
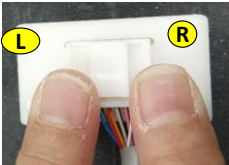
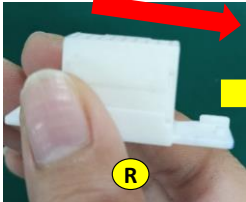
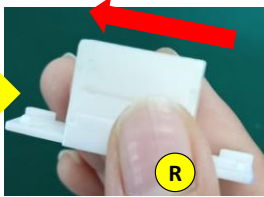
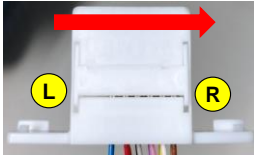


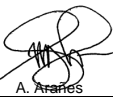
	<b>WORK INSTRUCTION</b>						Effectivity Date:		December 4, 2024	
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>						Validity Date:		n/a	
	Model code/Part number: 350B/320B/014B/360B/150B/		17J796-7051		Customer: TRP		Car Model: TOYOTA-COROLLA/RAV-4/ HIGHLANDER		Document No.: WI-ENG-PDE-091E	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.:		19	Page No.: 1 of 9

<b>PARTS:</b>		1. Assy parts				<b>JIG:</b>		1. Locking jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>				<b>TOOLS/PPE</b>		<b>QUALITY POINTERS</b>	
1	P5 <div>19</div> <div>LOW</div> <div>Connector Lock 1 (Assy parts with Black VM tube)</div>	<div></div> <div></div> <div></div> <div></div> <div></div> <div>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>.</div> <div>LEFT SIDE OF CONNECTOR LOCK</div> <div>RIGHT SIDE OF CONNECTOR LOCK</div>				<div><b>Safety Instruction</b> Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		<div><b>Important reminders/Note/s:</b> 1. <b>MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b></div> <div>1. No damaged double lock. 2. No half-locked connector</div>	

Revision History						Prepared by		Reviewed by		Approved by		Noted by	
12/04/24	19	Inclusion of Quality improvement measures (based on Mizen Boshi activity). Inclusion of Car model "TOYOTA-COROLLA/RAV-4/ HIGHLANDER".				D.Castillo	C. Villanueva	A. Arañes	n/a				n/a
09/25/24	18	Update Work procedure of process 3-4.				D.Castillo	C.Villanueva	A. Arañes	n/a				
06/24/24	17	Change Process 1 procedure 2-4 from LEFT thumb to RIGHT thumb. Add Good and No good to Process 4.				D.Castillo	C.Villanueva	A. Arañes	n/a				
07/25/23	16	Transfer process of Connector lock (Assy parts with Black VM tube) from P3 due to TPS improvements. Remove measurement and transfer to P6.				M. Ariola	J. Loterte	C.Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	June 02, 2017		

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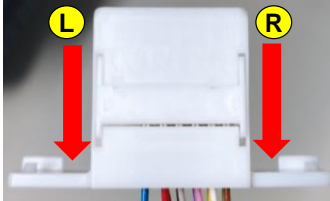
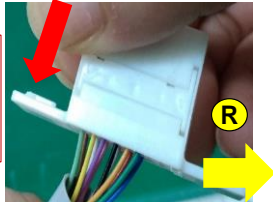
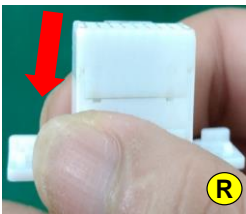
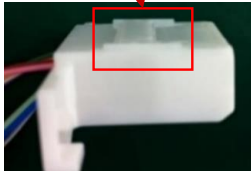
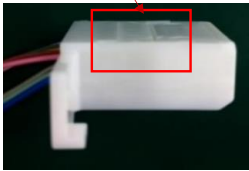
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WORK INSTRUCTION  
TAPING ASSEMBLY PROCESS

Effectivity Date:	December 4, 2024		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-091E		
Revision No.:	19	Page No.:	2 of 9

Process Name/Title:	TAPING ASSEMBLY PROCESS		
Model code/Part number:	350B/320B/014B/ 360B/150B/	17J796-7051	Customer: TRP
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	<div><div>19</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

## TAPING ASSEMBLY PROCESS

Effectivity Date:

December 4, 2024

Process Name/Title:

Model code/Part number:

350B/320B/014B/  
360B/150B/

17J796-7051

Customer: TRP

Car Model:

TOYOTA-COROLLA/  
RAV-4/ HIGHLANDER

Validity Date:

n/a

Document No.:

