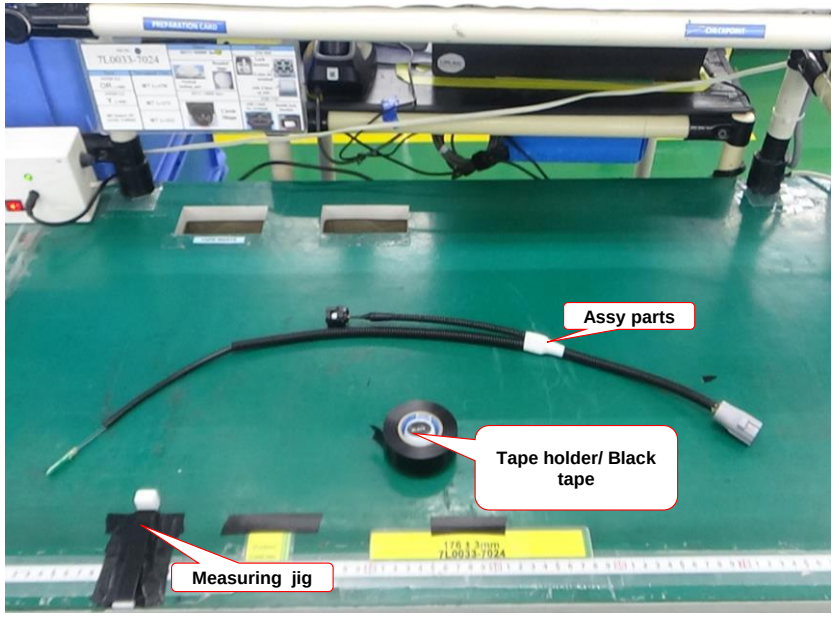
	WORK INSTRUCTION			Effectivity Date:	July 10, 2024	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 010B / 7L0033-7024	Customer: TRQSS	Car Model: TOYOTA-CAMRY	Document No.:	WI-ENG-PDE-065C	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	11	Page No.: 1 of 5

PARTS:	1. Assy parts: Black tape			JIG:	1. Measuring jig
NO.	PROCESS NAME	11 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P3	11 Table Lay-out	**Table Lay-out**  	**Safety Instruction** Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) **Housekeeping** 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. **Alert level** For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. **MEASURING JIG** 	1.No missing parts / tools 2.No excess parts / tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
07/10/24	11	Separate clamp assembly to Clamp assembly jig and transfer Taping 2 and Taping 3 from P1 and P2 due to process improvement. Inclusion of car model "TOYOTA-CAMRY". Update table lay-out, Measurement and Visual inspection.	D.Castillo	C.Villanueva	A. Arañes	N/A				
05/12/23	10	Inclusion of quality check points; improvement of by two's inspection; improve the important reminders/Note/s and document references; additional checkpoints for clamp; Additional checkpoint for bando gun usage	J. Loterte	C. Villanueva	A. Arañes	n/a				
01/15/22	9	Change part number from 7L0033-7023 to 7L0033-7024 due to change of PCB from 2 chip (61C619-0002) to 1 chip (7N0994-7060); Change wire color from Gray (GR) to Green (G) (Refer to CL-ENG-PDE-207B; CL-ENG-PDE-207A;). Improve work procedure and illustration.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	D. Castillo	C.Villanueva	A. Arañes	N/A
							Est. Date:	September 24, 2018		

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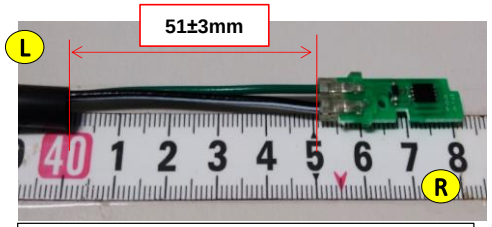
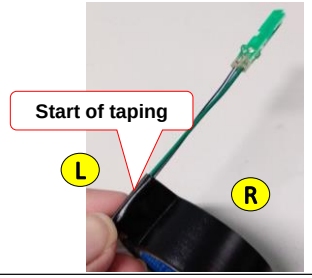
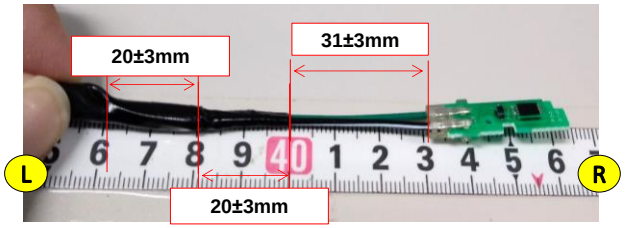
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 010B / 7L0033-7024	Customer: TRQSS	Car Model: TOYOTA-CAMRY	Document No.:	WI-ENG-PDE-065C	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	11	Page No.: 2 of 5

