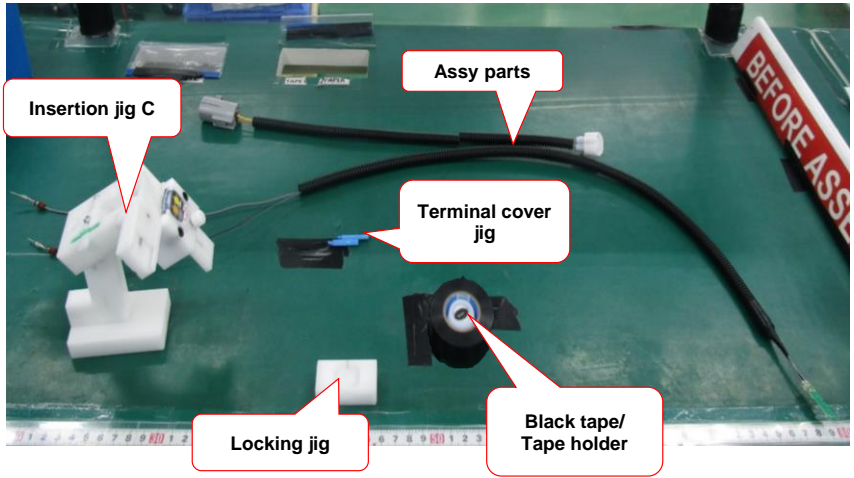
	<b>WORK INSTRUCTION</b> <b>TAPING ASSEMBLY PROCESS</b>				Effectivity Date:	October 15, 2024		
	Process Name/Title:				Validity Date:	n/a		
	Model code/Part number: <b>177D / 7L0128-7020B</b>		Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA-COROLLA</b>	Document No.:	<b>WI-ENG-PDE-1098B</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	1 of 9

<b>PARTS:</b>	1. Assy parts; Black tape			JIG:	1. Insertion jig with switch cover 2. Locking jig 3. Terminal cover jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
1	P2	<p>Table lay-out</p> 	<p><b>Safety Instruction</b> Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p><b>Document reference/s:</b> 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>	


  

Revision History						Prepared by	Reviewed by	Approved by	Noted by
10/15/24	1	Change from Pre-launch to Masspro.	D.Castillo	C. Villanueva	A. Arañes	n/a			
10/11/24	0	Initial issue.	D.Castillo	C. Villanueva	A. Arañes	n/a			
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 11, 2024	



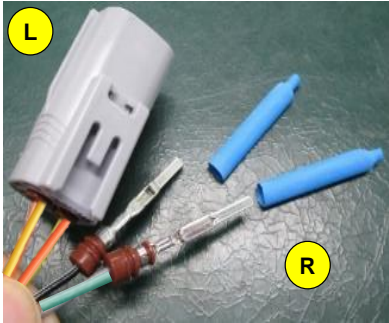

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	Process Name/Title:		Model code/Part number: <b>177D / 7L0128-7020B</b>		Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA-COROLLA</b>	Document No.:	<b>WI-ENG-PDE-1098B</b>			
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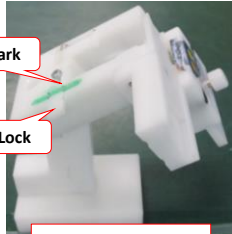
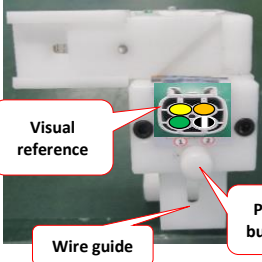
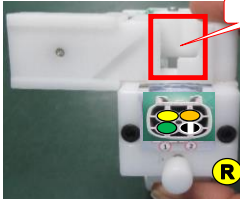

