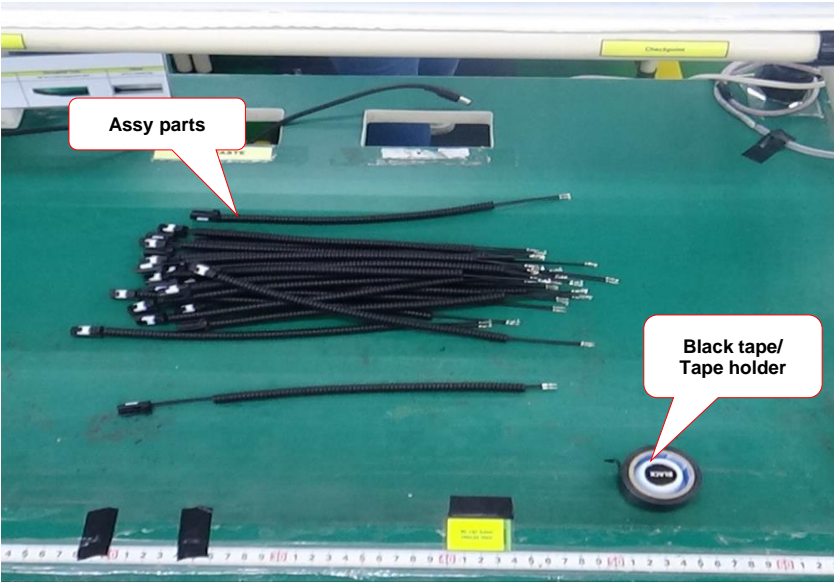



	WORK INSTRUCTION				Effectivity Date:	July 26, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 491D/564D / 7R0151-7020A		Customer: TRMX	Car Model: TOYOTA-SEQUOIA	Document No.:	WI-ENG-PDE-843		
	Purpose: <input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	1	Page No.:	1 of 4

PARTS:		1. Assy parts; Black tape			JIG:	n/a	
NO.	PROCESS NAME	<div>1</div> WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
1	P1	<div>Table Lay-out</div> 			<div>Safety Instruction</div> <p>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<div>Document reference/s:</div> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>2. Refer to WI-ENG-PDE-989 for Offline assembly process</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>	

Revision History								Prepared by	Reviewed by	Approved by	Noted by			
07/26/24	1	Separate Wire insertion to connector and COT to wire insertion to Offline assembly process. Separate Clamp assembly to Clamp assembly process. Improved Table lay-out, Measurement and Visual inspection/Quality checkpoints. Change from Pre-launch to Masspro.					D.Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
02/16/24	0	Initial issue.					D.Castillo	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change					Revised	Reviewed	Approved	Noted	Est. Date:	February 16, 2024		

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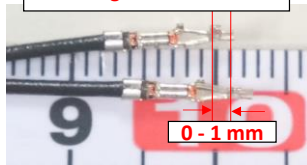
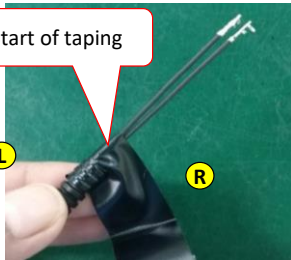
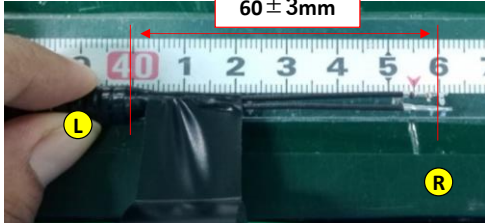
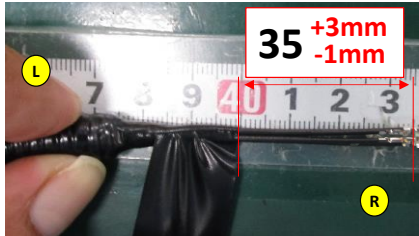
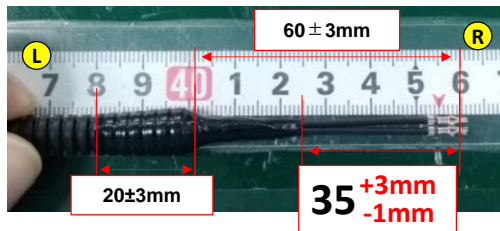

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	Taping 1 COT to wire near terminal		MEASURING TAPE	<div><div>Wire alignment tolerance</div><div></div></div> <div><div>1. No flip-out tape</div><div>2. No peel-off tape</div><div>3. No loose tape</div><div>4. No missing tape</div><div>5. No wrong dimension</div><div>6. No wrong use of tape</div></div> <div><div>Important reminders/Note/s:</div><div>1. Please use calibrated/verified measuring tape when getting the measurement.</div></div> <div><div>Document references:</div><div>1. Refer to WI-ENG-PDE-588 for Tape and tube end standard tolerance</div><div>2. Refer to WI-PRO-ASY-001 for Taping process</div></div>
		<div><div><div>Start of taping</div><div></div></div><div><div>1. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.</div></div><div><div><div>60 ± 3mm</div><div></div></div><div><div>2. Measure from end of COT up to terminal pointed tip 60±3mm then continue the taping process using both hands.</div></div><div><div><div>35 +3mm -1mm</div><div></div></div><div><div>3. Confirm measurement of 35+3mm/-1mm from end of tape up to terminal pointed tip then continue the taping process using both hands.</div></div><div><div><div>60 ± 3mm</div><div><div>20±3mm</div><div>35 +3mm -1mm</div><div></div></div></div><div><div>4. After taping, check the measurement, taping condition and terminal appearance.</div></div></div></div></div></div>		<div></div>	

