
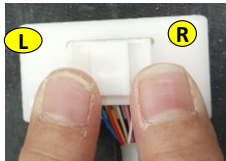
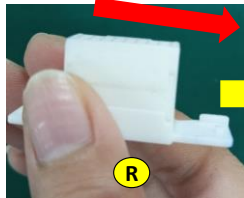
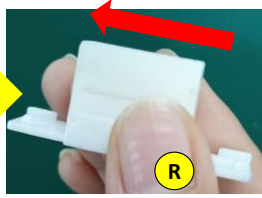

	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>March 12, 2025</b>		
	<b>Process Name/Title:</b> <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	<b>n/a</b>		
	<b>Model code/Part number:</b> <b>560B / 17L544-7050</b>		<b>Customer:</b> <b>TRP</b>	<b>Car Model:</b> <b>TOYOTA-INNOVA</b>	Document No.:	<b>WI-ENG-PDE-268E</b>		
	<b>Purpose:</b> <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	<b>8</b>	Page No.:	<b>1 of 9</b>

<b>PARTS:</b> 1. Assy parts					<b>JIG:</b> 1. Locking jig	
<b>NO.</b> 1	<b>PROCESS NAME</b> P5 Connector Lock 1 (Assy parts with Black VM tube)	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
					<b>Safety Instruction</b> Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)	<b>Important reminders/Note/s:</b> 1. <b>MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b>
		 <p>1. Get the assy parts using left hand then put the connector to locking jig using right hand.          2. Press down the connector to locking jig 2x using using left &amp; right thumb (<b>Same timing</b>)          3. Touch the connector lock after locking (<i>See below sequence in checking of connector lock</i>)</p>				
		 <p><b>LEFT SIDE OF CONNECTOR LOCK</b></p>			<b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.	1. No damaged double lock. 2. No half-locked connector
		 <p><b>RIGHT SIDE OF CONNECTOR LOCK</b></p>				
		 <p><b>Checking point (LEFT to RIGHT)</b></p>			<b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	
		<p>2. Ensure that connector is in locked condition by slide touching the connector lock from <b>LEFT to RIGHT</b> using <b>right thumb</b>.</p>				

Revision History				Prepared by	Checked by	Reviewed by	Approved by
03/12/25	8	Inclusion of Quality improvement measures (based on Mizen Boshi activity).	D.Castillo	J. Loterte	C. Villanueva	A. Arañes	
08/15/23	7	Update template; Inclusion of <b>CAR MODEL "TOYOTA-INNOVA"</b> . Transfer process of Connector lock 1 (Assy parts with Black VM tube (Sunprene); Transfer process of Measurement from P5 to P6; Improve Work procedure/illustration process no.1 and 2 due to TPS improvements. (Please refer to ENGDRR-146 for Document revision request.)	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	
03/02/23	6	Standardized tube description :VM tube (Sunprene); Change WIP flow quantity from [1pc] flow [3pcs] flow due to 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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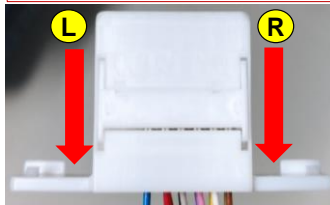
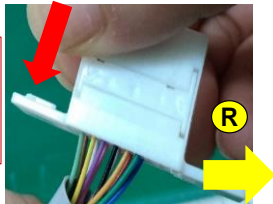
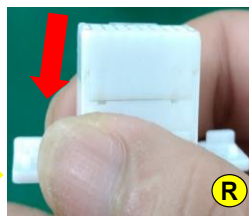
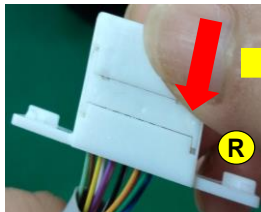
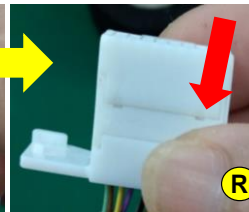
Process Name/Title: **560B / 17L544-7050**

