
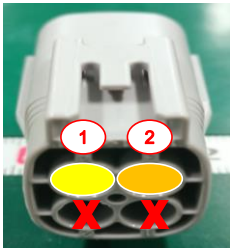


	<b>WORK INSTRUCTION</b>				Effectivity Date:	December 18, 2023		
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Process Name/Title:		Model code/Part number: <b>930B / 7N0204-7020</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-4 RUNNER</b>	Document No.: <b>WI-ENG-PDE-774</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	1 of 16


<b>PARTS:</b> 1. Connector 6188-0066 (GR) 2. AVSSf Y-OR L=364±2mm		JIG: n/a	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>
1	P1  Wire insertion to connector 6188-0066 (GR)	<div style="display: flex; justify-content: space-around;"> <div>  <p>CONNECTOR ORIENTATION</p> </div> <div>  <p>WIRE FACING</p> </div> </div> <div style="display: flex; justify-content: space-around; margin-top: 20px;"> <div>  <p>1. Get the connector using left hand and get the <b>Yellow wire</b> and insert to connector using right hand.</p> </div> <div>  <p>2. Hold the connector using left hand. Get the <b>Orange wire</b> and insert to connector using right hand.</p> </div> </div>	<div style="border: 1px dashed 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 dashed 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 dashed red; padding: 5px;"> <b>Alert level</b>          For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.       </div>
		<b>QUALITY POINTERS</b>	<b>Important reminders/Note/s:</b> 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
			<b>Document references:</b> 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
			1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing

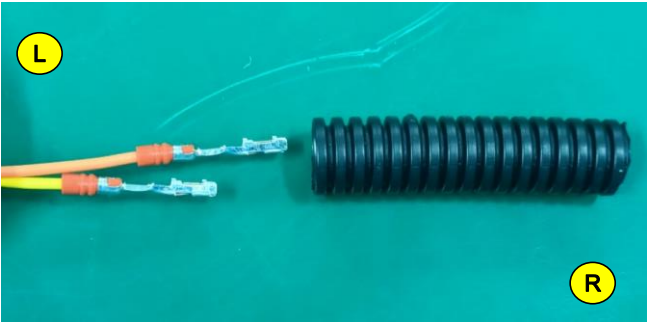

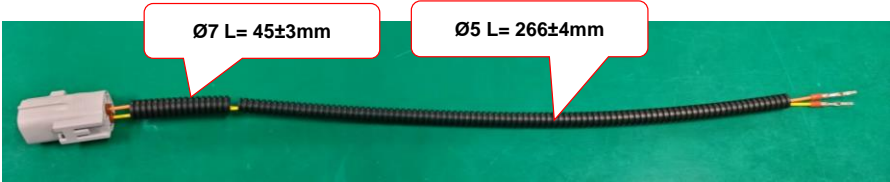
Revision History								Prepared by	Reviewed by	Approved by	Noted by
12/18/23	0	Initial issue					D.Castillo	C. Villanueva	A. Arañes	n/a	
Eff. Date	Rev. No	Details of Change					Revised	Reviewed	Approved	Noted	Est. Date:
											December 18, 2023

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	Model code/Part number: <b>930B / 7N0204-7020</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-4 RUNNER</b>	Document No.:	WI-ENG-PDE-774		
	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	2 of 16

<b>PARTS:</b>		1. Assy parts 2. Black corrugated tube $\varnothing 7$ L=45 $\pm$ 3mm (No slit) 3. Black corrugated tube $\varnothing 5$ L=266 $\pm$ 4mm (No slit)		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	Wire insertion to Black corrugated tube $\varnothing 7$ L=45 $\pm$ 3mm (No slit)	 <div style="border: 1px solid black; padding: 5px; margin-top: 10px;">         1. Get the Black corrugated tube <math>\varnothing 7</math> L=45<math>\pm</math>3mm (No slit) using right hand and insert Yellow wire and Orange wire by using left hand.       </div>		n/a	1. No wrong use of parts 2. No deformed terminal
3	P1 Wire insertion to Black corrugated tube $\varnothing 5$ L=266 $\pm$ 4mm (No slit)	 <div style="border: 1px solid black; padding: 5px; margin-top: 10px;">         1. Get the Black Corrugated Tube <math>\varnothing 5</math> L=266<math>\pm</math>4mm (No Slit) using left hand and insert Yellow wire and Orange wire by using left hand.       </div> 		n/a	1. No wrong use of parts 2. No wires left between COT with slit

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**December 18, 2023**

Model code/Part number:

