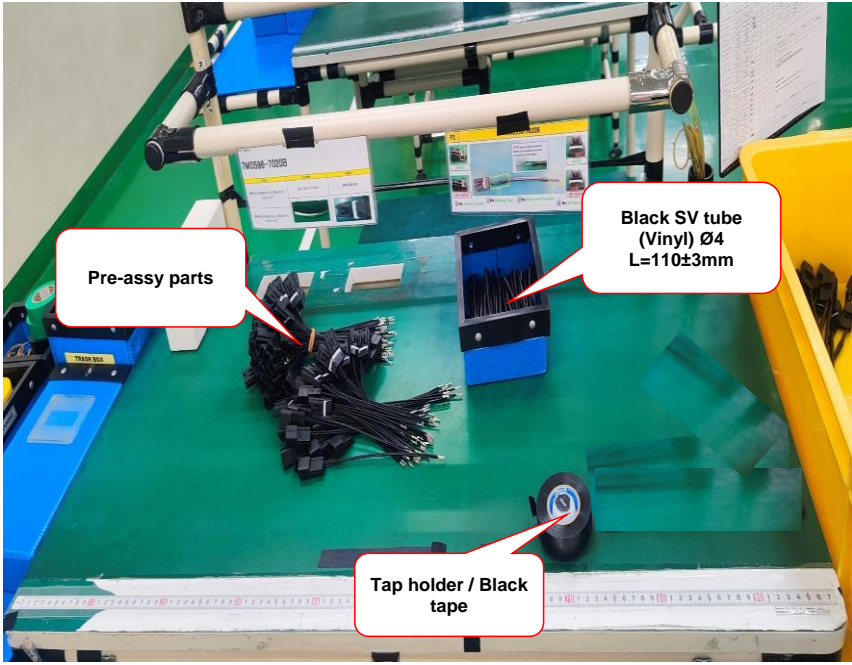

	WORK INSTRUCTION					Effectivity Date:		June 6, 2024	
	TAPING ASSEMBLY PROCESS					Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 400B / 7M0596-7020B		Customer: TRJ	Car Model: TOYOTA-VITZ		Document No.: WI-ENG-PDE-125	
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.: 7		Page No.: 1 of 4


PARTS:		1. Pre-assy parts (Black SV tube (Vinyl) Ø4 L=110±3mm); Black tape			JIG:		n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE		QUALITY POINTERS	
1	P1	<div>TABLE LAY-OUT</div>  <div>Pre-assy parts</div> <div>Black SV tube (Vinyl) Ø4 L=110±3mm</div> <div>Tap holder / Black tape</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>		<div>Document reference/s: 1. Refer to WI-ENG-PDE-124 for Offline Assembly.</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>	




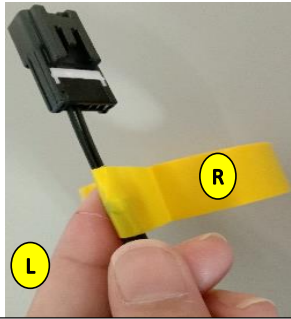
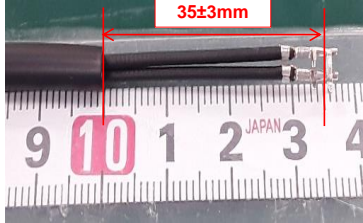


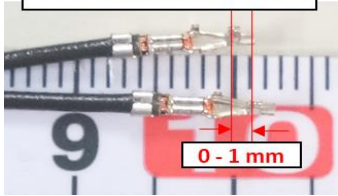
Revision History						Prepared by		Reviewed by		Approved by		Noted by	
06/06/24	7	Improved Measurement and Visual Inspection.				D.Castillo	C. Villanueva	A. Arañes	n/a				n/a
11/24/23	6	Update Quality checkpoints, include additional quality pointers (specify which part has a length of 25 +/- 3 and Tape width) due to DCS countermeasure (DC-0723-134). Update Taping 1 SV tube (Vinyl) to wire near connector taping and included the document reference for taping. Include Nakamono and document reference (WI-PRO-ASY-056) for Sub-assembly Hatsumono Nakamono Owarimono Inspection. Inclusion of Car model "TOYOTA-VITZ".				D. Castillo	C. Villanueva	A. Arañes	n/a				
06/10/23	5	Inclusion of Table lay-out and quality checkpoints; Improvw reminder/note/s and document references; standardize SV tube (Vinyl) term.				J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:		September 14, 2019	