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

Customer: **TRP**

Car Model: **TOYOTA-INNOVA**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	<div><div>8</div><div>LOW</div><div>Connector Lock 1 (Assy parts with Black VM tube) (Continuation)</div><div>P5</div></div>	<div><div>Checking point (TOP to BOTTOM)</div><div></div><div><div>LEFT SIDE OF CONNECTOR LOCK</div><div></div><div><div>RIGHT SIDE OF CONNECTOR LOCK</div><div></div></div><div><div>Before pressing</div><div></div><div><div>After pressing</div><div></div></div><div><div>3. Ensure that connector is in locked condition by touching the <b>LEFT SIDE</b> of connector lock from <b>TOP to BOTTOM</b> using <u>right thumb</u>.</div><div>4. Ensure that connector is in locked condition by touching the <b>RIGHT SIDE</b> of connector lock from <b>TOP to BOTTOM</b> using <u>right thumb</u>.</div></div></div></div></div>	n/a	1. No damaged double lock. 2. No half-locked connector

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

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Model code/Part number:

560B / 17L544-7050

Customer: TRP

Car Model:

TOYOTA-INNOVA

Document No.:

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Purpose:

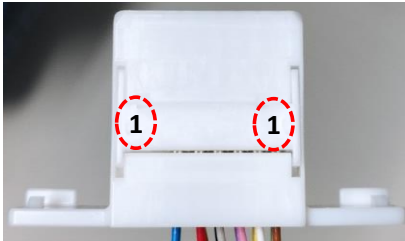
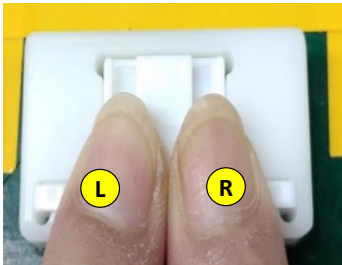
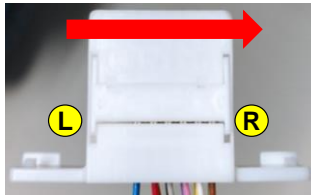
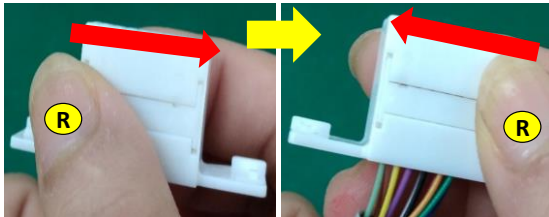
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	<div><div>8</div><div>Connector Lock 2 (Assy parts with N6GR VM tube)</div><div>LOW</div></div>	<div><div></div><div><p><b>Sequence of Pressing the Double Lock:</b> ① - ① <b>Method:</b> Press same timing using both thumbs</p></div><div></div><div><p>1. Get the assy parts using left hand then put the connector to locking jig using right hand. 2. Press down the connector to locking jig 2x using using left &amp; right thumb (<b>Same timing</b>) 3. Touch the connector lock after locking (<i>See sequence in checking of connector lock</i>).</p></div><div><div>Checking point (LEFT to RIGHT)</div><div></div><div></div><div><p>2. Ensure that connector is in locked condition by slide touching the connector lock from <b>LEFT to RIGHT</b> using <b>right thumb</b>.</p></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>

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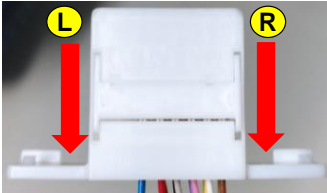
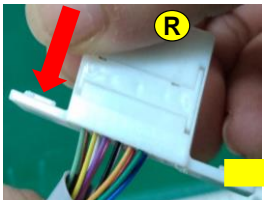
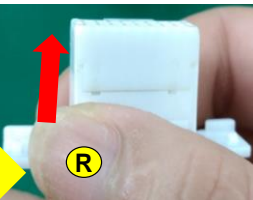

