
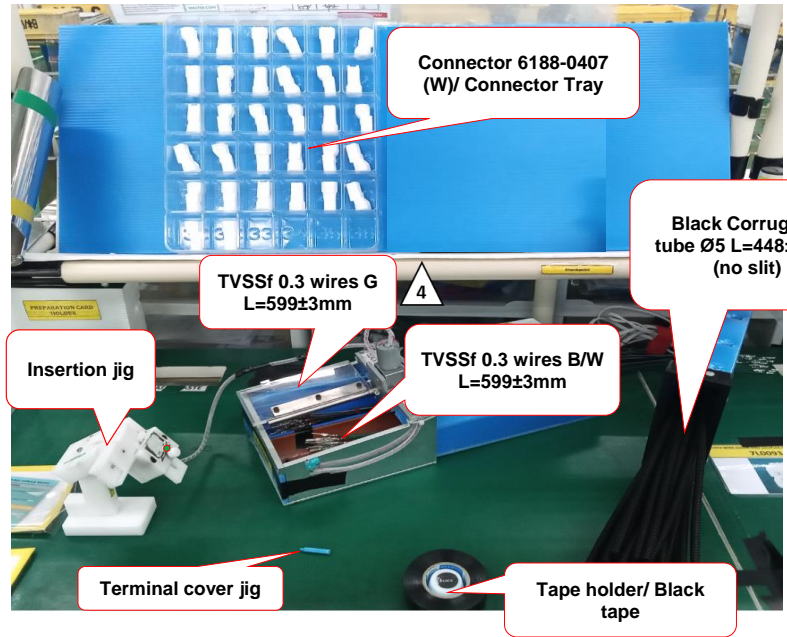




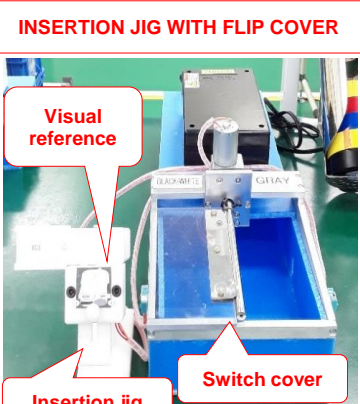
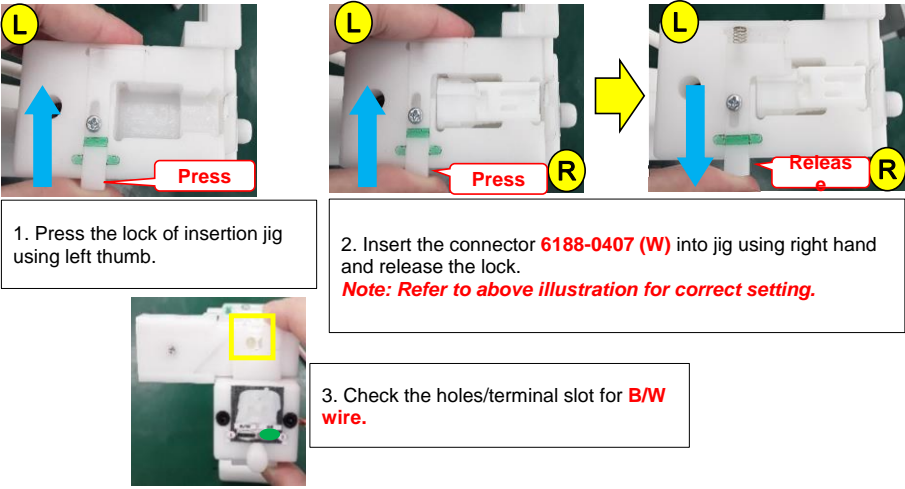
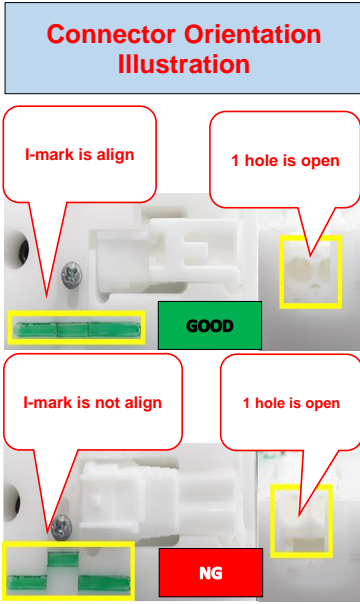
	WORK INSTRUCTION				Effectivity Date:		August 2, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 086D / 7N0098-7021A		Customer: TRJ	Car Model: TOYOTA-RAV4	Document No.:		WI-ENG-PDE-527A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		4	Page No.: 1 of 5