**930B****/****7N0204-7020**

Customer:

**TRJ**

Car Model:

**TOYOTA-4 RUNNER**

Document No.:

**WI-ENG-PDE-774**

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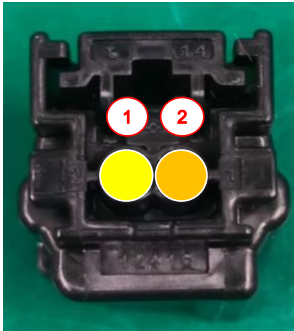

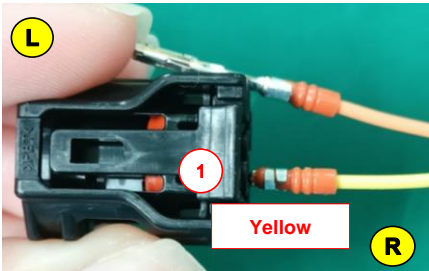
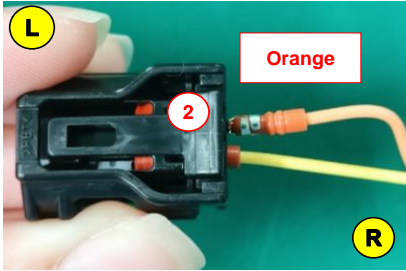
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<b>PARTS:</b>		1. Assy parts 2. Connector 6189-1161 (B)		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
4	P1  Wire insertion to connector 6189-1161 (B)	<div> CONNECTOR ORIENTATION</div> <div> VISUAL REFERENCE</div> <div> WIRE FACING</div> <div> 1. Get the connector using left hand and get the Yellow wire and insert to connector using right hand.</div> <div> 2. Hold the connector using left hand. Get the Orange wire and insert to connector using right hand.</div>		n/a	<p><b>Important reminders/Note/s:</b></p> <p>1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p><b>Document references:</b></p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p>

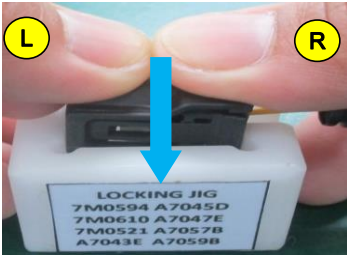

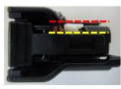




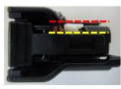



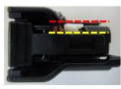




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	Model code/Part number: <b>930B / 7N0204-7020</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-4 RUNNER</b>	Document No.:	WI-ENG-PDE-774		
	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	4 of 16




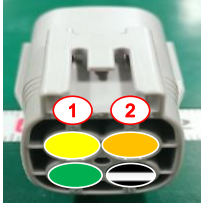

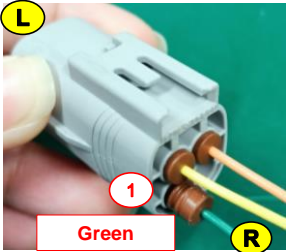
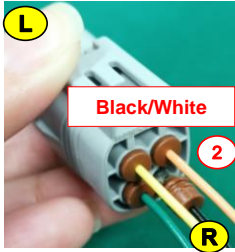
<b>PARTS:</b>		1. Assy parts 2. MRSW CP (TVSSf 0.3 G-B/W wires L=628±3mm)		3. Black corrugated tube ø7 L=510±5mm (No slit)		JIG:	1. Locking jig									
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS									
5	Connector lock	<div>  <p>LOCKING JIG 7M0594 A7045D 7M0610 A7047E 7M0521 A7057B A7043E A7059B</p> <p>1. Put the connector into locking jig using both hands and then press  <b>2x</b>. Check the connector if properly locked.</p> </div> <div> <p><b>Connector lock appearance</b></p> <table border="1"> <tr> <td><b>NG</b></td> <td><b>NG</b></td> <td><b>GOOD</b></td> </tr> <tr> <td></td> <td></td> <td></td> </tr> <tr> <td>Unlock Condition</td> <td>Half Lock Condition</td> <td>Full Lock Condition</td> </tr> </table> <div>   </div> <p><b>BEFORE PRESSING</b>      <b>AFTER PRESSING</b></p> </div>				<b>NG</b>	<b>NG</b>	<b>GOOD</b>				Unlock Condition	Half Lock Condition	Full Lock Condition	<div> <p><b>LOCKING JIG</b></p>  </div>	<p><b>Important reminders/Note/s:</b></p> <p><b>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b></p> <p>1. Use the provided jig tool to lock the connector.          2. No unlock/half-locked connector</p>
<b>NG</b>	<b>NG</b>	<b>GOOD</b>														
																
