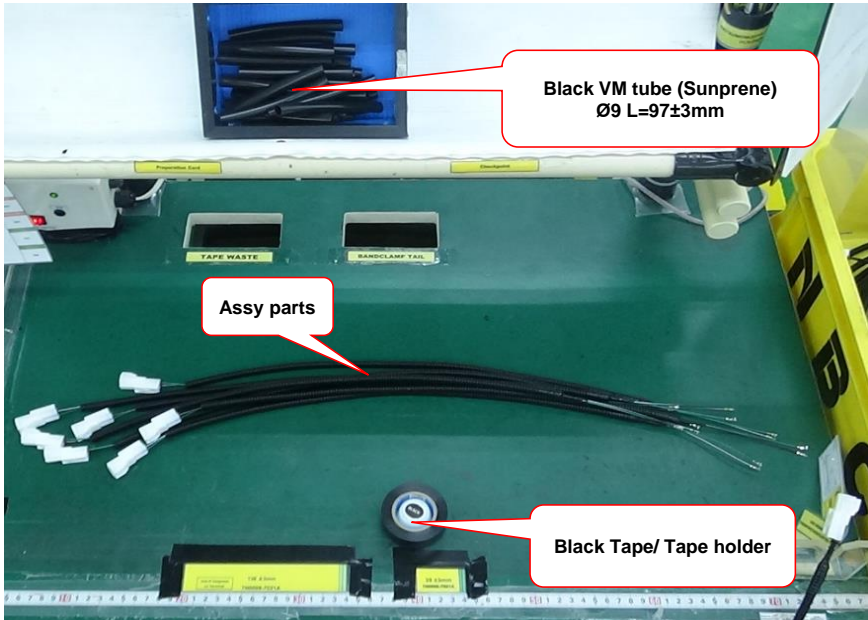




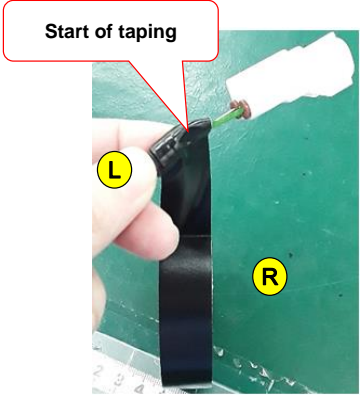
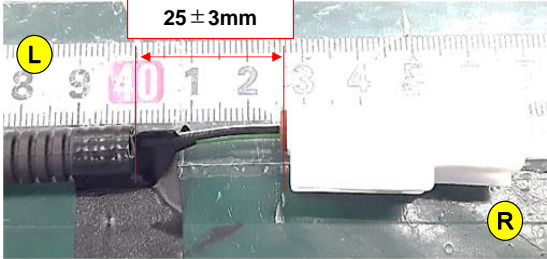
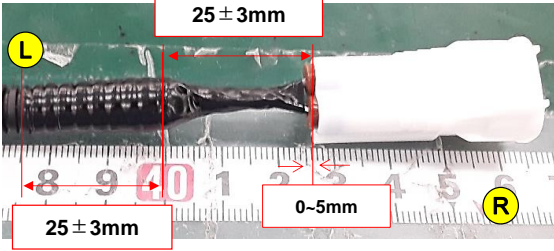

	WORK INSTRUCTION				Effectivity Date:		August 02, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 086D / 7N0098-7021A		Customer: TRJ	Car Model: TOYOTA-RAV4	Document No.:		WI-ENG-PDE-527B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		4	Page No.: 1 of 5

PARTS:		1. Assy parts; Black VM tube (Sunprene) Ø9 L=97±3mm; Black tape		JIG:		n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
1	P2 Table Lay-out	<div style="text-align: center;"> <div style="border: 1px solid red; padding: 5px; display: inline-block;">Table Lay-out</div>  </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. Inclusion of car model "TOYOTA-RAV-4". Improved table lay-out, measurement 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		
	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-527B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	4	Page No.:	2 of 5


