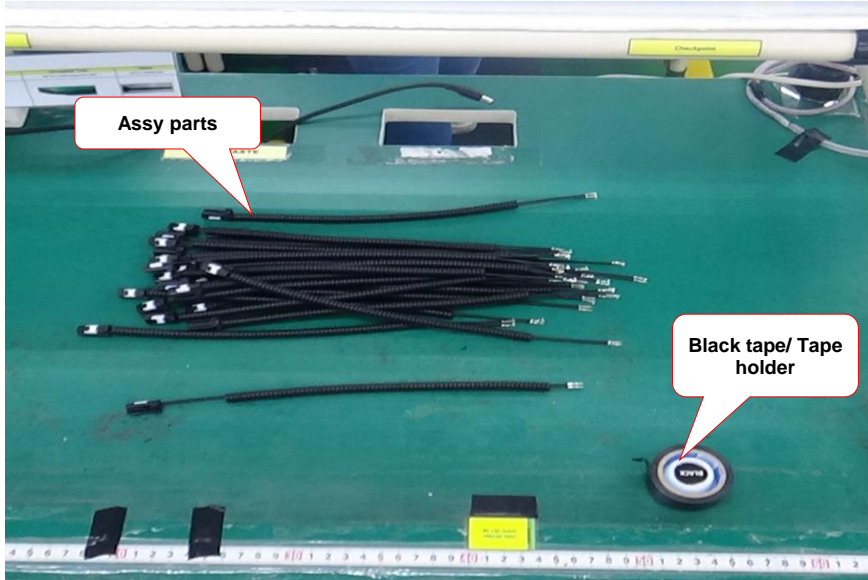





PARTS:	1. Assy parts; Black tape		JIG:	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	<p>Table Lay-out</p> 	<p>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to WI-ENG-PDE-989 for Offline assembly process</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>

Revision History							Prepared by	Reviewed by	Approved by	Noted by
							 A. Hernandez	 C. Villanueva	 A. Arañes	n/a
07/26/24	1	Separate Wire insertion to connector and COT to wire insertion to Offline assembly process. Separate Clamp assembly to Clamp assembly process. Improved Table lay-out, Measurement and Visual inspection/Quality checkpoints. Change from Pre-launch to Masspro.	A. Hernandez	C. Villanueva	A. Arañes	n/a				
02/16/24	0	Initial issue.	A. Hernandez	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted	Est. Date:	February 16, 2024	

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

491D/564D/7R0150-7020

Customer:

TRMX

Car Model:

TOYOTA-SEQUOIA

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

July 26, 2024

Validity Date:

n/a

Document No.:


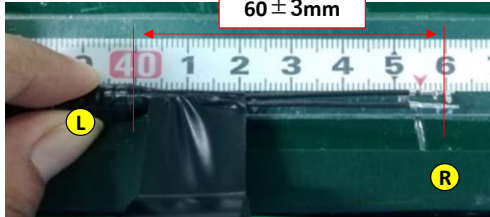
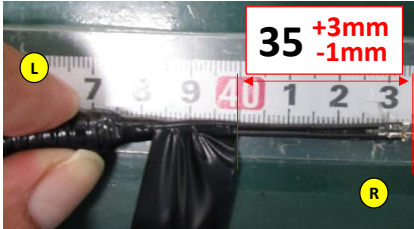
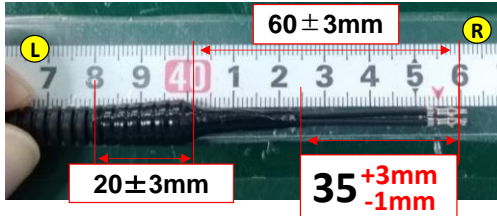

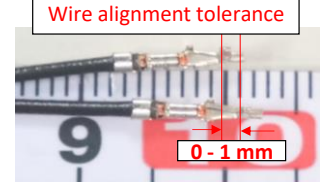
WI-ENG-PDE-842

Revision No.:

1

Page No.:

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PARTS:		1. Assy parts 2. Black tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	n/a Taping 1 COT to wire near terminal	<div><p>Start of taping</p></div> <div><p>60 ± 3mm</p></div> <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>35 +3mm -1mm</p></div> <div><p>2. Measure from end of COT up to terminal pointed tip 60±3mm then continue the taping process using both hands.</p></div> <div><p>60 ± 3mm 20 ± 3mm 35 +3mm -1mm</p></div> <div><p>3. Confirm measurement of 35+3mm/-1mm from end of tape up to terminal pointed tip then continue the taping process using both hands.</p></div> <div><p>4. After taping, check the measurement, taping condition and terminal appearance.</p></div>	MEASURING TAPE 	<div><p>Wire alignment tolerance 0 - 1 mm</p></div> <div><p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</p></div> <div><p>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p></div> <div><p>Document references: 1. Refer to WI-ENG-PDE-588 for Tape and tube end standard tolerance 2. Refer to WI-PRO-ASY-001 for Taping process</p></div>

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Effectivity Date:

July 26, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

491D/564D/7R0150-7020

Customer:

TRMX

Car Model:

TOYOTA-SEQUOIA

Document No.:

WI-ENG-PDE-842

Purpose:


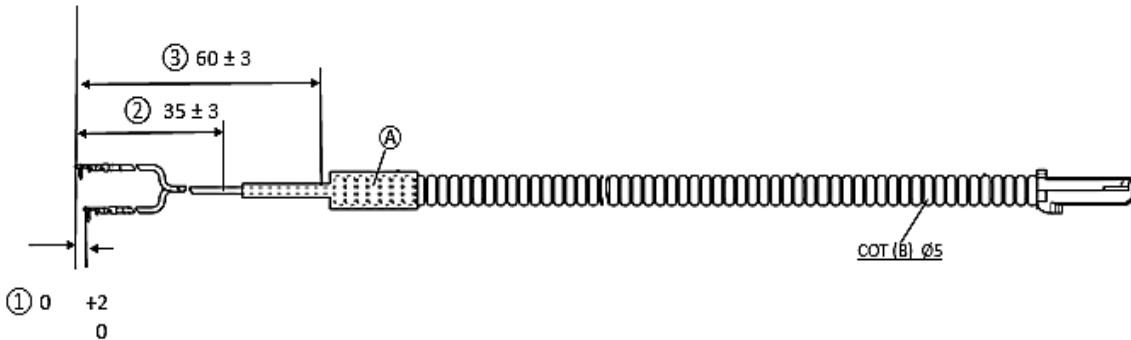
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	n/a	Measurement	<div>MEASURING TAPE</div>  	<div>1. No wrong dimension</div> <div>Important reminders and note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div>

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**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

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Validity Date:

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Model code/Part number:

491D/564D/7R0150-7020

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TOYOTA-SEQUOIA

Document No.:

WI-ENG-PDE-842

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

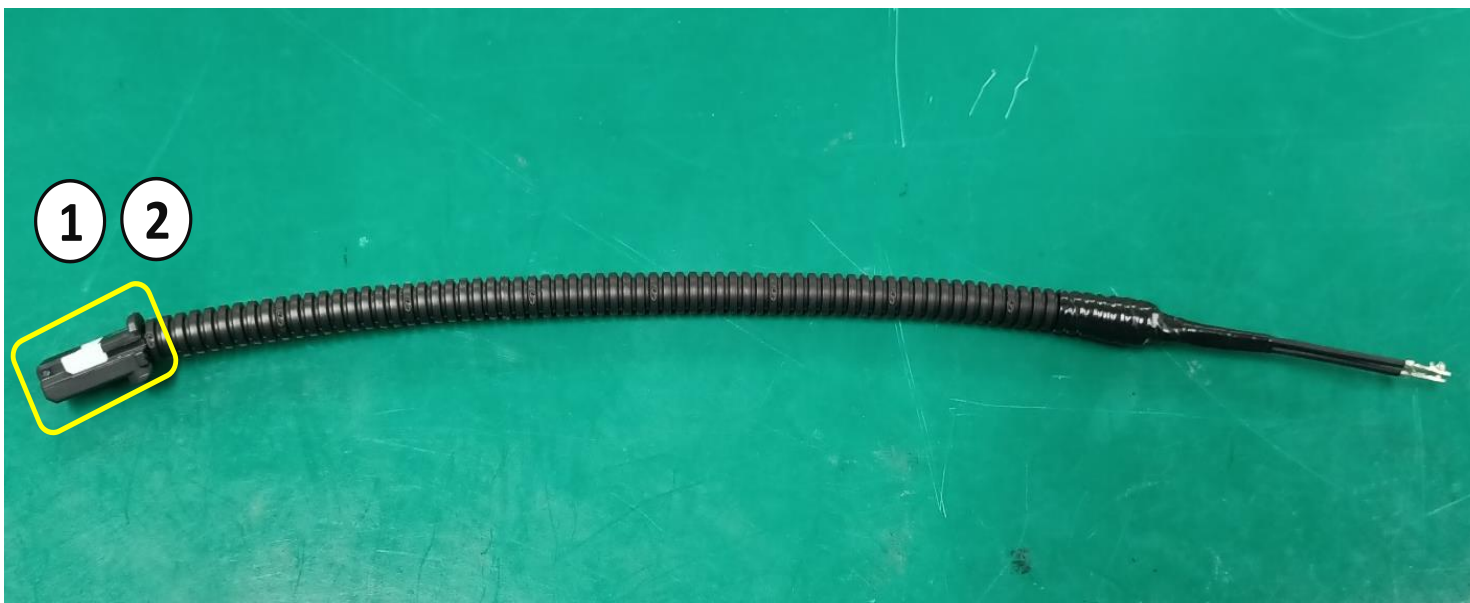
4 of 4

PARTS:

n/a

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P1****7R0150-7020****GOOD****NO GOOD****GOOD****NO GOOD****① No Unlock/Halflock Connector****② No Terminal Backing Out**

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