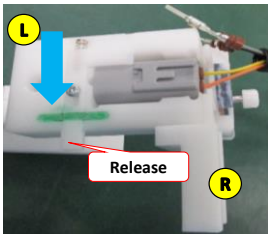
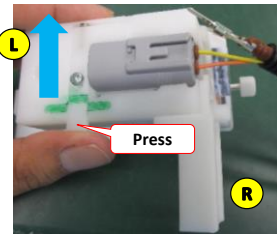
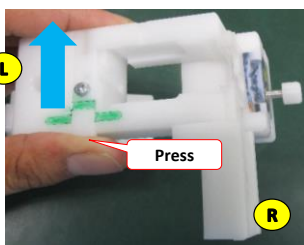
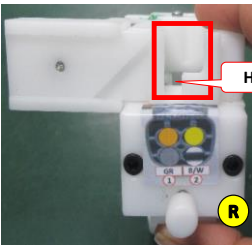
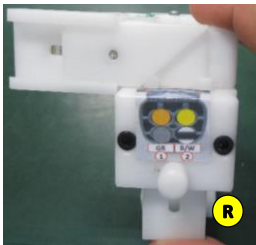

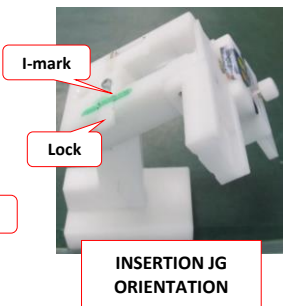
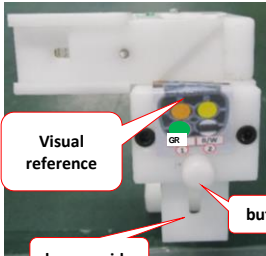
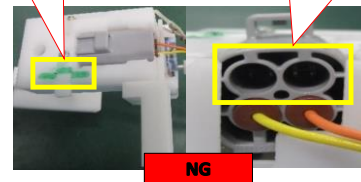
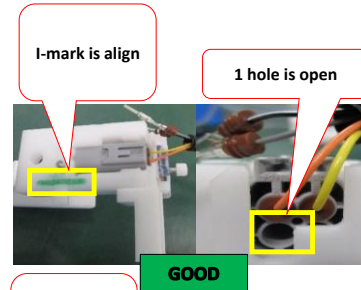
☒ MASSPRO

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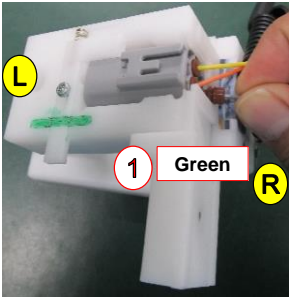
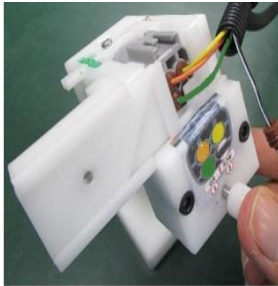
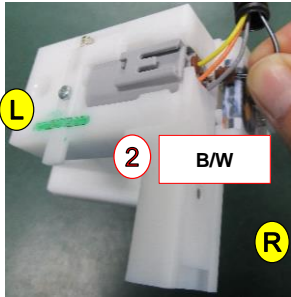
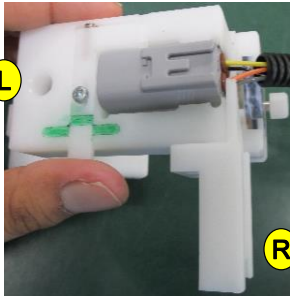
PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 Connector setting to insertion jig 6188-0066 (GR) (Assy parts)	<div><p>1. Push the lower wire guide upward using right thumb. Slot for <b>Green wire</b> will be opened.</p><p>2. Press the lock of insertion jig using left thumb.</p><p>3. Get the connector <b>6188-0066 (GR)</b> using right hand and insert to insertion jig. Release the lock after insertion. <b>Note: Follow the connector orientation.</b></p></div>		n/a	<div><p><b>CONNECTOR ORIENTATION ILLUSTRATION</b></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><p><b>Important reminders/Note/s:</b> <b>1. Follow the connector orientation</b></p></div>

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	<b>WORK INSTRUCTION</b>				Effectivity Date:	July 4, 2024		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>178D / 7N0128-7021A</b>		Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA-COROLLA</b>	Document No.:	<b>WI-ENG-PDE-419B</b>		
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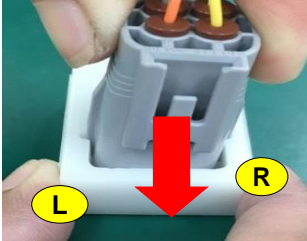


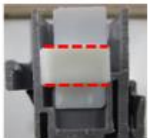
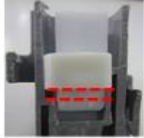
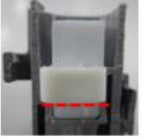

