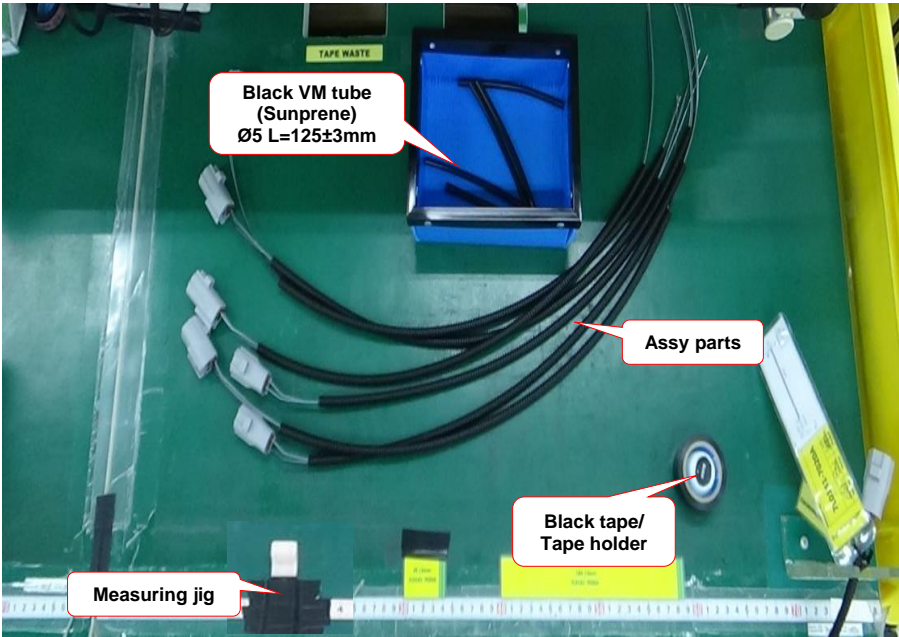
	WORK INSTRUCTION TAPING ASSEMBLY PROCESS			Effectivity Date:	September 13, 2024		
	Process Name/Title:			Validity Date:	n/a		
	Model code/Part number:	380D / 7L0141-7020B	Customer:	TRQSS	Car Model:	TOYOTA CAMRY	
	Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.:	WI-ENG-PDE-1052		
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PARTS:		1. Assy parts; Black VM tube (Sunprene) Ø5 L=125±3mm; Black tape		JIG:	1. Measuring jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1	<div> <div>TABLE LAY-OUT</div>  </div>		<div> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance. 2. Refer to WI-ENG-PDE-970 for Offline assembly process 1. No missing parts/tools 2. No excess parts/tools

Revision History						Prepared by	Reviewed by	Approved by	Noted by
09/13/24	1	Change from Pre-launch to Masspro.				A. Hernandez	C. Villanueva	A. Arañes	n/a
09/11/24	0	Initial issue.				A. Hernandez	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted
						Est. Date:	September 11, 2024		

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WORK INSTRUCTION

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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) Ø5 L=125±3mm		JIG:	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<div>Wire insertion to Black VM tube (Sunprene) Ø5 L=125±3mm</div> <div></div> <div>1. Get the VM tube (Sunprene) Ø5 L=125±3mm using right hand then insert the GR-B/W wires using left hand.</div>		N/A	1. No wrong use of parts 2. No deformed terminal

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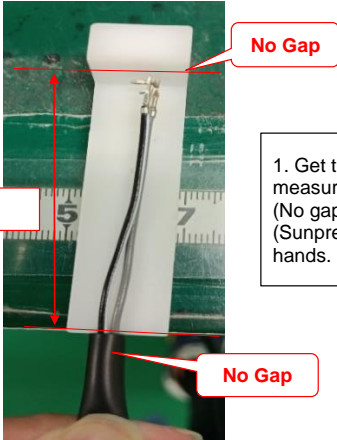
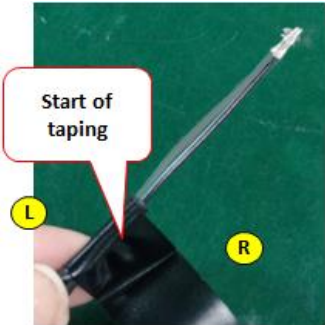
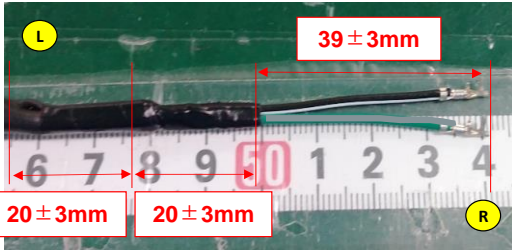