Unlock Condition	Half Lock Condition	Full Lock Condition														
6	P1 Wire insertion to Black corrugated tube ø7 L=510±5mm (No slit)	<div>  <p>1. Get the <b>MRSW CP (TVSSf 0.3 G-B/W wires L=628±3mm)</b> using both hands then insert the terminal cover jig using right hand.</p> </div> <div>  <p>2. Get the <b>Black corrugated tube ø7 L=510±5mm (No slit)</b> using left hand then insert the wires using right hand.</p> </div>				<div> <p><b>TERMINAL COVER JIG</b></p>  </div>	<p><b>Document references:</b></p> <p><b>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b></p> <p>1. No wrong usage of parts          2. No damaged rubber seal</p>									

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	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	<b>n/a</b>		
	Model code/Part number: <b>930B / 7N0204-7020</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-4 RUNNER</b>	Document No.:	<b>WI-ENG-PDE-774</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	5 of 16

PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	Wire insertion to assy parts (Black corrugated tube ø7 L=45±3mm (No slit))	 <p>1. Hold the COT (no slit) <b>ø7 L=45±3mm</b> using left hand then insert the <b>MRSW CP TVSSf 0.3 G-B/W wires L=628±3mm</b> using right hand.</p>  <p>2. After insertion, remove the cover jig using right hand.</p>		n/a	1. No wrong usage of parts 2. No damaged rubber seal
8	Wire insertion to connector 6188-0066 (GR)	    <p>1. Hold the connector part using left hand and hold the <b>Green wire</b> then insert to connector using right hand.</p>  <p>2. Hold the connector using left hand and hold the <b>Orange wire</b> then insert to connector using right hand.</p>		n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing  <b>Important reminders/Note/s:</b> 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.  <b>Document references:</b> 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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Effectivity Date:

**December 18, 2023**Model code/Part number: **930B / 7N0204-7020** Customer: **TRJ** Car Model: **TOYOTA-4 RUNNER**

Validity Date:

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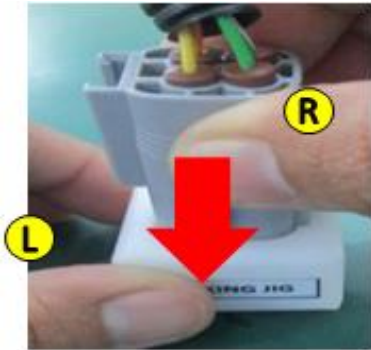




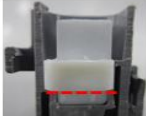

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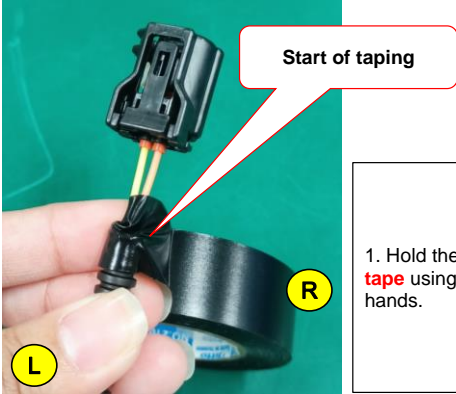
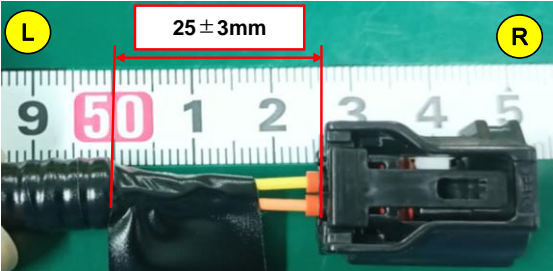
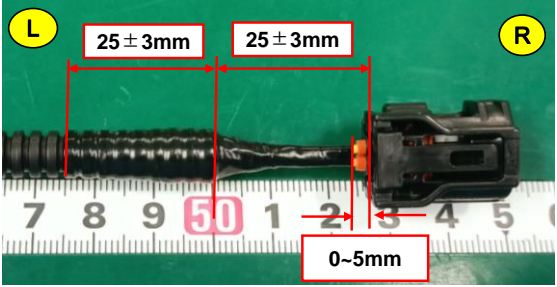