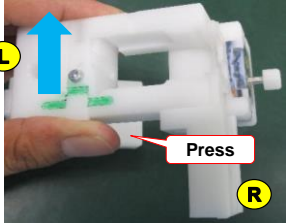
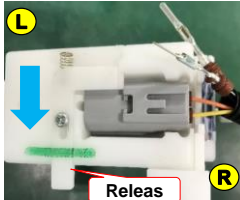
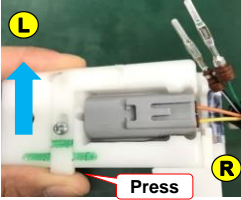
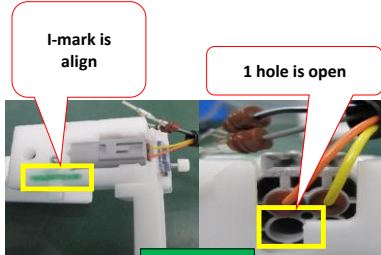
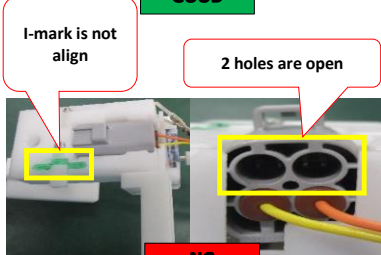
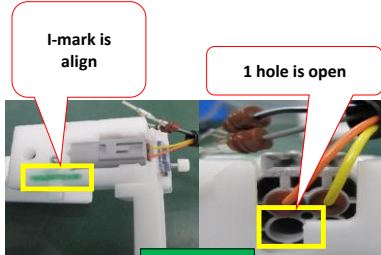
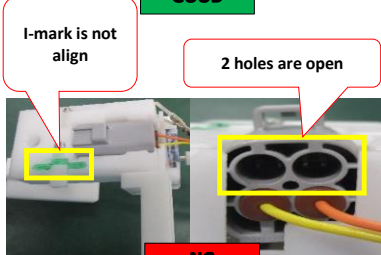
  

<b>PARTS:</b>		1. Assy parts		JIG:	1. Terminal cover jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
2	P2 Wire insertion to assy parts	<div>  <p>1. Get the <b>TVSSf G-B/W wires L=822±3mm</b> using both hands then insert the terminal cover jig using right hand.</p> </div> <div>  <p>COT Ø7 L=212±3mm</p> <p>2. Get the assy parts then hold the COT (no slit) <b>Ø7 L=212±3mm</b> using left hand then insert the <b>TVSSf G-B/W wires L=822±3mm</b> using right hand.</p> </div> <div>  <p>3. After insertion, remove the cover jig using right hand.</p> </div>		<div>  <p><b>TERMINAL COVER JIG</b></p> </div>	1. No wrong usage of parts 2. No damaged rubber seal 3. No exposed rubber seal during insertion	

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		<b>WORK INSTRUCTION</b>			Effectivity Date:		October 15, 2024		
Process Name/Title:		<b>TAPING ASSEMBLY PROCESS</b>			Validity Date:		n/a		
Model code/Part number:		<b>177D / 7L0128-7020B</b>		Customer: <b>TRQSS</b>		Car Model: <b>TOYOTA-COROLLA</b>		Document No.: <b>WI-ENG-PDE-1098B</b>	
Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.: 1      Page No.:      3 of 9	


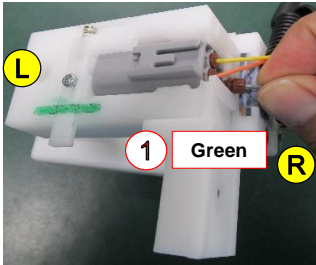
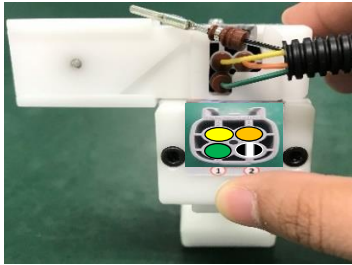
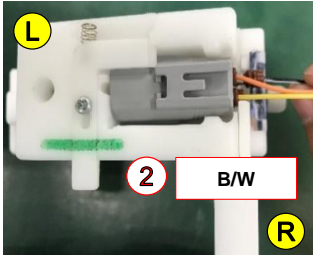

<b>PARTS:</b>		1. Assy parts			JIG:		1. Insertion jig				
<b>NO.</b>		<b>PROCESS NAME</b>		<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>		<b>QUALITY POINTERS</b>		
3		P2		<div><div></div><div></div><div></div><div></div><div><p>1. Push the lower wire guide upward using right thumb. Slot for <b>Green wire</b> will be opened.</p><p>2. Press the lock using left thumb.</p><p>3. Get the connector <b>6188-0066 (GR)</b> using right hand and insert to insertion jig. Release the lock after insertion. <i>Note: Follow the connector orientation.</i></p></div></div> <td colspan="2">n/a</td> <td colspan="3"><div><div>CONNECTOR ORIENTATION ILLUSTRATION</div><div><p><b>GOOD</b></p><p><b>NG</b></p></div><div><p>1. Use the provided jig per model</p><p>2. No wrong orientation of connector</p><p>3. No wrong use of connector</p><p>4. No damaged connector</p></div></div></td>			n/a		<div><div>CONNECTOR ORIENTATION ILLUSTRATION</div><div><p><b>GOOD</b></p><p><b>NG</b></p></div><div><p>1. Use the provided jig per model</p><p>2. No wrong orientation of connector</p><p>3. No wrong use of connector</p><p>4. No damaged connector</p></div></div>		

