
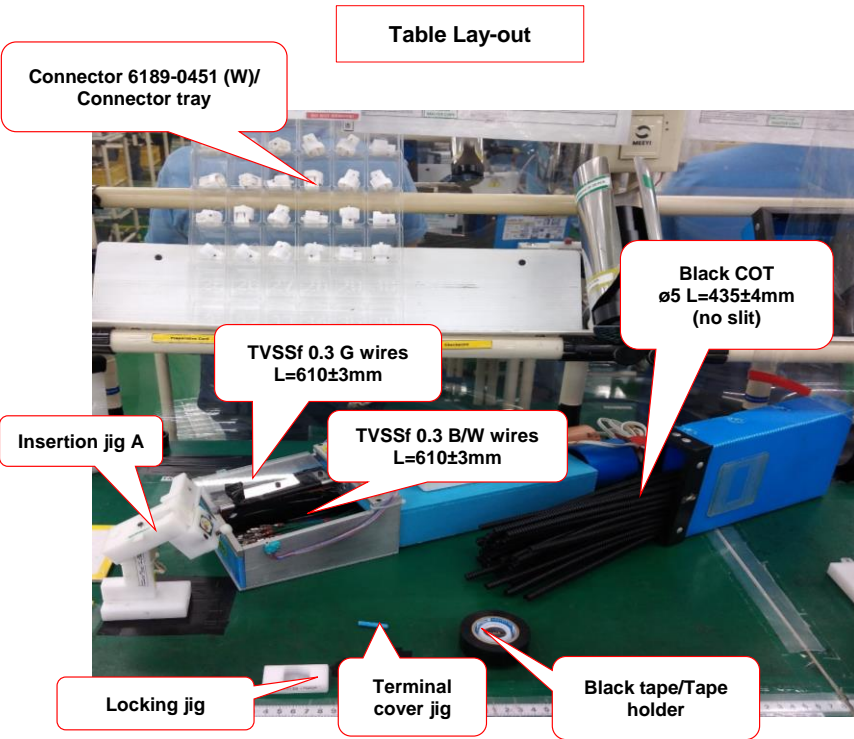


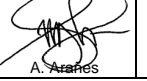


|   |   |  |               |                         |               |                   |   |                   |        |  |
|---|---|--|---------------|-------------------------|---------------|-------------------|---|-------------------|--------|--|
|  | WORK INSTRUCTION  |  |               |                         |               | Effectivity Date: |   | February 05, 2025 |        |  |
|   | Process Name/Title: TAPING ASSEMBLY PROCESS   |  |               |                         |               | Validity Date:    |   | n/a               |        |  |
|   | Model code/Part number: 011B / 7M0364-7021B   |  | Customer: TRJ | Car Model: TOYOTA CAMRY |               | Document No.:     |   | WI-ENG-PDE-1144A  |        |  |
|   | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO |  |               |                         | Revision No.: |                   | 2 | Page No.:         | 1 of 6 |  |

|        |              |  |  |  |      |   |   |   |  |  |
|--------|--------------|--|--|--|------|---|---|---|--|--|
| PARTS: |              | 1. All parts: Connector 6189-0451 (W); TVSSf 0.3 B/W wires L=610±3mm; TVSSf 0.3 G wires L=610±3mm; Black COT ø5 L=435±4mm (no slit); Black tape [1pc.] |  |  | JIG: |   | 1. Insertion jig with switch cover<br>2. Locking jig<br>3. Terminal cover jig |   |  |  |
| NO.    | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION   |  |  |      | TOOLS/PPE   |   | QUALITY POINTERS  |  |  |
| 1      | P1           | <div>Table Lay-out</div> <div></div>                                |  |  |      | <div><b>Safety Instruction</b><br/>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b><br/>1. Maintain and always practice 5's.<br/>2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b><br/>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div> |   | <div><b>Document reference/s:</b><br/>1. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length Tolerance</div> <div>1. No missing parts/tools<br/>2. No excess parts/tools</div> |  |  |

|                  |         |   |  |  |  |             |              |             |          |
|------------------|---------|---|--|--|--|-------------|--------------|-------------|----------|
| Revision History |         |   |  |  |  | Prepared by | Reviewed by  | Approved by | Noted by |
| 02/05/25         | 2       | Additional Quality pointers "No insufficient tape" as countermeasure to customer claim.   |  |  |  | D.Castillo  | C.Villanueva | A. Arañes   | N/A      |
| 10/30/24         | 1       | Change from Pre-launch to Masspro.  |  |  |  | D.Castillo  | C.Villanueva | A. Arañes   | N/A      |
| 10/22/24         | 0       | Initial issue. Transfer COT to wire near connector taping to P2 due to process improvement. Update Table lay-out and Visual inspection/Quality checkpoints. |  |  |  | D.Castillo  | C.Villanueva | A. Arañes   | N/A      |
| Eff. Date        | Rev. No | Details of Change   |  |  |  | Revised     | Reviewed     | Approved    | Noted    |

|   |  |   |  |   |  |               |  |
|---|--|---|--|---|--|---------------|--|
| Prepared by: <br>D. Castillo |  | Reviewed by: <br>C. Villanueva |  | Approved by: <br>A. Arañes |  | Noted by: N/A |  |
| Est. Date: October 22, 2024   |  |   |  |   |  |               |  |