PARTS:		1. Assy parts 2. Black tape [1pc]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1	Connector lock			
		<div><div></div><div><p>1. Put the connector into locking jig using both hands and then conduct <b>2x</b> pressing. Check the connector if properly locked.</p></div></div> <div><div></div><div><p>Before pressing</p></div><div></div><div><p>After pressing</p></div></div> <div><div><p>Connector Cross Sectional View</p><div><div></div><div><p>Unlock</p></div></div><div><div></div><div><p>Half Lock Condition</p></div></div><div><div></div><div><p>Full Lock Condition</p></div></div></div></div> <div><div><p>LOCKING JIG</p></div></div>		<p><b>Important reminders/Note/s:</b></p> <p><b>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b></p> <p>1. No unlock/half-locked connector 2. No damage connector</p>	

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	Model code/Part number: <b>930B / 7N0204-7020</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-4 RUNNER</b>	Document No.:	<b>WI-ENG-PDE-774</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	7 of 16

<b>PARTS:</b>		1. Assy parts 2. Black tape [1pc]		JIG:	n/a	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
10	P1  Taping 1 COT to wire near connector	<div><p>1. Hold the corrugated tube using left hand, get the <b>Black tape</b> using right hand then start pre-taping using both hands.</p></div> <div><p>2. Measure from end of the corrugated tube up to connector <b>25±3mm</b> then continue the taping process using both hands.</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>		<div><b>MEASURING TAPE</b></div> 	<p><b>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></p> <p><b>Document references:</b> <b>1. Refer to WI-PRO-ASY-001 for Taping process</b></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>	

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Car Model:

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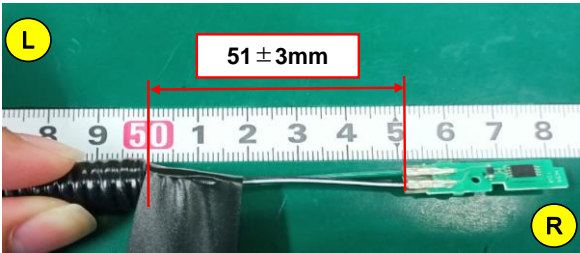
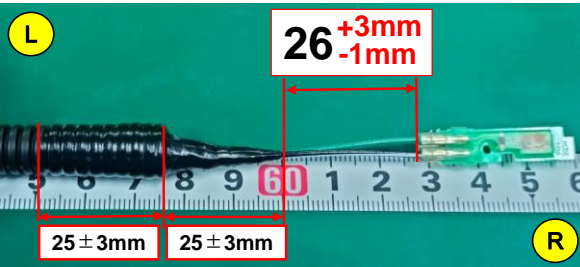
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PARTS:		1. Assy parts 2. Black tape [1pc]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1	Taping 2 COT to wire near hotmelted		<div>MEASURING TAPE</div> <div></div>	<p><b>Important reminders/Note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p><b>Document references:</b></p> <p>1. Refer to WI-PRO-ASY-001 for Taping process</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>

<div>L</div>	<div>R</div>	<div></div> <div>Start of taping</div> <div>1. Hold the corrugated tube using left hand, get the <b>Black tape</b> using right hand then start pre-taping using both hands.</div>
		<div></div> <div>51 ± 3mm</div> <div>2. Measure from end of the corrugated tube up to hotmelted wires <b>51±3mm</b> then continue the taping process using both hands.</div>
		<div></div> <div>26 +3mm -1mm</div> <div>25 ± 3mm 25 ± 3mm</div> <div>3. After taping, check the measurement, terminal appearance and taping condition.</div>