PARTS:		1. All parts: Connector 6188-0407 (W); TVSSf 0.3 wires G-B/W L=599±3mm; Black Corrugated tube Ø5 L=448±4mm (no slit); Black VM tube (Sunprene) Ø9 L=97±3mm; Black tape [1pc]		JIG:		1. Insertion jig with switch cover 2. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1	P1 <div style="text-align: center;">  </div> Table Lay-out	<div style="text-align: center;"> Table Lay-out </div> 		<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Safety Instruction 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;"> Housekeeping 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;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>		Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 1. No missing parts/tools 2. No excess parts/tools	

Revision History								Prepared by	Reviewed by	Approved by	Noted by		
08/02/24	4	Transfer VM tube insertion and COT to VM tube taping to P2 due to process improvement. Integrate locking jig to clamp assembly jig due to jig improvement. Aligned switch cover to insertion jig. Inclusion of car model "TOYOTA-RAV-4". Improved table lay-out and visual inspection/quality checkpoints.				D.Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
04/24/23	3	Inclusion of quality checkpoints				J. Loterte	C. Villanueva	A. Arañes	n/a				
10/27/22	2	Improve quality pointers: Reminders/notes and references in process no.1,3,4,6 and 8 due to document improvement.				M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	May 16, 2022		

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	WORK INSTRUCTION				Effectivity Date:	August 2, 2024				
	TAPING ASSEMBLY PROCESS				Validity Date:	n/a				
	Process Name/Title:		Model code/Part number: 086D / 7N0098-7021A		Customer: TRJ	Car Model: TOYOTA-RAV4		Document No.:	WI-ENG-PDE-527A	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		4	Page No.:	2 of 5	


PARTS:		1. Connector 6188-0407 (W)		JIG:	1. Insertion jig with switch cover	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS		
2	P1 Connector setting to Insertion jig 6188-0407 (W)	<div><p>Visual reference</p><p>INSERTION JIG WITH FLIP COVER</p><p>Lock</p><p>Holes</p><p>I-mark</p><p>Switch cover</p><p>Insertion jig</p></div> <div><p>Press</p><p>Press</p><p>Releas</p><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the connector 6188-0407 (W) into jig using right hand and release the lock. <i>Note: Refer to above illustration for correct setting.</i></p><p>3. Check the holes/terminal slot for B/W wire.</p></div>	n/a	<div><p>Connector Orientation Illustration</p><p>I-mark is align</p><p>1 hole is open</p><p>GOOD</p><p>I-mark is not align</p><p>1 hole is open</p><p>NG</p></div> <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>		

