


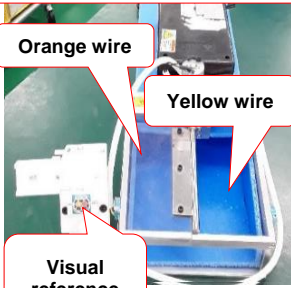

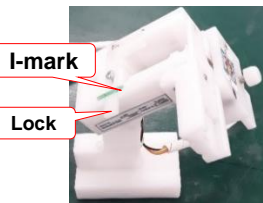

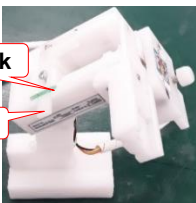
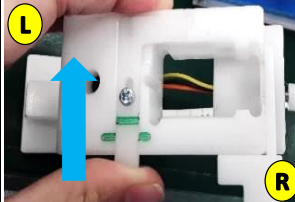
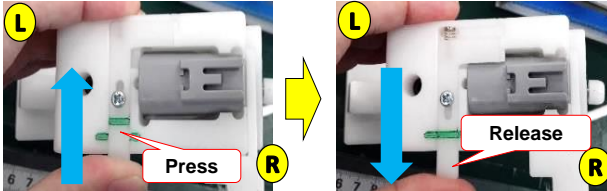
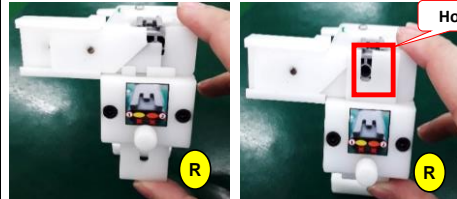

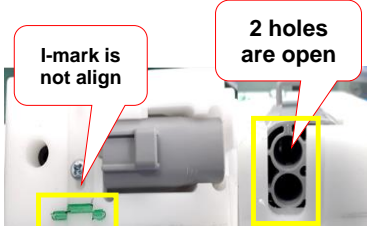
	WORK INSTRUCTION					Effectivity Date:		October 15, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS					Validity Date:		n/a	
	Model code/Part number: 177D / 7L0128-7020B		Customer: TRQSS		Car Model: TOYOTA-COROLLA		Document No.: WI-ENG-PDE-1098A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO					Revision No.:		1	Page No.: 1 of 10

PARTS:	1. Connector 6188-0066 (GR); Black Corrugated tube $\phi 7$ L=212 \pm 3mm (no slit); Black Corrugated tube $\phi 7$ L=115 \pm 3mm (no slit); Connector 6189-0451 (W); Black Corrugated tube $\phi 5$ L= 512 \pm 2mm (no slit); AVSSf 0.3 wires OR L=384 \pm 2mm; AVSSf 0.3 wires Y L=384 \pm 2mm; TVSSf 0.3 G-B/W L=822 \pm 3mm; Black tape			JIG:	1. Insertion jig with switch cover 2. Locking jig 3. Terminal cover jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
1	P1	Table lay-out			<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear required 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>		
Revision History			Prepared by		Reviewed by	Approved by	Noted by
10/15/24	1	Change from Pre-launch to Masspro.	D.Castillo	C. Villanueva	A. Arañes	n/a	
10/11/24	0	Initial issue.	D.Castillo	C. Villanueva	A. Arañes	n/a	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: October 11, 2024