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	WORK INSTRUCTION			Effectivity Date:	June 6, 2024							
	TAPING ASSEMBLY PROCESS			Validity Date:	n/a							
	Process Name/Title:			Model code/Part number:	400B / 7M0596-7020B	Customer:	TRJ	Car Model:	TOYOTA-VITZ	Document No.:	WI-ENG-PDE-125	
	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) Ø4 L=110±3mm 3. Black tape			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire Insertion to SV tube (Vinyl) Ø4 L=110±3mm	 <div>1. Get the SV tube (Vinyl) ø4 L=110±3mm using right hand then insert the 2pcs of Black wires.</div>		n/a	1. No wrong use of parts 2. No deformed terminal Important reminders/Note/s: 1. When inserting terminals in ø4 SV, orientation of terminals must be like on below figure. 
3	P1 Taping 1 Vinyl tube to wire near connector	 <div>1. Hold the SV tube (Vinyl) using left hand and measure the vinyl up to the end of connector 25mm.</div>  <div>2. Get Black tape and start taping using both hands.</div>  <div>3. After taping, check the measurement, wire alignment and tape condition. Check the measurement on vinyl tube to terminal pointed tip 35±3mm.</div> 		 	Important reminders/Note/s: 1. USED YELLOW TAPE TO EASY VISUALIZE THE TAPE SHIFTING BUT ACTUAL SHOULD BE BLACK . 2. Please use calibrated/verified measuring tape when getting the measurement. 3. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process. Do not attempt to repair. Document reference/s: 1. Refer to WI-PRO-ASY-001 for Taping procedure.

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**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 6, 2024

Model code/Part number:

400B / 7M0596-7020BCustomer: **TRJ**

Car Model:

TOYOTA-VITZ

Document No.:

WI-ENG-PDE-125

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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3 of 4**PARTS:**

1. Assy parts

JIG:

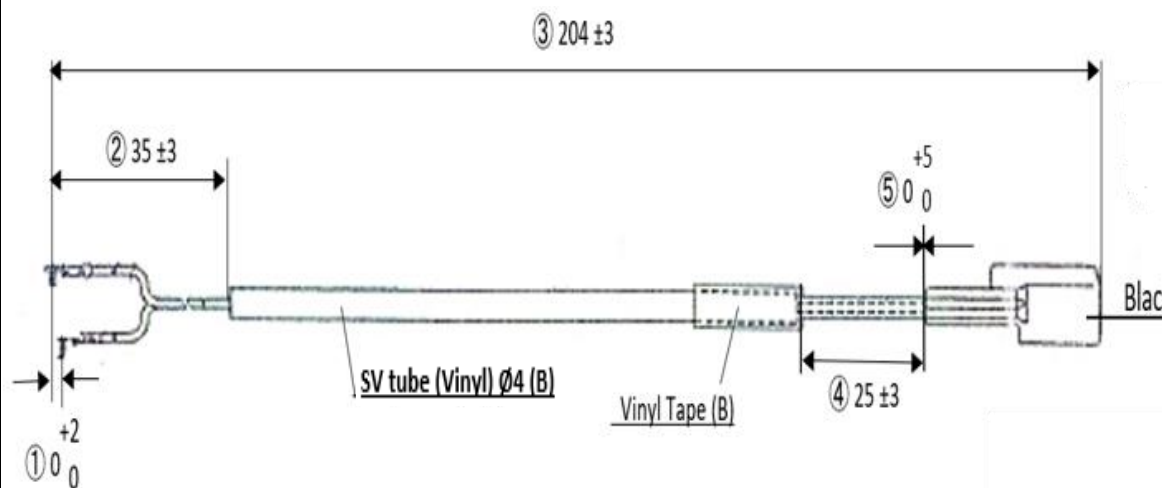
n/a

NO.**PROCESS NAME****7****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

4

P1

Measurement

**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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**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 6, 2024

Validity Date:

n/a

Model code/Part number:

400B / 7M0596-7020BCustomer: **TRJ**

Car Model:

TOYOTA-VITZ

Document No.:

WI-ENG-PDE-125

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

7

Page No.:

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PARTS:

1. Assy parts

JIG:

n/a

7 VISUAL INSPECTION**TAPING - P1****7M0596-7020B****GOOD****NO GOOD****① No Unlocked/Half-locked connector****② No Missing Tape/Wrong use of tape (Black tape)**

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