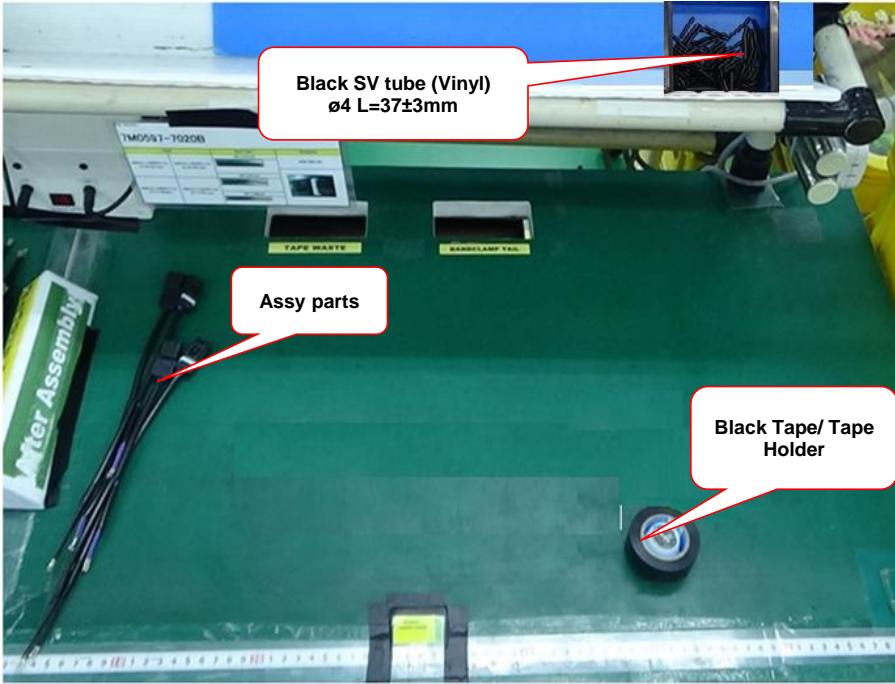





	<b>WORK INSTRUCTION</b>						Effectivity Date: <b>September 25, 2024</b>	
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>						Validity Date: <b>n/a</b>	
	Model code/Part number: <b>400B / 7M0597-7020B</b>		Customer: <b>TRJ</b>		Car Model: <b>TOYOTA-VITZ</b>		Document No.: <b>WI-ENG-PDE-078B</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.: <b>0</b> Page No.: <b>1 of 5</b>	

<b>PARTS:</b> 1. Assy parts; Black SV tube (Vinyl) ø4 L=37±3mm; Black tape		JIG: n/a	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>
1	P2 Table Lay-out	<div style="text-align: center;"> <b>TABLE LAY-OUT</b> </div> 	<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> <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: 10px;"> <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>
		<div style="text-align: center;"> <b>CONNECTOR ILLUSTRATION</b> </div> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <div style="background-color: green; color: white; padding: 2px 5px;"><b>GOOD</b></div>  <div style="background-color: green; color: white; padding: 2px 5px;"><b>6098-3803 (B)</b></div> </div> <div style="text-align: center;"> <div style="background-color: red; color: white; padding: 2px 5px;"><b>NG</b></div>  <div style="background-color: red; color: white; padding: 2px 5px;"><b>6098-3802 (W)</b></div> </div> </div>	


  

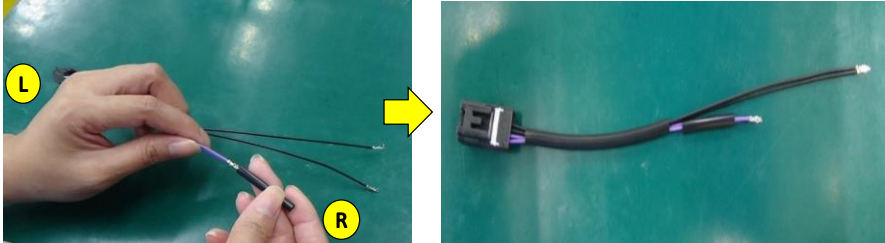
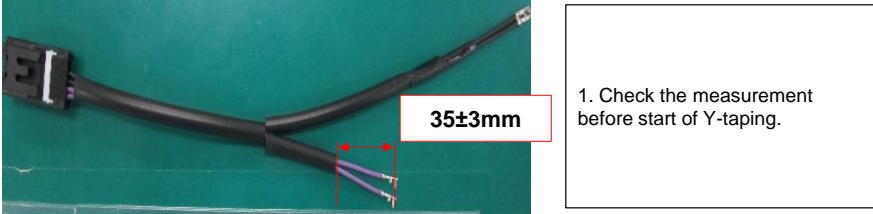
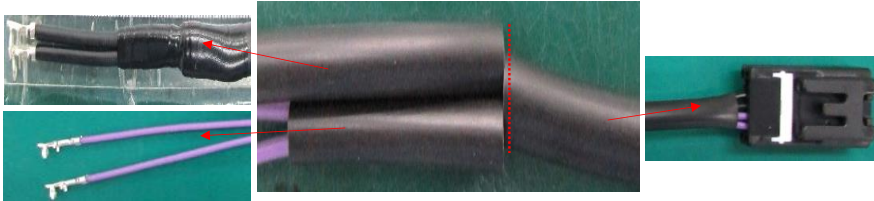