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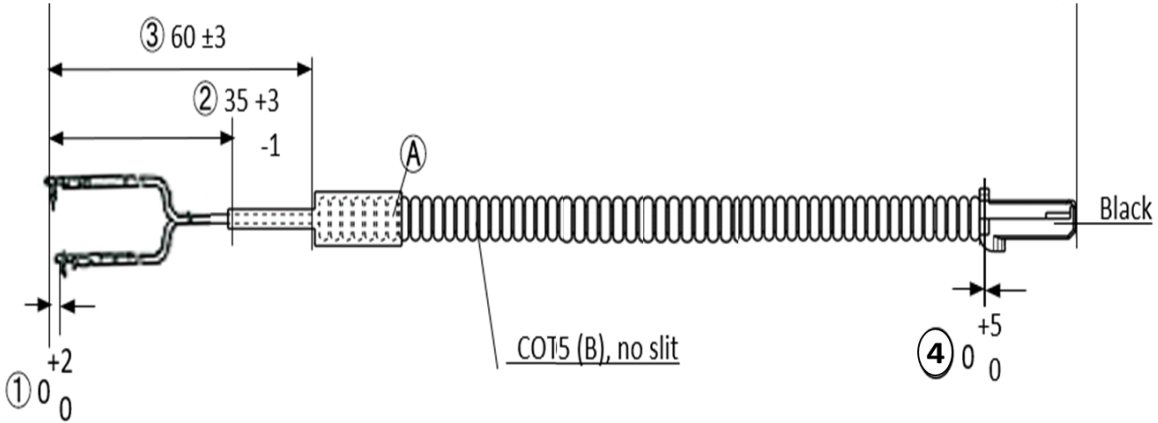
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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

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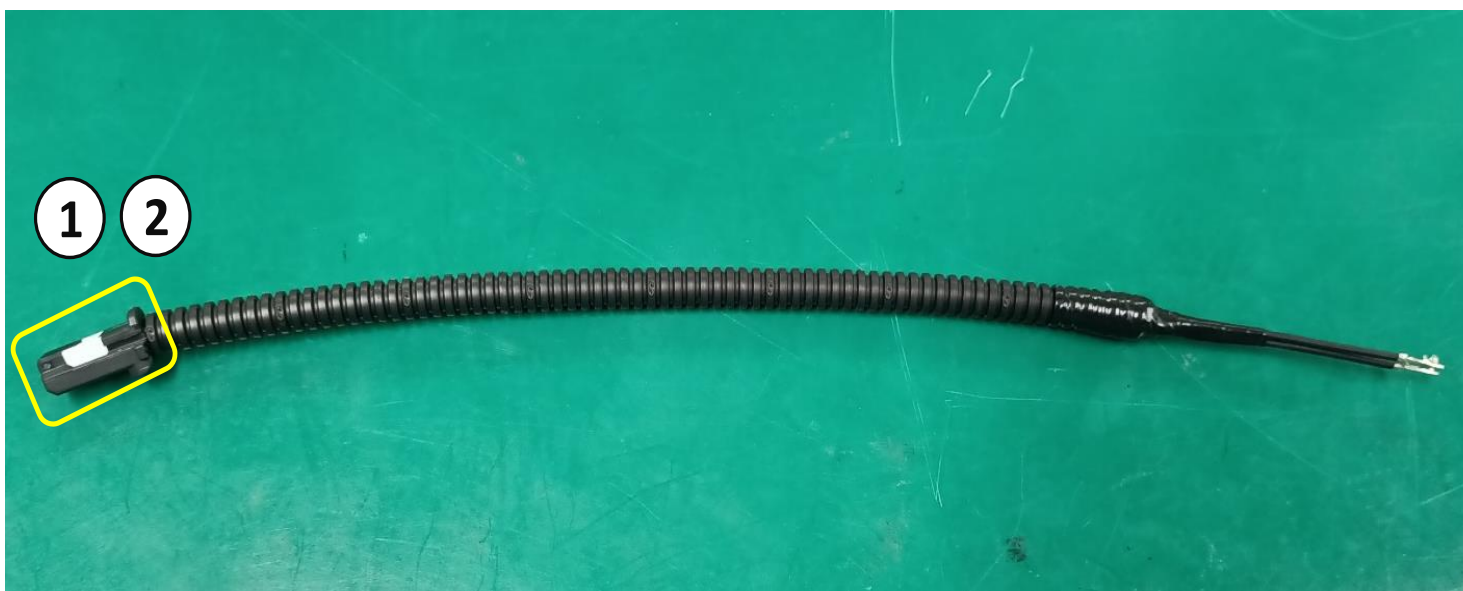
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P1****7R0151-7020A****GOOD****NO GOOD****GOOD****NO GOOD****① No Unlock/Halflock Connector****② No Terminal Backing Out**

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