					ISTRUCTION		Effectivity Date:		April 20, 202	4
			Process Name/Title:		NG ASSEMBLY PROC		Validity Date:		n/a	
			Model code/Part number:	420/440 / A7446C	Customer: TRQSS	Car Model: TOYOTA-LAND CRUISER	Document No.:		WI-ENG-PDE-87	72B
			Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	1	Page No.:	1 of 8
PARTS:			parts; Black tape				JIG:	1. Insertion ji 2. Terminal c 3. Locking jig	over jig	
N	0.	P	ROCESS NAME	WORK	PROCEDURE/ ILLUSTRA	ATION	TOOLS/PPE QUALITY POINTERS			
					TABLE LAY-OUT		Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)			
	1		Table lay-out	Assy parts			Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.		ng parts/tools s parts/tools	
				Document of the Co			Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.			
				Insertion jig C	g jig Terminal cover	Tape holder/ Black tape				
	1			Revision History			Prepared by R	leviewed by	Approved by	Noted by
		-								
04/20/24	1	Change	from Pre-launch to Masspro. Col	rrect the process sequence. Update the measu	urement. Inclusion of Table lay-out.	D.Castillo C. Villanueva A. Arañes	n/a Catuo	long villan	ALCO I	
04/16/24		Initial Iss	ue.			D.Castillo C. Villanueva A. Arañes	n/a D. Castillo C. Villanueva A. Aranes n/a			
Eff. Date	Rev. No	<u> </u>		Details of Change		Revised Reviewed Approved N	oted Est. Date: April 1	16, 2024		



			,	WORK INSTRUCTION		Effectivity Date:	April 20, 2024					
		Process Name/Title:	400/440 / 47	TAPING ASSEMB			Validity Date:		n/a			
		Model code/Part number:		Customer:	TRQSS Car Model: To			_	WI-ENG-PDE-87			
		Purpose:	PROTOTYPE	PRE-LAUNCH	H MASSPRO)	Revision No.:	1	Page No.:	2 of 8		
PARTS:	1. Assy 2. Black						JIG:	1. Terminal	1. Terminal cover jig			
NO.	F	ROCESS NAME		WORK PROCEDURE	/ ILLUSTRATION		TOOLS/PPE	C	QUALITY POINT	ERS		
2	P2	Taping 1 Black Corrugated tube to Black SV tube (Vinyl)	99 ± 3n 1. Measure from end of Bi (No slit) up to Hotmelted w 99±3mm using both hand L 20 ± 3mm	lack Corrugated tube wires (G-B/W wires)	2 u g u s u u	Hold the assy parts sing left hand, then et the black tape sing right hand then tart taping process sing both hands. 3. After taping, check the measurement and taping condition.	6 7 8 9 10 1 2 3 4 5 6 7 8 9 10 10 10 10 10 10 10 10 10 10 10 10 10	1. Pleas measur measur 1. Refe Taping 1. No flip-o 2. No peel-3. No loose 4. No missi 5. No wron	ment reference. er to WI-PRO-ASY: process out tape of tape e tape	verified tting the		
3	<u>/:</u>	Wire insertion to Black corrugated tube (Assy parts)	1. Get the terminal cover Hold the assy parts using	jig then insert to both terminal left hand then insert the G-B/	als (Hotmelted wires G-B/W) // W wires using right hand.	using both hands.			g usage of parts rmed terminal			

			WORK IN		Effectivity Date:	1				
	CI	Process Name/Title:	TAPII	NG ASSEMBLY PROC	ESS	Validity Date:		n/a		
		Model code/Part number:	420/440 / A7446C	Customer: TRQSS	Car Model: TOYOTA-LAND CRUISER	Document No.:		WI-ENG-PDE-87	′2B	
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	1	Page No.:	3 of 8	
PARTS:	1. Assy	parts				JIG:	1. Insertion jig			
NO.	ı	PROCESS NAME	WORK	PROCEDURE/ ILLUSTR	ATION	TOOLS/PPE	(QUALITY POIN	TERS	
4	/_ P2	Connector setting to insertion jig 6189-0093 (W)	Visual reference Button Wire guide 1. Push the lower wire guide upwa for Green wire will be opened.	I-mark Lock	NSERTION JIG ORIENTATION Press 2. Press the lock using left thumb. 1. Push the wire guide upward using right hand. Slot for Green wire will be opened.	n/a	1. Use the 2. No wron 3. No wron	provided jig per m g orientation of co g use of connecto aged connector	odel nnector	