WI-ENG-PDE-091E

Purpose:

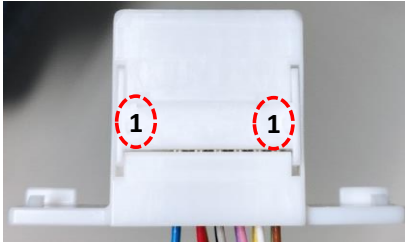

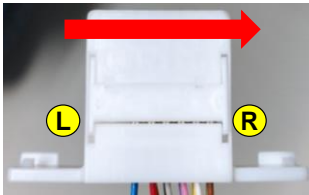
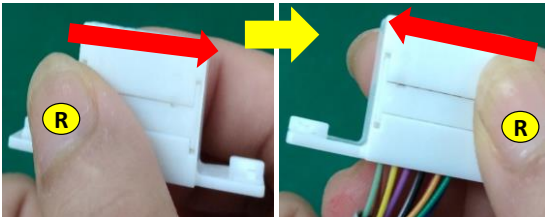
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	<div>19</div> <div>LOW</div> <div>Connector Lock 2 (Assy parts with N6GR VM tube)</div> <div>P5</div>	<div></div> <div><b>Sequence of Pressing the Double Lock:</b> ① - ① <b>Method:</b> Press same timing using both thumbs</div> <div></div> <div><div>Checking point (LEFT to RIGHT)</div></div> <div></div> <div>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>.</div>			<div>1. No wrong wire insertion</div> <div>2. No terminal backing out</div> <div>3. No deformed terminal</div> <div>4. Make sure wires are properly inserted.</div> <div>5. Must have slight MOVEMENT after insertion</div> <div>6. No bend terminal/wires</div>

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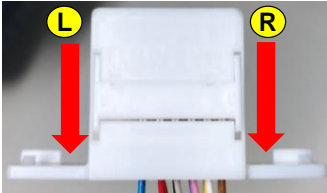
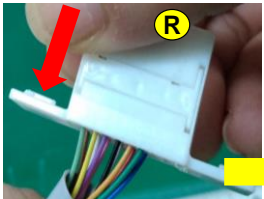
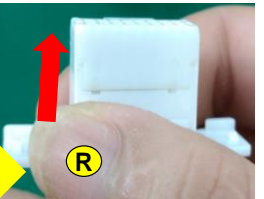

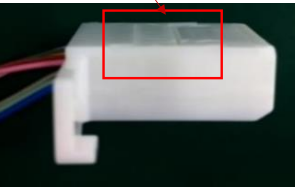
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WORK INSTRUCTION  
TAPING ASSEMBLY PROCESS

Effectivity Date:	December 3, 2024		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-091E		
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Process Name/Title:	TAPING ASSEMBLY PROCESS		
Model code/Part number:	350B/320B/014B/ 360B/150B/	17J796-7051	Customer: TRP
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	<div>19</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>		n/a	<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>1. No damaged double lock. 2. No half-locked connector</div>

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## WORK INSTRUCTION

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## TAPING ASSEMBLY PROCESS

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Model code/Part number:

350B/320B/014B/  
360B/150B/

17J796-7051

Customer: TRP

Car Model:

TOYOTA-COROLLA/  
RAV-4/ HIGHLANDER

Document No.:

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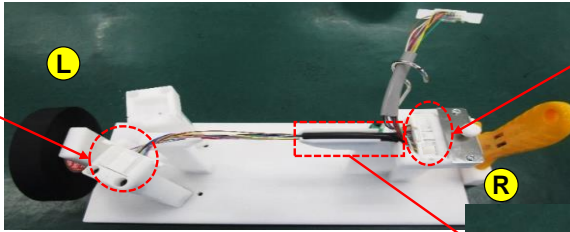