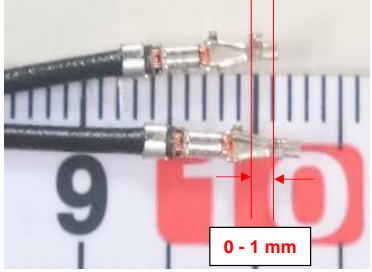
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PARTS:		1. Assy parts 2. Black tape		JIG:	1. Measuring jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Taping 1 Black sunprene tube to wire near terminal	 <p>1. Get the assy parts and set to measuring jig. First, set the terminal tip (No gap). Last, set the VM tube (Sunprene) (No gap) using both hands.</p>  <p>2. Hold the tube using left hand, get the Black tape using right hand then start taping process using both hands.</p>  <p>3. After taping, check the taping condition, measurement and wire alignment.</p>		 	<p>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</p> <p>Wire alignment tolerance</p>  <p>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p>

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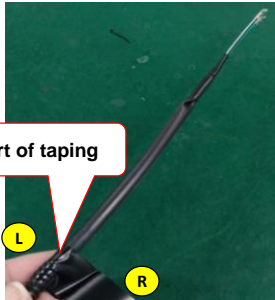


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PARTS:		1. Assy parts 2. Black tape		JIG:	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 Taping 2 Black COT to Black VM tube (Sunprene)	 <p>1. Measure from end of corrugated tube up to terminal pointed tip 184±3mm using both hands.</p>  <p>2. Hold the corrugated tube and sunprene tube using left hand, get the Black tape then start taping process using both hands.</p>  <p>3. After taping, check the taping condition, measurement and wire alignment.</p>			<p>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <ul style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1	Measurement	<div>MEASURING TAPE</div> <div></div> <div><p>① 0 +2/-0</p><p>② 60 ±3</p><p>③ 39 ±3</p><p>④ 184 ±3</p><p>⑤ 0 +5/-0</p><p>Gray</p><p>NOTE: A - Taping (B)</p><p>VM tube (Sunprene) (B) Ø5</p><p>COT Ø5 (B), no slit</p></div>	<div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension</div>

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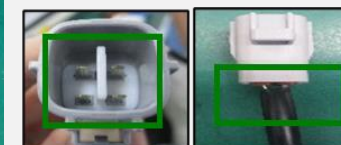
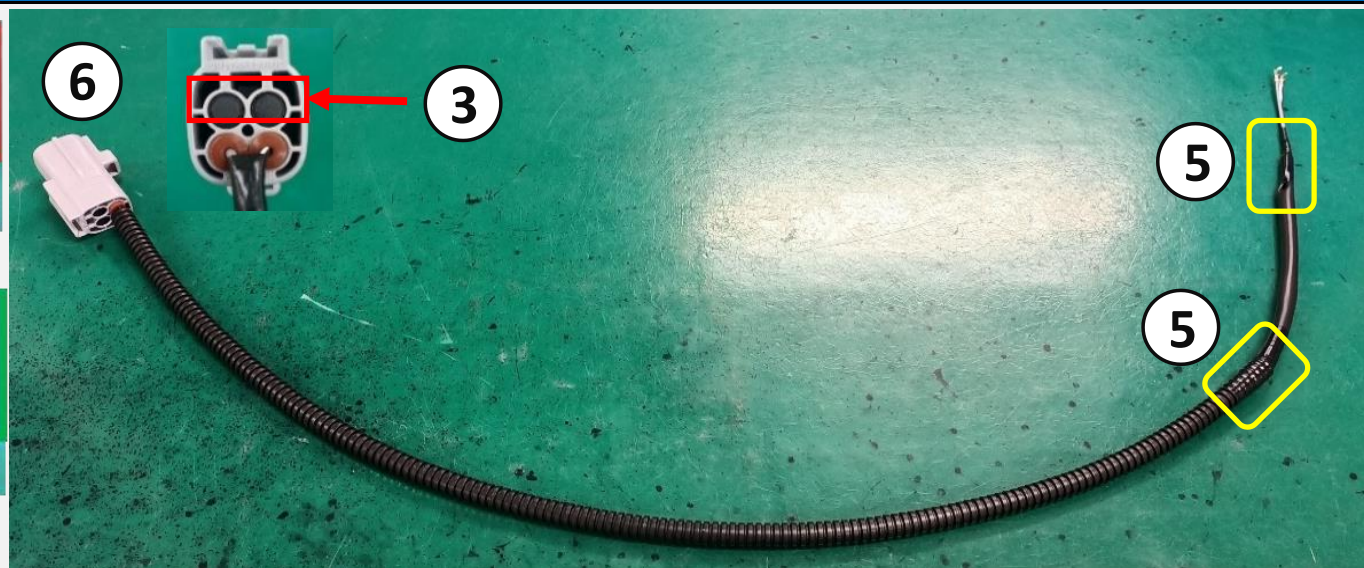
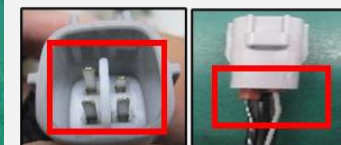
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**P1****7L0141-7020B****NO GOOD****GOOD****GOOD****GOOD****NO GOOD****NO GOOD****1****No Unlock/ Half Lock Connector****2****No Wrong Insert****3****No Missing Dummy Seal****4****No Terminal Backing out****5****No Missing Tape****6****No Deformed Terminal**

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