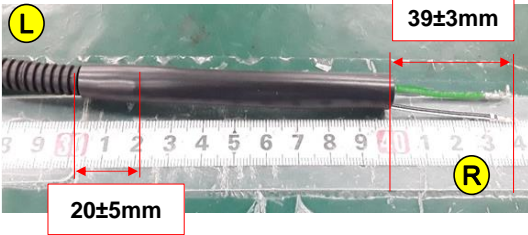
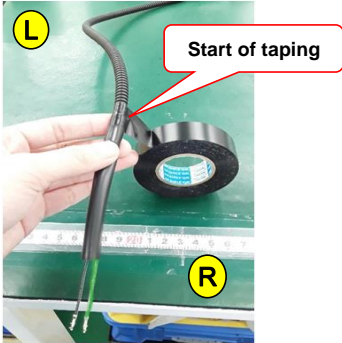
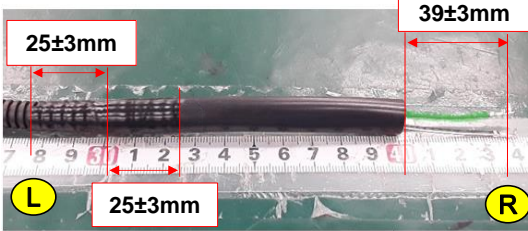

PARTS:	1. Black tape			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
2	P2 Taping 2 Corrugated tube to wire near Connector	<div><p>Start of taping</p><p>L R</p></div> <div><p>25 ± 3mm</p><p>L R</p></div> <div><p>25 ± 3mm</p><p>0~5mm</p><p>L R</p></div> <div><p>1. Hold the corrugated tube using left hand, get Black tape and start pre-taping using right hand.</p><p>2. Measure from end of corrugated tube up to the edge of connector 25±3mm then continue the taping process using both hands</p><p>3. After taping, check the measurement and taping condition.</p></div>	<div><p>MEASURING TAPE</p></div>	<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 flip-out tape 2.No peel-off tape 3. No loose tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape</p>	

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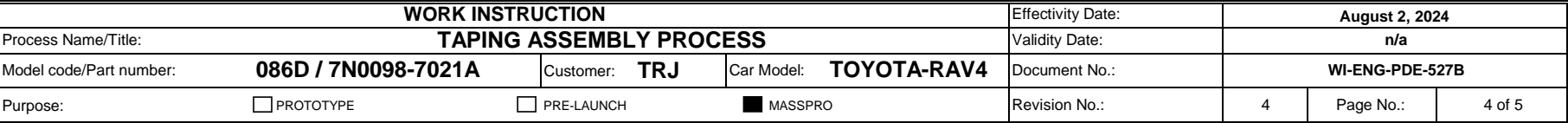
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	WORK INSTRUCTION				Effectivity Date:		August 2, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 086D / 7N0098-7021A		Customer: TRJ	Car Model: TOYOTA-RAV4	Document No.:		WI-ENG-PDE-527B	
	Purpose: <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 VM tube Ø9 L=97±3mm 3. Black tape			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	4 Wire insertion to Black VM tube Ø9 L=97±3mm	 <div> 1. Get the Black VM tube Ø9 L=97±3mm using right hand and insert the G-B/W wires using left hand </div>	n/a	1. No wrong use of parts 2. No deformed terminal	
4	P2 Taping 3 Corrugated tube to Black VM tube (Sunprene)	<div>  <div> 1. Hold the COT using left hand and check the dimension from VM tube to terminal tip 39±3mm using both hands. </div> </div> <div>  <div> 2. Hold the assy parts, get Black tape then start taping process using both hands. </div> </div> <div>  <div> 3. After taping, check the measurement and taping condition. </div> </div>	<div> MEASURING TAPE  </div>	<div> Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. </div> <div> Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure. </div> <div> 1. No peel-off tape 2. No flip-out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape </div>	

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**WORK INSTRUCTION**

Process Name/Title:

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-527B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

4

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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P2****7N0098-7021A****1****2****No Missing Tape(Black Tape)**

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