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	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a			
	Process Name/Title:		Model code/Part number: <b>177D / 7L0128-7020B</b>		Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA-COROLLA</b>	Document No.:	<b>WI-ENG-PDE-1098B</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	1	Page No.:	4 of 9	


<b>PARTS:</b>	1. Assy parts			JIG:	1. Insertion jig			
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
4	P2  Wire insertion to Connector 6188-0066 (GR) (Assy parts)	<div><div>TERMINAL FACING</div></div> <div><div>1 Hold the <b>G wire</b> then insert to terminal slot <b>1</b> using right hand.</div></div> <div><div>2. Press the button using right thumb. The slot for <b>B/W wire</b> will be opened.</div></div> <div><div>3. Hold the <b>B/W wire</b> then insert to terminal slot <b>2</b> using right hand.</div></div> <div><div>4. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</div></div>			n/a	<p><b>Important reminders/Note/s:</b></p> <ul style="list-style-type: none"><li>1. Please hold the wire near terminal.</li><li>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</li></ul> <p><b>Document references:</b></p> <ul style="list-style-type: none"><li>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</li><li>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</li></ul> <ul style="list-style-type: none"><li>1. No loose insertion</li><li>2. No wrong insertion</li><li>3. One by one insertion</li><li>4. No deformed terminal</li><li>5. No wrong wire facing</li></ul>		

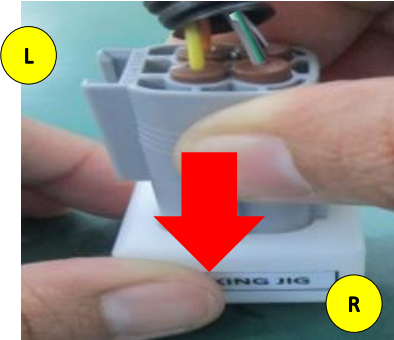


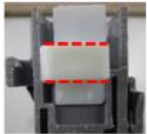
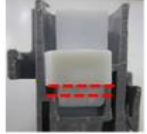


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	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>177D / 7L0128-7020B</b>		Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA-COROLLA</b>	Document No.:	<b>WI-ENG-PDE-1098B</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	5 of 9

<b>PARTS:</b>	1. Assy parts			JIG:	1. Locking jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
5	P2	Connector lock	<div><div>1. Put the connector into locking jig using both hands and then conduct <b>2x</b> pressing. Check the connector if properly locked.</div><div><div>Before pressing</div><div>After pressing</div></div><div><b>Connector Cross Sectional View</b><div><div>NG<div>Unlock</div></div><div>NG<div>Half Lock Condition</div></div><div>GOOD<div>Full Lock Condition</div></div></div></div><div><div>LOCKING JIG</div></div><div><div><b>Document references:</b> 1. Manual locking may cause damaged connector lock</div><div>1. Use the provided locking jig per model 2. No unlock/half-locked connector 3. No damaged lock</div></div></div>		