		1	WORK INST	FRUCTION		Effectivity Date:		April 20, 2024		
		Process Name/Title:			Y PROCESS	Validity Date:		n/a		
		Model code/Part number:	420/440 / A7446C		TRQSS Car Model: TOYOTA-LAND CRUISER			WI-ENG-PDE-87	'2R	
		Purpose:		PRE-LAUNCH	MASSPRO	Revision No.:	1	Page No.:	4 of 8	
PARTS:	1. Assy	parts				JIG:	1. Insertion jig			
NO.	F	PROCESS NAME	WORK P	ROCEDURE/ I	ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
5	P2	Wire insertion to connector 6189-0093 (W)	1 Hold the Green wire then insert to terminal slot 1 using right hand. R B/W 3. Hold the B/W wire then insert to terminal slot 2 using right hand.	4. After ins	2. Press the button using right thumb. The slot for B/W wire will be opened. Pertion, push the lock using left thumb then hold and gently pull out the connector from jig using	n/a	2. No loose 3. No wron 4. One by 5. No defo 6. No wron Importa 1. Pleas 2. Make inserted Conduct insertio Do not of Docume 1. Please 1. Please	ng insertion one insertion rmed terminal ng wire facing ant reminders/Not te hold the wire no sure wires are p of. the Pull-Push-Pull-F	e/s: ear terminal. roperly Push after	

			WO	Effectivity Date:	April 20, 2024					
		Process Name/Title:		TAPING ASSEMBL			Validity Date:		n/a	
		Model code/Part number:	420/440 / A7446		l e	TOYOTA-LAND CRUISER	Document No.:		WI-ENG-PDE-8	
		Purpose:	PROTOTYPE	☐ PRE-LAUNCH	MASSPI	RO	Revision No.:	1	Page No.:	5 of 8
PARTS:	1. Assy 2. Black						JIG:	1. Locking jig		
NO.	P	ROCESS NAME	V	NORK PROCEDURE/	ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
6		Connector lock	1. Put the connector into lockin and then press 2x. Check the lock.		GOOD Touche los Full Lock Before pres	After pressing	LOCKING JIG	2. No unlo	vided locking jig p ck/half-locked con ocument reference se refer to GL-PRG Push procedure.	nector ce/s: D-ASY-029
7	P2	Taping 4 Black SV tube (Vinyl) to wire near connector	1. Hold the corrugated tube using left hand, get the Black tape using right hand then start pre-taping using both hands.	30 ± 3mm 20 ± 3mm L 3. After taping, check	30 ± 3mm	2. Measure from end of the corrugated tube up to connector 30±3mm then continue the taping process using both hands.	MEASURING TAPE 6 7 8 9 10 1 2 3 4 5 6 7 8 9 1	6. No wron Impo 1. Pleas measur measur Docur	-of tape e tape e tape sing tape ng use of tape ng dimension ortant reminders/ se use calibrated ring tape when go rement. ment reference er to WI-PRO-AS)	and verified etting the

			WORK IN	Effectivity Date:	April 20, 2024					
		Process Name/Title:	TAPI	NG ASSEMBLY P	ROCESS	Validity Date:	n/a			
		Model code/Part number:	420/440 / A7446C	Customer: TR	QSS Car Model: TOYOTA-LAND CRUISER	Document No.:		WI-ENG-PDE-8	72B	
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	1	Page No.:	6 of 8	
PARTS:	1. Assy 2. Black					JIG:	n/a			
NO.	I	PROCESS NAME	WORK	PROCEDURE/ ILLU	ISTRATION	TOOLS/PPE	QUALITY POINTERS			
8	P2	Y-Taping	taping direction tape shifting 1/3 below taping direction tape shifting 1/2 4.Winding the tape backward 1/2 shi	Note: Do not exert excessive force during pulling & winding of tape 3. Wind other si 25mm.	the corrugated tube . It taping at the middle of combined atted tubes, then winding the tape going to gated tubes, width must be 20±3mm In the tape 1/3 shifting until it reach the de of corrugated tube, width must be Tape shifting 9mm below 20±3mm 20±3mm 20±3mm 20±3mm	6 7 8 9 10 1 2 3 4 5 6 7 8 9 1 2 3 4 5 6 7 8 9 1 2 3 4 5 6 7 8 9 1 2 3 4 5 6 7 8 9 1 1	6. No wror Importar 1. Use Y visualiza should k 2. Please	of tape e tape ing tape g use of tape ng dimension of reminders/Note ELLOW TAPE for ation of shifting li be BLACK TAPE. e use calibrated/v ng tape when get	easy nes, but actual erified	

