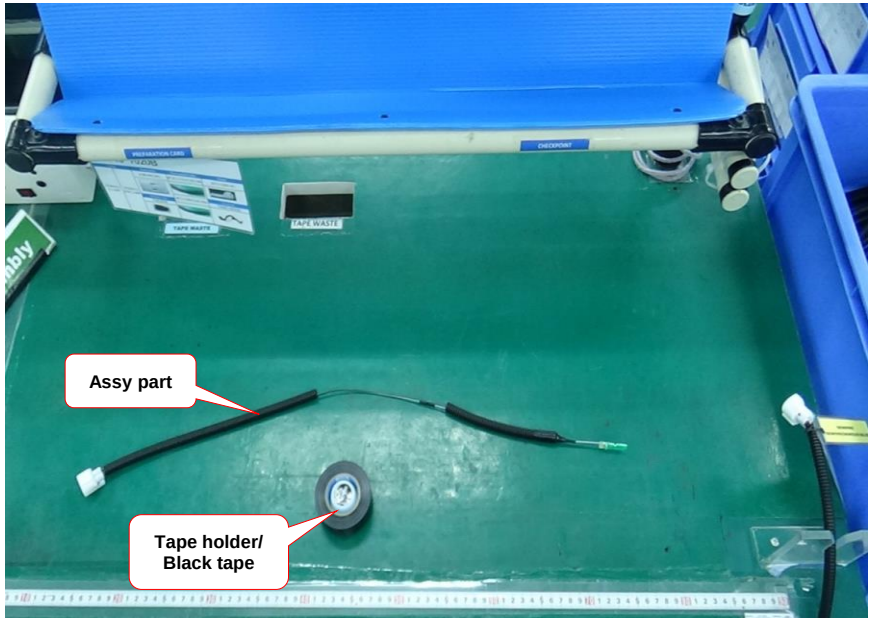
	WORK INSTRUCTION			Effectivity Date:	July 10, 2024		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 990B / 7N0143-7020B	Customer: TRJ	Car Model: TOYOTA PRIUS	Document No.:	WI-ENG-PDE-464B		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	4	Page No.:	1 of 5

PARTS:	1. Assy parts; Black tape			JIG:	N/A
NO.	PROCESS NAME		4 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	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.	1. No missing parts/ tools. 2. No excess parts/tools.

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
07/10/24	4	Transfer Taping 2 Black COT (no slit) to wire near PCB from P1 (WI-ENG-PDE-464A). Separate Clamp setting and Clamp assembly to Clamp assembly process. Inclusion of Car model "TOYOTA PRIUS". Improved Measurement and Visual inspection/Quality checkpoints.	D.Castillo	C.Villanueva	A. Arañes	N/A
12/13/22	3	Improve Quality pointers; Reminders/notes and references on pages no.1 to 8 due to document improvement. Improve Work procedure/illustration on process no.5 due to process improvement. Inclusion of Quality checkpoints.	M.Ariola	J.Loterte	C.Villanueva	A. Arañes
05/30/22	2	Change from ATO to SAKI process; Improve process illustration; Adjust measurement of edge of PCB to protector from 163mm to 155mm.	K.Doria	J.Loterte	C.Villanueva	A. Arañes

Prepared by	Reviewed by	Approved by	Noted by
D. Castillo	C.Villanueva	A. Arañes	N/A
Est. Date:	April 13, 2022		

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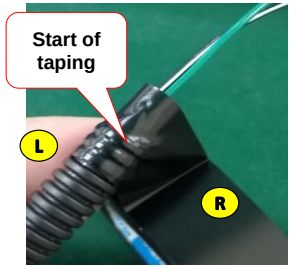
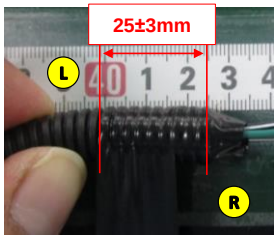
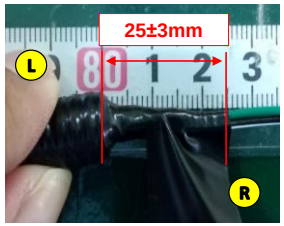
PARTS:	1. Assy parts 2. Black tape	JIG:	N/A

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 (4)	Taping 2 Black COT (no slit) to wire near Taping 1 and PCB	 1. Hold the assy parts using left hand, get **Black tape** then conduct pre-taping using both hands.  2. Confirm measurement of **25±3mm** from end of tape up to end of COT then continue the taping process using both hands.  2. Confirm measurement of **25±3mm** from end of tape up to end of COT then continue the taping process using both hands. 6. 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.* 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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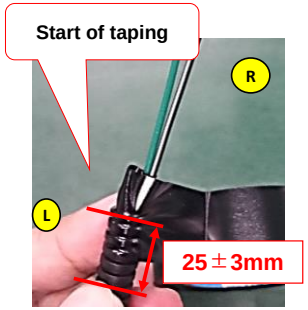
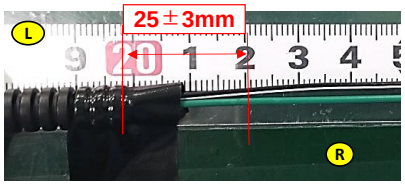
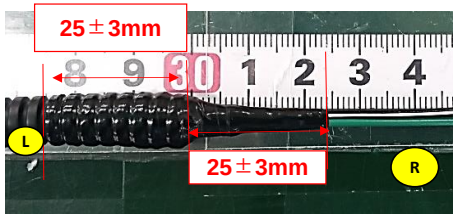
	WORK INSTRUCTION			Effectivity Date:	July 10, 2024	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 990B / 7N0143-7020B	Customer: TRJ	Car Model: TOYOTA PRIUS	Document No.:	WI-ENG-PDE-464B	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	4	Page No.: 3 of 5