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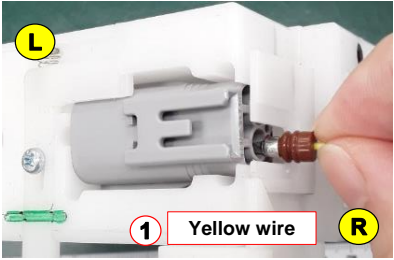
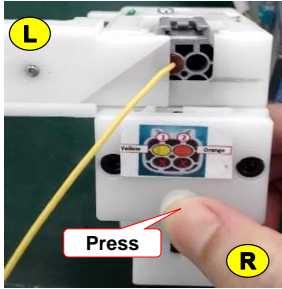
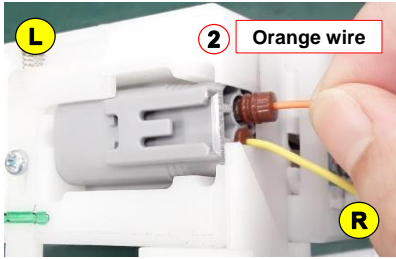
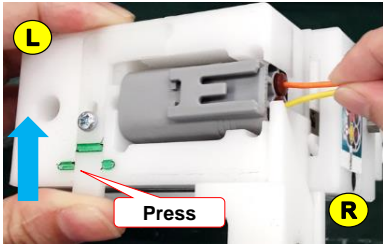
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		TAPING ASSEMBLY PROCESS				Validity Date:		n/a					
		Model code/Part number: 177D / 7L0128-7020B		Customer: TRQSS		Car Model: TOYOTA-COROLLA		Document No.:		WI-ENG-PDE-1098A			
		Purpose: <input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:		1 Page No.: 2 of 10			
PARTS:		1. Connector 6188-0066 (GR)				JIG:		1. Insertion jig with swith cover					
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS			
2		P1		<div><div>Insertion jig with switch cover</div><div><div>Orange wire</div><div>Yellow wire</div><div>Visual reference</div></div><div><div>Insertion jig with switch cover</div></div><div><div>I-mark</div><div>Lock</div></div><div><div>CONNECTOR ORIENTATION</div></div><div><div>INSERTION JG ORIENTATION</div></div></div> <div><div><div>1. Press the lock using left thumb.</div></div><div><div>2. Get the connector 6188-0066 (GR) using right hand and insert to insertion jig. Release the lock after insertion. Note: Follow the connector orientation.</div></div></div> <div><div><div>Hole</div><div>3. Push the lower wire guide upward using left thumb. Slot for Yellow wire will be opened.</div></div></div>				n/a		<div><div>CONNECTOR ORIENTATION ILLUSTRATION</div><div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div></div><div><div>I-mark is not align</div><div>2 holes are open</div><div>NG</div></div></div> <div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div>			

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	3 of 10

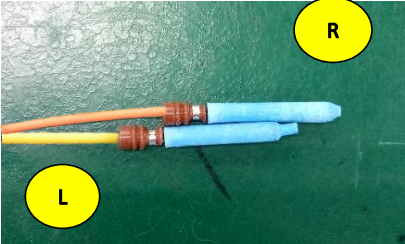


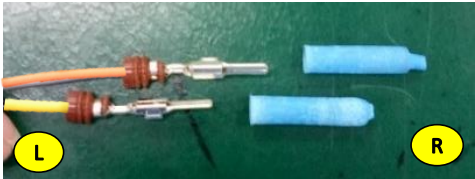

PARTS:		1. AVSSf 0.3 wire OR L=384±2mm 2. AVSSf 0.3 wire Y L=384±2mm		JIG:	1. Insertion jig with swith cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to Connector 6188-0066 (GR)	<div><p>TERMINAL FACING</p></div> <div><p>1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot 1 using right hand.</p></div> <div><p>2. Press the button using right thumb. The slot for Orange wire will be opened.</p></div> <div><p>3. Get the Orange 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> <p>n/a</p>		n/a	<p>Important reminders/Note/s:</p> <p>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:</p> <p>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> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p>

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	WORK INSTRUCTION			Effectivity Date:	October 15, 2024							
	TAPING ASSEMBLY PROCESS			Validity Date:	n/a							
	Process Name/Title:			Model code/Part number:	177D / 7L0128-7020B	Customer:	TRQSS	Car Model:	TOYOTA-COROLLA	Document No.:	WI-ENG-PDE-1098A	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:		1	Page No.:	4 of 10		