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**February 05, 2025**

Model code/Part number:

**011B / 7M0364-7021B**

Customer:

**TRJ**

Car Model:

**TOYOTA CAMRY**

Document No.:

**WI-ENG-PDE-1144A**

Purpose:

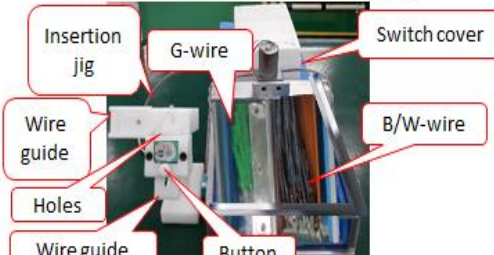

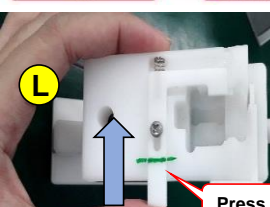
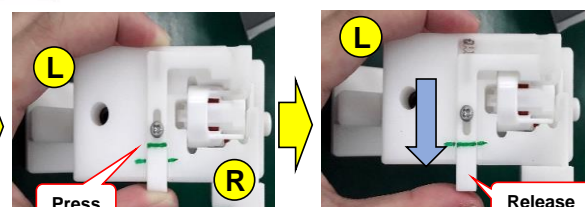
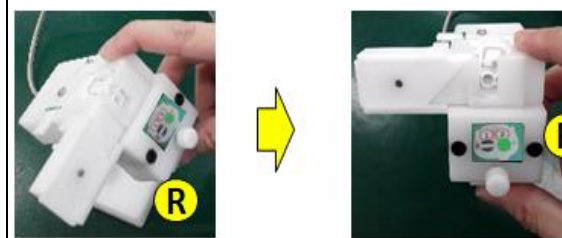


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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| PARTS: |              | 1. Connector 6189-0451 (W)<br>2. TVSSf 0.3 G-B/W L=610±3mm  |  | JIG:      | 1. Insertion jig with switch cover   |
|--------|--------------|---|--|-----------|--|
| NO.    | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION  |  | TOOLS/PPE | QUALITY POINTERS   |
| 2      | P1           | <div><div>INSERTION JIG WITH SWITCH COVER</div><div></div><div><br/>Connector orientation</div><div><br/>1. Press the lock of insertion jig using left thumb.</div><div><br/>2. Insert the connector <b>6189-0451 (W)</b> into jig using right hand and release the lock.<br/><b>Note: Follow the connector orientation.</b></div><div><br/>3. Push the guide using left hand. The slot for <b>B/W wire</b> will be opened.</div></div> |  | n/a       | <div><div>Connector Orientation Illustration</div><div></div><div></div><div>1. Use the provided jig per model<br/>2. No wrong orientation of connector<br/>3. No wrong use of connector<br/>4. No damaged connector</div></div> |

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**WORK INSTRUCTION**

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February 05, 2025

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

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Model code/Part number:

011B / 7M0364-7021B

Customer: TRJ

Car Model: TOYOTA CAMRY

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|        |               |   |  |      |                                    |  |
|--------|---------------|---|--|------|------------------------------------|--|
| PARTS: | 1. Assy parts |   |  | JIG: | 1. Insertion jig with switch cover |  |
| NO.    | PROCESS NAME  | WORK PROCEDURE/ ILLUSTRATION              |  |      | TOOLS/PPE                          | QUALITY POINTERS   |
| 3      | P1            | Wire insertion to connector 6189-0451 (W) |  |      | n/a                                | <div><p><b>Important reminders/Note/s:</b></p><p>1. Please hold the wire near terminal.</p><p>2. Make sure wires are properly inserted.</p><p>Conduct <b>Pull-Push-Pull-Push</b> after insertion.</p><p>Do not exert extra force.</p></div> <div><p><b>Document references:</b></p><p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p><p>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p></div> <div><p>1. No loose insertion</p><p>2. No wrong insertion</p><p>3. One by one insertion</p><p>4. No deformed terminal</p><p>5. No wrong wire facing</p></div> |

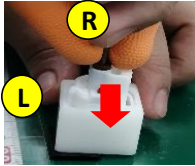
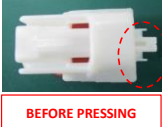

