
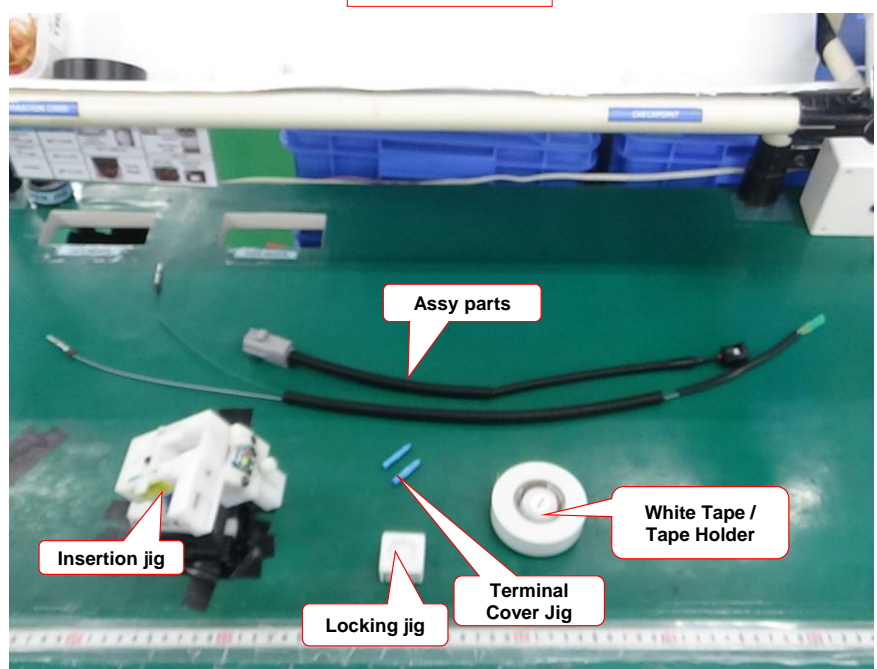



	<b>WORK INSTRUCTION</b> <b>TAPING ASSEMBLY PROCESS</b>				Effectivity Date: <b>July 10, 2024</b>	
	Process Name/Title:				Validity Date: <b>n/a</b>	
	Model code/Part number: <b>010B / 7L0033-7024</b>		Customer: <b>TRQSS</b>		Car Model: <b>TOYOTA-CAMRY</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.: <b>WI-ENG-PDE-065B</b>		Revision No.: <b>10</b>	
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<b>PARTS:</b> 1. Assy Parts ; White Tape		<b>JIG:</b> 1. Insertion jig 2. Locking jig 3. Terminal cover jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<div style="text-align: center;">  <b>WORK PROCEDURE/ ILLUSTRATION</b> </div>	<b>TOOLS/PPE</b>
1	P2 Table Lay-out	<div style="text-align: center;">  </div>	<div style="border: 1px solid red; padding: 5px; margin-bottom: 5px;"> <b>Safety Instruction</b>          Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)       </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 5px;"> <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 style="border: 1px solid red; padding: 5px;"> <b>Alert level</b>          For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.       </div>
		<b>QUALITY POINTERS</b> 1. No missing parts/tools 2. No excess parts/tools	


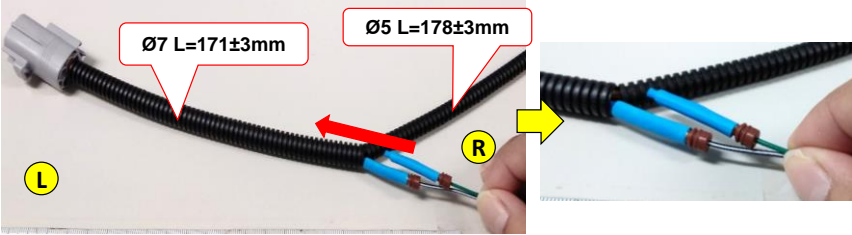
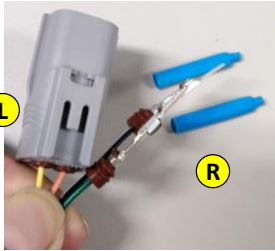