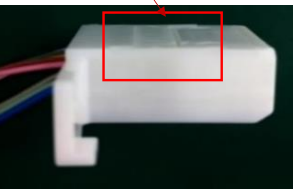
Process Name/Title: **560B / 17L544-7050**

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

Customer: **TRP**

Car Model: **TOYOTA-INNOVA**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	<div>8</div> <div>LOW</div> <div>Connector Lock 2 (Assy parts with N6GR VM tube) (Continuation)</div> <div>P5</div>	<div>Checking point (TOP to BOTTOM)</div> <div></div> <div><div>LEFT SIDE OF CONNECTOR LOCK</div><div></div><div><div>RIGHT SIDE OF CONNECTOR LOCK</div><div></div></div><div><div>Before pressing</div><div></div><div><div>After pressing</div><div></div></div><div><div>3. Ensure that connector is in locked condition by touching the <b>LEFT SIDE</b> of connector lock from <b>TOP to BOTTOM</b> using <b>right thumb</b>.</div><div>4. Ensure that connector is in locked condition by touching the <b>RIGHT SIDE</b> of connector lock from <b>TOP to BOTTOM</b> using <b>right thumb</b>.</div></div></div></div>		n/a	<div>1. No damaged double lock.</div> <div>2. No half-locked connector</div>

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Model code/Part number:

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Customer: TRP

Car Model:

TOYOTA-INNOVA

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Purpose:




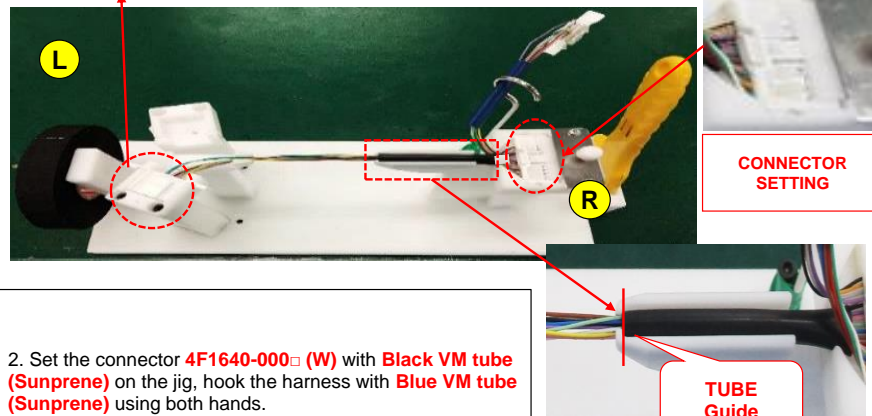
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PARTS:	1. Assy parts		JIG:	1. Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P5 <div>8</div> <div>HIGH</div> <div>Taping 1 &amp; 2 Wire taping (Tesa)</div>	<div><div><div>BEFORE PRESSING</div></div><div><div>AFTER PRESSING</div></div><div><div>CONNECTOR SETTING</div></div><div><div>2. Set the connector 4F1640-000 (W) with Black VM tube (Sunprene) on the jig, hook the harness with Blue VM tube (Sunprene) using both hands.</div></div></div> <div><div>1. Set the connector 1827842-1 (W) then push the guide lock using right index finger.</div><div>CONNECTOR SETTING</div><div>TUBE Guide</div></div>	n/a	<div>1. No wrong setting of harness 2. No wrong orientation of connector 3. Wires must align properly to avoid bend wire .</div> <div>Important reminders/Note/s:</div> <div>1. Make sure that both BLACK and BLUE VM tube ( Sunprene) must reach the TUBE guide before taping process.</div> <div>2. Long wires must be exposed near connector 4F1640-000 (W) during setting of harness on jig to avoid the loose wire move along (1827842-1 (W) connector .</div>

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Model code/Part number:

560B / 17L544-7050

Customer: TRP

Car Model: TOYOTA-INNOVA

Document No.:

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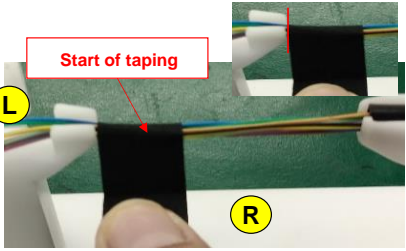
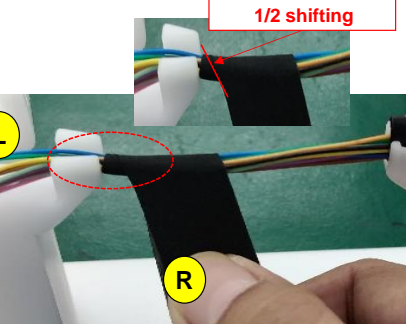
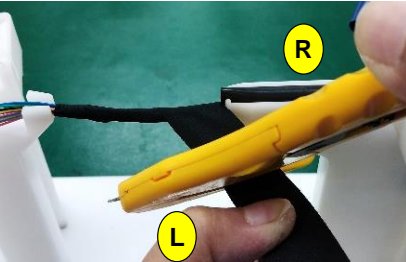

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts			JIG:	1. Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P5  <div>8</div>  <div>HIGH</div>  Taping 1 & 2 Wire taping (Tesa) (Continuation)	<div>  </div> <div>3. Using the guide, make <b>1 winding</b> of tape before shifting.</div> <div>4. Wind the <b>1/2 shifting or 3-4 winds</b> going to the right side near VM tube (Sunprene) using both hands.</div> <div>5. Use the provided cutter to cut the tesa tape using both hands.</div>		n/a	<div><b>Important reminders/Note/s:</b> <b>1. No holding/fixing of wire during taping.</b></div> <div></div> <div>1. No loose tape 2. No excessive tape winding 3. No damage on parts 4. No peel off tape 5. No bend wire 6. No NG of end tape</div>

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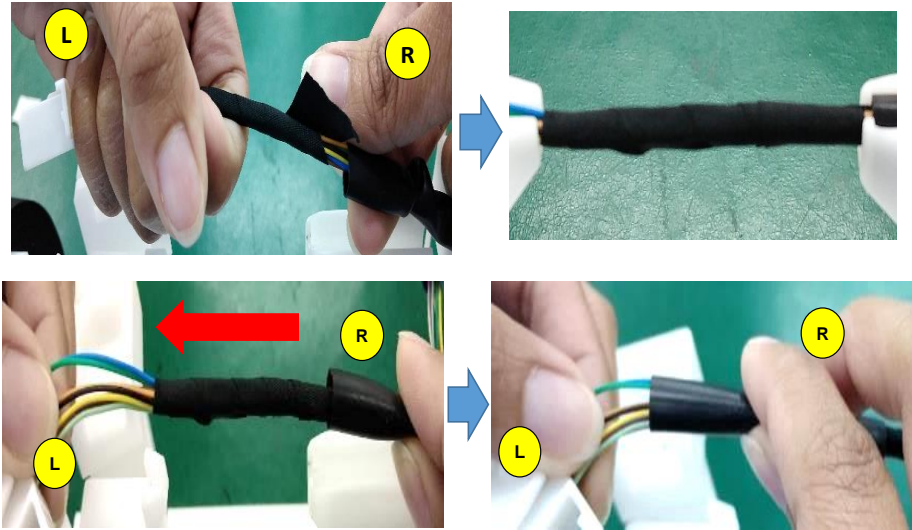

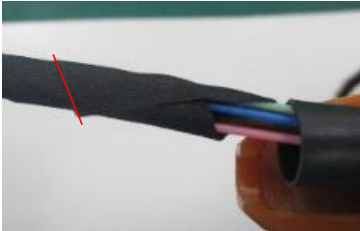
WORK INSTRUCTION  
TAPING ASSEMBLY PROCESS

Effectivity Date:	March 12, 2025		
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Process Name/Title: **TAPING ASSEMBLY PROCESS**