Model code/Part number: 420/440 / A7446C Customer: TRQSS Car Model: TOYOTA-LAND CRUISER Document No.: WI-ENG-PDE-872B Purpose: PROTOTYPE PRE-LAUNCH MASSPRO Revision No.: 1 Page No.: 7 of the second				W	ORK INSTRUCTION				Effectivity Date:		April 20, 2024			
PARTS: 1. Assy parts NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE MEASURING TAPE Important reminders and note/s: 1. Peers use calcibrate/weifled measurement MEASURING TAPE Important reminders and note/s: 1. Peers use calcibrate/weifled measurement Tools/PPE Important reminders and note/s: 1. Peers use calcibrate/weifled measurement measurement Tools/PPE Important reminders and note/s: 1. Peers use calcibrate/weifled measurement measurement Tools/PPE Important reminders and note/s: 1. Peers use calcibrate/weifled measurement measurement Tools/PPE Important reminders and note/s: 1. Peers use calcibrate/weifled measurement measurement Tools/PPE Important reminders and note/s: 1. Peers use calcibrate/weifled measurement measurement Tools/PPE Important reminders and note/s: 1. Peers use calcibrate/weifled measurement measurement Tools/PPE Important reminders and note/s: 1. Peers use calcibrate/weifled measurement measurement Tools/PPE Important reminders and note/s: 1. Peers use use calcibrate/weifled measurement measurement Tools/PPE Important reminders and note/s: 1. Peers use calcibrate/weifled measurement Tools/PPE Important reminders and note/s: 1. Peers use use use use use use use use use us			Process Name/Title:				1				n/a			
PARTS: 1. Assy parts NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION MEASURING TAPE Important reminders and note/s: 1. Please use calibrated verified measuring last vitral getting the measurement. 2. For Hatsumono, Nakamono and Owarimono Inspection Document reference/s: 1. Refer to W-PRO-ASY-056 for State assembly Hatsumono Inspection Owarimono Inspection NOTE: NOTE: NOTE: A Taping (8) NOTE: A Ta			Model code/Part number:	420/440 / A74	46C Customer:	TRQSS	Car Model: TOYOTA-	LAND CRUISER	Document No.:		WI-ENG-PDE-87	≥B		
NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS MEASURING TAPE Important reminders and note/s: 1. Please use calibrated verified neasuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono. Document reference/s: 1. Refer to Wi-PRO-ASY 7058 for Substance of National Nati			Purpose:	PROTOTYPE	☐ PRE-LAUNC	Н	MASSPRO		Revision No.:	1	Page No.:	7 of 8		
MEASURING TAPE 1. Please use calibrated/welfled measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono. Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sut assembly Hatsumono Nakamono Owarimono Inspection NOTE: NOTE: NOTE: 1. No wrong dimension NOTE: No. Color Wire Type No. Color Wire Type 1. No wrong dimension NOTE: 1. No wrong dimension	PARTS:	1. Assy	parts						JIG:	n/a				
9 P2 Measurement NOTE: No Taping (B) No Taping (NO.	F	ROCESS NAME		WORK PROCEDURE	/ ILLUSTR	ATION		TOOLS/PPE	QUALITY POINTERS				
				1 26±3 SV tube (Viny NOTE: A - Taping (B) 2 99±3 SV tube (Viny	wire Type TABLE 5. Color Wire Type G AVSS 0.3f B/W AVSS 0.3f Y AVSS 0.3f	СОТ Ø7 (B)		(4) 112± (3)	MEASURING TAPE 6 7 8 9 (1) 1 2 3 4 5 6 7 8 9 (1) 105 (B) 175 ± 5 107 (B) 6 30 ± 3 175 ± 5	Importa 1. Pleas measure 2. For H. Owarimo Docum 1. Refer assembly Owarimo	nt reminders and e use calibrated/ve ng tape when gettirement. atsumono, Nakamono. ent reference/s to WI-PRO-ASY-05 y Hatsumono Nakano Inspection	note/s: rified ng the ono and		

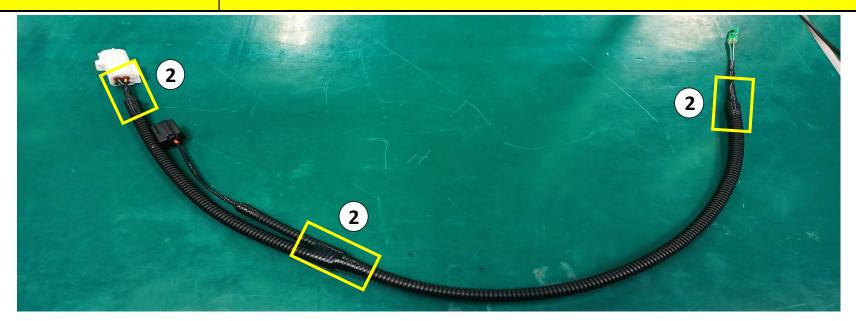


			Effectivity Date:		April 20, 2024							
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		Model code/Part number:	420/440	/ A7446C	Cu	ustomer:	TRQSS	Car Model: TOYOTA-LAND CRUISE	R Document No.:		WI-ENG-PDE-8	72B
		Purpose:	☐ PROTOTYP	E	☐ PR	RE-LAUNCH		MASSPRO	Revision No.:	1	Page No.:	8 of 8
PARTS:	1. Assy	parts							JIG:	n/a		
										1		

QUALITY CHECKPOINTS

TAPING - P2

A7446C



1 No Deformed terminal

2 No Missing tape

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