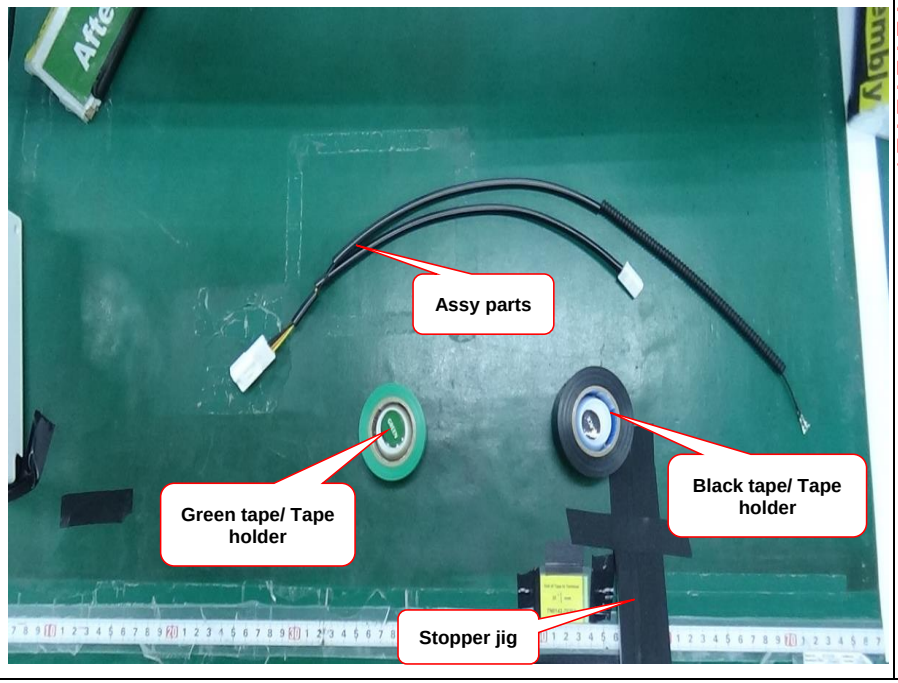
	WORK INSTRUCTION			Effectivity Date:	May 29, 2024		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 990B / 7N0142-7020A	Customer: TRJ	Car Model: TOYOTA-PRIUS	Document No.:	WI-ENG-PDE-453B		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	4	Page No.:	1 of 4

PARTS:	1. Assy parts; Black tape: Green Tape			JIG:	n/a
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
1	P2	4 Table Lay-out	4 **Table Lay-out** 	**Safety Instruction** Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) **Housekeeping** 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. **Alert level** For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	1. No missing parts/ tools. 2. No excess parts/ tools.

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
05/29/24	4	Transfer to new format and inclusion of Car model "TOYOTA-PRIUS". Improve measurement and visual inspection. Split type process transfer Y-Taping process to P3.	A.Hernandez	C. Villanueva	A.Arañes	n/a
6/16/23	3	Change table lay-out; Changed Quality Checkpoints illustration; Transferred process of Taping 1; COT to wire near terminal from P1 to P2 due to new process distribution. Standardized tube description: SV tube (Vinyl) on process no. 3.	M.Ariola	J. Loterte	C. Villanueva	A.Arañes
12/17/22	2	Improve Quality pointers;Reminders/notes and references on pages no.1,2,3,4,6,7 and 8 due to document improvement. Improve work procedure/illustration on process no. 5 due to process improvement. Inclusion of Quality checkpoints.	M.Ariola	J. Loterte	C. Villanueva	A.Arañes

Prepared by	Reviewed by	Approved by	Noted by
A.Hernandez	C. Villanueva	A.Arañes	n/a
Est. Date:	March 15, 2022		

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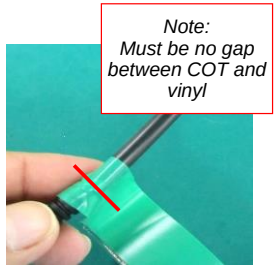
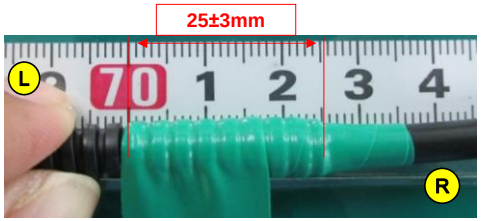
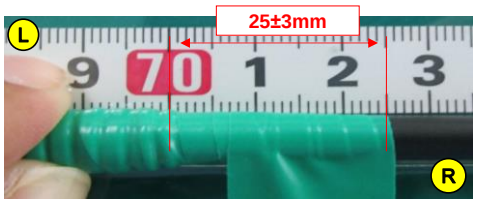
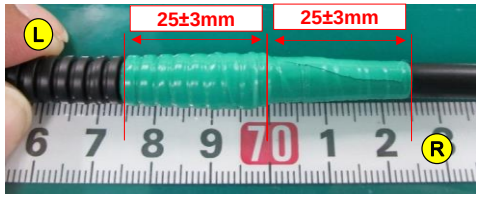
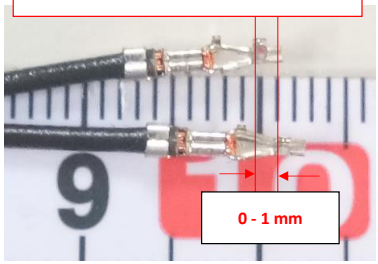
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	4	Page No.:	2 of 4