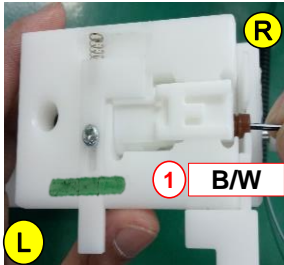
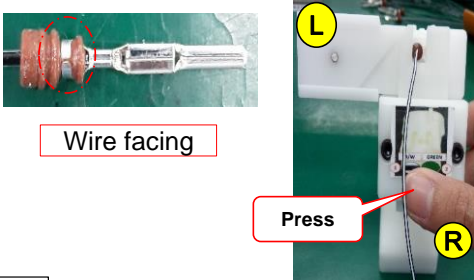
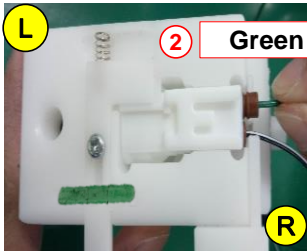
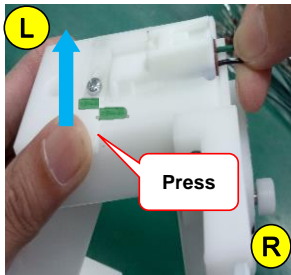
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	WORK INSTRUCTION				Effectivity Date:	August 2, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 086D / 7N0098-7021A		Customer: TRJ	Car Model: TOYOTA-RAV4	Document No.:	WI-ENG-PDE-527A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	4	Page No.:	3 of 5


PARTS:	1. TVSSf 0.3 wires G-B/W L=599±3mm			JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	P1 Wire Insetion to Connector 6188-0407 (W)	<div><p>1. Hold the Insertion jig using left hand. Get Black /White wire then insert to terminal slot 1 using right hand.</p></div> <div><p>2. Push the button using right hand. The slot for Green wire will be opened.</p></div> <div><p>3. Get the Green wire then insert to terminal slot 2 using right hand.</p></div> <div><p>4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div>	n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p>Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p>	

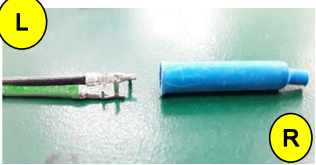

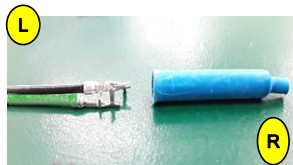

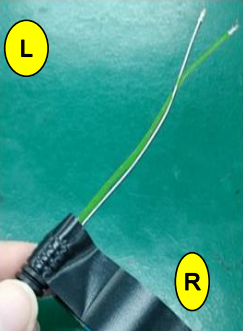
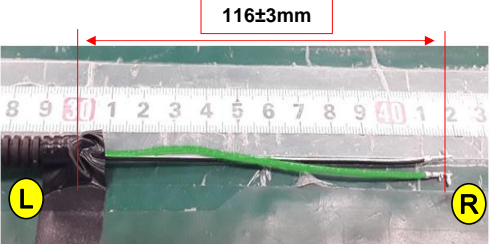
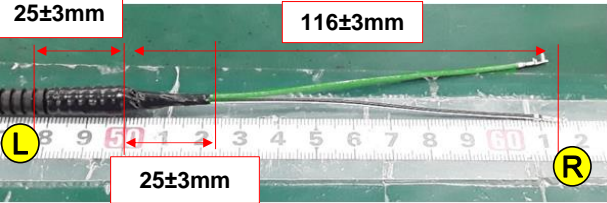

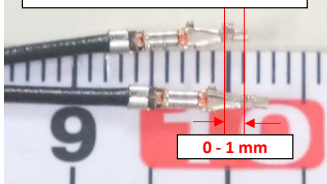
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	TAPING ASSEMBLY PROCESS				Validity Date:	n/a					
	Process Name/Title:		Model code/Part number: 086D / 7N0098-7021A		Customer: TRJ	Car Model: TOYOTA-RAV4		Document No.:	WI-ENG-PDE-527A		
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:	4	Page No.:

PARTS:	1. Assy parts 2. Black Corrugated tube Ø5 L=448±4mm (no slit)				JIG:	1. Locking jig 2. Terminal cover jig				
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS			
4	Wire insertion to Corrugated tube Ø5 L=448±4mm (no slit)	<div><div><p>1. Get the terminal cover jig using right hand then insert the G-B/W wires using left hand.</p></div><div><p>2. Get the Corrugated Ø5 L=448±4mm (no slit) using right hand and insert the G-B/W wires using left hand</p></div><div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div></div> <div><div>TERMINAL COVER JIG</div></div>				1. No wrong use of parts 2. No deformed terminal				
5	P1 Taping 1 COT to wire near terminal	<div><div><p>1. Hold the COT using left hand get Black tape using right hand and conduct pre taping using both hands.</p></div><div><p>2. Measure the end of COT to terminal tip 116±3mm and continue the process using both hands</p></div><div><p>3. After taping, check the measurement, terminal appearance and taping condition.</p></div></div> <div><div>MEASURING TAPE</div></div>				<div><div><p>Wire alignment tolerance 0 - 1 mm</p></div><p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p><p>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p><p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p></div>				

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WORK INSTRUCTION

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TAPING ASSEMBLY PROCESS

Effectivity Date:

August 2, 2024

Validity Date:

n/a

Model code/Part number:

086D / 7N0098-7021A

Customer: TRJ

Car Model: TOYOTA-RAV4

Document No.:

WI-ENG-PDE-527A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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PARTS:

1. Assy parts

JIG:

n/a



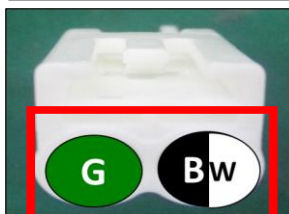
VISUAL INSPECTION/ QUALITY CHECKPOINTS

P1

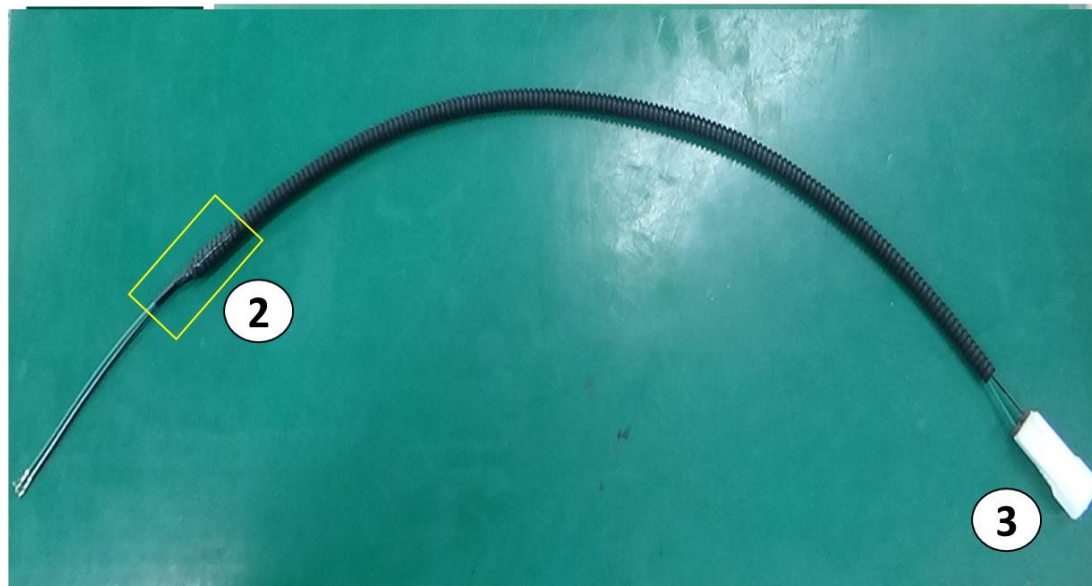
7N0098-7021A



GOOD



NO GOOD



GOOD



GOOD



NO GOOD



NO GOOD

1 No Wrong Insert

2 No Missing Tape
(taping on COT to wire)

3 No Deformed Terminal

4 No Terminal Backing out

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