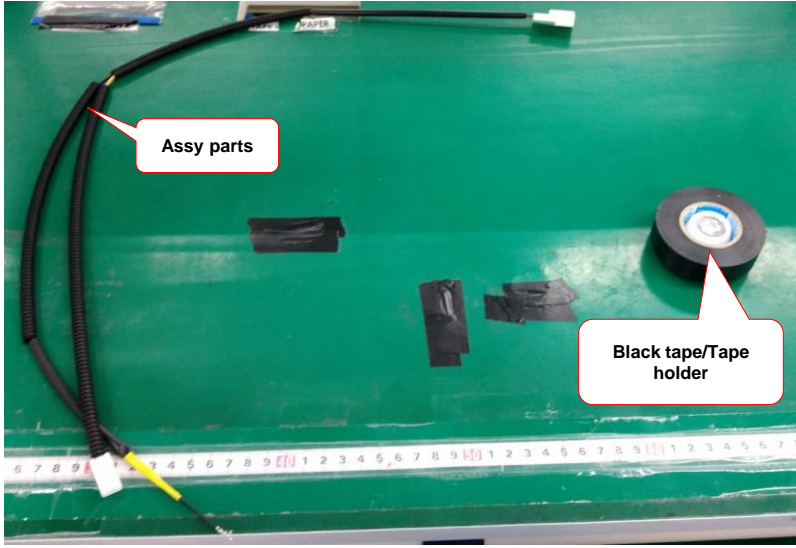

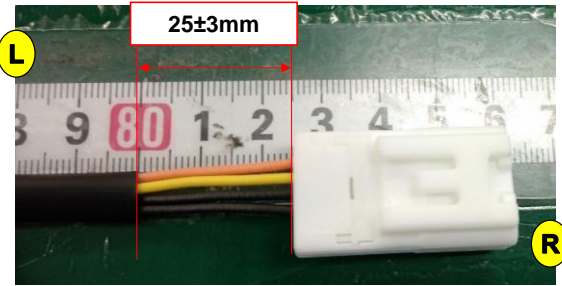
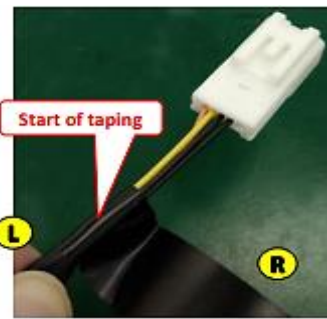
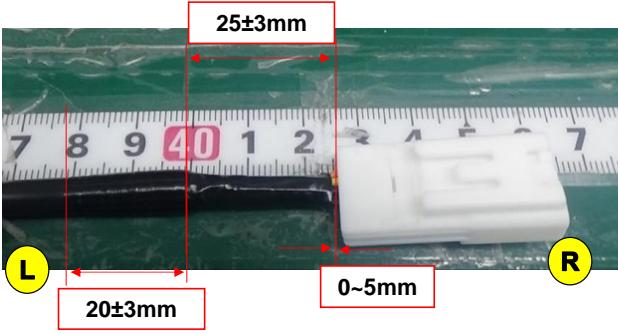
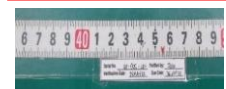


	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>June 18, 2024</b>			
	<b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	<b>n/a</b>			
	Process Name/Title:				Document No.:	<b>WI-ENG-PDE-392B</b>		
	Model code/Part number:	<b>096D / 7L0118-7021A</b>	Customer:	<b>TRQSS</b>	Car Model:	<b>TOYOTA-HIGHLANDER</b>		
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	3	Page No.:	1 of 7	

<b>PARTS:</b>		1. Assy parts; Black tape [1pc.]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P2	<div> <div>3</div> <div>Table Lay-out</div>  </div>		<div> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div> <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> <b>Alert level</b>            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
06/18/24	3	Separate Clamp setting and clamp assembly to Clamp assembly process due to process improvement. Transfer Taping 2 and 4 from WI-ENG-PDE-392A. Update table lay-out. Improved Measurement and Visual inspection.	D. Castillo	C. Villanueva	A. Arañes	n/a	
07/25/23	2	Additional sequence to taping jig, improvement due to QC claim (Missing spot tape). Transfer to new format. Inclusion of car model "TOYOTA-HIGHLANDER".	D.Castillo	J. Loterte	C. Villanueva	A. Arañes	
12/03/23	1	Merge from P3 to P2. Transfer process of 3,5,6 and 7 from P3 due to process improvement. Improve Quality pointers; Reminders/notes and references on pages no.1 to 13 due document improvement. Improve work procedure Illustration on Process no.6- Visual/By two's inspection. Inclusion of Quality checkpoints.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:
							February 4, 2022

