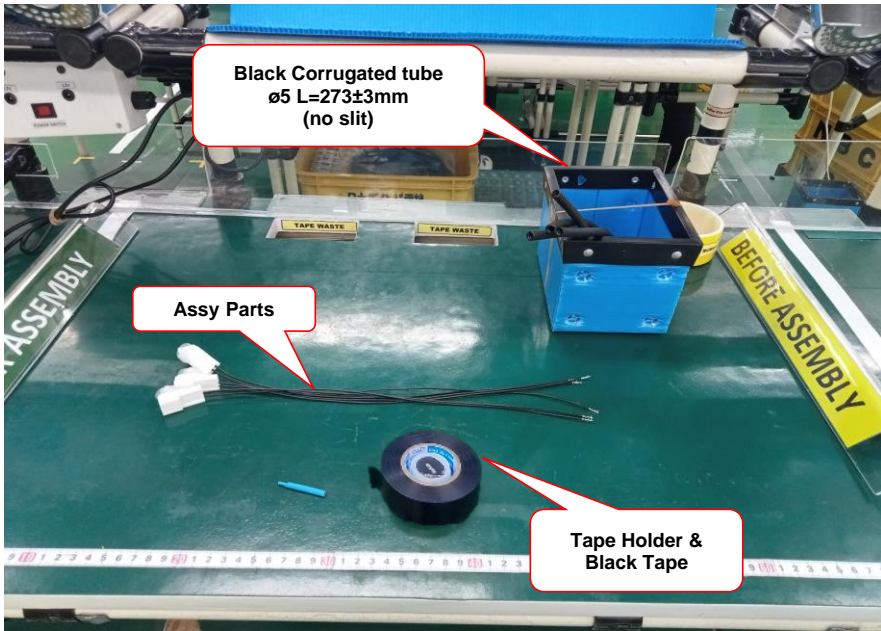



	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date:	May 15, 2025	
	Process Name/Title:				Validity Date:	n/a	
	Model code/Part number: 400D / 7L0159-7020		Customer: TRQSS	Car Model: TOYOTA-bZ4X(BEV)	Document No.:	WI-ENG-PDE-1205	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.: 1 of 5

PARTS:	1.Assy Parts 2.Black Corrugated tube ø5 L=273±3mm (no slit) 3.Black Tape	JIG:	n/a
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Table Lay out	<div>TABLE LAY-OUT</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 1.No missing parts 2.No excess parts tools

Revision History								Prepared by	Checked by	Reviewed by	Approved by
05/15/25	1	Change pre-launch to mass pro	A.Buban	n/a	C.Villanueva	A.Arañes					
03/05/25	0	Initial issue	A.Buban	J.Loterte	C.Villanueva	A.Arañes		A. Buban	n/a	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Checked by	Reviewed by	Approved by	Est. Date:	March 5,2025			

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Purpose:



PROTOTYPE



PRE-LAUNCH




MASSPRO

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PARTS:		1. Assy Parts 2. Black Corrugated tube $\phi 5$ L=273 \pm 3mm (no slit)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<div>Wire Insertion to Black Corrugated tube $\phi 5$ L=273\pm3mm (no slit)</div> <div>1. Get the terminal cover jig using right hand then insert the B-B wires using left hand.</div> <div>2. Get the Black corrugated tube (no slit) $\phi 7$ L=273\pm3mm using right hand then insert the B-B wires using left hand.</div> <div>3. After insertion, remove the terminal cover jig using right hand.</div>		<div>TERMINAL COVER JIG</div> 	1.No wrong of parts 2.No wire left between COT with slit

