
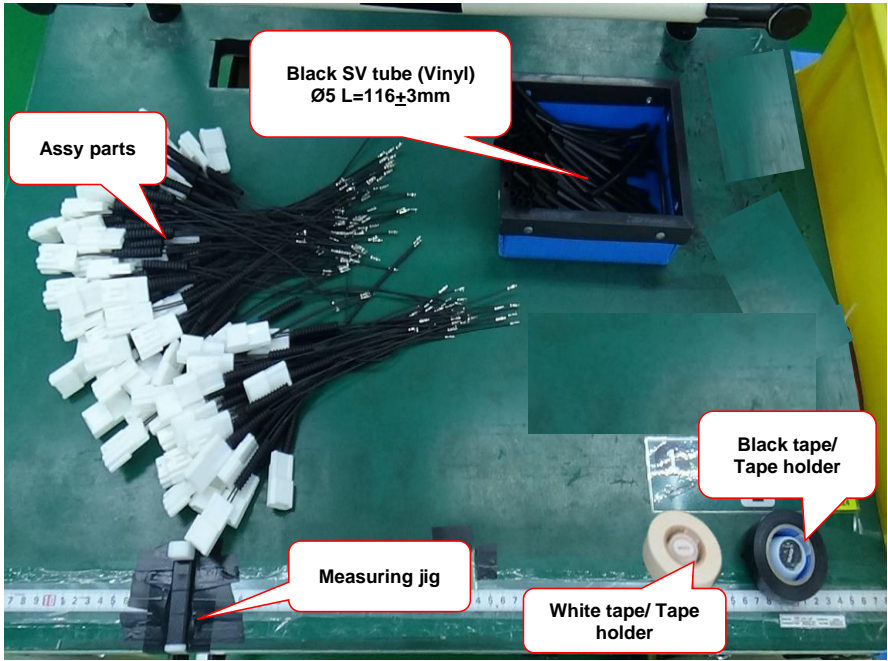





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|---|---|--|-----------------------|----------------------------------|-------------------|--|-----------------------|------------------|
|  | WORK INSTRUCTION | | | | Effectivity Date: | | May 22, 2024 | |
| | Process Name/Title: TAPING ASSEMBLY PROCESS | | | | Validity Date: | | n/a | |
| | Model code/Part number: 927B / 7R0101-7020 | | Customer: TRMX | Car Model: TOYOTA COROLLA | Document No.: | | WI-ENG-PDE-067 | |
| | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO | | | | Revision No.: | | 6 | Page No.: 1 of 5 |

| | | | | | | | | | |
|------------------|---------------------|--|--|--|--|---|------------------|---|-----------|
| PARTS: | | 1. Assy parts; Black SV tube (Vinyl) Ø5 L=116+3mm; Black tape; White tape | | | | JIG: | | 1. Measuring jig | |
| NO. | PROCESS NAME | <div>6</div> WORK PROCEDURE/ ILLUSTRATION | | | | TOOLS/PPE | | QUALITY POINTERS | |
| 1 | P1 | <div>TABLE LAY-OUT</div>  | | | | <div>Safety Instruction</div> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) | | <div>Document reference/s:</div> 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to WI-ENG-PDE-066 for Offline assembly process | |
| | | | | | | <div>Housekeeping</div> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. | | 1. No missing parts/tools. 2. No excess parts/tools. | |
| | | | | | | <div>Alert level</div> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. | | | |
| Revision History | | | | | | | | | |
| | | | | | | Prepared by | Reviewed by | Approved by | Noted by |
| 05/22/24 | 6 | Transfer wire insertion to COT process to Offline assembly process due to Process improvement. Inclusion of Car model "TOYOTA-COROLLA". Improved Measurement and Visual inspection. Update Table lay-out | | | | D. Castillo | C. Villanueva | A. Arañes | n/a |
| 05/17/23 | 5 | Inclusion of table lay-out and quality pointers; improve important reminders/note/s & Document references; improve By two's inspection. | | | | J. Loterte | C. Villanueva | A. Arañes | n/a |
| 07/08/21 | 4 | Removal of marking and add tape quantity. | | | | D. Castillo | C. Villanueva | A. Shimamura | A. Arañes |
| Eff. Date | Rev. No | Details of Change | | | | Revised | Reviewed | Approved | Noted |
| | | | | | | Est. Date: | January 17, 2020 | | |

