

	WORK INSTRUCTION					Effectivity Date:		September 25, 2024		
	TAPING ASSEMBLY PROCESS					Validity Date:		n/a		
	Process Name/Title:		Model code/Part number: 400B / 7M0597-7020B		Customer: TRJ	Car Model: TOYOTA-VITZ	Document No.:		WI-ENG-PDE-078A	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		9	Page No.:	1 of 4	

PARTS:	1. Assy parts; Black SV tube (Vinyl) ø4 L=97±3mm; Black tape					JIG:	1. Terminal cover jig					
NO.	PROCESS NAME	<div style="border: 1px solid black; padding: 2px; display: inline-block;">9</div> WORK PROCEDURE/ ILLUSTRATION					TOOLS/PPE	QUALITY POINTERS				
1	P1	<div style="text-align: center;"> TABLE LAY-OUT </div>					<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px solid red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	<div style="margin-bottom: 20px;"> Document references: 1. Refer to WI-ENG-PDE-256 for Offline Assembly process </div> <div> 1. No missing parts/tools 2. No excess parts/tools </div>				


Revision History								Prepared by		Reviewed by		Approved by		Noted by	
09/25/24	9	Separate Y-taping process and Measurement to P2. Improved Table lay-out and Visual inspection/Quality check points.	D.Castillo	C. Villanueva	A. Arañes	n/a				<div style="display: flex; justify-content: space-between;"> Est. Date: May 04, 2021 n/a </div>					
02/17/23	8	Improve Work procedure/Illustration on process no.3 Taping 1: VT to wire near terminal; Additional notes as countermeasure for deformed terminal. Standardized description: Black SV tube (Vinyl).	M. Ariola	J. Loterte	C. Villanueva	A. Arañes									
01/20/23	7	Inclusion of Batching quantity [18pcs] as countermeasure for audit findings; Table 1 and Table 2 in process name Inclusion of Quality checkpoint on page no.7	D.Castillo	J. Loterte	C. Villanueva	A. Arañes									
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted									





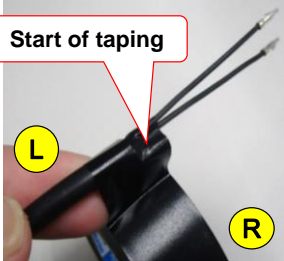


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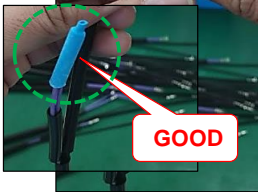
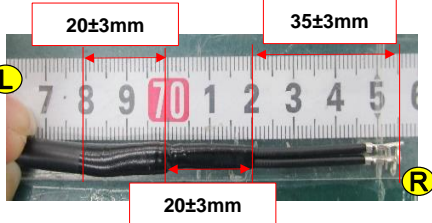
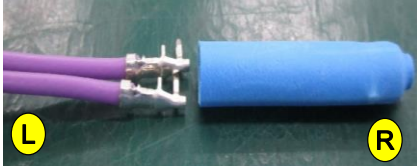


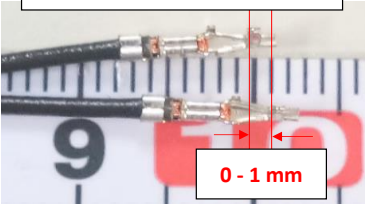
PARTS:	1. Assy parts 2. Black SV tube (Vinyl) $\phi 4$ L=97 \pm 3mm 3. Black tape			JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Black SV tube (Vinyl) $\phi 4$ L=97 \pm 3mm	 <p>1. Get the Black SV tube (Vinyl) $\phi 4$ L=97\pm3mm using right hand then insert the B-B wires using left hand.</p>  <p>$\phi 4$ L=97\pm3mm</p>		n/a	1. No wrong use of parts 2. No deformed terminal
3	P1 Taping 1 Black SV tube (Vinyl) to wire near terminal	 <p>1. Get the terminal cover jig using right hand then insert to V-V wires.</p>  <p>2. Hold the Black SV tube (Vinyl) using left hand and measure from end of Black SV tube (Vinyl) up to the terminal pointed tip 55\pm3mm.</p>  <p>3. Hold the assy parts using left hand, get the Black tape and conduct pre-taping between Black SV tube (Vinyl) and wire using right hand. Note: No need to fold Black SV tube (Vinyl) since its $\phi 4$.</p>		 <p>TERMINAL COVER JIG</p>  <p>MEASURING TAPE</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 wrong use of tape 7. No scratch on tube Important reminder/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. During taping of VT to wire make sure that operator's hands are not hitting the terminal of violet wire to avoid deformed terminal. Document references: 1. Please refer to WI-PRO-ASY-001 for taping procedure.

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	9	Page No.:	3 of 4

PARTS:	1. Assy parts 2. Black tape			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
4	P1 Taping 1 SV tube (Vinyl) to wire near terminal (Continuation)	<div>NO GOOD</div> <div>GOOD</div> <div></div> <div></div> <div>NOTE: During taping of VT to wire make sure that operator's hands are not hitting the terminal of violet wire to avoid deformed terminal.</div> <div>4. After taping, check the measurement, wire alignment and taping condition.</div> <div>5. Remove the terminal cover jig using right hand.</div>	<div>TERMINAL COVER JIG </div> <div>MEASURING TAPE </div>	<div>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 wrong use of tape 7. No scratch on tube</div> <div>Important reminder/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document references: 1. Please refer to WI-PRO-ASY-001 for taping procedure.</div> <div>Wire alignment tolerance 0 - 1 mm</div>	

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Effectivity Date:

September 25, 2024

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n/aModel code/Part number: **400B / 7M0597-7020B** Customer: **TRJ** Car Model: **TOYOTA-VITZ**

Document No.:

WI-ENG-PDE-078APurpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

9

Page No.:

4 of 4**PARTS:**

1. Assy parts

JIG:

n/a**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P1****7M0597-7020B****1** No Missing Tape(Black Tape)

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