  

Revision History						Prepared by	Reviewed by	Approved by	Noted by
07/10/24	10	Transfer wire insertion to assy parts from P1 and transfer COT to VM tube (Sunprene) Taping to P3 due to process improvement. Inclusion of car model "TOYOTA-CAMRY". Update table lay-out, and Visual inspection.	D. Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes
04/24/23	9	Inclusion of quality checkpoints	J. Loterte	C. Villanueva	A. Arañes	n/a			
06/01/22	8	Remove process no.2 and transfer to P1 due to Process Improvement. Change table Lay-out. Removal of old Revision Triangles.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes			
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 24, 2018	

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	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>July 10, 2024</b>		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>010B / 7L0033-7024</b>		Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA-CAMRY</b>	Document No.:	<b>WI-ENG-PDE-065B</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	10	Page No.:	2 of 6

<b>PARTS:</b>	1. Assy parts			JIG:	1. Terminal cover 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 terminal cover jig using right hand then insert to both terminals (<b>G-B/W wires</b>) using right hand.</p></div> <div><p>2. Hold the COT <b>Ø7 L=171±3mm</b> using left hand then insert the <b>G-B/W wires</b> using right hand.</p></div> <div><p>3. After insertion, remove the cover jig using right hand.</p></div>			<div><b>TERMINAL COVER JIG</b></div> 	1. No wrong usage of parts 2. No damaged rubber seal		

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## WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

July 10, 2024

Model code/Part number:

010B / 7L0033-7024

Customer:

TRQSS

Car Model:

TOYOTA-CAMRY

Document No.:

WI-ENG-PDE-065B

Purpose:

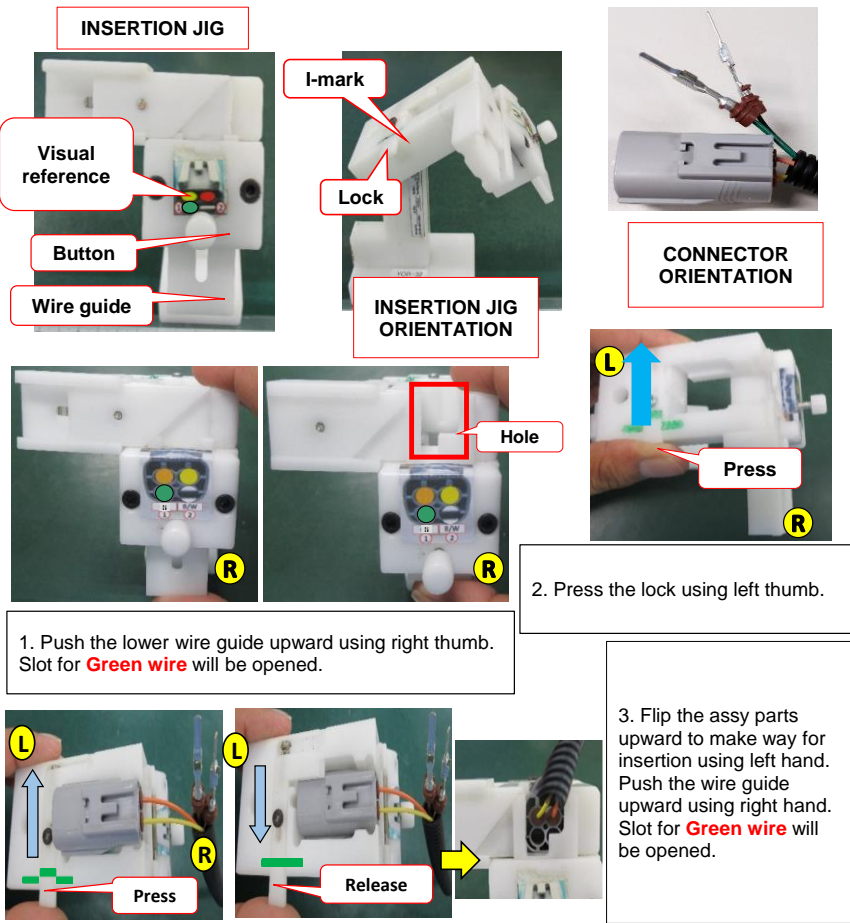
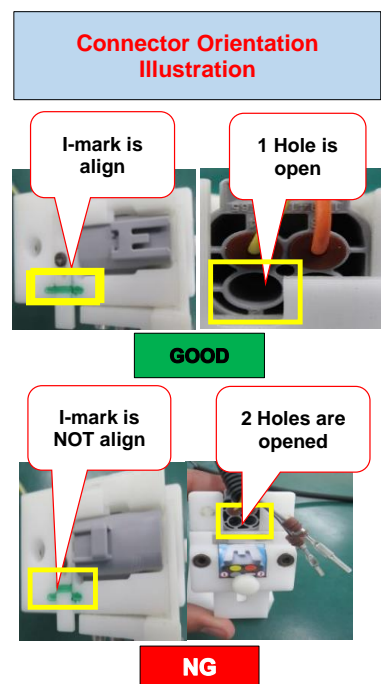
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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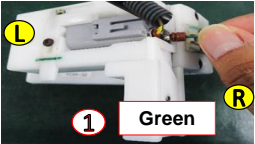

