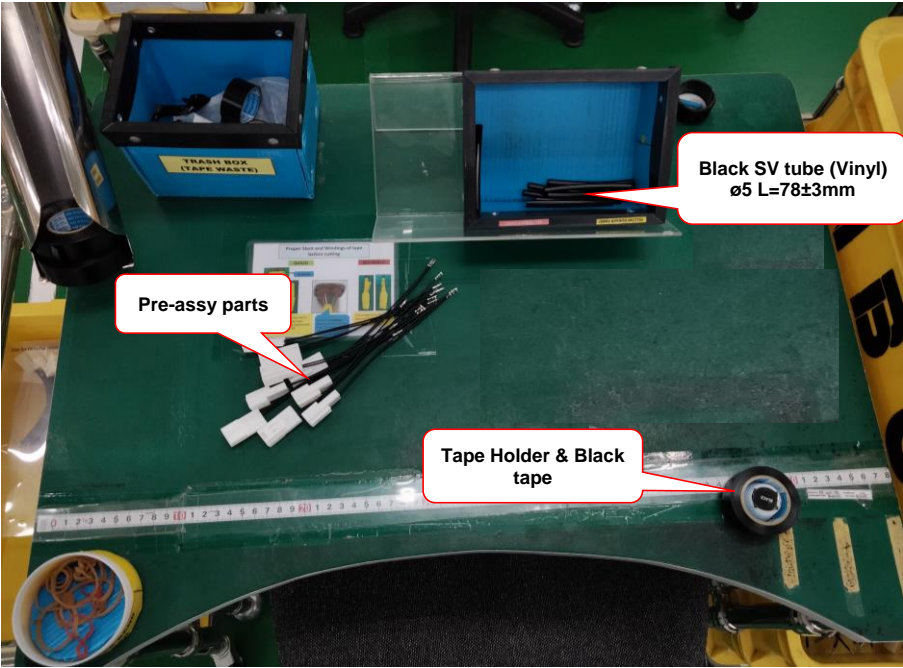
	WORK INSTRUCTION			Effectivity Date:	May 17, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 164B / 7M0544-7020A	Customer: TRJ	Car Model: TOYOTA AURIS	Document No.:	WI-ENG-PDE-045		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	7	Page No.:	1 of 4


PARTS:		1. Pre-assy parts (IRRAX A 0.3 B L=145±2mm [2pcs.]); Black SV tube (vinyl) ø5 L=78±3mm; Black tape			JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
1	P1	<div>TABLE LAY-OUT</div> 			<div>Safety Instruction</div> <div>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping</div> <div>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level</div> <div>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	



