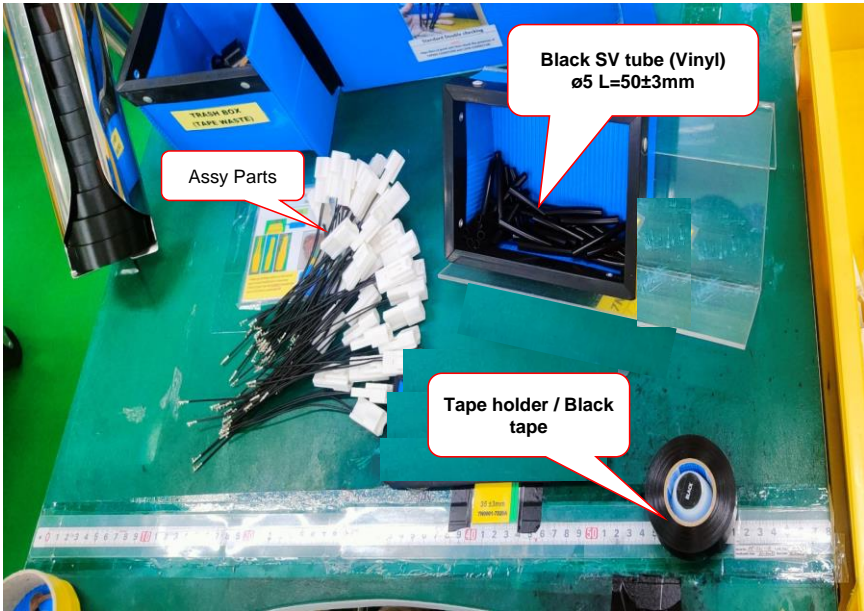


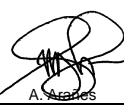


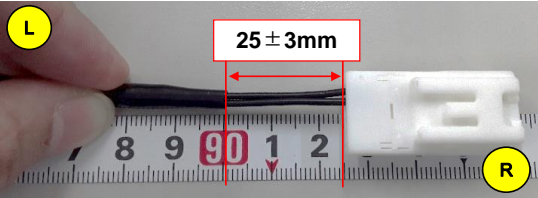
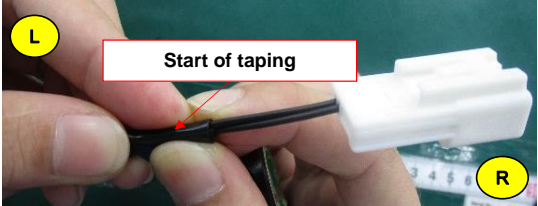
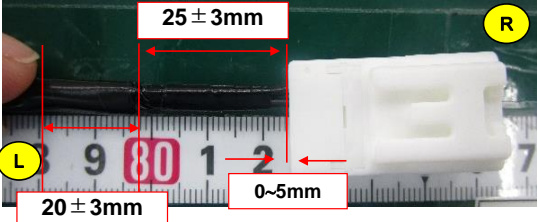

	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date: May 22, 2024	
	Process Name/Title:				Validity Date: n/a	
	Model code/Part number: 150B / 7N0001-7020A		Customer: TRMX	Car Model: TOYOTA COROLLA	Document No.: WI-ENG-PDE-161	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: 5		Page No.:	1 of 5

PARTS: 1. Assy Part; Black SV tube (Vinyl) ø5 L=50±3mm; Black tape		JIG: n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
1	P1 Table Lay-out	<div style="text-align: center;"> <p>TABLE LAY OUT</p>  </div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> <p>Safety Instruction</p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> <p>Housekeeping</p> <ol style="list-style-type: none"> Maintain and always practice 5's. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>
		<p>Document References:</p> <p>1. Refer to WI-ENG-PDE-160 Offline Assembly Process</p> <p>1. No wrong parts/tools 2. No excess/lacking of parts/tools</p>	