	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>June 18, 2024</b>		
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>096D / 7L0118-7021A</b>		Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA-HIGHLANDER</b>	Document No.:	<b>WI-ENG-PDE-392B</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	3	Page No.:	2 of 7

<b>PARTS:</b>	1. Assy parts 2. Black tape			JIG:	n/a			
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
3	P2 Taping Black SV tube (Vinyl) to wire near connector	<div><div></div><div></div><div></div><div>1. Measure from end of SV tube (Vinyl) up to end of connector <b>25±3mm</b> using both hands.</div><div>2. Get the <b>Black tape</b> using right hand then start taping between SV tube (Vinyl) to wire using both hands. <i>(Note: Do not fold the vinyl tube Ø5 with 4 wires)</i></div><div>3. After taping, check the measurement and taping condition.</div></div>			<div><b>MEASURING TAPE</b></div> 	<b>Important reminders/Note/s:</b>  1. Please use calibrated/verified measuring tape when getting the measurement. 2. Please refer to WI-PRO-ASY-001 for taping procedure.  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		

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## WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

June 18, 2024

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Model code/Part number:

096D

/ 7L0118-7021A

Customer:

TRQSS

Car Model:

TOYOTA-HIGHLANDER

Document No.:

WI-ENG-PDE-392B

Purpose:

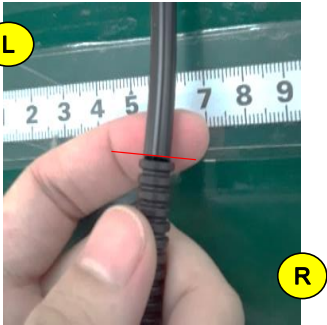
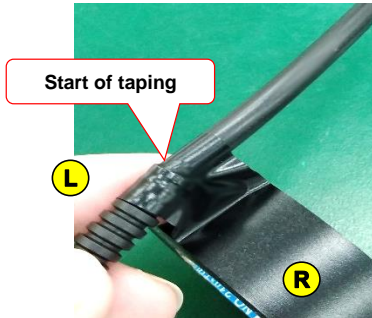
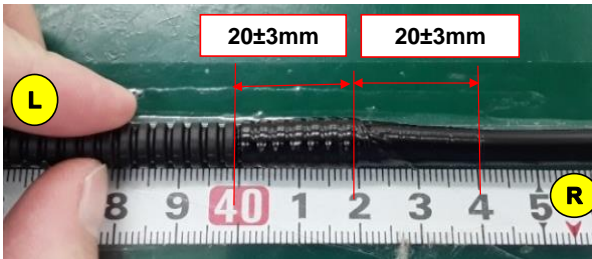

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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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	P2  Taping 3 Black Cot to Black SV tube (Vinyl) near connector	<div><div></div><div></div><div></div><div>1. Fix the corrugated tube and SV tube (Vinyl) using both hands.</div><div>2. Get the <b>Black tape</b> and start taping process using both hands.</div><div>3. After taping, check the measurement and taping condition.</div></div>		<div>MEASURING TAPE</div> 	<p><b>Important reminders/Note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement. 2. Please refer to WI-PRO-ASY-001 for taping procedure.</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>

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Model code/Part number: 096D

/ 7L0118-7021A

Customer: TRQSS

Car Model: TOYOTA-HIGHLANDER

Effectivity Date:

June 18, 2024

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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

P2

Taping 4  
Black Corrugated tube to  
Black VM tube  
(Sunprene) near  
terminal

**176±3mm**

**L** **R**

1. Measure from end of corrugated tube up to end of terminal pointed tip **176±3mm** using both hands.

**L** **R**

**Start of taping**

2. Fix the corrugated tube and SV tube (vinyl) using both hands.

3. Get the **black tape** and start taping process using both hands.

**176±3mm**

**L** **R**

**20±3mm** **20±3mm**

4. After taping, check the measurement and taping condition.

### MEASURING TAPE



### Important reminders/Note/s:


1. Please use calibrated/verified measuring tape when getting the measurement.
2. Please refer to WI-PRO-ASY-001 for taping procedure.