Model code/Part number: **560B / 17L544-7050** Customer: **TRP** Car Model: **TOYOTA-INNOVA**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:	1. Assy parts			JIG:	1. Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	<div>8</div> <div>HIGH</div> <div>Taping 1 &amp; 2 Wire taping (Tesa) (Continuation)</div>	<div><p>6. Remove the connector <b>4F1640-000□ (W) [with Black VM tube (Sunprene) ]</b> from jig using left hand then press the tape using right hand. Avoid touching the adhesive.</p></div> <div><p>7. After taping, pull the vinyl tube to the left side position using right hand.</p></div>		<div><p>OLFA Cutter</p></div>	<p><b>Important reminders/Note/s:</b> <b>1. The end tape must be half wrap</b></p>  <ul style="list-style-type: none"><li>1. No loose tape</li><li>2. No excessive tape winding</li><li>3. No damage on parts</li><li>4. No peel off tape</li><li>5. No bend wire</li><li>6. No NG of end tape</li></ul>

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WORK INSTRUCTION  
TAPING ASSEMBLY PROCESS

Effectivity Date:

March 12, 2025

Process Name/Title:

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

Customer: TRP

Car Model: TOYOTA-INNOVA

Document No.:

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

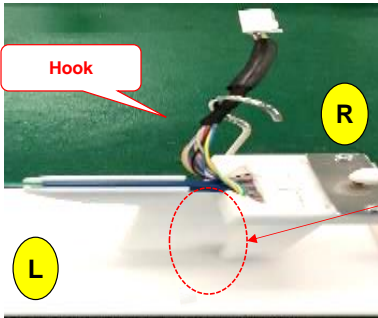

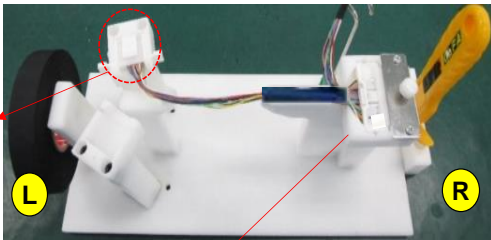

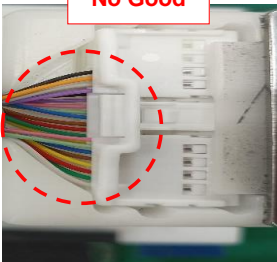


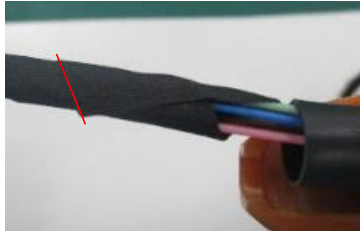
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PARTS:	1. Assy parts		JIG:	1. Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	<div>8</div> <div>HIGH</div> <div>Taping 1 &amp; 2 Wire taping (Tesa) (Continuation)</div> <div>P5</div>	<div><p>Hook</p><p>R</p><p>L</p></div> <div></div> <div><p>8. Place the assy parts with <b>Black VM tube (Sunprene)</b> to Hook.</p></div> <div><p>L</p><p>R</p></div> <div><p>9. Set the assy with <b>Blue VM tube (Sunprene)</b> then repeat the process from step 3 to 7.</p></div> <div><p>Good</p><p>No Good</p></div>	<div></div> <div>OLFA Cutter</div>	<div></div> <div><p><b>Important reminders/Note/s:</b></p><p>1. <b>Pink &amp; Light green wires must be on bottom of other wires, not expose.</b></p><p>2. <b>No holding/fixing of wire during taping.</b></p><p>1. No loose tape 2. No excessive tape winding 3. No damage on parts 4. No peel off tape 5. No bend wire 6. No NG of end tape</p></div>

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**March 12, 2025**

Validity Date:

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Model code/Part number:

**560B / 17L544-7050**Customer: **TRP**

Car Model:

**TOYOTA-INNOVA**

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Purpose:



☐ **PROTOTYPE**☐ **PRE-LAUNCH**☒ **MASSPRO**

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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	P5 Pass WIP to P6	<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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