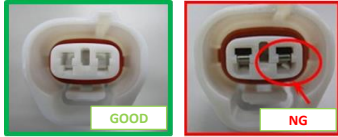

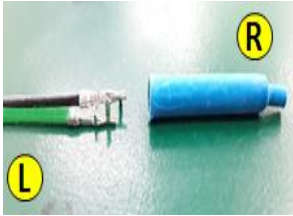

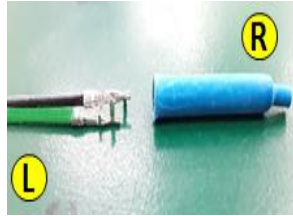

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|  | <b>WORK INSTRUCTION</b>   |  |                      |                                | Effectivity Date: | February 05, 2025 |           |        |
|   | Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>  |  |                      |                                | Validity Date:    | n/a               |           |        |
|   | Model code/Part number: <b>011B / 7M0364-7021B</b>  |  | Customer: <b>TRJ</b> | Car Model: <b>TOYOTA CAMRY</b> | Document No.:     | WI-ENG-PDE-1144A  |           |        |
|   | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO |  |                      |                                | Revision No.:     | 2                 | Page No.: | 4 of 6 |

|   |  |   |  |
|---|--|---|--|
| <b>PARTS:</b><br>1. Assy parts<br>2. Black Corrugated tube ø5 L=435±4mm (no slit) |  | JIG:<br>1. Locking jig<br>2. Terminal cover jig   |  |
| <b>NO.</b>  | <b>PROCESS NAME</b>  | <b>WORK PROCEDURE/ ILLUSTRATION</b>   | <b>TOOLS/PPE</b>   |
| 4   | Connector lock   |     <p>1. Put the connector into locking jig then press <b>2x</b> using both hands. Check the lock if properly locked.</p> <p>Check the double lock deformation</p>                                       | <div>Locking jig</div>          |
| 5   | Wire insertion to Black Corrugated tube ø5 L=435±4mm (no slit) |    <p>1. Get the terminal cover jig using right hand and insert wires using left hand.</p> <p>2. Get the black corrugated tube (no slit) ø5 L=435±4mm using right hand and insert the wires using left hand</p> <p>3. After insertion, remove the terminal cover jig using right hand.</p> | <div>Terminal cover jig</div>  |
|   |  | <b>QUALITY POINTERS</b><br><b>Important reminders/Note/s:</b><br><b>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b><br>1. No half-locked and unlock<br>2. No lock deformation<br>3. Use provided jig tool to lock the connector   |  |

|  |   |                      |
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## WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Model code/Part number:

011B / 7M0364-7021B

Customer: TRJ

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Purpose:

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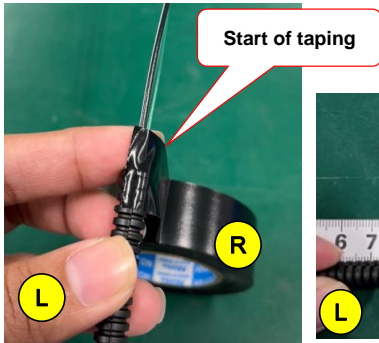
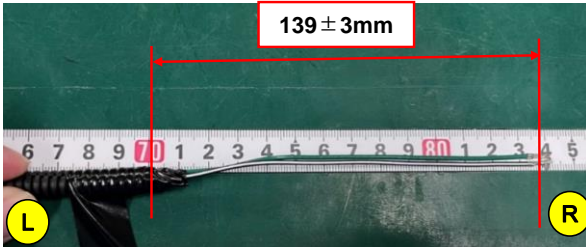
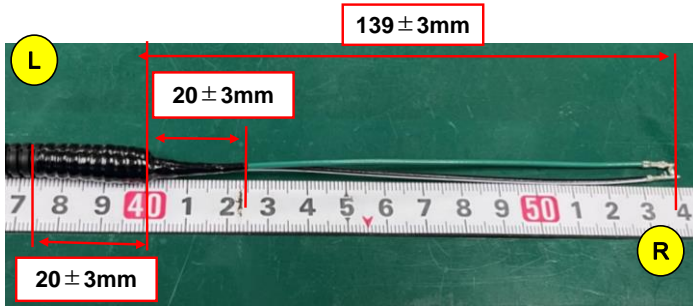