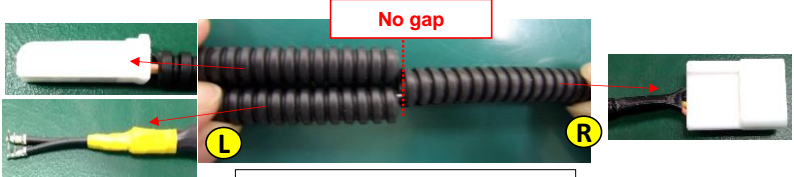
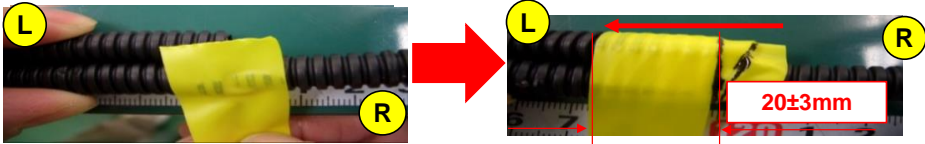
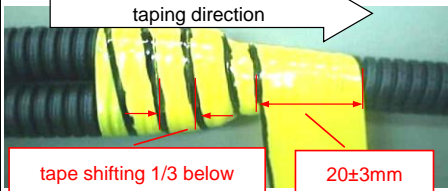
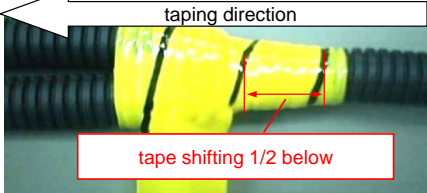
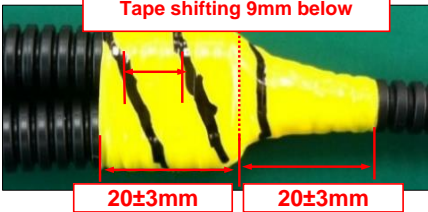

1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong use of tape
6. No wrong dimension

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	3	Page No.:	5 of 7


<b>PARTS:</b>	1. Assy parts 2. Black tape			JIG:	n/a				
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>			
4	P2	Y-taping	<div><p>1. Fix the 3 corrugated tube .</p></div> <div><p>2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side , width must be same with tape (<b>20±3mm</b>)</p></div> <div><p>3. Wind the tape <b>1/3 shifting</b> until it reach the other side of corrugated tube (<b>must be 20±3mm</b>)</p></div> <div><p>4. Wind the tape backward <b>1/2 shifting</b></p></div> <div><p>5. Wind the tape <b>1/2 shifting</b> going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.</p></div>			<div><b>MEASURING TAPE</b></div> 	<p><b>Important reminders/Note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement. 2. Please refer to WI-PRO-ASY-001 for taping procedure. 3. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines, But actual should be <b>BLACK TAPE</b>.</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>		


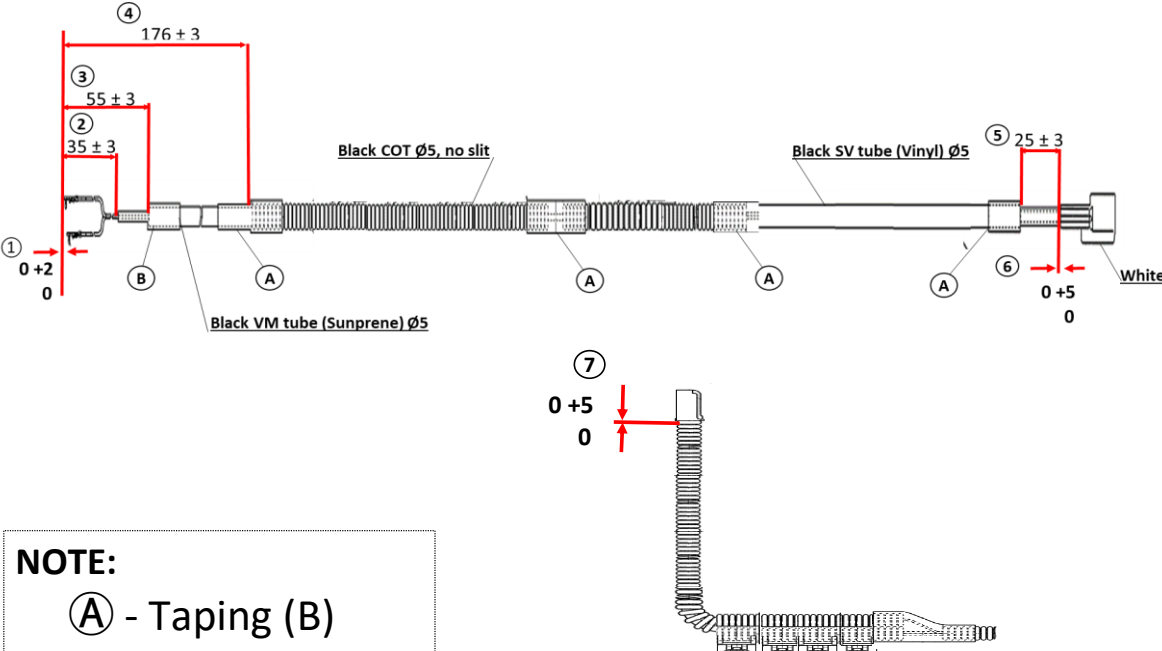
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	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	0	Page No.:	6 of 7	