PARTS:	1. Assy parts 2. Black tape	JIG:	N/A

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2	Taping 3 Corrugated tube Ø7 L=248±2mm (no slit) to wire between the other COT	 1.Get the **Black tape** using right hand then start taping process using both hand.  2. Measure from end of COT up to wire **25 ±3mm** then continue the taping process using both hands.  3. After taping, check the measurement and taping condition. **Note: Proper Taping location** 	**Measuring tape** 	***Important reminders/note/s:*** *1.Please use calibrated/verified measuring tape when getting the measurement.* 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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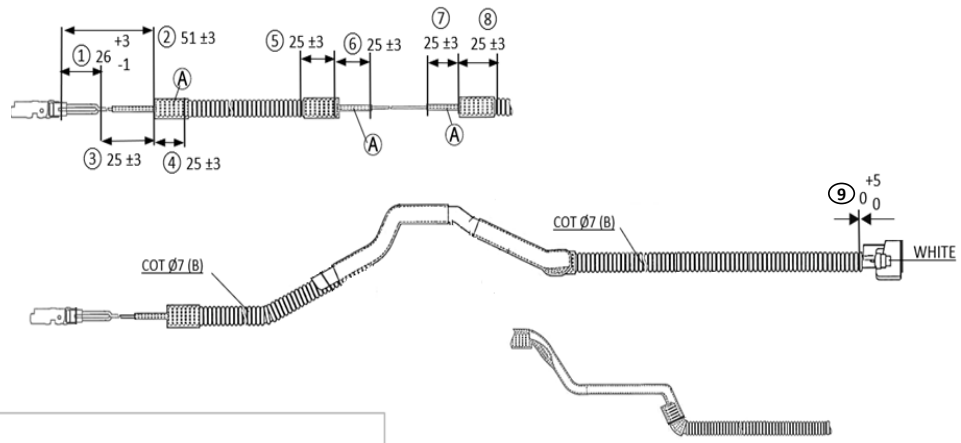
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	4 — Page No.: 4 of 5

PARTS:	1. Assy parts	JIG:	N/A

NO.	PROCESS NAME		4 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Clamp Assy	Measurement	 NOTE: Ⓐ - Taping (B) Ⓑ - Taping (P) Ⓓ - Protector (B) *for item number ①, Dimension tolerance is different from the master drawing due to Internal change only.*	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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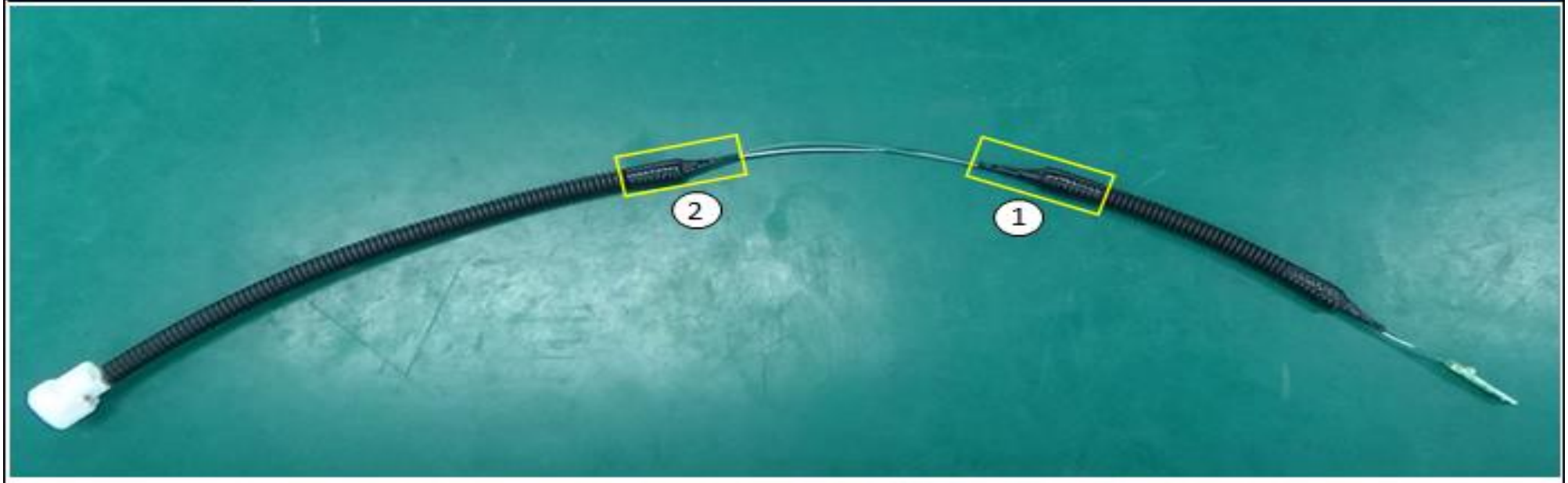
PARTS:	1. Assy parts	JIG:	N/A

4 VISUAL INSPECTION/ QUALITY CHECKPOINTS

P2 **7N0143-7020B**



1 **No Missing tape**
COT to wire near Taping 1 and PCB

2 **No Missing tape**
COT to wire between the other COT

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