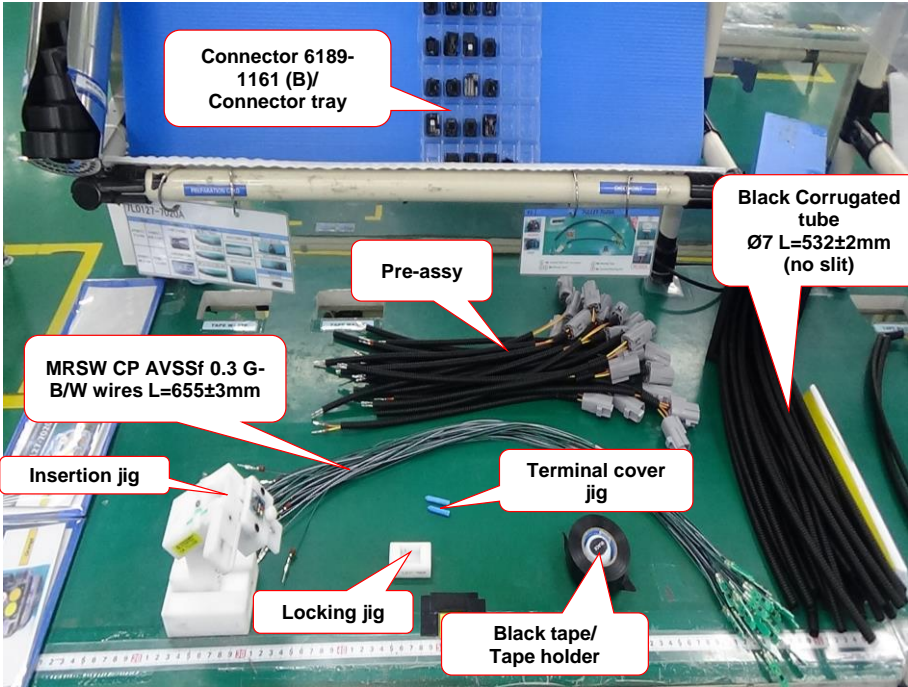
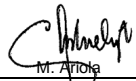

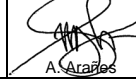
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	TAPING ASSEMBLY PROCESS				Validity Date:		-		
	Process Name/Title:		Model code/Part number: 177D / 7L0127-7020B		Customer: TRQSS		Car Model: TOYOTA-COROLLA		
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.:		WI-ENG-PDE-1046A		
				Revision No.:		1		Page No.:	1 of 8

PARTS:		1. Connector 6189-1161 (B); Black Corrugated tube Ø5 L=286±3mm (no slit); Black Corrugated tube Ø7 L=532±2mm (no slit); MRSW CP TVSSf 0.3 G-B/W wires L=655±3mm; Black tape				JIG:		1. Insertion jig 2. Locking jig 3. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	P1	<div>TABLE LAY-OUT</div> 				<div>Safety Instruction</div> <p>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>		<div>Document reference/s:</div> <p>1. Refer to WI-ENG-PDE-587 for Offline Assembly Process 2. Refer to WI-PRO-KIT-005 for Wire taping without Vinyl tube 3. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</p>	

Revision History						Prepared by		Reviewed by		Approved by		Noted by	
09/17/24	1	Change Purpose from Pre-launch to Masspro.				M. Ariola	C. Villanueva	A. Arañes	n/a				
09/10/24	0	Initial issue.				M. Ariola	C. Villanueva	A. Arañes	n/a				n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:		September 10, 2024	

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177D / 7L0127-7020B

Customer:

TRQSS

Car Model:

TOYOTA-COROLLA

Validity Date:

-

Purpose:



PROTOTYPE



PRE-LAUNCH



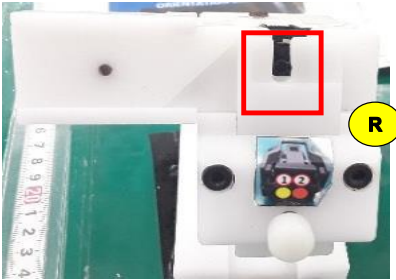
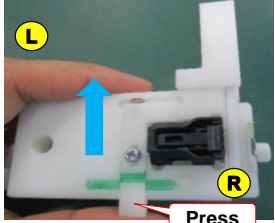
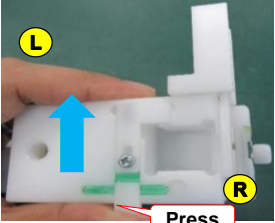
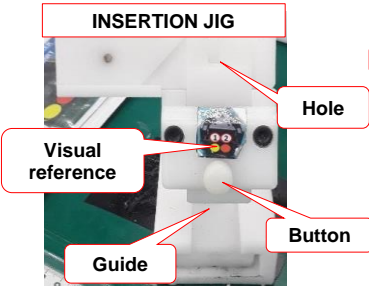
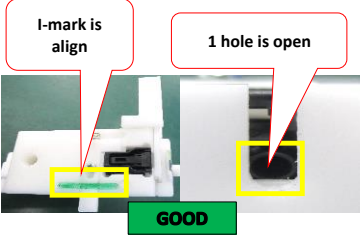
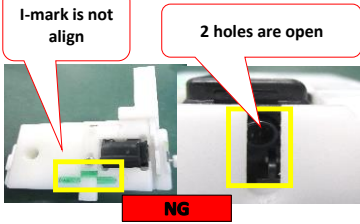
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PARTS:		1. Connector 6189-1161 (B)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1 Connector setting to insertion jig 6189-1161 (B)	<div><div></div><div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Get the connector 6189-1161 (B) using right hand and insert to insertion jig. Release the lock after insertion.</p><p>3. Push the lower wire guide upward using left thumb. Slot for Yellow wire will be opened.</p></div></div>		n/a	<div><p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p><p>CONNECTOR ORIENTATION ILLUSTRATION</p><div><p>GOOD</p></div><div><p>NG</p></div></div>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

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177D / 7L0127-7020B

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Car Model:

TOYOTA-COROLLA

Purpose:



PROTOTYPE



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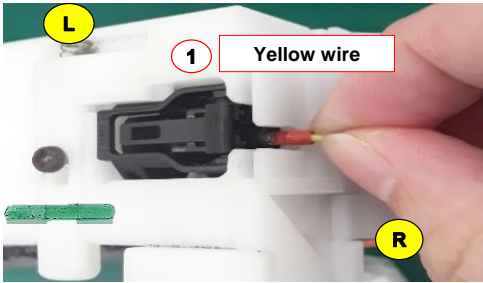
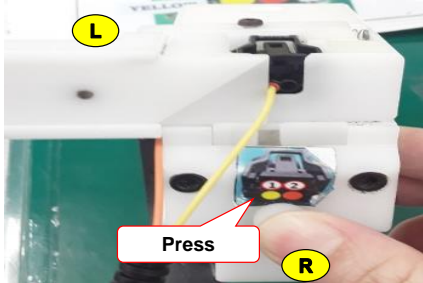
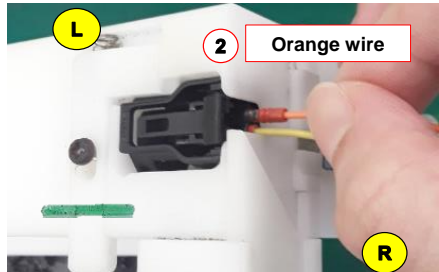
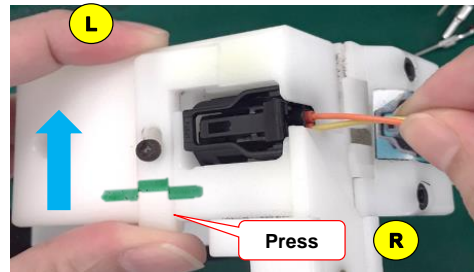
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PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to connector 6189-1161 (B)	<div><p>WIRE FACING</p></div> <div><p>1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot 1 using right hand.</p></div> <div><p>2. Press the button using right thumb. The slot for Orange wire will be opened.</p></div> <div><p>3. Get the Orange wire then insert to terminal slot 2 using right hand.</p></div> <div><p>4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div>	n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>Important reminders/Note/s: 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force</div> <div>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance. 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure</div>

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Car Model:

TOYOTA-COROLLA

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PROTOTYPE



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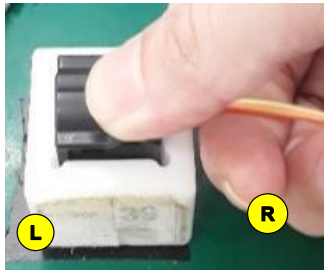
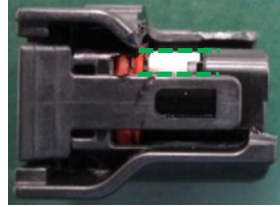
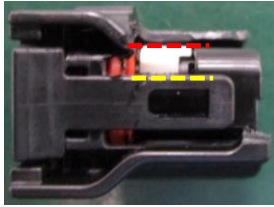
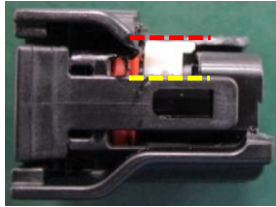