Revision History						Prepared by	Reviewed by	Approved by	Noted by
05/22/24	5	Change process sequence due to process improvement. Inclusion of Car model "TOYOTA-COROLLA". Improved Measurement and Visual inspection.	D.Castillo	C.Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes
05/17/23	4	Inclusion of Table lay-out and quality check points; improve important reminders and note/s & document references; Improve by two's inspection.	J. Loterte	C. Villanueva	A. Arañes	n/a			
07/08/21	3	Revised due to removal of marking.	M. Catapang	C. Villanueva	himamura	A. Arañes			
03/15/21	2	Revise due to standardize the color of connector in accordance with color standardization of plastic parts (Please refer to GL-COM-003 for Color Standardization for Plastic Parts). Apply some improvements. Removal of cycle time.	M. Catapang	C. Villanueva	himamura	A. Arañes			
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 17, 2018	n/a

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	WORK INSTRUCTION				Effectivity Date:		May 22, 2024	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 150B / 7N0001-7020A		Customer: TRMX		Car Model: TOYOTA COROLLA	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.:		Revision No.:		5	Page No.:
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PARTS:		1. Assy parts 2. Black SV tube (Vinyl) ø5 L=50±3mm 3. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2		<div><div><div>L</div><div>R</div></div><div>1. Get the Black SV tube (Vinyl) ø5 L= 50±3mm using right hand then insert the B-B wires.</div></div>		N/A	1. No wrong usage of parts 2. No deformed terminal
3	<div>5 P1</div> <div>Taping 1 Vinyl tube to wire near connector</div>	<div><div><div>L</div><div>R</div></div><div>25 ± 3mm</div><div>1. Measure from end of SV tube (Vinyl) to connector 25mm using both hands.</div></div> <div><div><div>L</div><div>R</div></div><div>Start of taping</div><div>2. Hold the SV tube (Vinyl) using left hand then start taping using right hand.</div></div> <div><div><div>L</div><div>R</div></div><div>25 ± 3mm 20 ± 3mm 0~5mm</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 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</div>

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model code/Part number:

150B / 7N0001-7020A

Customer:

TRMX

Car Model:

TOYOTA COROLLA

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

May 22, 2024

Validity Date:

n/a

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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	P1 <div>5</div> Taping 2 SV Tube (Vinyl) to wire near terminal	<div><div><div><div><div>L</div><div>55 ± 3mm</div><div>R</div></div></div><div><div>1. Measure from end of the SV Tube (vinyl) up to the terminal tip 55mm using both hands.</div></div></div><div><div><div><div>L</div><div>Start of taping</div><div>R</div></div></div><div><div>2. Hold the SV Tube (vinyl) using left hand, get the Black tape then start taping using right hand.</div></div></div><div><div><div><div>L</div><div>20 ± 3mm</div><div>35 ± 3mm</div><div>R</div></div></div><div><div>3. After taping, check the condition of tape, measurement and wire alignment.</div></div></div></div> <div><div><div>MEASURING TAPE</div><div></div></div></div>		<div><div><div>Important reminders and Note/s:</div><div>1. Please use calibrated/verified measuring tape when getting the measurement.</div><div>Document reference/s:</div><div>1. Refer to WI-PRO-ASY-001 for taping procedure.</div><div>1. No flip-out tape</div><div>2. No peel-off tape</div><div>3. No loose tape</div><div>4. No missing tape</div><div>5. No wrong dimension</div><div>6. No wrong use of tape</div></div><div><div><div>Wire alignment tolerance</div><div></div></div></div></div>	