Revision History						Prepared by	Reviewed by	Approved by	Noted by			
						 D. Castillo	 C. Villanueva	 A. Arañes	n/a			
09/25/24	0	Initial issue. Separate Y-taping process and Measurement from P1.			D. Castillo					C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change			Revised					Reviewed	Approved	Noted

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<b>PARTS:</b>	1. Assy parts 2. Black SV tube (Vinyl) $\phi 4$ L=37 $\pm$ 3mm 3. Black tape			JIG:	1. n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	Wire insertion to Black SV tube (Vinyl) $\phi 4$ L=37 $\pm$ 3mm	<div></div> <div>1. Get the viny tube <math>\phi 4</math> L=37<math>\pm</math>3mm using right hand then insert the V-V wires using left hand.</div>		n/a	1. No wrong use of parts 2. No deformed terminal
3	P2 Y-Taping	<div></div> <div>No gap between Black SV tube (Vinyl)</div> <div></div>		<div>MEASURING TAPE</div> 	1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. No wide interval between Vinyl tube 6. No exposed wire  <b>Important reminder/Note/s:</b> 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines, but actual should be <b>BLACK TAPE</b> .

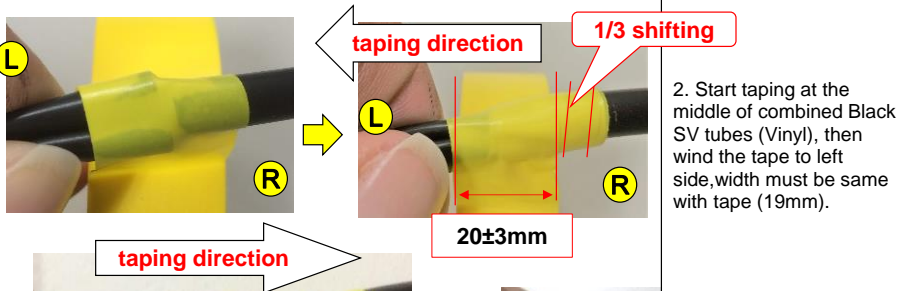
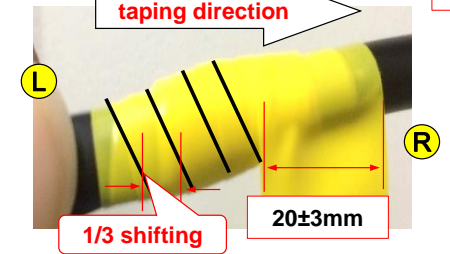
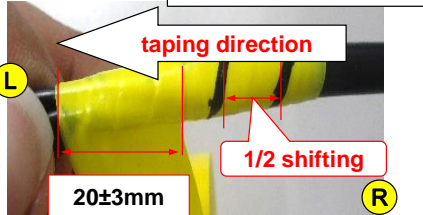
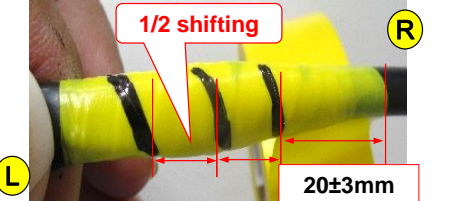
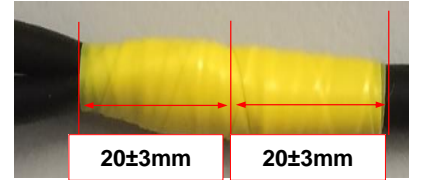

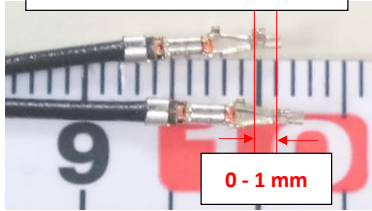
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	Model code/Part number: <b>400B / 7M0597-7020B</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-VITZ</b>	Document No.:	<b>WI-ENG-PDE-078B</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	3 of 5


<b>PARTS:</b>	1. Assy parts 2. Black tape			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
3	P2 Y-Taping (Continuation)	<div><p>2. Start taping at the middle of combined Black SV tubes (Vinyl), then wind the tape to left side, width must be same with tape (19mm).</p></div> <div><p>3. Wind the tape <b>1/3 shifting</b> until it reach the other side of vinyl tube (must be tape width)</p></div> <div><p>4. Wind the tape backward <b>1/2 shifting</b>.</p></div> <div><p>5. Wind the tape <b>1/2 shifting</b> going to other side of vinyl tube then cut the tape.</p></div> <div><p>6. After taping, check the measurement and taping condition.</p></div>	<div><p>MEASURING TAPE</p></div>	<p>1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. No wide interval between Vinyl tube 6. No exposed wire</p> <p><b>Important reminder/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b> <b>2. Use <u>YELLOW TAPE</u> for easy visualization of shifting lines, but actual should be <u>BLACK TAPE</u>.</b></p> <div><p>Wire alignment tolerance 0 - 1 mm</p></div>	


