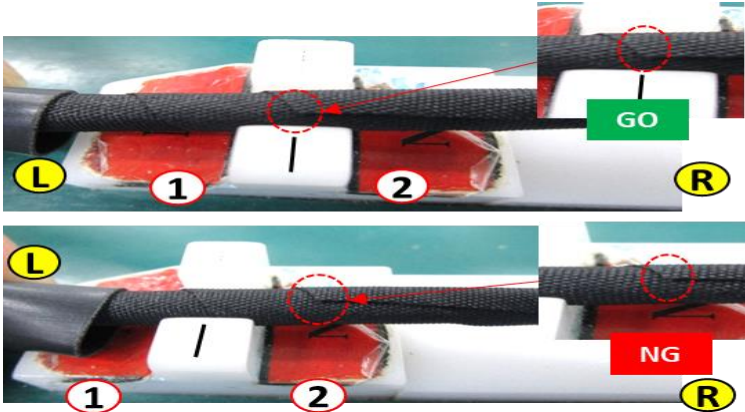
	WORK INSTRUCTION						Effectivity Date:		December 4, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS						Validity Date:		n/a	
	Model code/Part number: 350B/320B/014B/ 360B/150B/		17J796-7051		Customer: TRP	Car Model: TOYOTA-COROLLA/ RAV-4/ HIGHLANDER	Document No.:		WI-ENG-PDE-091F	
	Purpose: <input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:		18	Page No.: 1 of 7

PARTS:	1. Assy parts			JIG:	1. Measuring jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
1	<div><div>18</div><div>HIGH</div><div>P5</div><div>Measurement</div></div>	<div></div> <div>1. After taping, check the END POINT TAPE using measuring jig.</div>			<div>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	<div>Important reminders/Note/s: 1. END POINT TAPE should be within the limit GO. If end point tape reaches the location 1 and 2 it will be considered as NG.</div> <div>1. No wrong dimension</div>		

Revision History							Prepared by	Reviewed by	Approved by	Noted by	
12/04/24	18	Inclusion of Quality improvement measures (based on Mizen Boshi activity). Inclusion of Car model "TOYOTA-COROLLA/ RAV-4/ HIGHLANDER".					D.Castillo	C. Villanueva	A. Arañes	n/a	
09/25/24	17	Additional Important reminders/Note/s and Visual reference (Page 3).					D.Castillo	C.Villanueva	A. Arañes	n/a	
06/24/24	16	Additional quality pointers to Process 2, Additional Important reminders/Note/s, Good and No Good and Improved Visual inspection to Process 4.					D.Castillo	C.Villanueva	A. Arañes	n/a	
07/25/23	15	Transfer process of Measurement from P5 due to TPS improvements.					M. Ariola	J. Loterte	C.Villanueva	A. Arañes	
Eff. Date	Rev. No	Details of Change					Revised	Reviewed	Approved	Noted	
							Est. Date:	June 02, 2017			

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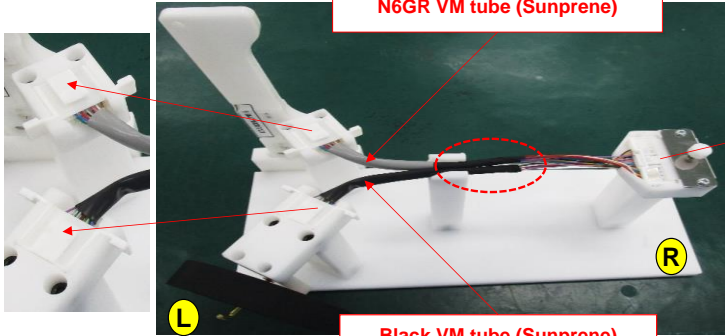

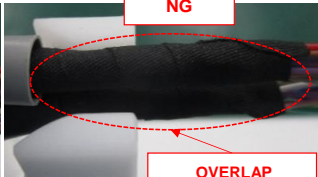
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WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

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Process Name/Title:	TAPING ASSEMBLY PROCESS		
Model code/Part number:	350B/320B/014B/ 360B/150B/	17J796-7051	Customer: TRP
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:		1. Assy parts 2. Tesa tape 51036		JIG:	1. Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	<div>18</div> <div>HIGH</div> <div>P5</div> <div>Taping 3 Wire taping (Tesa)</div>	<div><div><div><p>BEFORE PRESSING</p></div><div><p>AFTER PRESSING</p></div></div><div><div><p>N6GR VM tube (Sunprene)</p><p>Black VM tube (Sunprene)</p><p>CONNECTOR SETTING</p></div><div><p>1. Set the connector 1827842-1 (W) then push the guide lock using right index finger.</p><p>2. Continue to set the harness on Jig 2. (See picture for the correct setting).</p></div><div><div><p>GOOD</p></div><div><p>NG</p><p>OVERLAP</p></div></div></div></div>		n/a	1. No wrong setting of harness 2. No wrong orientation of connector 3.Wires must allign properly to avoid bend wire .