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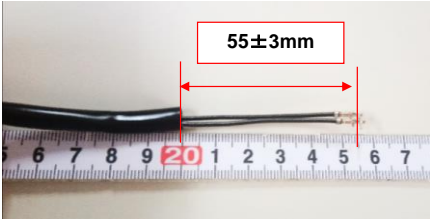
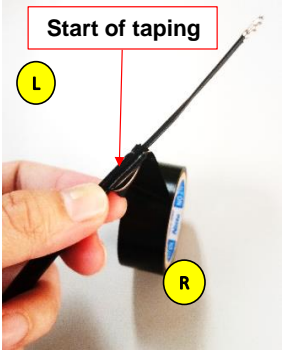
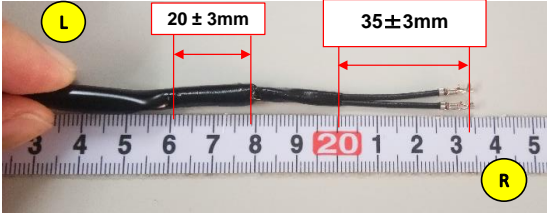

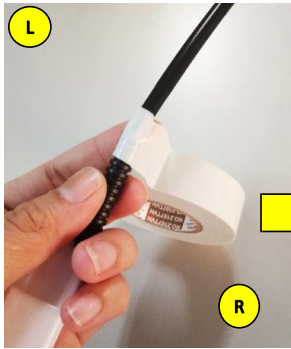
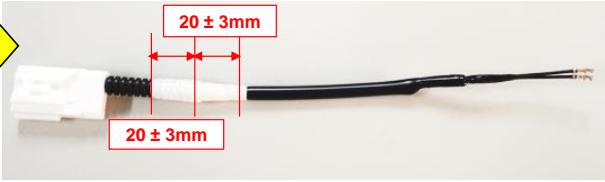
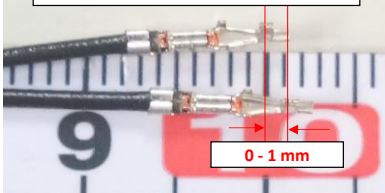
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|---------------|--|---|--|------------------|--|
| PARTS: | | 1. Assy parts 2. Black SV tube (Vinyl) Ø5 L=116+3mm | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 2 | P1 Wire insertion to Black SV tube (Vinyl) Ø5 L=116+3mm | <div><div>1. Get the Black SV tube (Vinyl) Ø5 L=116+3mm using right hand then insert the Black wires using left hand.</div></div> | | n/a | 1. No wrong usage of parts 2. No deformed terminals |

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| | Model code/Part number: 927B / 7R0101-7020 | | Customer: TRMX | Car Model: TOYOTA COROLLA | Document No.: | WI-ENG-PDE-067 | |
| | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO | | | Revision No.: | 6 | Page No.: | 3 of 5 |

| | | | | | |
|---------------|--|--|--|---|---|
| PARTS: | 1. Assy parts 2. Black tape 3. White tape | | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 3 | P1 Taping 1 SV tube (Vinyl) to wire near terminal | <div><p>55±3mm</p></div> <div><p>Start of taping</p><p>2. Get the Black tape, hold the Vinyl tube using left hand then fold the vinyl tube and start taping using right hand.</p></div> <div><p>20 ± 3mm 35 ± 3mm</p><p>3. After taping, check the measurement, taping condition and wire alignment.</p></div> | |  <p>Measuring tape</p> | <p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <p>1. No peel-off tape 2. No flip-out tape 3. No loose tape 4. No wrong use of tape 5. No wrong tape measurement 6. No missing tape</p> |
| 4 | Taping 2 Corrugated tube to SV tube (Vinyl) | <div><p>1. Hold the harness using left hand, get the White tape using right hand and begin the taping process.</p></div> <div><p>20 ± 3mm 20 ± 3mm</p></div> | |  <p>Wire alignment tolerance</p> <p>0 - 1 mm</p> | |

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**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 22, 2024

Model code/Part number:

927B / 7R0101-7020

Customer:

TRMX

Car Model:

TOYOTA COROLLA

Document No.:

WI-ENG-PDE-067

Purpose:

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4 of 5**PARTS:**

1. Assy parts

JIG:

