

	<b>WORK INSTRUCTION</b>					Effectivity Date:		April 25,2025	
	<b>TAPING ASSEMBLY PROCESS</b>					Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: <b>164 / 7M0544-7020B</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-AURIS</b>		Document No.: <b>WI-ENG-PDE-1195</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		2	Page No.:	1 of 4

<b>PARTS:</b>	1. Pre-assy parts (IRRAX A 0.3 B L=145±2mm [2pcs.]); Black SV tube (vinyl) ø5 L=78±3mm; Blue tape					JIG:	n/a
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Table Lay-out	<div style="border: 1px solid red; padding: 5px; display: inline-block; margin-bottom: 10px;"> <b>2</b> </div> <div style="border: 1px solid red; padding: 5px; display: inline-block; margin-bottom: 10px;"> <b>TABLE LAY-OUT</b> </div>	<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> <b>Safety Instruction</b>            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;"> <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 style="border: 1px solid red; padding: 5px;"> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>	1.No missing parts/tools 2.No excess parts/tools

Revision History								Prepared by		Checked by		Reviewed by		Approved by	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Checked	Approved	Est. Date:	February 5,2025							
04/25/2025	2	Update table lay out	A. Buban	J. Loterte	C. Villanueva	A. Arañes									
02/19/2025	1	Change pre-launch to mass-pro	A. Buban	n/a	C. Villanueva	A. Arañes									
02/05/2025	0	-Initial issue -Change tape color from black to blue	A. Buban	n/a	C. Villanueva	A. Arañes									

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## TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

164 / 7M0544-7020B

Customer: TRJ

Car Model: TOYOTA-AURIS

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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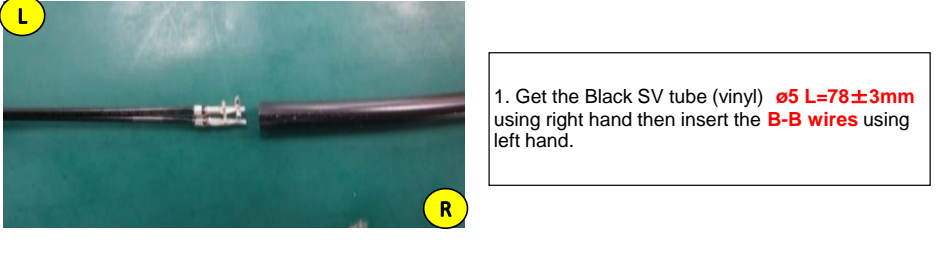
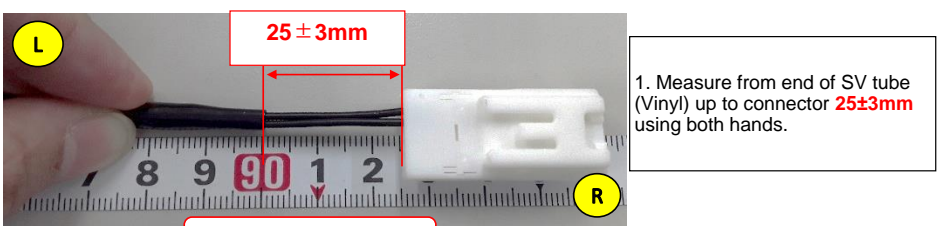

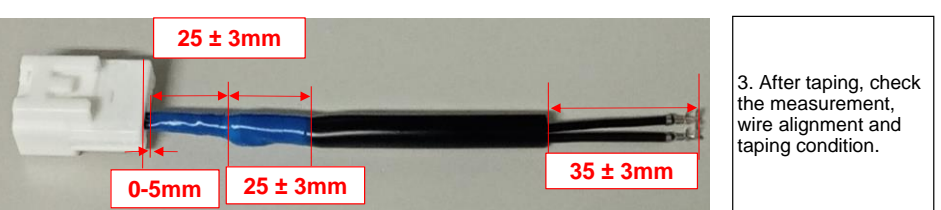

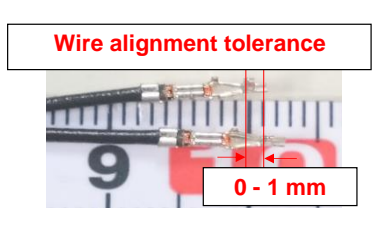
WI-ENG-PDE-1195

Revision No.:

2

Page No.:

2 of 4

PARTS:	1. Pre-assy parts 2.Black SV tube (vinyl) ø5 L=78±3mm 3. Blue tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Black SV tube (Vinyl) ø5 L=78±3mm		n/a	1. No wrong usage of parts
3	P1 Taping 1 Black SV tube (Vinyl) to wire near connector	  	 <p>Measuring tape</p>	 <p>Wire alignment tolerance</p> <p>0 - 1 mm</p> <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> <p><b>Important reminders/note/s:</b> 1.Please use calibrated/verified measuring tape when getting the measurement.</p> <p><b>Document reference/s:</b> 1.Refer to WI-PRO-ASY-001 for taping procedure.</p>

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PRE-LAUNCH



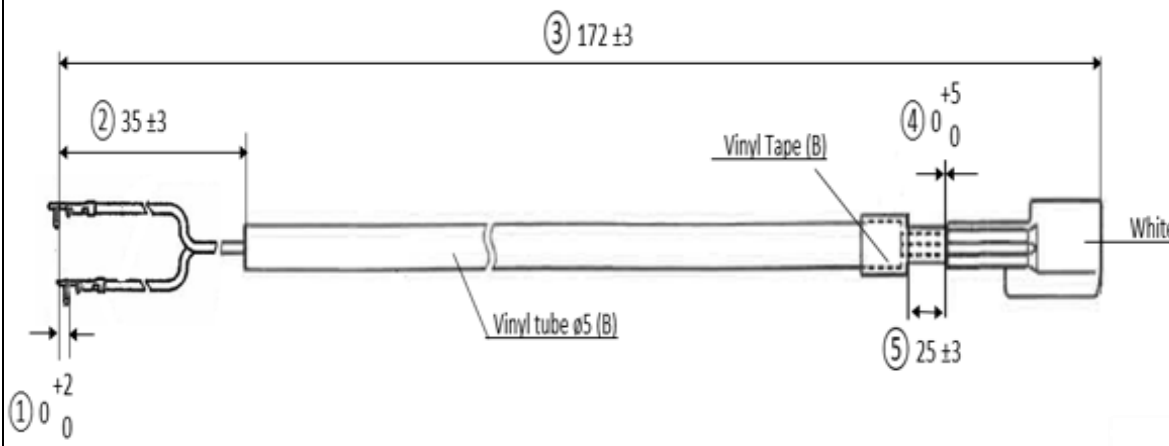

MASSPRO

Revision No.:

2

Page No.:

3 of 4

PARTS:		Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	Measurement	<div><div>Measuring tape</div></div>		<p><b>Important reminders and note/s:</b></p> <ol style="list-style-type: none"><li>1. Please use calibrated/verified measuring tape when getting the measurement.</li><li>2. For Hatsumono, Nakamono and Owarimono.</li></ol> <p><b>Document reference/s:</b></p> <ol style="list-style-type: none"><li>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</li></ol> <p>1. No wrong dimension</p>

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MASSPRO

Revision No.:

2

Page No.:

4 of 4

**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P1****7M0544-7020B****1****No Unlocked/Half-Locked Connector****3****No Missing Tape and No  
Wrong use of Tape****2****No Deformed Terminal**

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