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

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Process Name/Title:

Model code/Part number:

350B/320B/014B/
360B/150B/

17J796-7051

Customer: TRP

Car Model:

TOYOTA-COROLLA/
RAV-4/ HIGHLANDER

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PARTS:

1. Assy parts
2. Tesa tape 51036

JIG:

1. Taping jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

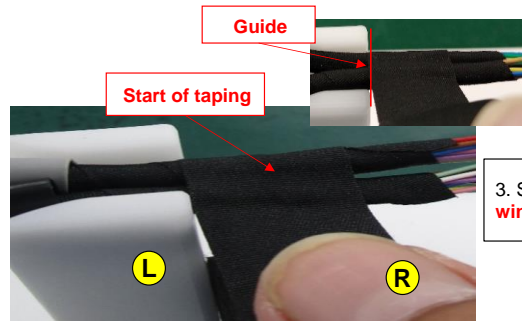
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P5

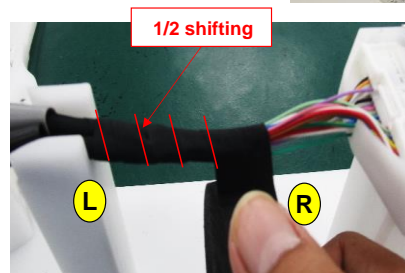
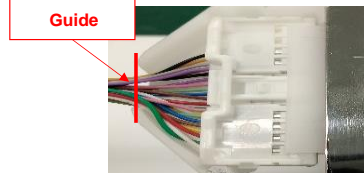
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HIGH

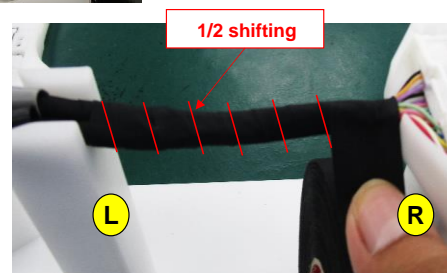
Taping 3
Wire taping (Tesa)
(Continuation)



3. Start taping using guide **1 1/2**
winding.



4. Make **1/2 shifting** or **6-7 windings** going to the right side until it reach the guide near connector.



5. Make **2 windings** of tape before cut.

1. No loose tape
2. No excessive tape winding
3. No damage on parts
4. No peel off tape
5. No bend wire
6. No NG of end tape

Important reminders/Note/s:

1. **No holding/fixing of wire during taping.**



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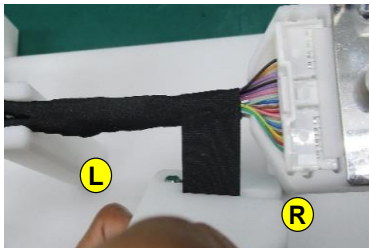
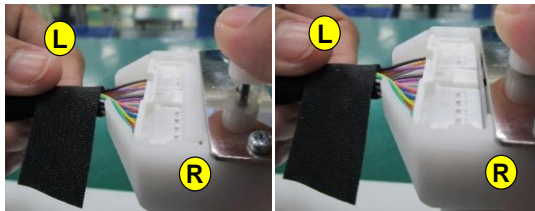
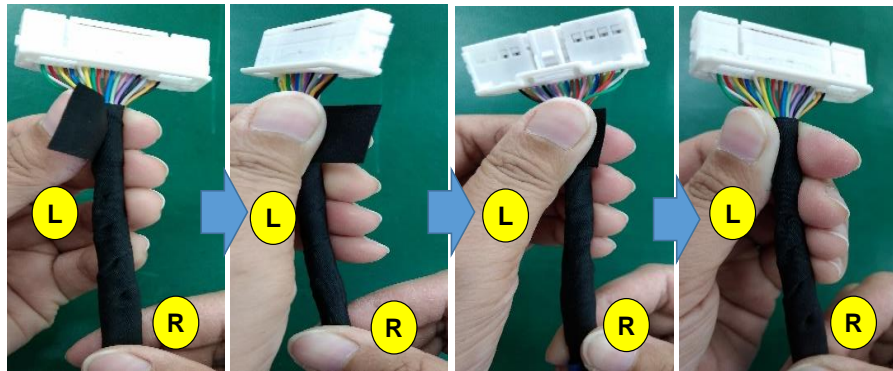

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PARTS:		1. Assy parts 2. Tesa tape 51036			JIG:	1. Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	P5 <div>18</div> <div>HIGHc</div> <div>Taping 3 Wire taping (Tesa) (Continuation)</div>	<div><div>6. Cut the tape using provided cutter only using both hands.</div></div> <div><div>BEFORE PRESSING</div><div>AFTER PRESSING</div><div>7. Hold the assy parts then press the lock button using right thumb. Remove the harness from jig.</div></div> <div><div>8. Press the end tape using left hand. Do not touch the adhesive</div></div>			 <div>Use only this cutter</div>	1. No loose tape 2. No excessive tape winding 3. No damage on parts 4. No peel off tape 5. No bend wire 6. No NG of end tape