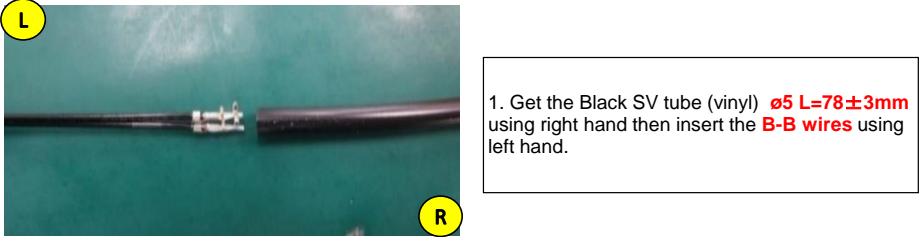

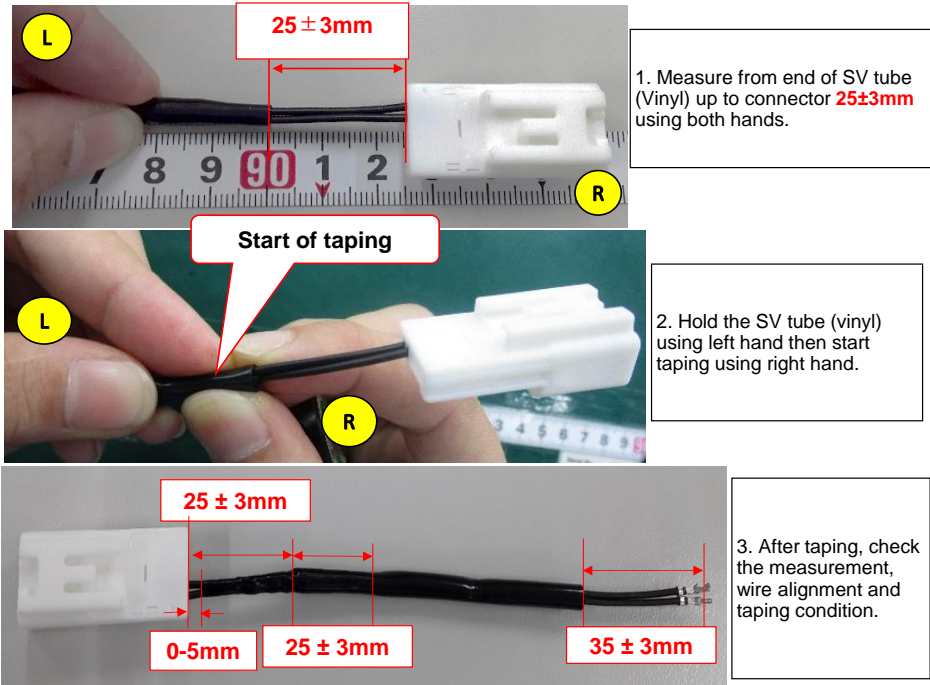

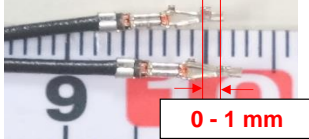

Revision History								Prepared by	Reviewed by	Approved by	Noted by
05/17/24	7	Inclusion of all improvements (Table lay-out; Important reminders and note/s; Document references;). Standardized tube description SV tube (vinyl). Inclusion of car model "TOYOTA-AURIS". Update Measurement and Visual inspection.				D. Castillo	C. Villanueva	A. Arañes	n/a		
07/08/21	6	Revised due to removal of marking.				M. Catapang	C. Villanueva	A. Shimamura	A. Arañes		
05/14/21	5	Removal of validity date. Apply some improvements.				M. Catapang	C. Villanueva	A. Shimamura	A. Arañes		
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	February 01, 2018

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	WORK INSTRUCTION				Effectivity Date:	May 17, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 164B / 7M0544-7020A		Customer: TRJ	Car Model: TOYOTA AURIS	Document No.:	WI-ENG-PDE-045		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	7	Page No.:	2 of 4

PARTS:		1. Pre-assy parts 2.Black SV tube (vinyl) $\phi 5$ L=78 \pm 3mm 3. Black tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	 Wire insertion to Black SV tube (Vinyl) $\phi 5$ L=78 \pm 3mm		n/a	1. No wrong usage of parts
3	P1  Taping 1 Black SV tube (Vinyl) to wire near connector	 <p>1. Measure from end of SV tube (Vinyl) up to connector 25\pm3mm using both hands.</p> <p>2. Hold the SV tube (vinyl) using left hand then start taping using right hand.</p> <p>3. After taping, check the measurement, wire alignment and taping condition.</p>	 <p>Measuring tape</p>	 <p>Wire alignment tolerance</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> Important reminders/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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Effectivity Date:

May 17, 2024

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Model code/Part number:

164B / 7M0544-7020A

Customer: TRJ

Car Model: TOYOTA AURIS

Document No.:

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PARTS:

1. Assy parts

JIG:

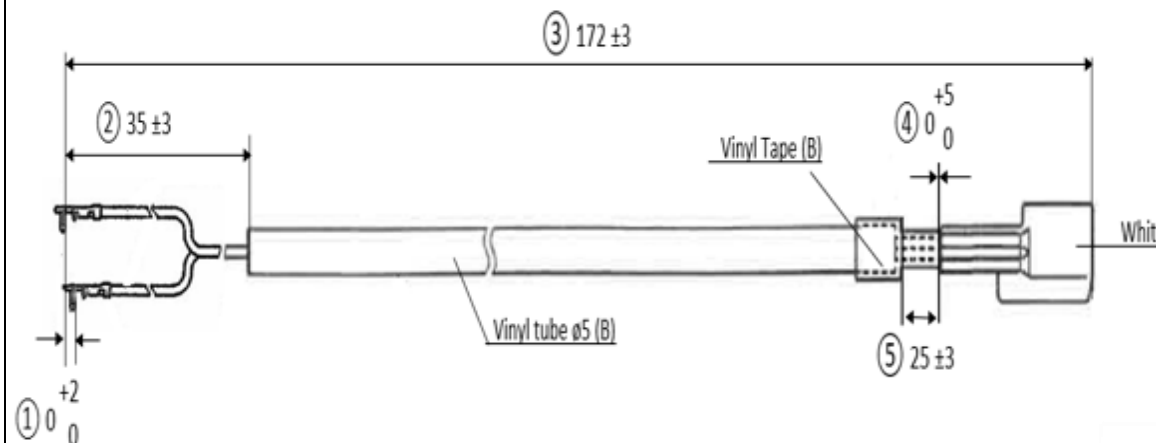
n/a

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

4

P1

Measurement



Measuring tape

**Important reminders and note/s:**

1. Please use calibrated/verified measuring tape when getting the measurement.

2. For Hatsumono, Nakamono and Owarimono.

Document reference/s:

1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection

1. No wrong dimension

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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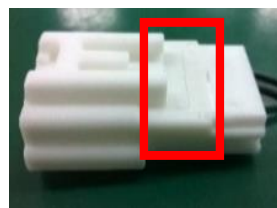
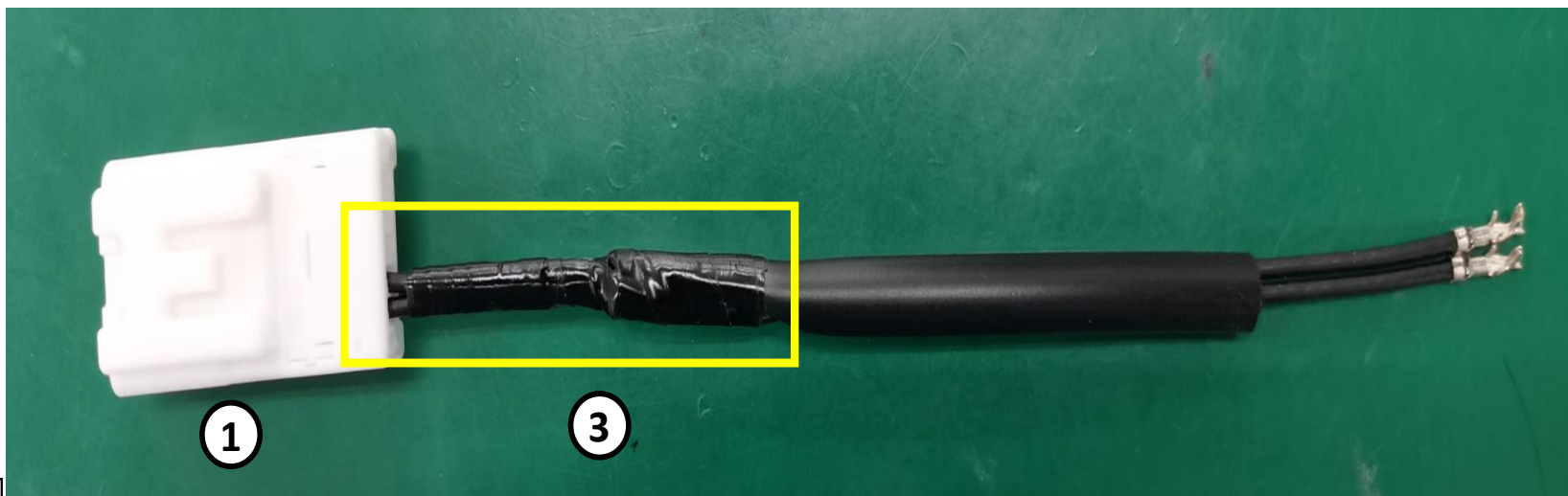
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING-P1****7M0544-7020A****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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