<b>PARTS:</b>	1. Assy parts			JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
4	P2 Wire insertion to connector 6188-0066 (GR) (Assy parts)	<div><p>WIRE FACING</p></div> <div><p>1 Hold the <b>G wire</b> then insert to terminal slot <b>1</b> using right hand.</p></div> <div><p>2. Press the button using right thumb. The slot for <b>B/W wire</b> will be opened.</p></div> <div><p>3. Hold the <b>B/W wire</b> then insert to terminal slot <b>2</b> using right hand.</p></div> <div><p>4. After insertion, push the lock using left thumb 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><b>Important reminders/Note/s:</b> <i>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.</i></p> <p><b>Document references:</b> <i>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i></p>

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	<b>WORK INSTRUCTION</b>				Effectivity Date:		July 4, 2024				
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a				
	Process Name/Title:		Model code/Part number: <b>178D / 7N0128-7021A</b>		Customer: <b>TRQSS</b>		Car Model: <b>TOYOTA-COROLLA</b>				
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.:		WI-ENG-PDE-419B				
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<b>PARTS:</b>		1. Assy parts		JIG:		1. Locking jig			
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>		<b>QUALITY POINTERS</b>			
5	P2	Connector Lock		<div><p>1. Put the connector into locking jig using right hand then press <b>2x</b>. Touch the connector lock to confirm if properly locked.</p><p>Before pressing</p><p>After pressing</p><div><p><b>Coupler Cross Sectional View</b></p><div><p><b>NG</b></p><p>Unlock</p></div><div><p><b>NG</b></p><p>Half Lock Condition</p></div><div><p><b>GOOD</b></p><p>Full Lock Condition</p></div></div></div>		<div><p><b>LOCKING JIG</b></p></div>		<p><b>Important reminders /Note/s:</b></p> <p><b>1.MANUAL LOCKING MAY CAUSED DAMAGED LOCK</b></p> <p>1. Use the provided locking jig per model 2. No unlock/half-locked connector</p>	

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Model code/Part number:

178D / 7N0128-7021A

Customer:

TRQSS

Car Model:

TOYOTA-COROLLA

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

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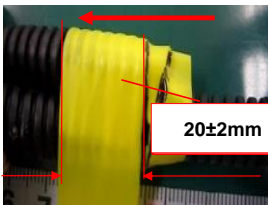
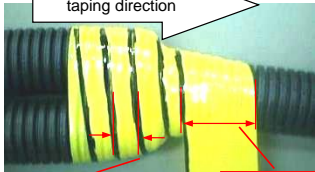
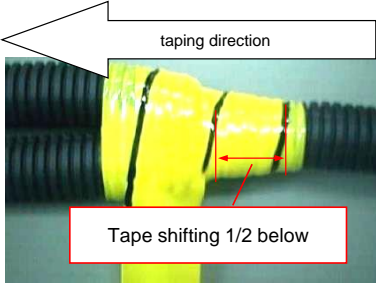


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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P2	<div>NO GAP BETWEEN CORRUGATED TUBES</div> <div></div> <div>1. Fix the corrugated tube .</div> <div></div> <div></div> <div>20±2mm</div> <div>2. Start taping at the middle of combined Corrugated tubes, then winding the tape to left side width must be same with (20±2mm)</div> <div></div> <div>taping direction</div> <div>Tape shifting 1/3 below</div> <div>20±2mm</div> <div>3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be same with 20±2mm)</div> <div></div> <div>taping direction</div> <div>Tape shifting 1/2 below</div> <div>4. Wind the tape backward 1/2 shifting.</div>		<div>MEASURING TAPE</div> <div></div>	<div>Important reminders and Note/s:</div> <div>1. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines, but actual should be <b>BLACK TAPE</b>.</div> <div>2. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-ASY-001 for taping procedure.</div> <div>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</div> <div>Y-TAPING ORIENTATION</div> <div></div>

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## WORK INSTRUCTION

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## TAPING ASSEMBLY PROCESS

Effectivity Date:

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Model code/Part number:

178D / 7N0128-7021A

Customer:

TRQSS

Car Model:

TOYOTA-COROLLA

Document No.:

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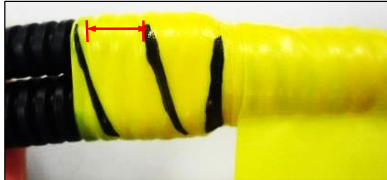

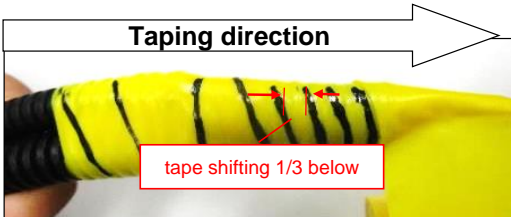
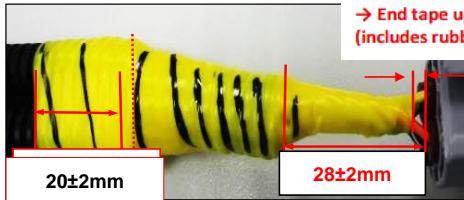
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P2	Y-taping (Continuation)		<div>MEASURING TAPE</div>	<p><b>Important reminders and Note/s:</b></p> <p>1. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines, but actual should be <b>BLACK TAPE</b>.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p><b>Document reference/s:</b></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> <div>5. Wind the tape <b>1/2</b> shifting going to other side of corrugated tube.</div> <div></div> <div>6. Make the half of tape outside the COT then wind it 2-3 times as Pre-Taping.</div> <div></div> <div>7. Wind the tape <b>1/3</b> shifting until it reach the wire , make 3 winds to wires then cut.</div> <div></div> <div>8. After taping, check the measurement and taping condition.</div>			