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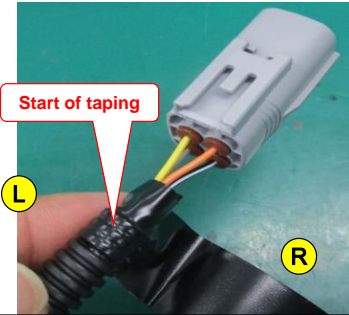
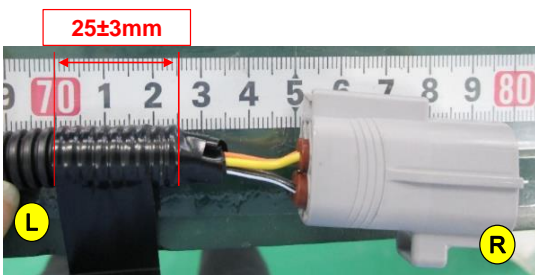
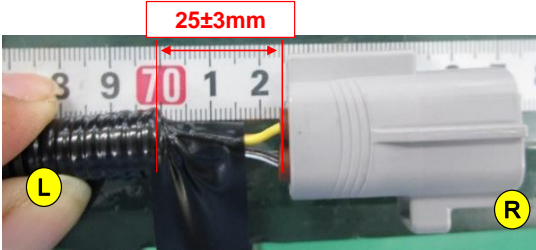
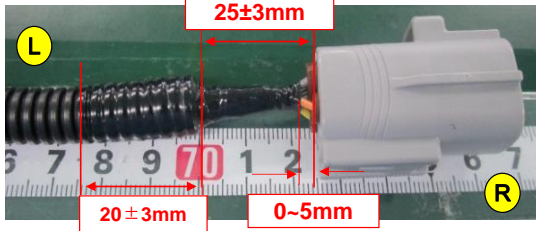

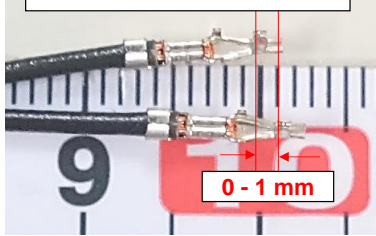
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	Model code/Part number: 177D / 7L0128-7020B		Customer: TRQSS	Car Model: TOYOTA-COROLLA	Document No.:	WI-ENG-PDE-1098B	
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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
6	P2 Taping 2 Black Corrugated tube to wire near terminal	<div><p>1. Hold the corrugated tube using left hand then start taping using right hand.</p></div> <div><p>2. Confirm <b>25±3mm</b> measurement from end of tape up to end of corrugated tube then continue the taping process using both hands.</p></div> <div><p>3. Measure from end corrugated tube up to edge of connector <b>25±3mm</b> then continue the taping process using both hands.</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></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.</p> <p><b>Document reference/s:</b></p> <p>1. Please refer to WI-PRO-ASY-001 for taping procedure.</p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape</p> <div>Wire alignment tolerance</div> 	



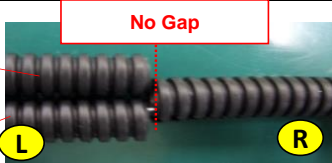
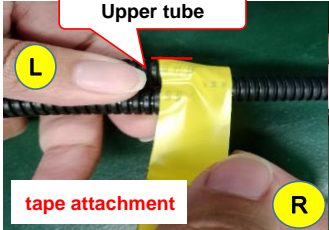
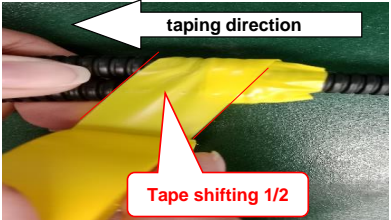
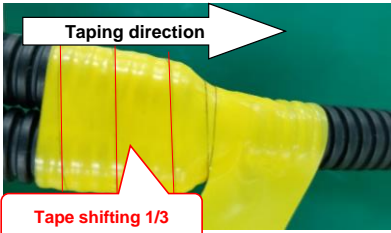
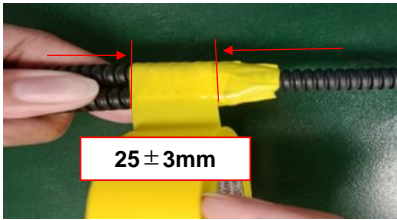
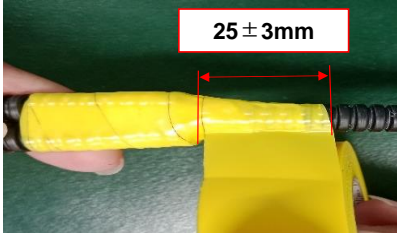
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	Model code/Part number: <b>177D / 7L0128-7020B</b>		Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA-COROLLA</b>	Document No.:	<b>WI-ENG-PDE-1098B</b>		
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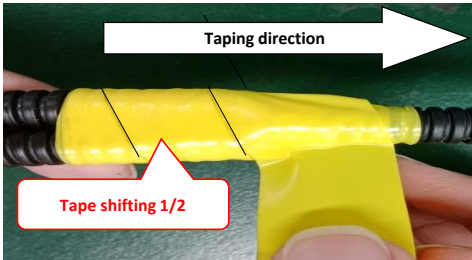
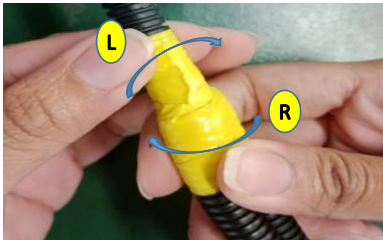
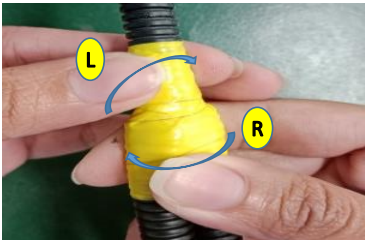
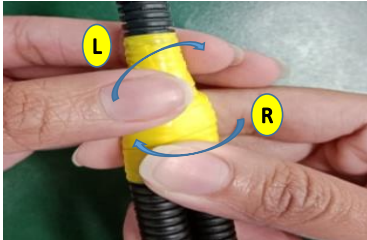
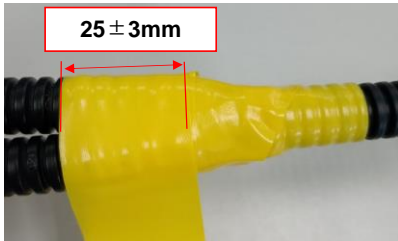
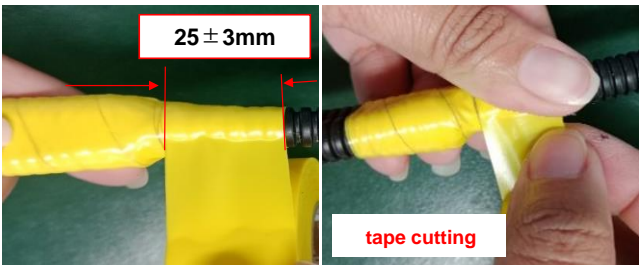
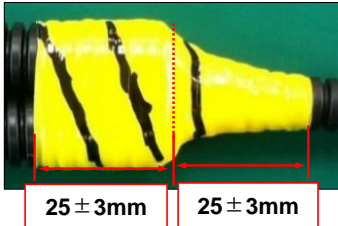
  

