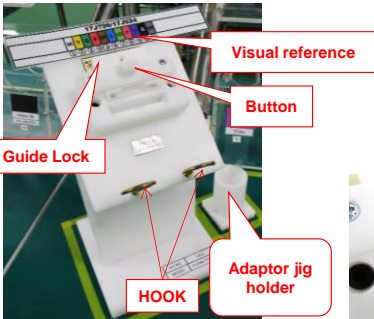
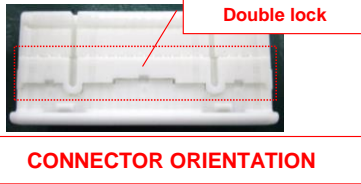
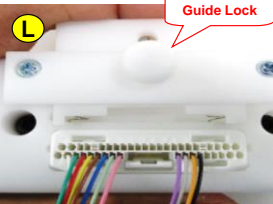


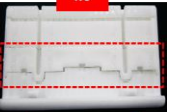
	<b>WORK INSTRUCTION</b> <b>TAPING ASSEMBLY PROCESS</b>				Effectivity Date: <b>March 12, 2025</b>	
	Process Name/Title:				Validity Date: <b>n/a</b>	
	Model code/Part number: <b>560B / 17L544-7050</b>		Customer: <b>TRP</b>	Car Model: <b>TOYOTA-INNOVA</b>	Document No.: <b>WI-ENG-PDE-268B</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.: <b>7</b> Page No.: <b>1 of 5</b>	


<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>
1	P2  <div style="border: 1px solid black; padding: 5px; text-align: center;"> <b>HIGH</b> </div> Connector setting to insertion jig (Assy parts) 1827842-1 (W)	<div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;">  <p><b>INSERTION JIG</b></p> </div> <div style="width: 50%;">  <p><b>CONNECTOR ORIENTATION</b></p> </div> </div> <p>1. Get the connector <b>1827842-1 (W) (Assy parts)</b> using left hand then set to insertion jig.</p> <div style="display: flex; justify-content: space-around;"> <div>  <p><b>BEFORE PRESSING</b></p> </div> <div>  <p><b>AFTER PRESSING</b></p> </div> </div> <p>2. Press the guide lock using left index finger.</p>	<div style="border: 1px solid red; padding: 5px;"> <b>Safety Instruction</b>          Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)       </div> <div style="border: 1px solid red; padding: 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>
		<div style="border: 1px solid red; padding: 5px;"> <b>Quality Pointers</b> </div> <p>1. Use the provided jig per model          2. No wrong usage of parts          3. No wrong orientation of connector          4. No damaged connector          5. No half-locked connector</p> <p><b>Important reminders/Note/s:</b>          1. <b>Automatically dispose and replace the unit if once encountered Bend terminal, Difficulty of insertion, Half-locked connector.</b>          2. <b>If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process. Do not attempt to repair.</b>          3. <b>Follow the connector orientation.</b></p> <div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;"> <div style="background-color: green; color: white; padding: 2px 5px;">GOOD</div>  <div style="border: 1px solid red; padding: 2px;">UNLOCK</div> </div> <div style="text-align: center;"> <div style="background-color: red; color: white; padding: 2px 5px;">NG</div>  <div style="border: 1px solid red; padding: 2px;">HALF-LOCKED</div> </div> </div> <p style="text-align: center; border: 1px solid red; padding: 5px;">Connector must be no damaged/half-locked/locked</p>	




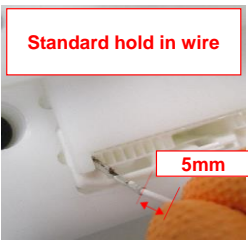






Revision History				Prepared by		Checked	Reviewed by	Approved by
03/11/25	7	Inclusion of Quality improvement measures (based on Mizen Boshi activity).	D.Castillo	J. Loterte	C. Villanueva	A. Arañes		
08/15/23	6	Update Template; Inclusion of <b>CAR MODEL "TOYOTA-INNOVA"</b> . Transfer process of connector lock from P2 to P4 Due to TPS improvement. (Please refer to <b>ENGDRR-146</b> for Document revision request).	M. Ariola	J. Loterte	C. Villanueva	A. Arañes		
03/02/23	5	Standardized Tube description: VM tube (Sunprene); Change WIP flow quantity from [1pc] flow to [3pcs] flow; Update work procedure/ Illustration on process no. 4 (Connector lock) as process improvement.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes		
Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved	Est. Date:	May 14, 2021

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	<b>WORK INSTRUCTION</b>			Effectivity Date:	March 12, 2025		
	<b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Process Name/Title:			Customer:	TRP	Car Model:	TOYOTA-INNOVA
	Model code/Part number:	560B / 17L544-7050		Document No.:	WI-ENG-PDE-268B		
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	7	Page No.:	2 of 5