PARTS:		1. Black corrugated tube (no slit) $\varnothing 7$ L= 212 \pm 3mm 2. Black corrugated tube (no slit) $\varnothing 7$ L= 115 \pm 3mm			JIG:	1. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
4	P1 Wire insertion to Black corrugated tube (no slit) $\varnothing 7$ L= 212 \pm 3mm and Black corrugated tube (no slit) $\varnothing 7$ L= 115 \pm 3mm	<div><p>1. Get the assy parts using left hand, get the terminal cover jig using right hand and insert to both terminals.</p></div> <div><p>2. Hold the wires using left hand. Get the Corrugated tube (no slit) $\varnothing 7$ L=212\pm3mm using right hand then insert the Y-OR wires using left hand.</p></div> <div><p>3. Hold the wires using left hand. Get the Corrugated tube (no slit) $\varnothing 7$ L=115\pm3mm using right hand then insert the Y-OR wires using left hand.</p></div> <div><p>4. After insertion, remove the terminal cover jig using right hand.</p></div>			<div>TERMINAL COVER JIG</div> 	1. No wrong use of parts 2. No deformed terminal	

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**WORK INSTRUCTION**

Effectivity Date:

October 15, 2024

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

177D / 7L0128-7020B

Customer:

TRQSS

Car Model:

TOYOTA-COROLLA

Document No.:

WI-ENG-PDE-1098A

Purpose:



PROTOTYPE



PRE-LAUNCH



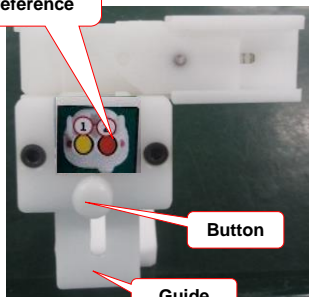
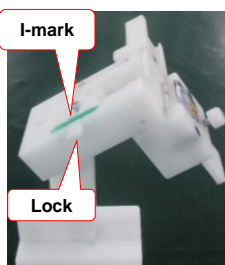

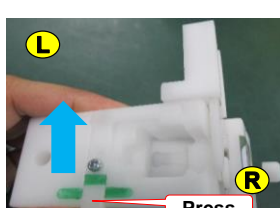
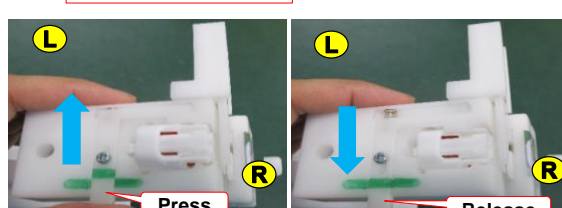
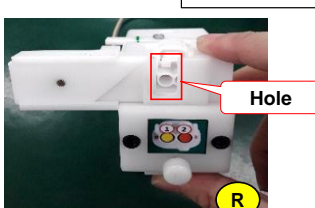