<b>PARTS:</b> 1. Assy parts 2. Black tape		JIG:		n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
7	P2  Y-Taping	<div> <div> <b>ANY FACING</b>   </div> <div> <b>CONNECTOR FACING</b>   </div> <div>  <p>1. Fix the 3 corrugated tube.  <i>Note: Follow the Connector facing</i></p> </div> <div>  <p>Upper tube  pre-tape  tape attachment</p> </div> <div>  <p>taping direction  Tape shifting 1/2</p> </div> <div> <p>3. Winding the tape 1/2 shifting going to the left side.</p> </div> <div>  <p>Taping direction  Tape shifting 1/3</p> </div> <div> <p>5. Winding the tape 1/3 shifting going to the right side until reach the other side of tube.</p> </div> <div>  <p>25 ± 3mm</p> </div> <div> <p>4. Make 2 windings, width must be 25±3mm.</p> </div> <div>  <p>25 ± 3mm</p> </div> <div> <p>6. Make 2 windings, width must be 25±3mm.</p> </div> </div>		<ol style="list-style-type: none"> <li>No loose tape</li> <li>No flip-out tape</li> <li>No peel-off tape</li> <li>No wrong use of tape</li> <li>No wrong dimension-out tape</li> <li>No exposed wire</li> <li>No gap between tubes</li> <li>Follow the connector facing</li> </ol> <p><b>Document reference/s:</b>  1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p><b>Important reminders/Note/s:</b>  1. Use <u>yellow</u> tape for easy visualization of tape shifting, but actual should be <u>BLACK TAPE</u>.  2. Please use calibrated/verified measuring tape when getting the measurement.</p>

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	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>177D / 7L0128-7020B</b>		Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA-COROLLA</b>	Document No.: <b>WI-ENG-PDE-1098B</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	8 of 9