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WORK INSTRUCTION

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PROTOTYPE



PRE-LAUNCH



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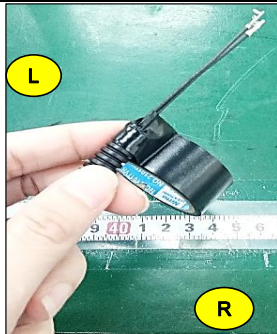
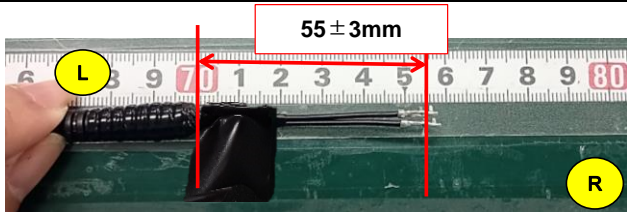
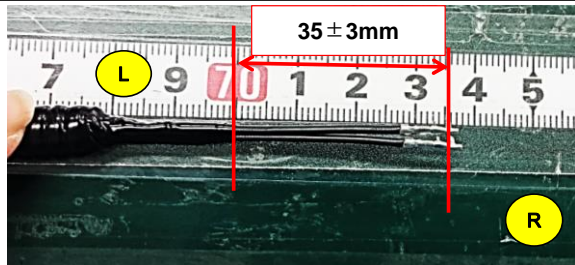
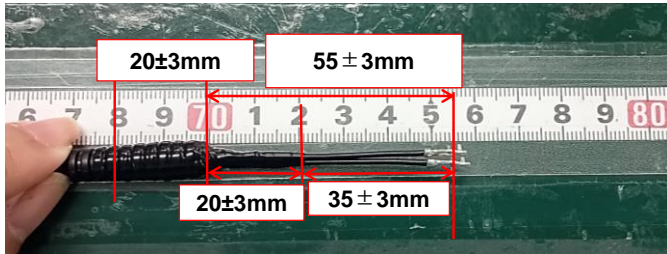

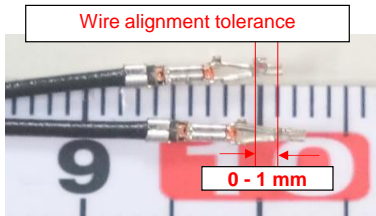
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PARTS:		1. Assy Parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1	<div><div><p>1. Hold the assy parts using left hand. Get the Black tape using right hand then start taping between COT to wire using both hands.</p></div><div><p>2. Measure form end of COT up to terminal pointed tip 55±3/-1 then continue the taping process using both hands</p></div><div><p>3. Measure form end of tape up to terminal pointed tip 35±3/-1 then continue the taping process using both hands</p></div><div><p>4. After taping, check the measurement, terminal alignment and taping condition.</p></div></div> <div><p>Measuring Tape</p></div> <div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div> <div><p>Important reminders/Note/s:</p><p>1. Please use calibrated/verified measuring tape when getting the measurement.</p><p>Document references:</p><p>1. Refer to WI-PRO-ASY-001A for Taping process</p><ul style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No wrong dimension5. No wrong use of tape6. No missing tape7. No insufficient tape</div>			

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TAPING ASSEMBLY PROCESS

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400D / 7L0159-7020

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Purpose:



PROTOTYPE



PRE-LAUNCH



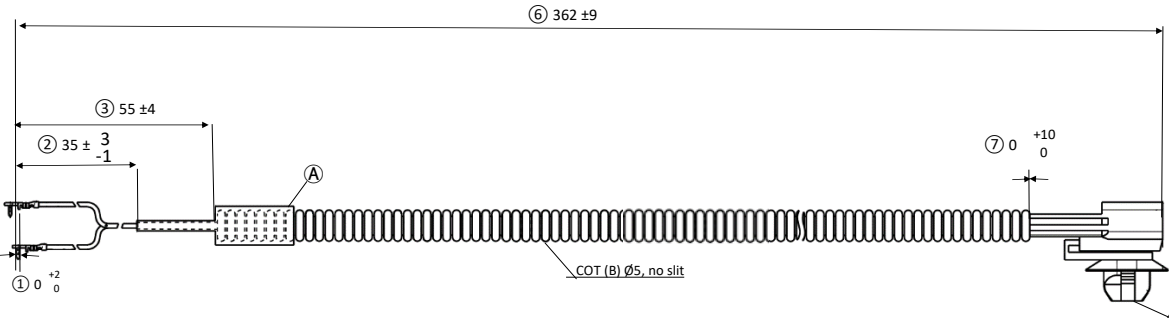
MASSPRO

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PARTS:		1.Assy Parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	Measurement	 <p>NOTE: Ⓐ - Taping (B) Ⓒ - Clamp (W) *Unit of dimension is in millimeter (mm)</p>		<p>Important reminders/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, and Owarimono</p> <p>1. No wrong Dimension</p>

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PROTOTYPE



PRE-LAUNCH



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PARTS:

1.Assy Parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING P-1****7L0159-7020**

① No Missing and No Wrong
used of tape

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