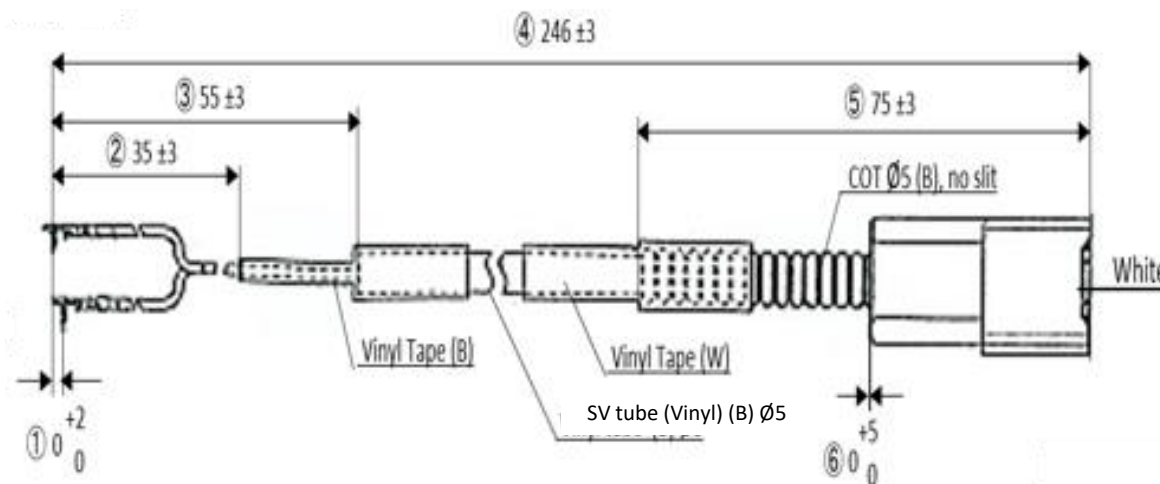
n/a

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

5

P1

Measurement

**Measuring tape****Important reminders and note/s:**

1. Please use calibrated/verified measuring tape when getting the measurement.

2. For Hatsumono, Nakamono and Owarimono.

Document reference/s:

1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection

1. No wrong dimension

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**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

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Validity Date:

n/a

Model code/Part number:

927B / 7R0101-7020

Customer:

TRMX

Car Model:

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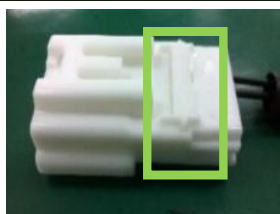
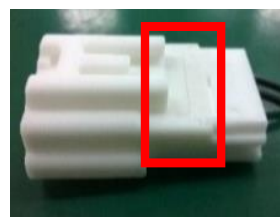
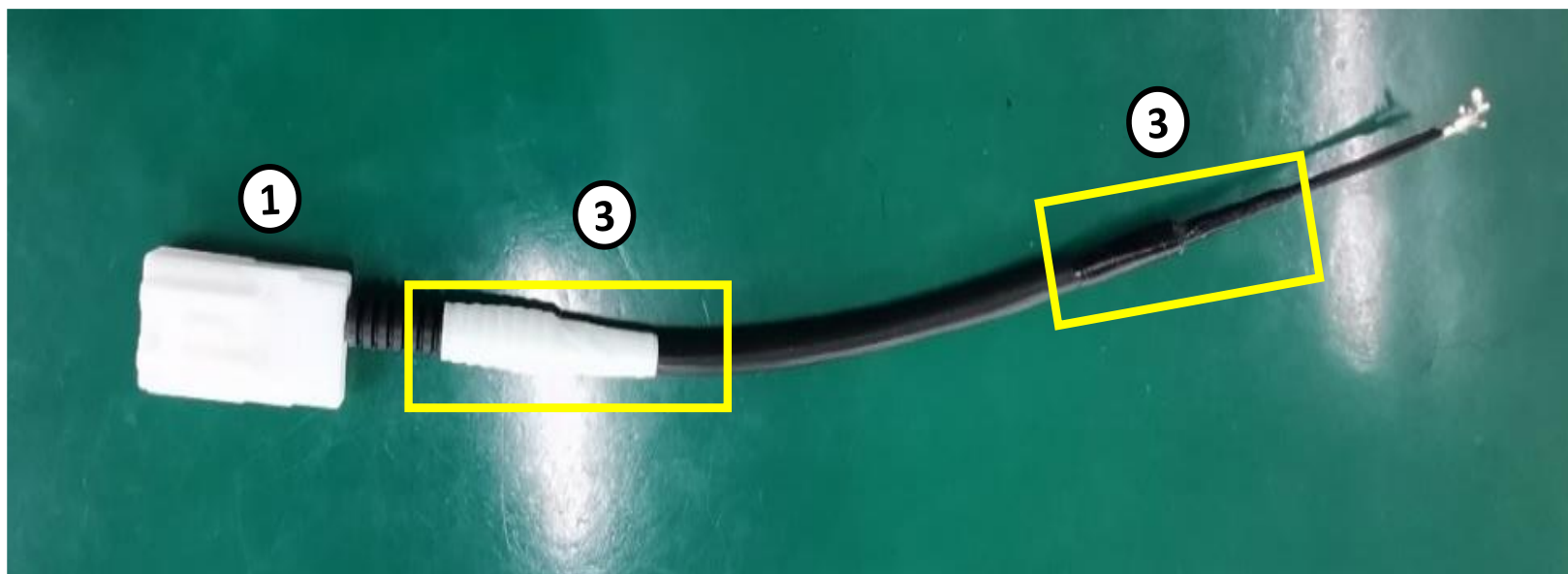
5 of 5

PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P1****7R0101-7020****GOOD****NO GOOD**

- ① No Deformed Terminal
- ② No Unlocked/Half-locked Connector

- ③ No Missing Tape and No Wrong use of tape

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