<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>	
7	P2  Y-Taping (Continuation)	<div></div> <div></div> <div></div> <div></div> <div></div>			<div></div> <div></div>		<div><p>1. No loose tape</p><p>2. No flip-out tape</p><p>3. No peel-off tape</p><p>4. No wrong use of tape</p><p>5. No wrong dimension-out tape</p><p>6. No exposed wire</p><p>7. No gap between tubes</p><p>8. Follow the connector facing</p></div> <div><p><b>Document reference/s:</b></p><p>1. Refer to <b>WI-PRO-ASY-001C</b> for <b>taping procedure (special)</b>.</p></div> <div><p><b>Important reminders/Note/s:</b></p><p>1. Use <b>yellow tape</b> for easy visualization of tape shifting, but actual should be <b>BLACK TAPE</b>.</p><p>2. Please use calibrated/verified measuring tape when getting the measurement.</p></div> <div></div>

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**October 15, 2024**

Model code/Part number:

**177D / 7L0128-7020B**

Customer:

**TRQSS**

Car Model:

**TOYOTA-COROLLA**

Document No.:

**WI-ENG-PDE-1098B**

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

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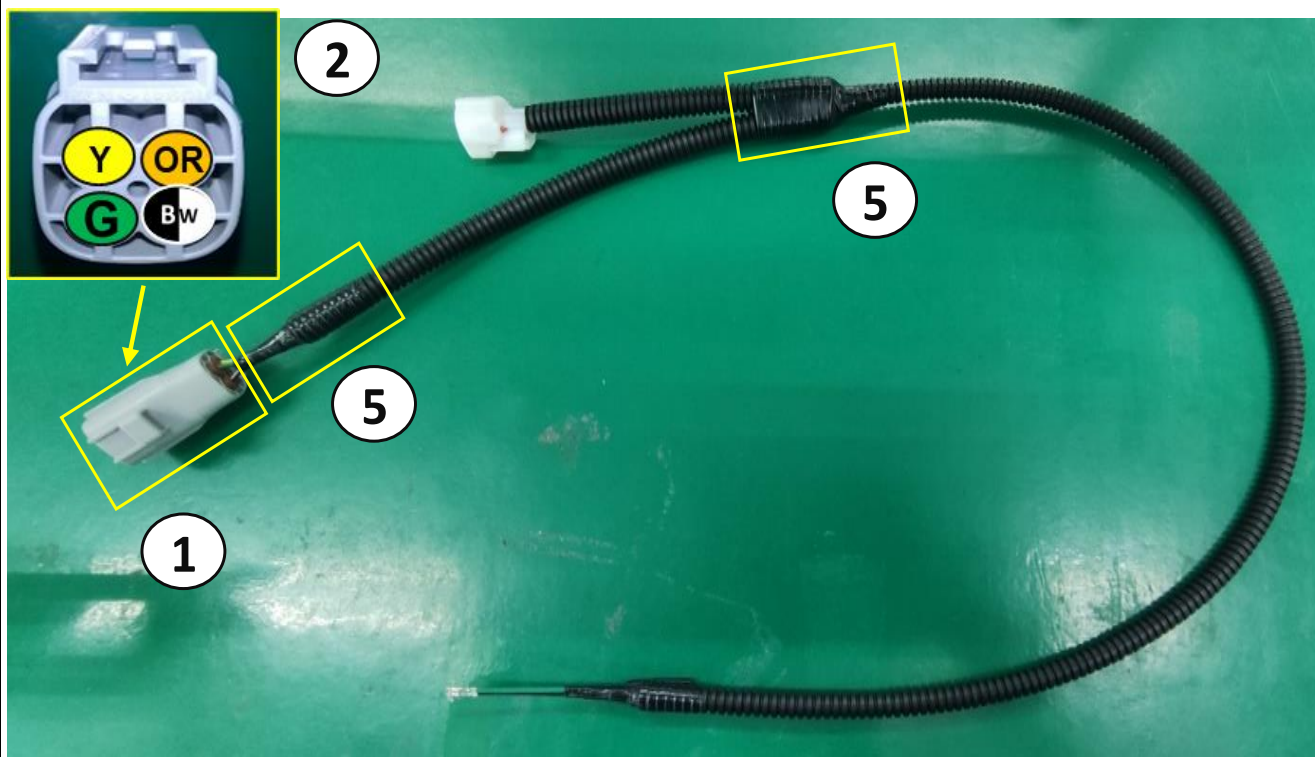
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P2****7L0128-7020B**

- ① No **Unlocked/ Half-locked connector**
- ② No **Wrong Insert**
- ③ No **Deformed terminal**
- ④ No **Terminal backing out**
- ⑤ No **Missing Tape**
- ⑥ No **Wrong connector orientation (Y-taping)**

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