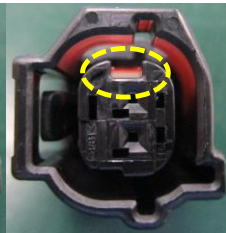
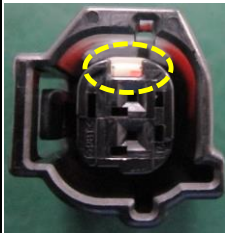
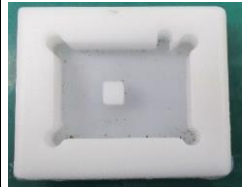
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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	<div><p>1. Put the connector into locking jig and push down 2x using both hands. Check the connector lock if properly locked.</p></div> <div><p>BEFORE PRESSING AFTER PRESSING GOOD NO GOOD UNLOCK CONDITION HALF LOCKED CONDITION FULLY LOCKED CONDITION</p></div>		<div><div>LOCKING JIG</div></div>	<p>1. Use the provided locking jig per model 2. No unlock/half-locked connector 3. No damaged lock</p> <p>Important reminders/Note/s:</p> <p>1. Manual locking may cause damaged connector lock.</p> <p>2. Set aside the assy parts</p>

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

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177D / 7L0127-7020B

Customer:

TRQSS

Car Model:

TOYOTA-COROLLA

Document No.:

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Purpose:



PROTOTYPE



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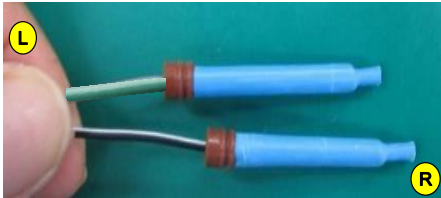


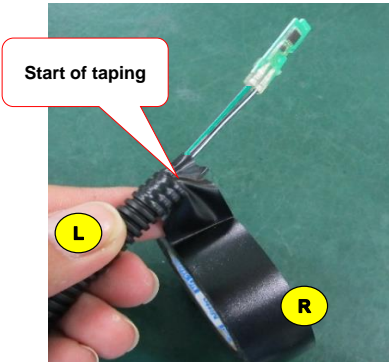

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PARTS:		1. MRSW CP TVSSf 0.3 G-B/W wires L=655±3mm 2. Black Corrugated tube Ø7 L=532±2mm (no slit)		3. Assy parts 4. Black tape	JIG:	1. Terminal cover jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1	Wire insertion to Black Corrugated tube Ø7 L=532±2mm (no slit)	<div></div> <div>1. Get the MRSW CP TVSSf 0.3 G-B/W wires L=655±3mm using left hand, then get the terminal cover jig using right hand then insert to both terminals (G-B/W wires) using right hand.</div> <div></div> <div>2. Get the corrugated tube Ø7 L=532±2mm using right hand then insert the G-B/W wires using left hand. After insertion, remove the cover jig using right hand.</div>		<div>TERMINAL COVER JIG</div> 	1. No wrong usage of parts 2. No damaged rubber seal Important reminders/Note/s: 1. Refer to WI-PRO-CNC-017 for the Wire and Strip length tolerance.
6		Taping 1 Black corrugated tube to wire near PCB	<div></div> <div>1. Hold the assy parts using left hand, get the Black tape then conduct pre-taping using both hands.</div>		<div>MEASURING TAPE</div> 	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 Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.

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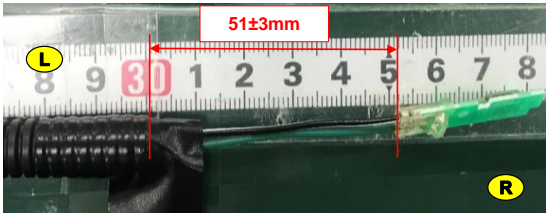
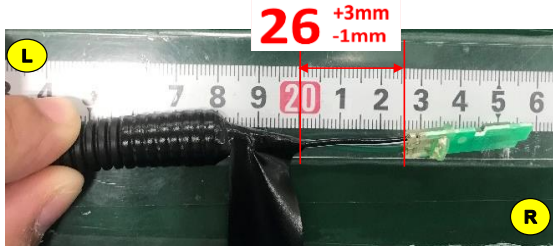
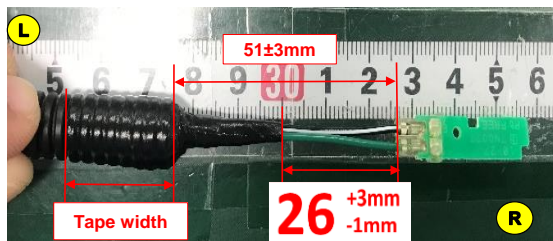