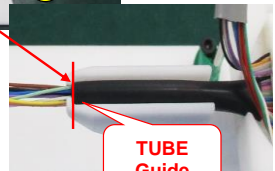
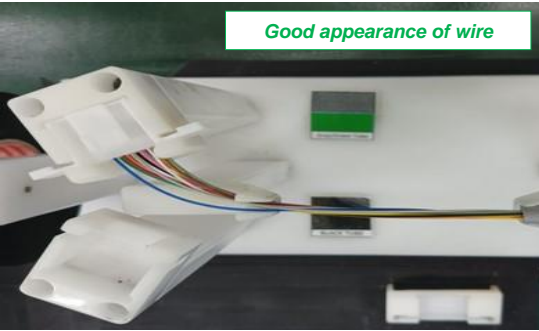
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PARTS:	1. Assy parts			JIG:	1. Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	<div>19</div> <div>P5</div> <div>HIGH</div> <div>Taping 1 &amp; 2 Wire taping (Tesa)</div>	<div><div><div>Guide Lock</div><div>R</div><div>BEFORE PRESSING</div></div><div><div>R</div><div>AFTER PRESSING</div></div><div><div>CONNECTOR SETTING</div></div><div><div>L</div><div>R</div></div><div><div>CONNECTOR SETTING</div></div><div><div>TUBE Guide</div></div><div><div>Good appearance of wire</div></div><div><div>1. Set the connector <b>1827842-1 (W)</b> then push the guide lock using right index finger.</div><div>2. Set the connector <b>4F1640-000 (W)</b> with <b>Black VM tube (Sunprene)</b> on the jig, hook the harness with <b>N6GR VM tube (Sunprene)</b> using both hands.</div></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><b>Important reminders/Note/s:</b>  <b>1. Make sure that both BLACK and LIGHT GRAY VM tube ( Sunprene) must reach the TUBE guide before taping process.</b>  <b>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 .</b></div>

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## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

December 4, 2024

Process Name/Title:

Model code/Part number:

350B/320B/014B/  
360B/150B/

17J796-7051

Customer: TRP

Car Model:

TOYOTA-COROLLA/  
RAV-4/ HIGHLANDER

Document No.:

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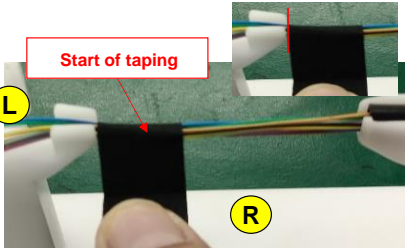
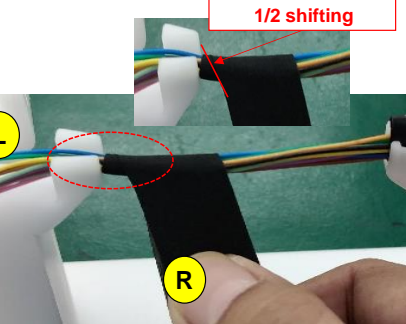
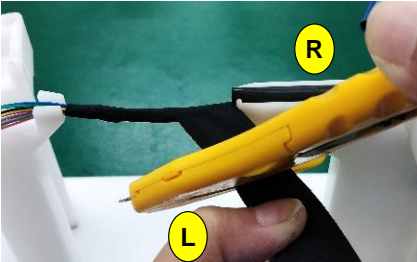

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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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>19</div> <div>HIGH</div> <div>Taping 1 &amp; 2 Wire taping (Tesa) (Continuation)</div>	<div><p>Start of taping</p></div> <div><p>1/2 shifting</p></div> <div><p></p></div> <div><p>3. Using the guide, make <b>1 winding</b> of tape before shifting.</p></div> <div><p>4. Wind the <b>1/2 shifting or 3-4 winds</b> going to the right side near VM tube (Sunprene) using both hands.</p></div> <div><p>5. Use the provided cutter to cut the tesa tape using both hands.</p></div>		n/a	<p><b>Important reminders/Note/s:</b></p> <p><b>1. No holding/fixing of wire during taping.</b></p>  <ol 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></ol>

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## TAPING ASSEMBLY PROCESS

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350B/320B/014B/  
360B/150B/

17J796-7051

Customer: TRP

Car Model:

TOYOTA-COROLLA/  
RAV-4/ HIGHLANDER

Document No.:

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Purpose:


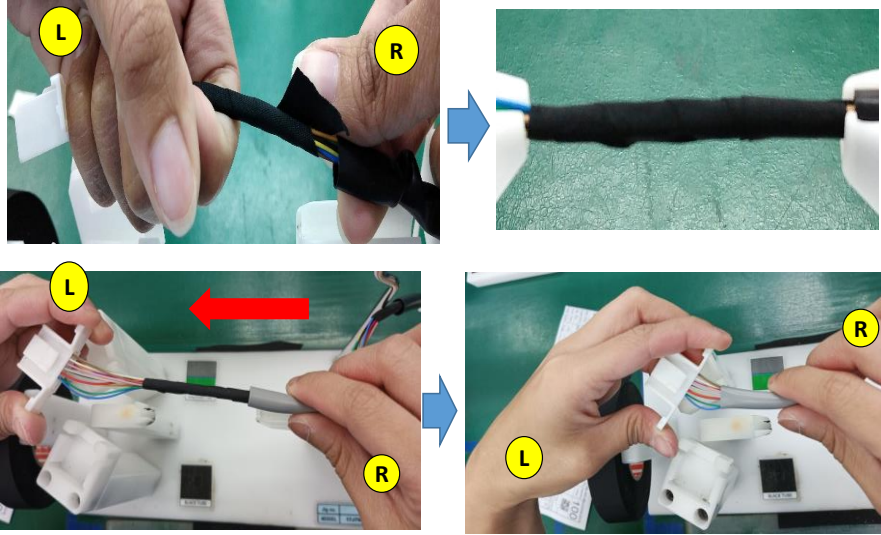

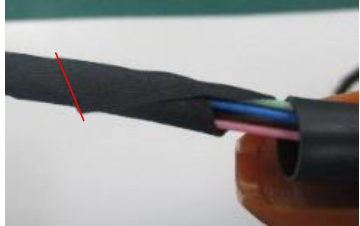
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PARTS:	1. Assy parts			JIG:	1. Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P5 <div>19</div> <div>HIGH</div> <div>Taping 1 &amp; 2 Wire taping (Tesa) (Continuation)</div>	<div></div> <div></div> <div>6. Remove 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.</div> <div>7. After taping, pull the vinyl tube to the left side position using right hand.</div>		<div>OLFA Cutter</div> 	<div><b>Important reminders/Note/s:</b></div> <div><b>1. The end tape must be half wrap</b></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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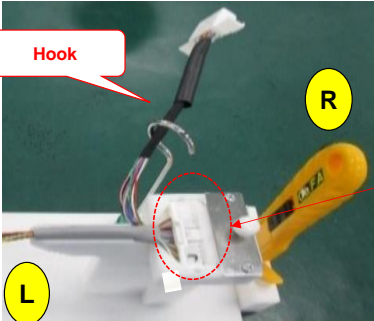


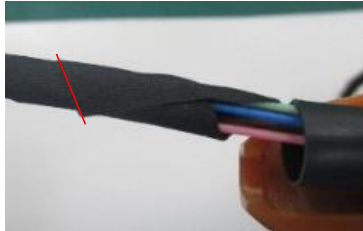

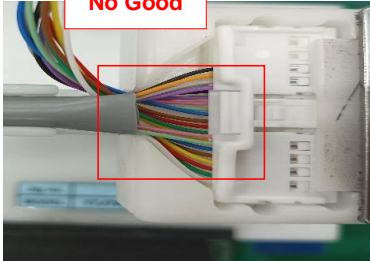


WORK INSTRUCTION  
TAPING ASSEMBLY PROCESS

Effectivity Date:	December 4, 2024		
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Process Name/Title:	TAPING ASSEMBLY PROCESS		
Model code/Part number:	350B/320B/014B/ 360B/150B/	17J796-7051	Customer: TRP
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

Car Model: TOYOTA-COROLLA/  
RAV-4/ HIGHLANDER

PARTS:		1. Assy parts		JIG:	1. Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	<div><div>19</div><div>HIGH</div><div>Taping 1 &amp; 2 Wire taping (Tesa) (Continuation)</div></div>	<div><div><div><div>Hook</div><div>R</div><div>L</div></div><div></div><div></div><div>8. Place the assy parts with <b>Black VM tube (Sunprene)</b> to Hook.</div></div></div>		<div><div>OLFA Cutter</div><div></div></div>	<div><div><b>Important reminders/Note/s:</b></div><div>1. <b>Pink &amp; Light green wires must be on bottom of other wires, not expose.</b></div><div>2. <b>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></div>
		<div><div><div><div>Good</div><div>No Good</div></div><div></div><div></div></div></div>			

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**WORK INSTRUCTION**

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**TAPING ASSEMBLY PROCESS**

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350B/320B/014B/  
360B/150B/**17J796-7051**Customer: **TRP**

Car Model:

**TOYOTA-COROLLA/  
RAV-4/ HIGHLANDER**

Document No.:

**WI-ENG-PDE-091E**

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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**PARTS:**

1. Assy parts

JIG:

1. WIP Holder

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

4

P5

Pass WIP to P6

**3 PIECES FLOW**1. Pass WIP to WIP Holder.  
**Note: Three pieces flow.****WIP HOLDER**

1. No WIP overflow

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