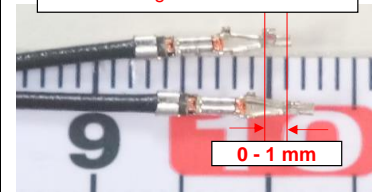
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| PARTS: |  | 1. Assy parts<br>2. Black tape   |  | JIG:  | n/a  |
|--------|--|--|--|---|--|
| NO.    | PROCESS NAME   | WORK PROCEDURE/ ILLUSTRATION   |  | TOOLS/PPE   | QUALITY POINTERS   |
| 6      | P1<br>Taping<br>Corrugated tube to wire<br>near terminal | <div></div> <div></div> <div><p>1. Hold the assy parts using left hand. Get the <b>Black tape</b> using right hand then start taping between COT to wire using both hands.</p><p>2. Measure form end of COT up to terminal pointed tip <b>139±3mm</b> then continue the taping process using both hands</p></div> <div></div> <div><p>3. After taping, check the measurement, terminal alignment and taping condition.</p></div> |  | <div><b>MEASURING TAPE</b></div>  <div>2</div> | <p><b>Important reminders/Note/s:</b></p> <p>1. <b>Please use calibrated/verified measuring tape when getting the measurement.</b></p> <p><b>Document references:</b></p> <p>1. Refer to WI-PRO-ASY-001A for Taping process</p> <p>1. No flip-out tape<br/>2.No peel-off tape<br/>3. No loose tape<br/>4. No wrong dimension<br/>5. No wrong use of tape<br/>6. No missing tape<br/>7. No insufficient tape</p> <div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div> |

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**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**

Effectivity Date:

**February 05, 2025**Model code/Part number: **011B / 7M0364-7021B**Customer: **TRJ**Car Model: **TOYOTA CAMRY**

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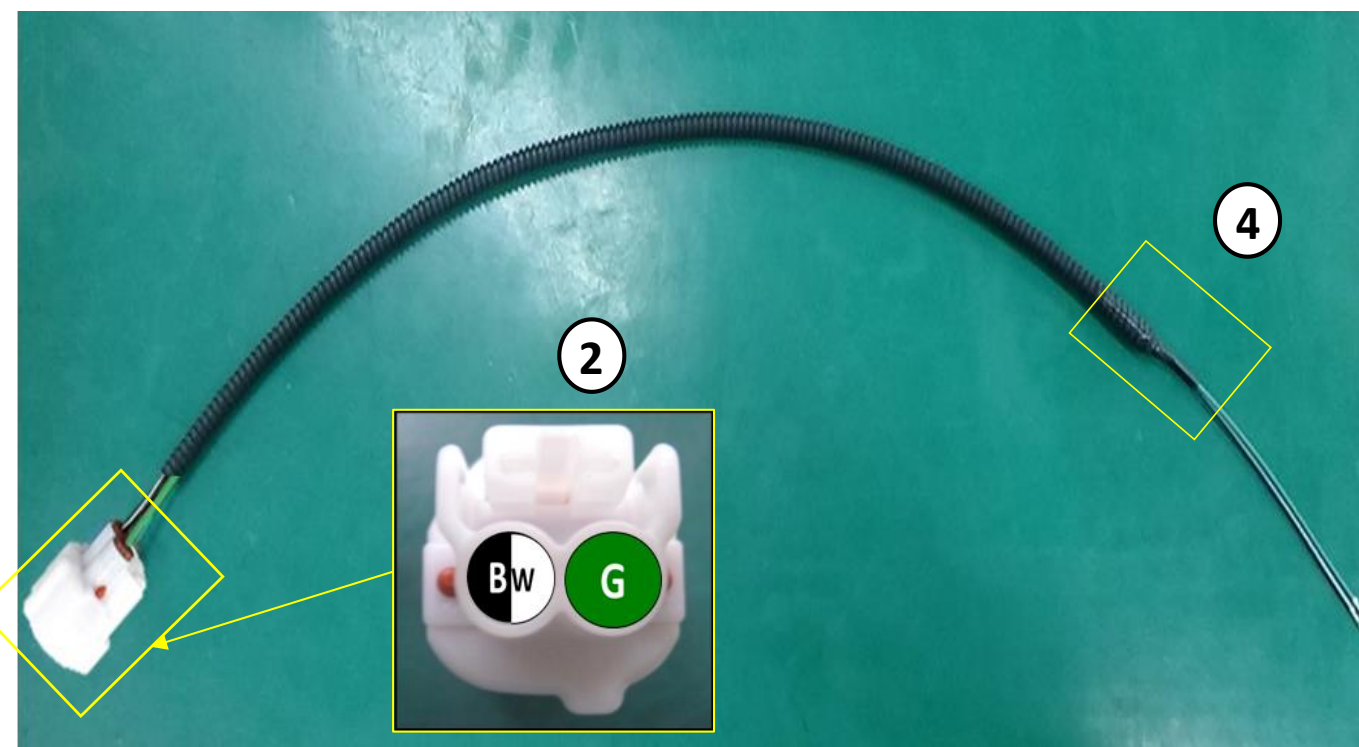
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**6 of 6****PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P1****7M0364-7021B**

- ① No Unlocked/  
Half-locked connector
- ② No Wrong Insert
- ③ No Terminal Backing Out
- ④ No Missing Tape

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