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**WORK INSTRUCTION**

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TAPING ASSEMBLY PROCESS

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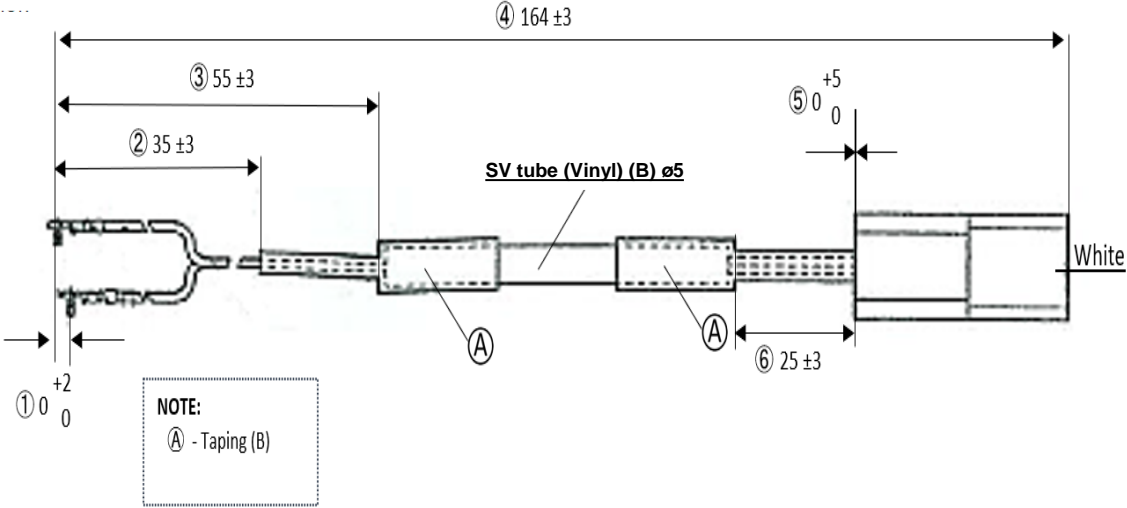
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PARTS:	1. Assy part		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1	Measurement	<div>Measuring tape</div> 	<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>
				

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TAPING ASSEMBLY PROCESS

Effectivity Date:

May 22, 2024

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Model code/Part number:

150B / 7N0001-7020A

Customer: TRMX

Car Model: TOYOTA COROLLA

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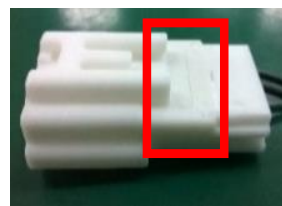
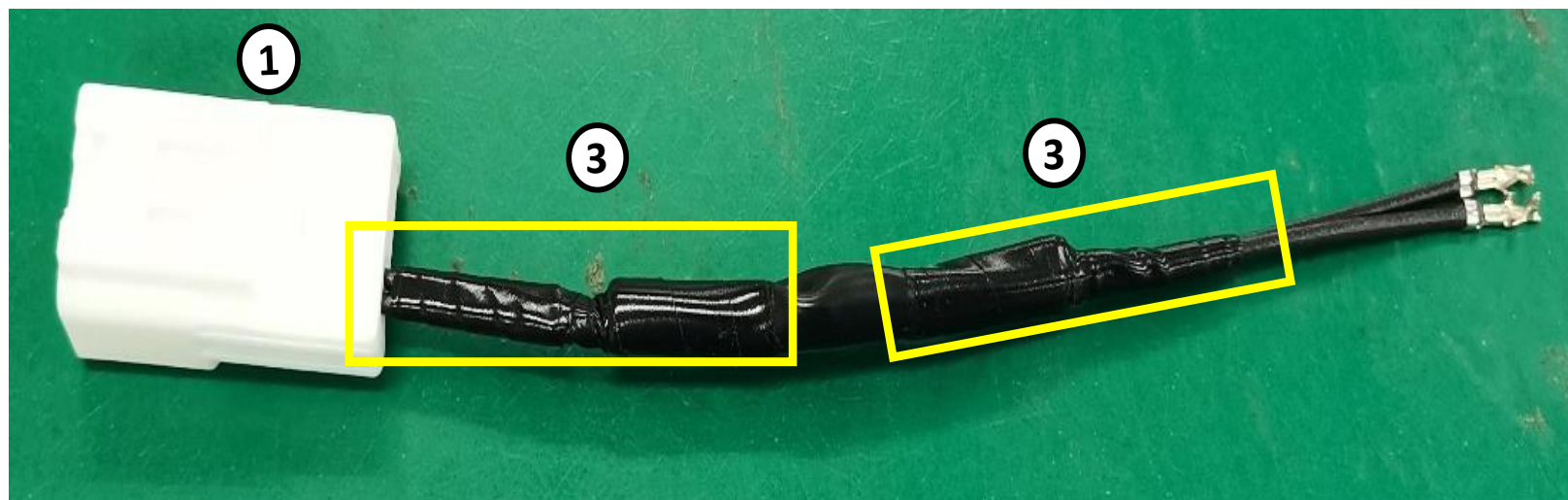
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P1****7N0001-7020A****GOOD****NO GOOD****① No Deformed Terminal****② No Unlocked/Half-locked Connector****③ No Missing Tape and No Wrong use of tape**

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