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## TAPING ASSEMBLY PROCESS

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☒ PRE-LAUNCH

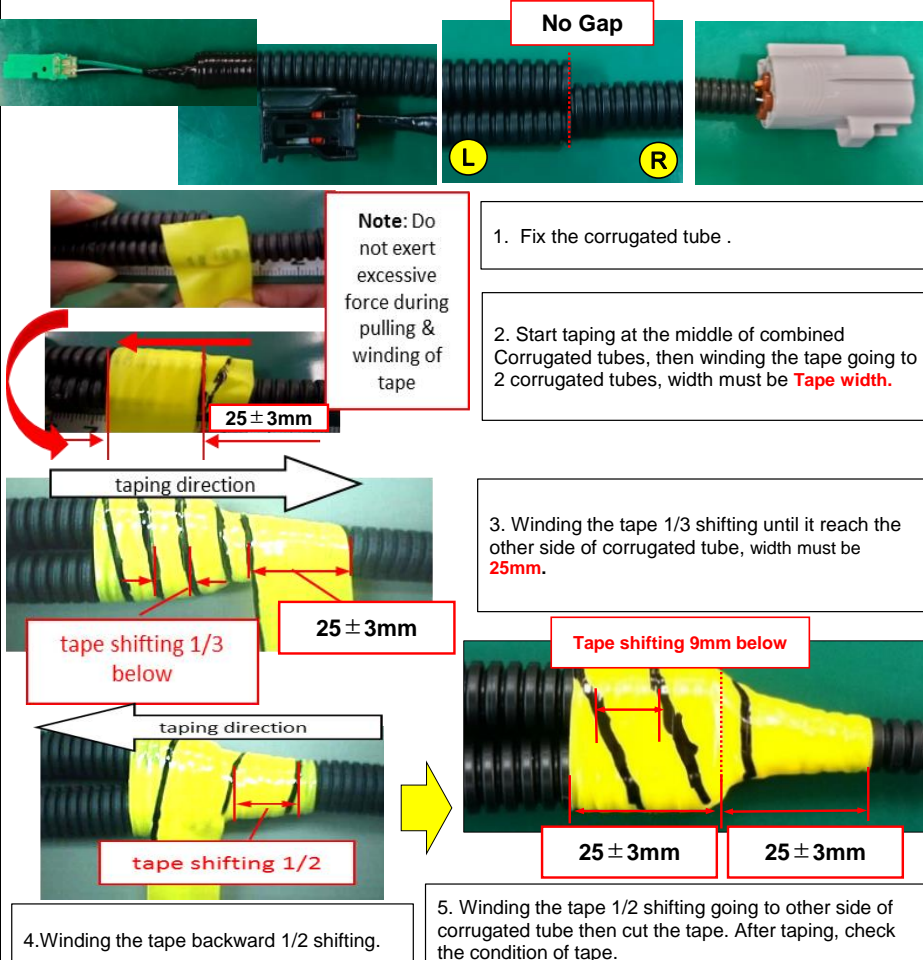

☐ MASSPRO

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PARTS:		1. Assy parts 2. Black tape [1pc]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
12	P1	Y-taping			
		<div><div></div><div><p>1. Fix the corrugated tube .</p><p>2. Start taping at the middle of combined Corrugated tubes, then winding the tape going to 2 corrugated tubes, width must be <b>Tape width</b>.</p><p>3. Winding the tape 1/3 shifting until it reach the other side of corrugated tube, width must be <b>25mm</b>.</p><p>4. Winding the tape backward 1/2 shifting.</p><p>5. Winding the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.</p></div></div>		<div><div>MEASURING TAPE</div></div>	<p><b>Important reminders/Note/s:</b></p> <p>1. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines, but actual should be <b>BLACK TAPE</b>.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p><b>Document references:</b></p> <p>1. Refer to WI-PRO-ASY-001 for Taping process</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>

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Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**December 18, 2023**

Model code/Part number:

**930B****/****7N0204-7020**

Customer:

**TRJ**

Car Model:

**TOYOTA-4 RUNNER**

Document No.:

**WI-ENG-PDE-774**

Purpose:




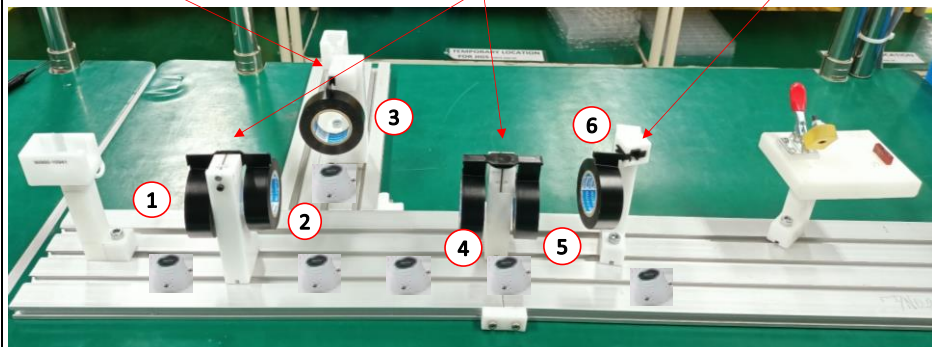
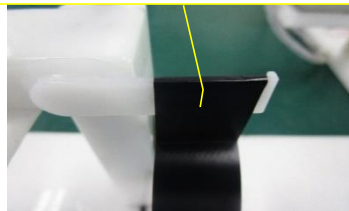
☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