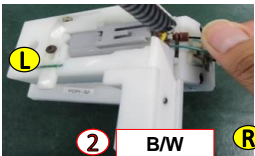
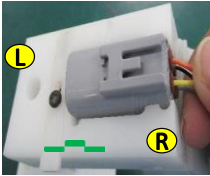
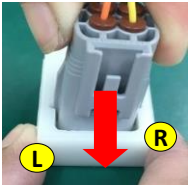



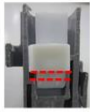


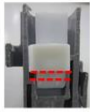



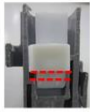

PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	<p>Connector setting to insertion jig 6188-0066 (GR) (Assy parts)</p>  <p>1. Push the lower wire guide upward using right thumb. Slot for <b>Green wire</b> will be opened.</p> <p>2. Press the lock using left thumb.</p> <p>3. Flip the assy parts upward to make way for insertion using left hand. Push the wire guide upward using right hand. Slot for <b>Green wire</b> will be opened.</p>		n/a	<p><b>Connector Orientation Illustration</b></p>  <p><b>GOOD</b></p> <p><b>NG</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>

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	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>July 10, 2024</b>		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>010B / 7L0033-7024</b>		Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA-CAMRY</b>	Document No.:	<b>WI-ENG-PDE-065B</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	10	Page No.:	4 of 6

<b>PARTS:</b>	1. Assy parts			JIG:	1. Insertion jig 2. Locking jig								
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>									
4	Wire insertion to connector 6188-0066 (GR)	<div><p>1 Hold the <b>Green</b> wire then insert to terminal slot <b>1</b> using right hand.</p></div> <div><p><b>WIRE FACING</b></p><p>2. Press the button using right thumb. The slot for <b>B/W</b> wire will be opened.</p></div> <div><p>3. Hold the <b>B/W</b> wire 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	<div><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><b>Important reminders /Note/s:</b> 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div></div>									
5	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></div> <div><p><b>Before pressing</b></p></div> <div><p><b>After pressing</b></p></div> <div><p><b>Coupler Cross Sectional View</b></p><table><tr><td><b>NG</b></td><td><b>NG</b></td><td><b>GOOD</b></td></tr><tr><td></td><td></td><td></td></tr><tr><td>Unlock</td><td>Half Lock Condition</td><td>Full Lock Condition</td></tr></table></div>	<b>NG</b>	<b>NG</b>	<b>GOOD</b>				Unlock	Half Lock Condition	Full Lock Condition	<div><p><b>LOCKING JIG</b></p></div>	<div><b>Important reminders /Note/s:</b> 1. MANUAL LOCKING MAY CAUSED DAMAGED LOCK 2. No unlock/half-locked connector</div>
<b>NG</b>	<b>NG</b>	<b>GOOD</b>											
													
Unlock	Half Lock Condition	Full Lock Condition											

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# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

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Process Name/Title:

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010B / 7L0033-7024

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Car Model:

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Document No.:

WI-ENG-PDE-065B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

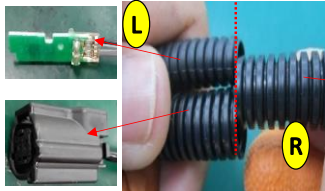
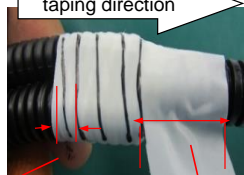

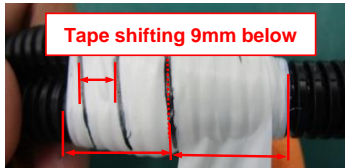


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PARTS:		1. Assy parts 2. White tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P2	Y-taping	<div><div>No Gap between tubes</div><div></div><div>1. Fix the corrugated tube .</div><div><div>Note: Do not exert excessive force during pulling &amp; winding of tape</div><div></div><div>taping direction</div><div>20±3mm</div></div><div><div>2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side , width must be same with tape (19mm)</div><div></div><div>20±3mm</div></div><div><div>3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width)</div><div></div><div>Tape shifting 9mm below</div><div>20±3mm</div><div>20±3mm</div></div><div><div>4. Wind the tape backward 1/2 shifting</div><div></div><div>tape shifting 1/2 below</div></div><div><div>5. Wind the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.</div><div></div><div>tape shifting 1/2 below</div></div></div> <div>n/a</div> <div><p><b>Important reminders and Note/s:</b></p><p>1. Use <u>WHITE TAPE</u> only</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><ol 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></ol></div>		

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

July 10, 2024

Validity Date:

n/a

Model code/Part number:

**010B / 7L0033-7024**

Customer:

**TRQSS**

Car Model:

**TOYOTA-CAMRY**

Document No.:

**WI-ENG-PDE-065B**

Purpose:

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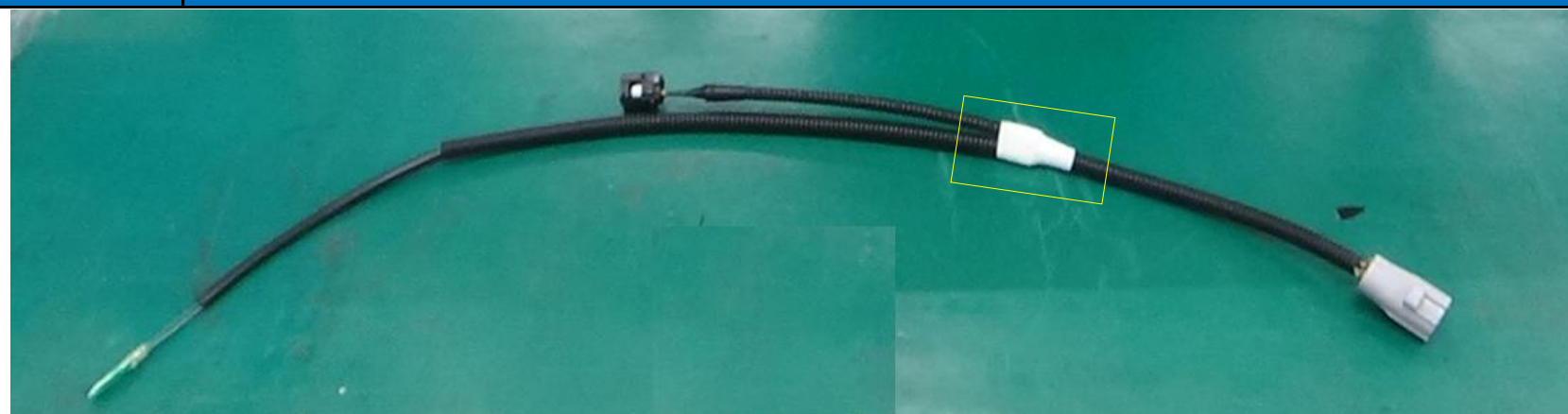
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P2****7L0033-7024****1****No Wrong insert****2****No Unlocked/Half-locked connector****3****No Missing tape****2****NO GOOD****GOOD**

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