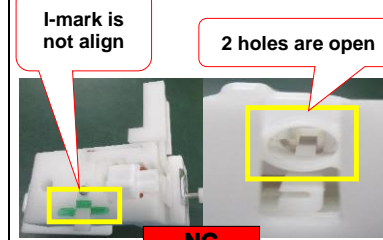

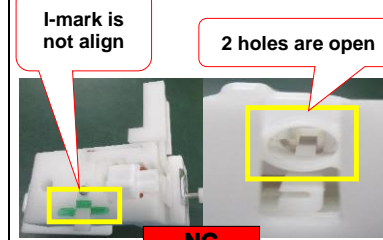
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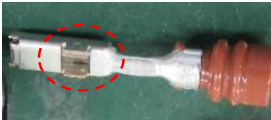
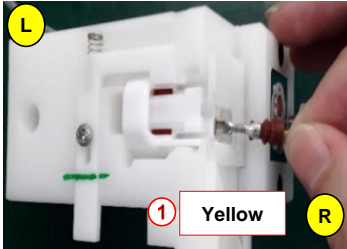
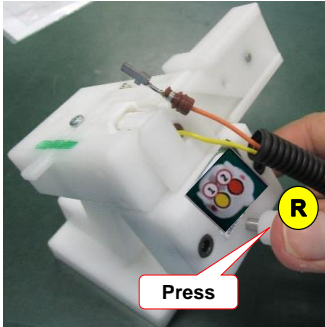
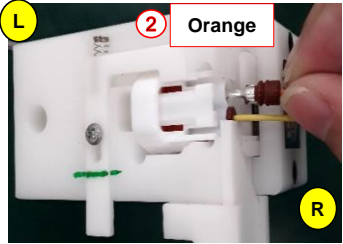
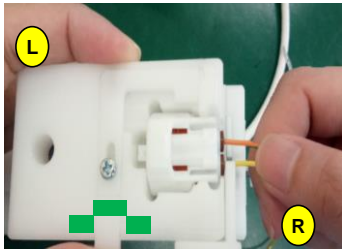
PARTS:		1. Connector 6189-0451 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1 Connector setting to insertion jig 6189-0451 (W)	<div><div><div><p>INSERTION JIG</p></div><div><p>INSERTION JIG ORIENTATION</p></div><div><p>CONNECTOR ORIENTATION</p></div></div><div><div><p>Press</p></div><div><p>Press Release</p></div><div><p>Hole</p></div><div><p>1. Press the lock using left thumb.</p><p>2. Get the connector 6189-0451 (W) using right hand and insert to insertion jig. Release the lock after insertion. Note: Follow the connector orientation.</p><p>3. Push the lower wire guide upward using left thumb. Slot for Yellow wire will be opened.</p></div></div><td>n/a</td><td><div><div><p>CONNECTOR ORIENTATION ILLUSTRATION</p><div><div><p>GOOD</p></div><div><p>NG</p></div></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></div></div></td></div>		n/a	<div><div><p>CONNECTOR ORIENTATION ILLUSTRATION</p><div><div><p>GOOD</p></div><div><p>NG</p></div></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></div></div>

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	Model code/Part number: 177D / 7L0128-7020B		Customer: TRQSS	Car Model: TOYOTA-COROLLA	Document No.: WI-ENG-PDE-1098A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	6 of 10


PARTS:	1. Assy parts			JIG:	1. Insertion jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
6	P1	<div><p>TERMINAL FACING</p></div> <div><p>1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot 1 using right hand.</p></div> <div><p>2. Press the button using right thumb. The slot for Orange wire will be opened.</p></div> <div><p>3. Get the Orange 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>Important reminders/Note/s:</p> <p>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:</p> <p>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> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p>		


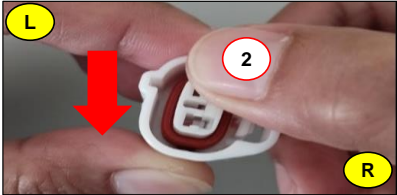
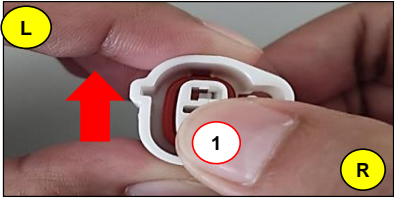
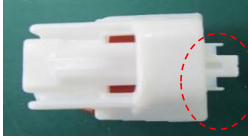




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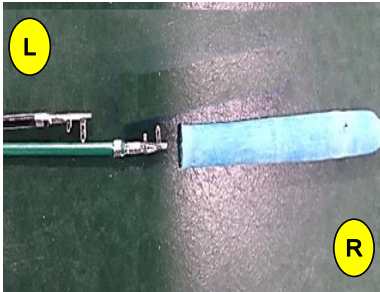