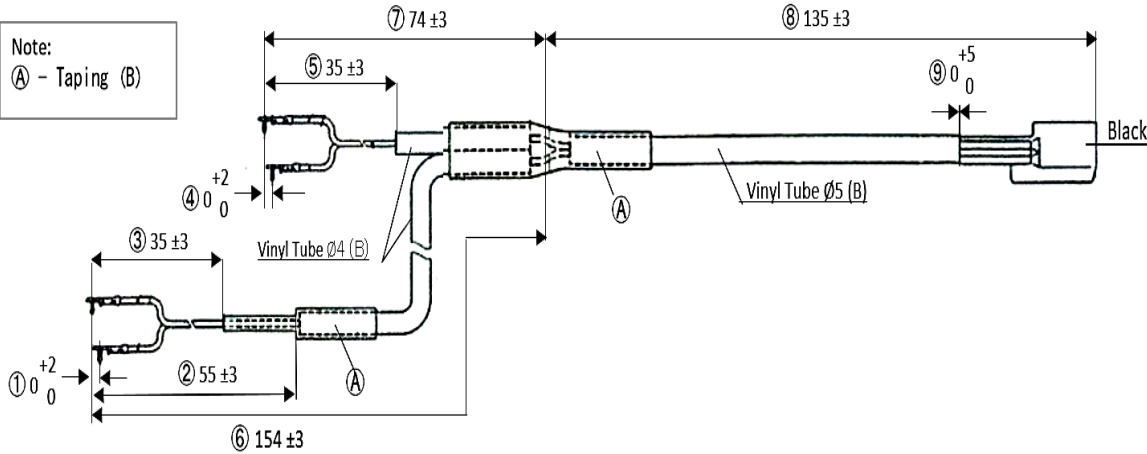
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	Model code/Part number: <b>400B / 7M0597-7020B</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-VITZ</b>	Document No.:	<b>WI-ENG-PDE-078B</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	4 of 5

<b>PARTS:</b>	1. Assy parts			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
4	P2	Measurement	<div><div>MEASURING TAPE</div></div>  <p>Note: A - Taping (B)</p>	<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:

**September 25, 2024**

Validity Date:

n/a

Model code/Part number: **400B / 7M0597-7020B** Customer: **TRJ** Car Model: **TOYOTA-VITZ**

Document No.:

**WI-ENG-PDE-078B**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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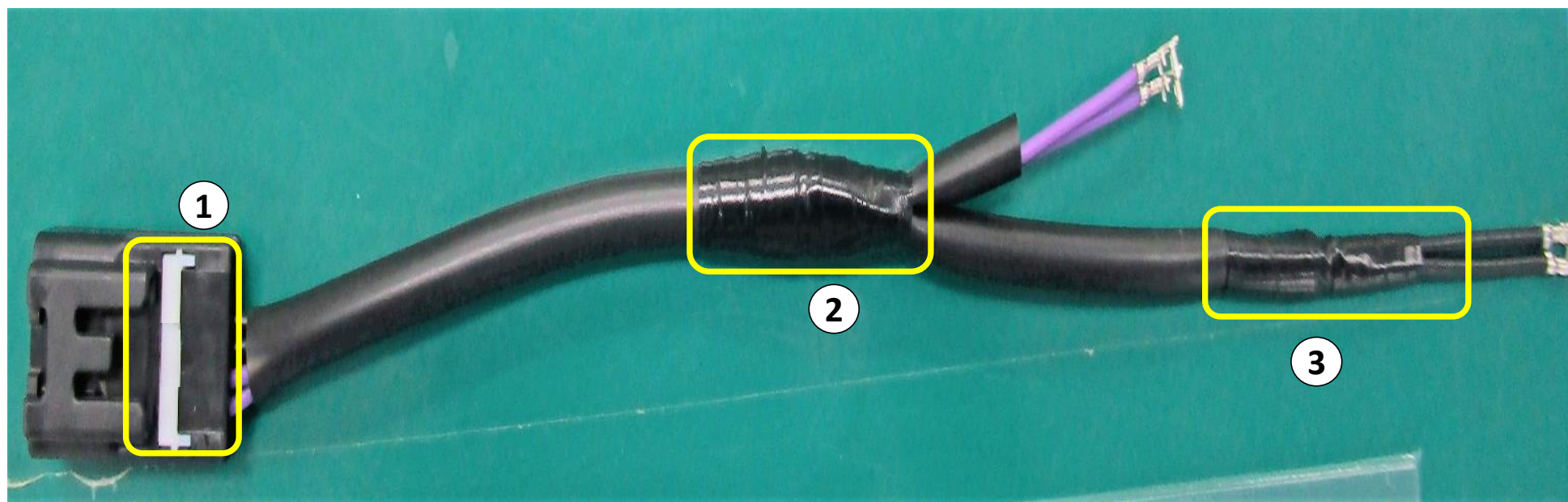
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P2****7M0597-7020B****1 No Unlocked/ Half-locked Connector****2 3 No Missing Tape**

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