PARTS:	1. Assy parts 2. Black tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2	Taping 1 Black corrugated tube to Vinyl tube	 1. Get the COT and vinyl tube using both hands.  2. Fix the corrugated tube to vinyl tube using left hand then get **Green tape** and start taping using right hand.  3. Confirm measurement of **25±3mm** from end of tape up to end of COT then continue the taping process using both hands.  4. Confirm measurement of **25±3mm** from end of COT up to end of tape using both hands.  5. After taping, check the measurement and taping condition.	**Measuring tape** 	1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension ***Important reminders/note/s:*** *1.Please use calibrated/verified measuring tape when getting the measurement.* **Wire alignment tolerance** 

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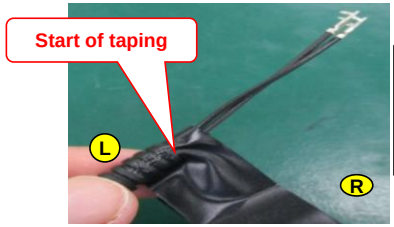
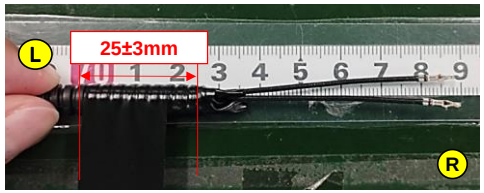
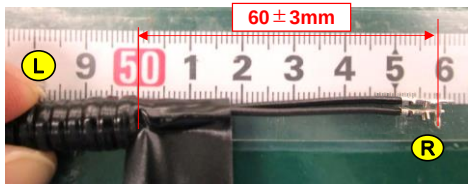
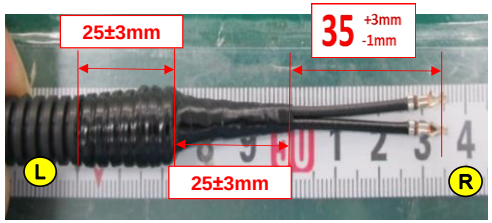
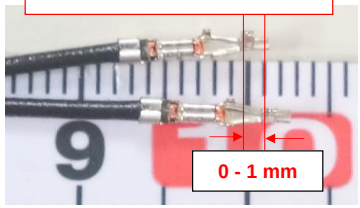
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	4	Page No.:	3 of 4

PARTS:	1. Black tape 2. Assy parts	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2	Taping 1 Black corrugated tube to Wire near terminal	 1. Hold the COT using left hand, get the **Black tape** using right hand then start pre-taping using both hands.  2. Confirm measurement of **25±3mm** from end of tape up to end of COT then continue the taping process using both hands.  3. Measure from end of COT up to terminal pointed tip **60±3mm** then continue the taping process using both hands.  4. After taping, check the measurement and taping condition.	n/a	 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension

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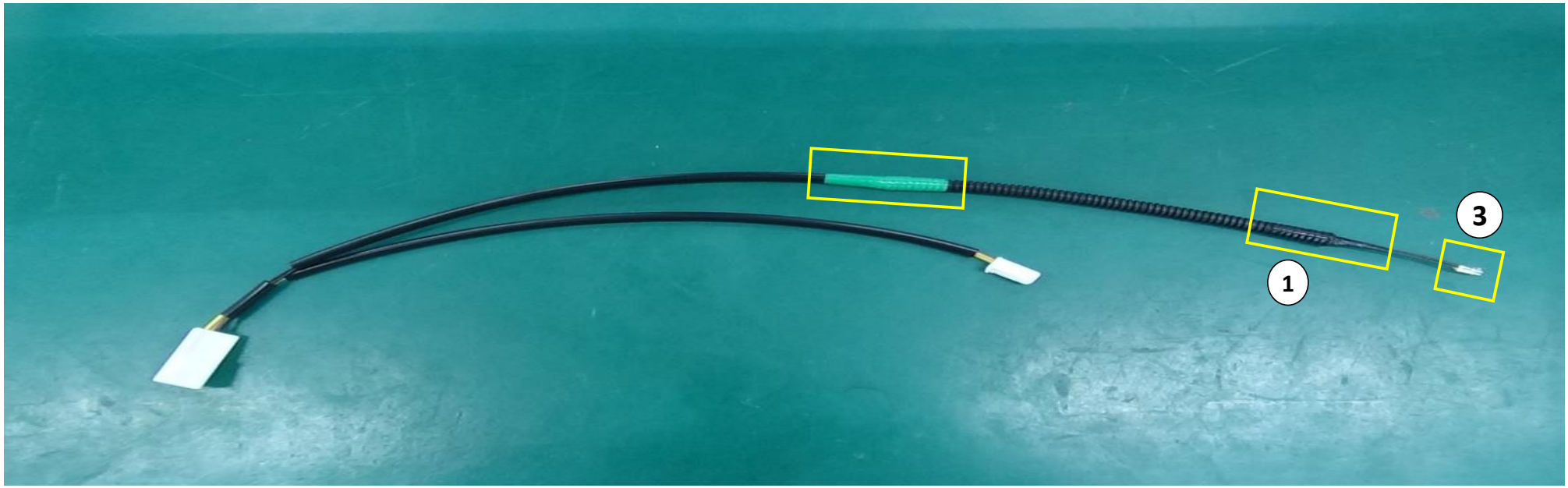
PARTS:	1.Assy parts	JIG:	n/a

4 **VISUAL INSPECTION/QUALITY CHECKPOINTS**

P2	**7N0142-7020A**



1 2 **No Missing/ Wrong Use Of Tape**

3 **No Deformed Terminal**

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