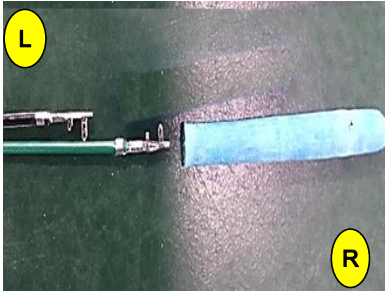

PARTS:	1. Assy parts			JIG:	1. Locking jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
7	P1	Connector lock					
		<div><div>1. Put the connector into locking jig using right hand. Then press to lock 2x using both hands.</div><div>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</div><div><div>BEFORE PRESSING</div><div>AFTER PRESSING</div></div><div><div>GOOD</div><div>NG</div></div><div>Check the double lock deformation</div></div>		<div>LOCKING JIG</div> 	<div>Document references:</div> <div>1. Manual locking may cause damaged connector lock</div> <div>1. No wrong usage of parts</div> <div>2. No deformed terminal</div>		

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		1	Page No.:	8 of 10	


PARTS:		1. Assy parts 2. Black Corrugated tube ø5 L=512±2mm (no slit)		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1 Wire insertion to Black Corrugated tube ø5 L=512±2mm (no slit)	<div></div> <div>1. Get the terminal cover jig using right hand then insert the G-B/W wires using left hand.</div> <div></div> <div>2. Get the Black Corrugated tube ø5 L=512±2mm (no slit) using right hand and insert to G-B/W wires using left hand.</div> <div></div> <div>3. After insertion, remove the terminal cover jig using right hand.</div>		<div>TERMINAL COVER JIG</div> 	1. No wrong usage of parts 2. No deformed terminal

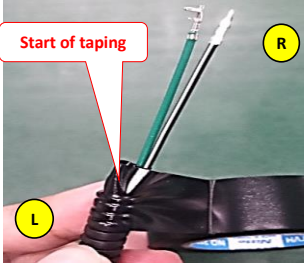
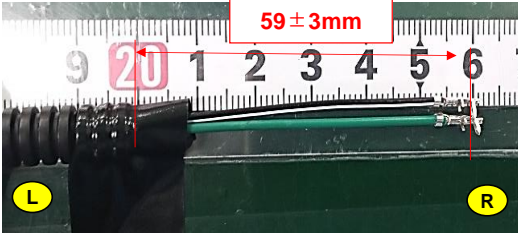
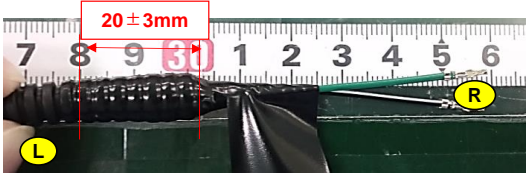

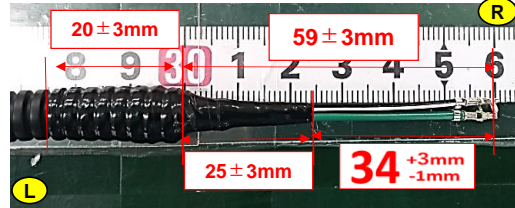

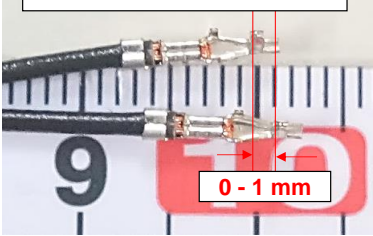
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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
9	P1 Taping 1 Black Corrugated tube to wire near terminal	<div><p>1. Hold the COT using left hand, get the black tape using right hand then start pre-taping using both hands.</p></div> <div><p>2. Measure from end of COT up to terminal pointed tip 59±3mm then continue the taping process using both hands.</p></div> <div><p>3. Confirm measurement from end of tape up to end of COT 20±3mm then continue the taping process using both hands.</p></div> <div><p>4. Measure from end of tape up to terminal pointed tip 34(+3/-1mm) then continue the taping process using both hands.</p></div> <div><p>5. After taping, check the measurement, wire alignment and taping condition.</p></div>		<div>MEASURING TAPE</div> 	<div>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document reference/s: 1. Please refer to WI-PRO-ASY-001 for taping procedure.</div> <div>Wire alignment tolerance</div> 	