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PARTS:		1. Black tape [6pcs] 2. Clamp 82711-33650 (B)		3. Clamp 82711-3A640 (B) 4. Clamp 82711-48210 (B)		JIG:	1. Temporary jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
13	P1	Clamp Setting	<div><div> 82711-3A640 (B)</div><div> 82711-48210 (B)</div><div> 82711-33650 (B)</div><div>1. Get 2pcs of clamp <b>82711-48210 (B)</b> using right hand and set to clamp location <b>1,2,4 and 5</b> using both hands.</div><div>2. Get 1pc of clamp <b>82711-3A640 (B)</b> using right hand and set to clamp location <b>3</b> using both hands.</div><div>3. Get 1pc of clamp <b>82711-33650 (B)</b> using right hand and set to clamp location <b>6</b> using both hands.</div><div>4. Initially attach <b>Black tape</b> to clamp location <b>1, 2, 3, 4, 5 and 6</b> using both hands.</div></div>			n/a	<div><p><b>Important reminders/Note/s:</b></p><p><b>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</b></p><p>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</p></div> <div><div>One side tape under clamp</div></div>

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# WORK INSTRUCTION

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☐ PROTOTYPE

☒ PRE-LAUNCH

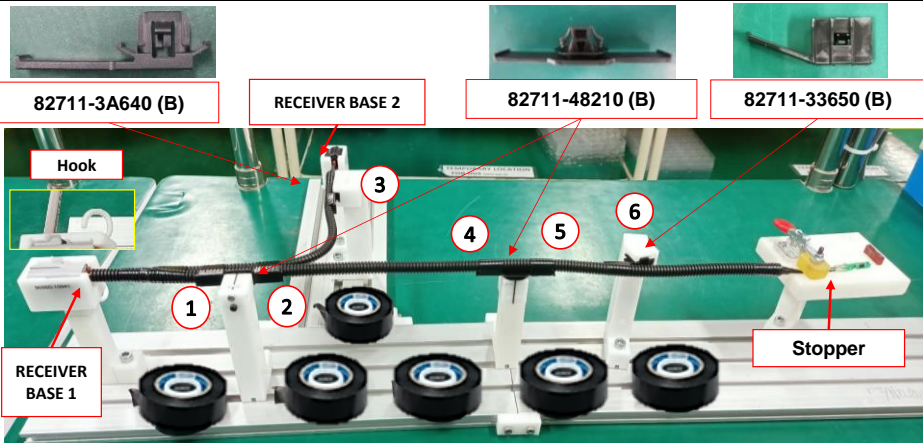
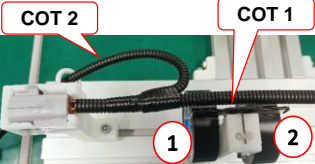
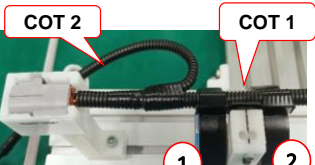
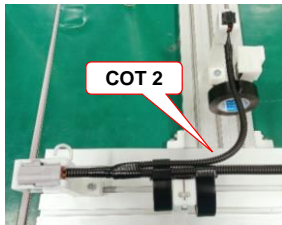
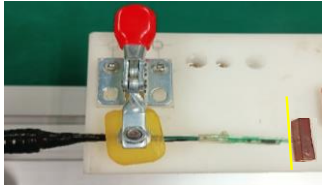
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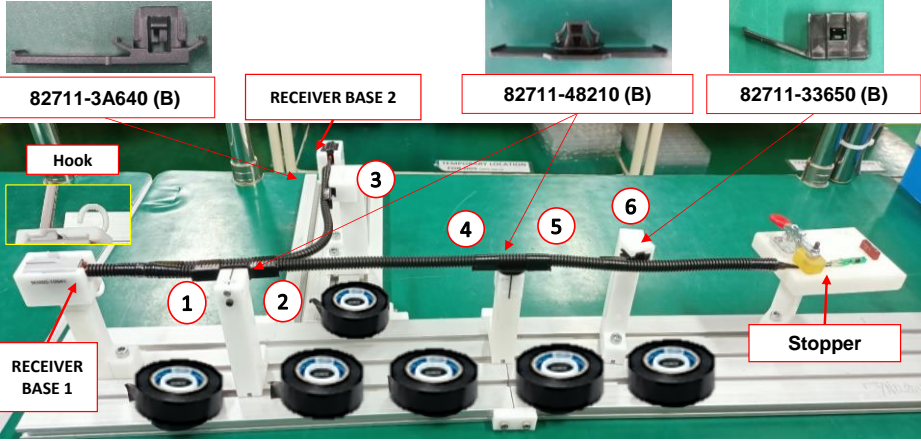
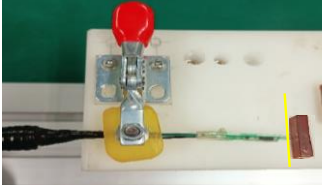
PARTS:		1. Assy parts 2. Black tape [6pcs]		JIG:	1. Temporary jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
14	P1 Clamp Assembly	<div></div> <div><div>ConnectorSetting</div><div><p>1. Put the assy into jig. <i>(See above picture for the correct setting).</i> First, set the connector <b>6188-0066 (GR)</b> to <b>Receiver base 1</b>. Second, set the connector <b>6189-1161 (B)</b> to hook then continue to set the harness in jig. Last, set the <b>hotmelted</b> within stopper then press by toggle clamp.</p></div></div> <div><div><div><div>COT 2</div><div>COT 1</div><div>1</div><div>2</div></div><div><p>2. Hold the tape in clamp location <b>1</b>, make <b>2 windings</b> of tape using both hands. <b>NOTE: DO NOT CUT THE TAPE</b></p></div></div><div><div><div>COT 2</div><div>COT 1</div><div>1</div><div>2</div></div><div><p>3. Hold the tape in clamp location <b>2</b>, make <b>2 windings</b> of tape using both hands. <b>NOTE: DO NOT CUT THE TAPE</b></p></div></div><div><div><div>COT 2</div></div><div><p>4. After taping of clamp location <b>1</b> and <b>2</b>. Get the COT 2 and set the connector in <b>Receiver base 2</b>.</p></div></div></div>		n/a	<div></div> <div><b>Important reminders/Note/s:</b> <b>1. Make sure no gap between terminal and stopper jig</b></div> <div><div>1. No wrong use of parts</div><div>2. No wrong use of tape</div><div>3. No damaged clamp</div><div>4. No wrong clamp position</div></div>