PARTS:	1. Assy parts 2. CIVUS 0.13 W L=188±2mm; Y L=178±2mm; G L=184±2mm; R L=178±2mm; BR L=176±2mm; L L=175±2mm; LG L=176±2mm; P L=175±2mm; V L=188±2mm; B L=177±2mm; GR L=179±2mm (Group 2 wires)	JIG:	1. Insertion jig
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NO.	PROCESS NAME	WORK PROCEDURE/ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS																																												
2	<div><div>7</div><div>MEDIUM</div><div>Wire insertion to connector (Group 2 wires) 1827842-1 (W)</div></div>	<div><div>WIRE INSERTION ILLUSTRATION</div><div></div><div><table><tr><td colspan="11">17L544</td></tr><tr><td>W</td><td>Y</td><td>G</td><td>R</td><td>BR</td><td>L</td><td>LG</td><td>P</td><td>V</td><td>B</td><td>GR</td></tr><tr><td>188</td><td>178</td><td>184</td><td>178</td><td>176</td><td>175</td><td>176</td><td>175</td><td>188</td><td>177</td><td>179</td></tr><tr><td>1</td><td>2</td><td>3</td><td>4</td><td>5</td><td>6</td><td>7</td><td>8</td><td>9</td><td>10</td><td>11</td></tr></table></div><div><div>GOOD SHORT terminal</div><div></div><div>NG LONG terminal</div><div>Terminal facing</div></div><div><div>Standard hold in wire</div><div></div><div>5mm</div></div><div></div><div><div>1. Get the wire and hold it 5mm away from terminal. 2. Half insert the wire. 3. Release wire to check the color. 4. Conduct point checking in visual 5. Hold again 5mm away from terminal 6. Fully inserted wires (avoid bending during insertion)</div></div></div>	17L544											W	Y	G	R	BR	L	LG	P	V	B	GR	188	178	184	178	176	175	176	175	188	177	179	1	2	3	4	5	6	7	8	9	10	11	<div><div>Finger COTS</div><div></div></div>	<div><div>1. No wrong wire insertion 2. No terminal backing out 3. No deformed terminal 4. Make sure wires are properly inserted. 5. Must have slight MOVEMENT after insertion 6. No bend terminal/wires</div><div><div>Important reminders/Note/s:</div><div><div>1. Automatically dispose and replace the unit if once encountered Bend terminal, Difficulty of insertion, Half-locked connector. 2. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process. Do not attempt to repair. 3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 4. Follow the insertion sequence based on the visual reference 5. Hold on wire during insertion must be 5mm away from terminal end.</div></div><div><div>Document references:</div><div><div>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div></div></div></div></div>
17L544																																																
W	Y	G	R	BR	L	LG	P	V	B	GR																																						
188	178	184	178	176	175	176	175	188	177	179																																						
1	2	3	4	5	6	7	8	9	10	11																																						

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TAPING ASSEMBLY PROCESS

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March 12, 2025

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Model code/Part number: 560B / 17L544-7050

Customer: TRP

Car Model: TOYOTA-INNOVA

Document No.:

WI-ENG-PDE-268B

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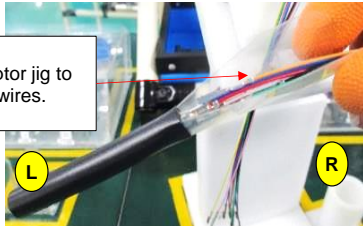




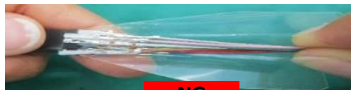


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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) $\phi 7$ L=55 $\pm$ 5mm		JIG:	1. Insertion jig 2. Adaptor jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 Wire insertion to Black VM tube (Sunprene) $\phi 7$ L=55 $\pm$ 5mm  MEDIUM	<div><p>1. Get the <b>Black VM tube (Sunprene)</b> <math>\phi 7</math> L=55<math>\pm</math>5mm using left hand then insert the adaptor jig using right hand.</p></div> <div><p>2. Hold the <b>Group 1 wires [12pcs.]</b> using right hand.</p></div> <div><p>Use the adaptor jig to easily insert wires.</p></div> <div><p>3. Insert the wires to <b>Black VM tube (Sunprene)</b> using right hand.</p></div>		<div><div>Adaptor jig</div><div>Finger COTS</div></div>	<div><p>GOOD</p><p>NG</p><p>Wires must not be inserted at the same time</p><p>1. No wrong use of parts. 2. No remaining wires outside black sunprene tube 3. No cut tube 4. Wires must not be inserted at the same time</p><div>STANDARD TUBE APPEARANCE</div><div><p>GOOD</p><p>NG</p><p>MUST BE NO CUT/DAMAGED TUBE</p></div></div>

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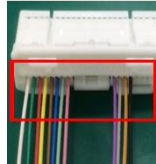
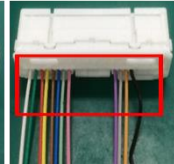
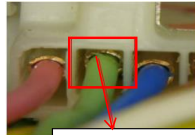
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PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	<div><div>7</div><div>MEDIUM</div><div>Wire insertion to Black VM tube (Sunprene) ø7 L=55±5mm (Continuation)</div></div>	<div><div><div>Button</div><div>L</div><div>R</div><div>BEFORE PRESSING</div><div>4. Press the button using left thumb.</div></div><div><div>L</div><div>R</div><div>AFTER PRESSING</div><div>5. Hold the wires using right hand then gently pull out the connector from jig. Check the insertion condition.</div></div></div>	<div><div>Finger COTS</div><div></div></div>	<div><div>1. No wrong use of parts 2. No remaining wires outside black sunprene tube 3. No cut tube</div><div><div>STANDARD TUBE APPEARANCE</div><div><div></div><div></div><div>GOOD</div><div>NG</div></div><div><div>MUST BE NO CUT/DAMAGED TUBE</div></div><div><div>No bend terminal/wires</div><div><div>GOOD</div><div>NG</div></div><div><div></div><div></div></div><div><div>No damaged/whitens</div><div></div></div></div></div></div>

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<b>PARTS:</b>	1. Assy parts			JIG:	1. WIP Holder
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
4	P2 Pass WIP to P3	<div>3 PIECES FLOW</div>  <div>1. Pass WIP to WIP Holder. <b>Note: Three pieces flow.</b></div>		<div>WIP HOLDER</div> 	1. No WIP overflow

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