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 15, 2024

Validity Date:

n/a

Model code/Part number:

177D / 7L0128-7020B

Customer:

TRQSS

Car Model:

TOYOTA-COROLLA

Document No.:

WI-ENG-PDE-1098A

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1. Assy parts

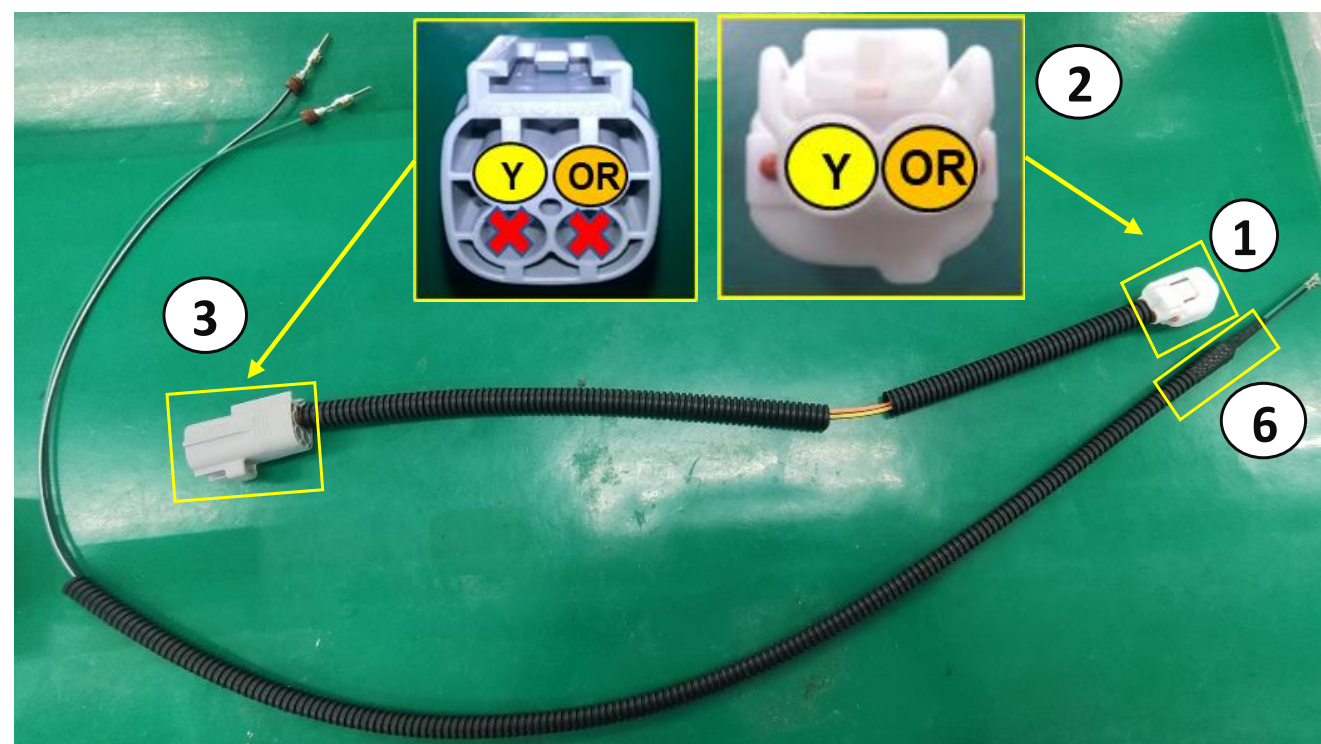
JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING - P1

7L0128-7020B



- ① No Unlocked/ Half-locked connector
- ② No Wrong Insert
- ③ No Deformed terminal
- ④ No Terminal backing out
- ⑤ No Missing Tape
- ⑥

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