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	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>December 18, 2023</b>		
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>930B / 7N0204-7020</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-4 RUNNER</b>	Document No.:	<b>WI-ENG-PDE-774</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	12 of 16

<b>PARTS:</b>	1. Assy parts 2. Black tape [6pcs]			JIG:	1. Temporary jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
14	P1 Clamp Assembly (Continuation)	<div></div> <div>5. Hold the tape on clamp location <b>1 and 2</b>, make <b>3 windings</b> of tape then cut the tape using both hands.</div> <div>6. Hold the tape on clamp location <b>3</b>, make <b>3 windings</b> of tape then cut the tape using both hands.</div> <div>7. Hold the tape on clamp location <b>4 and 5</b>, make <b>3 windings</b> of tape then cut the tape using both hands.</div> <div>8. Hold the tape on clamp location <b>6</b>, make <b>3 windings</b> of tape then cut the tape using both hands.</div> <div>9. Conduct <b>POINT CHECKING</b> before removing the harness from jig.</div>	n/a	<div></div> <div><b>Important reminders/Note/s:</b> <b>1. Make sure no gap between terminal and stopper jig</b></div> <div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div>	

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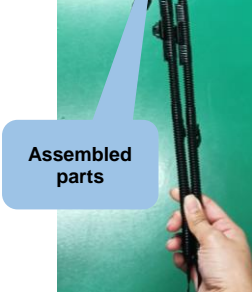
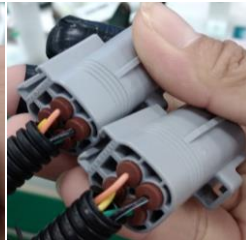





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PARTS:		1. Assy parts 2. Engineering sample		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
15	P1	Visual/By Two's Inspection	<div><p>ACTUAL PRODUCT</p></div> <div><p>Engineering sample</p></div> <div><p>Assembled parts</p></div> <div><p>2. Check the <b>connector lock condition, insertion and terminal.</b></p></div> <div><p>3. Check the <b>presence of clamp attachment, taping condition and Spot taping condition.</b></p></div> <div><p>1. Conduct <b>alignment of harness (Master sample vs. Assembled parts)</b> using both hands.</p></div>	<div>ENGINEERING SAMPLE</div> <div><p>MASTER SAMPLE</p></div> <p>1. No skip checking during inspection.</p>	