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17J796-7051

Customer: TRP

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TOYOTA-COROLLA/
RAV-4/ HIGHLANDER

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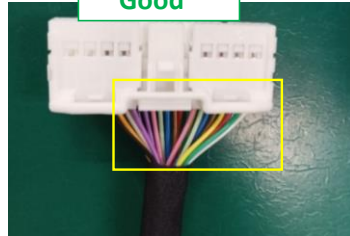


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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	<div><div>18</div><div>Medium</div><div>P5</div><div>Visual inspection</div></div>	<div><div><div>Good</div></div><div><div>No Good</div></div></div> <div></div> <div><div>9. After taping, check the alignment and condition of tape.</div><div>10. Proceed to Continuity checking of a product and follow the instructions.</div><div>11. After checking of continuity of a product, proceed to End tape pressing process and follow the instructions.</div></div>	n/a	<div>1. No loose tape 2. No excessive tape winding 3. No damage on parts 4. No peel off tape 5. No bend Wire</div> <div>Important reminders/Note/s: 1. All wires must be properly align and not tangled to avoid bend wire . (see picture for reference) 2. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</div> <div>Document references: 1. Refer to WI-ENG-PDE-010 Continuity Testing 2. Refer to WI-ENG-PDE-001 Sub Assembly Treatment on Lever Con Continuity Checker NG if encountered any defect/NG product 3. Refer to WI-ENG-PDE-096 End tape pressing process 4. Refer to IS-QAD-QAC-005 Inspection Standard 17J796-7051</div>

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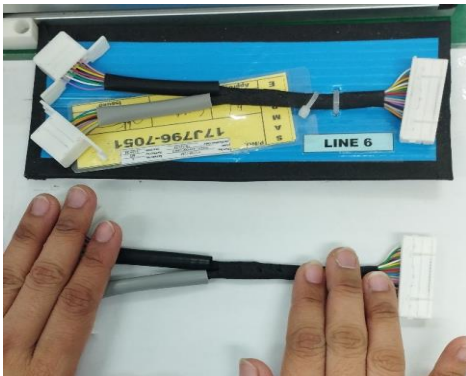


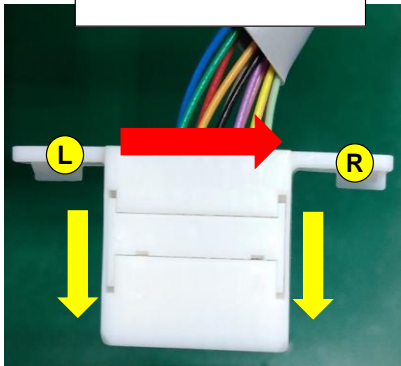
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PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P5 18 Medium Visual inspection (Continuation)	 LEGEND:  First way checking of connector lock  Second way checking of connector lock  N6GR VM TUBE (SUNPRENE)		n/a	1. No loose tape 2. No excessive tape winding 3. No damage on parts 4. No peel off tape 5. No bend wire 6. No NG of end tape 7. No damaged double lock 8. No half-locked connector

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	<div>18</div> <div>Medium</div> <div>Visual inspection (Continuation)</div>	<div><div><div>LEGEND:</div><div><div>→ First way checking of connector lock</div><div>→ Second way checking of connector lock</div></div></div><div><div>5. Ensure that connector is in locked condition by slide touching the connector lock from LEFT to RIGHT using right thumb.</div></div><div><div><div>BLACK VM TUBE (SUNPRENE)</div><div><div><div>L</div><div>R</div></div><div><div>→</div><div>↓</div><div>↓</div></div></div><div><div>6. Ensure that connector is in locked condition by touching the LEFT SIDE of connector lock from TOP to BOTTOM using right thumb.</div><div><div>7. Ensure that connector is in locked condition by touching the RIGHT SIDE of connector lock from TOP to BOTTOM using right thumb.</div></div></div><div><div>WAY OF CHECKING CONNECTOR LOCK</div><div><div><div>L</div><div>R</div></div><div><div>→</div><div>→</div></div></div><div><div><div>1</div><div>2</div></div><div><div><div>→</div><div>→</div></div></div></div><div><div>8. Ensure that connector is in locked condition by slide touching the connector lock from left to right sing right thumb based on the sequence illustrated.</div></div><div><div><div>9. Check the taping condition, must be no exposed end tape inside.</div></div></div></div></div></div></div>	n/a	<div>1. No loose tape</div> <div>2. No excessive tape winding</div> <div>3. No damage on parts</div> <div>4. No peel off tape</div> <div>5. No bend wire</div> <div>6. No NG of end tape</div> <div>7. No damaged double lock</div> <div>8. No half-locked connector</div>

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