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	Model code/Part number: <b>178D / 7N0128-7021A</b>		Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA-COROLLA</b>	Document No.:		<b>WI-ENG-PDE-419B</b>	
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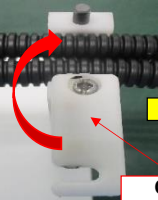
<b>PARTS:</b>		1. Assy parts 2. Black tape		JIG:	1. Spot taping jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
7	P2	Spot taping		<div>MEASURING TAPE</div> 	<p><b>Important reminders and Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></p> <ul style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong dimension</li><li>6. No wrong use of tape</li></ul>



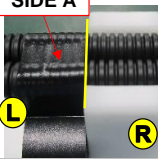
CONNECTOR SETTING



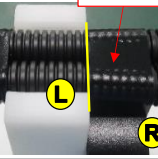
COT LOCK



COT LOCK



SIDE A



SIDE B

20±3mm 20±3mm

1. Get the assy parts then set into jig using both hands. (See above picture for correct setting). First, set the connector 6188-0066 (GR) to Receiver base. Continue to set the 2 COT in the COT guide then lock.

2. Hold the assy parts using left hand, get the Black tape then conduct 2 windings of tape on SIDE A then cut using both hands.

3. 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.

4. Check the measurement and taping condition.

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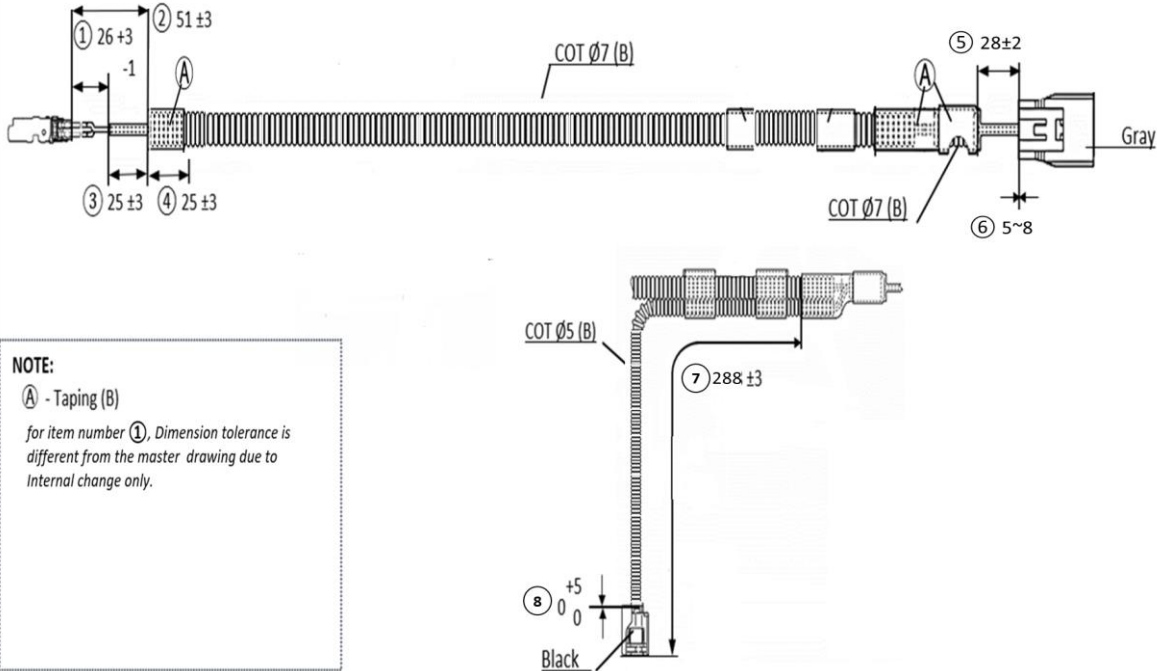
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P2	Measurement	<div><div>MEASURING TAPE</div></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**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

July 4, 2024

Validity Date:

n/a

Model code/Part number:

**178D / 7N0128-7021A**

Customer:

**TRQSS**

Car Model:

**TOYOTA-COROLLA**

Document No.:

**WI-ENG-PDE-419B**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

5

Page No.:

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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P2****7N0128-7021A****NO GOOD****GOOD****②****②****①**

**No WRONG INSERT**  
**No Unlock CONNECTOR**  
**No TERMINAL BACKING OUT**

**②**

**No MISSING TAPE**

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