PARTS:	1. Assy parts 2. Black tape	JIG:	1.Measuring jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3	11 Taping 2 Black VM tube (Sunprene) to wire near hotmelted wires	 1. Get the assy parts **G-B/W wires** with sunprene tube then measure from end of the sunprene tube up to the edge of hotmelt **51±3mm** using both hands.  2. Hold the sunprene tube using left hand, get the **Black tape** using right hand and begin taping process using both hands.  3. After taping, check the measurement and taping condition.	MEASURING JIG MEASURING TAPE 	***Important reminders and Note/s:*** ***1. Please use calibrated/verified measuring tape when getting the measurement.*** ***Document reference/s:*** ***1. 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 dimension 6. No wrong use of tape

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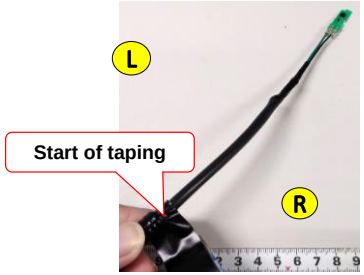
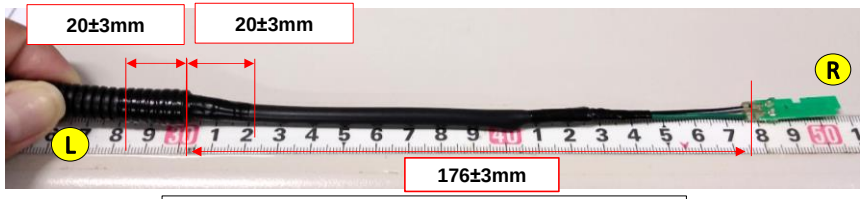
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number:	010B / 7L0033-7024	Customer: TRQSS	Car Model: TOYOTA-CAMRY	Document No.:	WI-ENG-PDE-065C	
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	11	Page No.: 3 of 5

PARTS:	1. Assy parts 2. Black tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	11 P3	Taping 3 Black Corrugated tube to Black VM tube (Sunprene)	 1. Measure from end of corrugated tube up to the edge of hotmelted wires **176±3mm** using both hands.  2. Hold corrugated tube using left hand, conduct pre-taping using both hands.  3. After taping, check the measurement and taping condition.	MEASURING TAPE 	***Important reminders and Note/s:*** ***1. Please use calibrated/verified measuring tape when getting the measurement.*** ***Document reference/s:*** ***1. 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 dimension 6. No wrong use of tape

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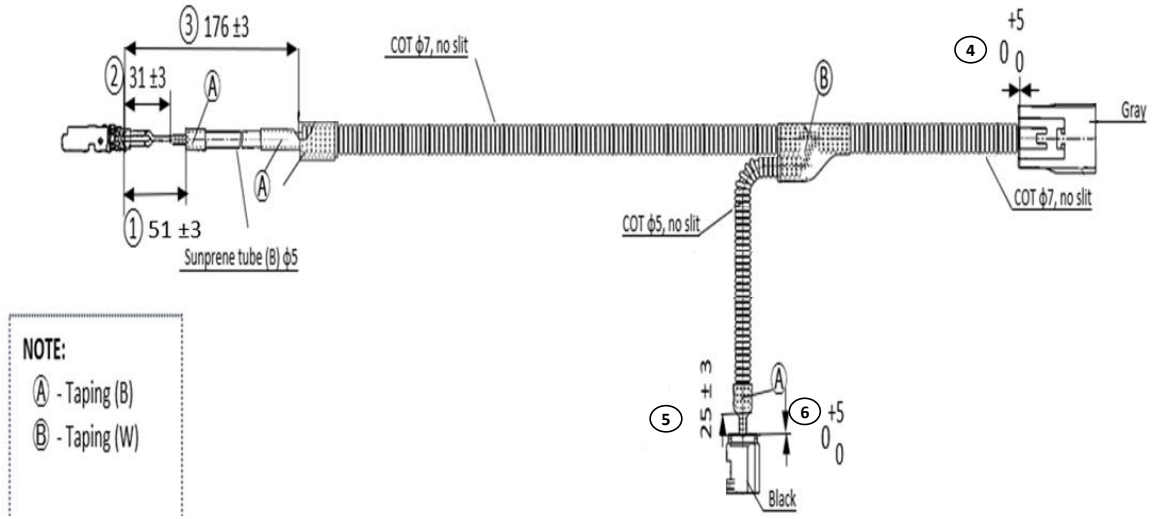
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	11	Page No.:	4 of 5

PARTS:	1. Assy parts	JIG:	n/a

NO.	PROCESS NAME		11 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P3	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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PARTS:	1. Assy parts	JIG:	n/a

11 **VISUAL INSPECTION/ QUALITY CHECKPOINTS**

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