PARTS:	n/a				JIG:	n/a	
NO.	PROCESS NAME	3 WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
5	P2	Measurement	<div></div> <div></div> <div><b>NOTE:</b> Ⓐ - Taping (B) Ⓑ - Taping (Y)</div>			<div><b>MEASURING TAPE</b></div> <div>1. No wrong dimension</div> <div><b>Important reminders and note/s:</b> 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.</div> <div><b>Document reference/s:</b> 1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div>	

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# WORK INSTRUCTION

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PARTS:

n/a

JIG:

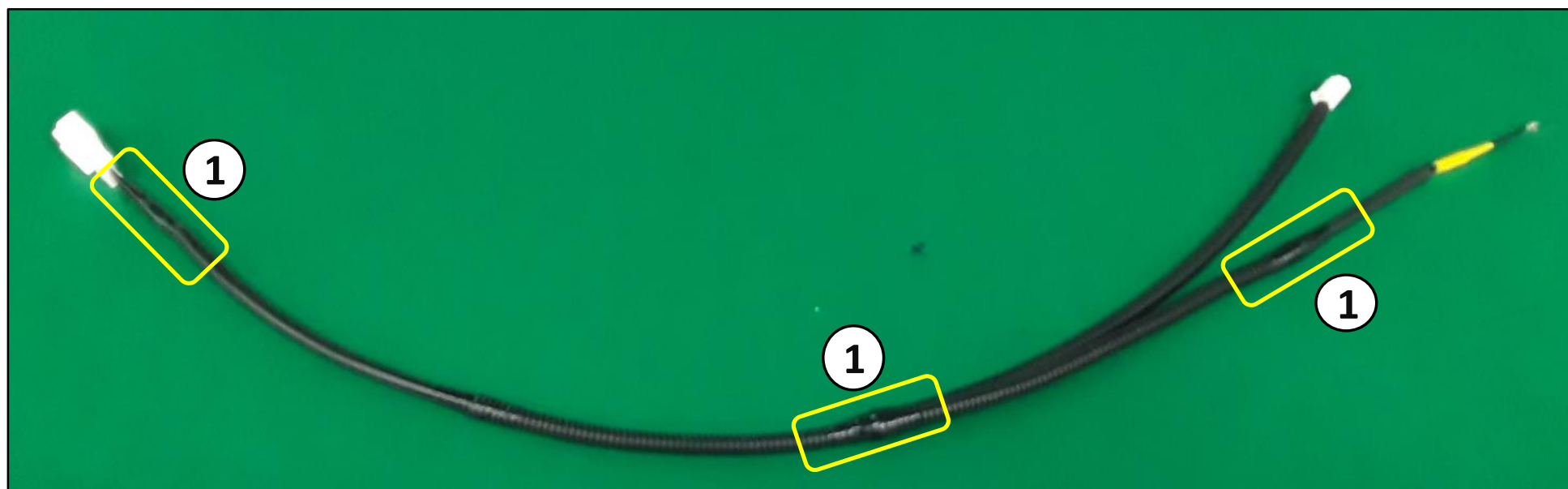
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### QUALITY CHECKPOINTS

# TAPING - P2

# 7L0118-7021A



① No Missing Tape

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