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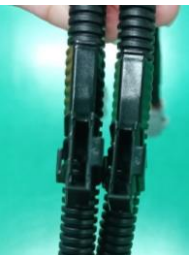


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<b>PARTS:</b>		1. Assy parts 2. Engineering sample	JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
15	P1  Visual/By Two's Inspection (Continuation)	 <b>ACTUAL PRODUCT</b>     4. Check the <b>presence of clamp attachment, taping condition</b> and <b>Taping condition</b> .	 5. Check the <b>taping condition</b> and <b>appearance of PCB</b> .	<div>ENGINEERING SAMPLE</div>  1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position

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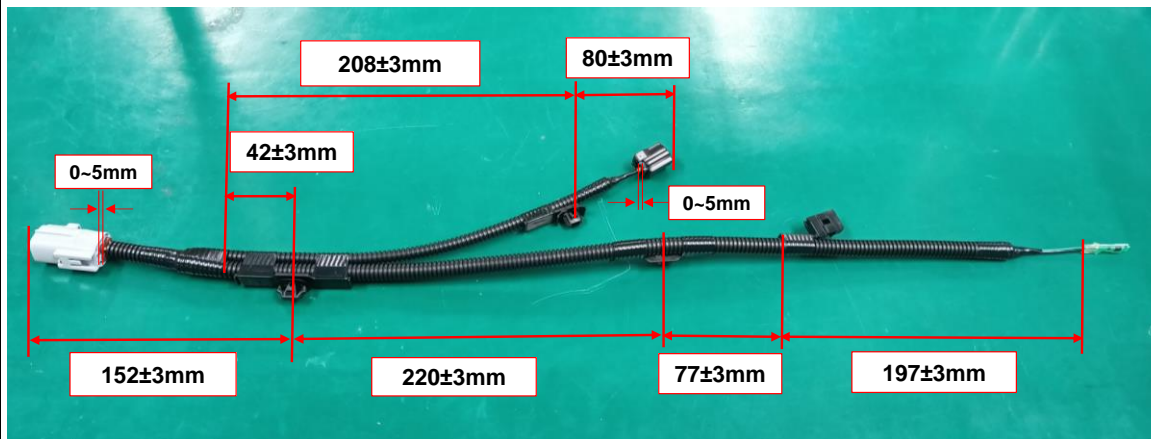
**WI-ENG-PDE-774**Purpose: ☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

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

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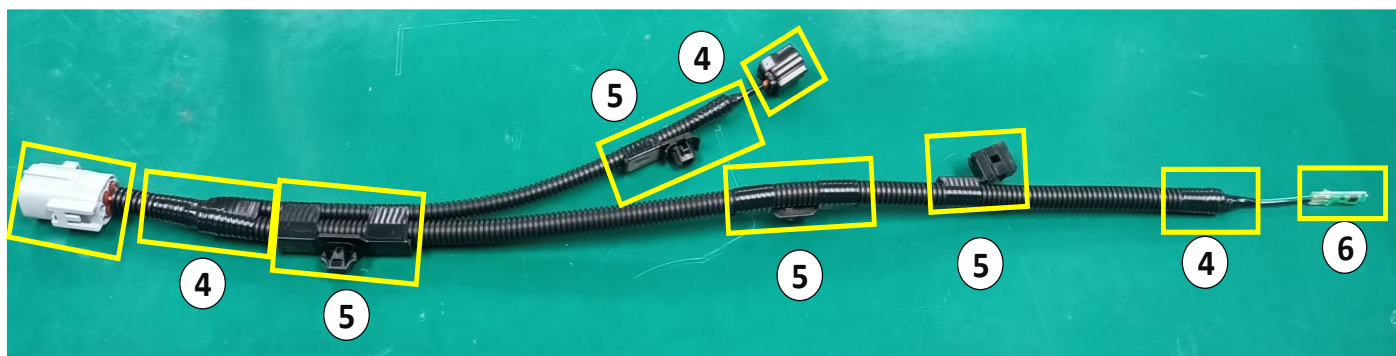
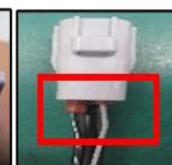
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1. Assy parts

JIG:

n/a

**QUALITY CHECKPOINTS****P1****7N0204-7020****NO GOOD****GOOD****① No Unlock/ Halflocked Connector****② No Wrong Insert****③ No Terminal Backing Out****④ No Missing tape****⑤ No Missing clamp (4pcs)****⑥ No Deformed Hotmelted****GOOD****GOOD****NO GOOD****NO GOOD**

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