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1 Taping 1 Black corrugated tube to wire near PCB (Continuation)	 <p>2. Measure from end of COT up to edge of hot melted wires 51±3mm then continue the taping process using both hands.</p>  <p>3. Confirm measurement of 26 (+3/-1mm) from end of tape up to edge of PCB then continue the taping process using both hands.</p>  <p>4. After taping, check the measurement and taping condition.</p>		<div>MEASURING TAPE</div> 	<p>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</p> <p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p>

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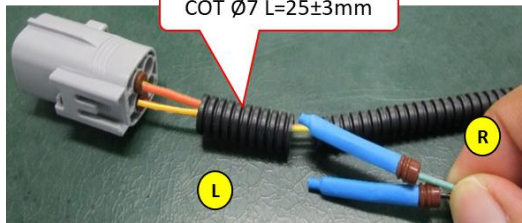
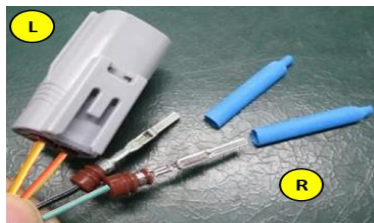

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PARTS:		1. Assy parts		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1	<div><div></div><div></div><div></div></div> <div>Wire insertion to COT (no slit) Ø7 L=25±3mm (Assy parts)</div> <div>COT Ø7 L=25±3mm</div> <div>1. Get the MRSW CP G-B/W wires L=655±3mm using both hands then insert the terminal cover jig using right hand.</div> <div>2. Get the assy parts then hold the COT (no slit) Ø7 L=25±3mm using left hand then insert the MRSW CP G-B/W wires L=655±3mm using right hand.</div> <div>3. After insertion, remove the cover jig using right hand.</div>		<div>TERMINAL COVER JIG</div> 	1. No wrong usage of parts 2. No damaged rubber seal 3. No exposed rubber seal during insertion

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PARTS:

JIG:

n/a

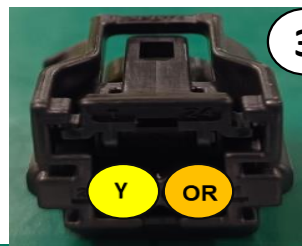
VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING - P1

7L0127-7020B



2



3

1

No Unlocked /Half-locked Connector

2

3

No Wrong Insert

4

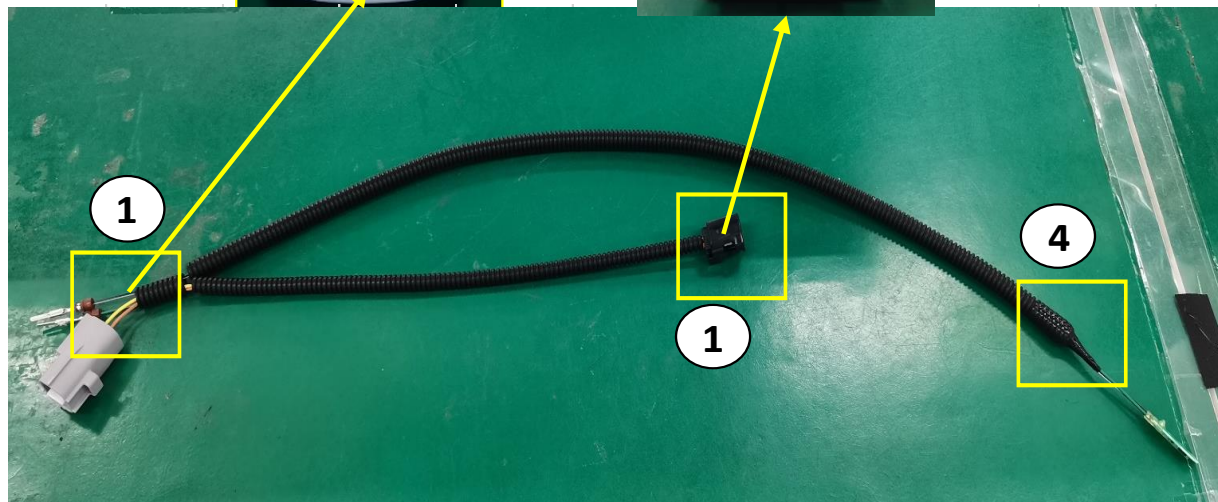
No Missing Tape

5

No Deformed Terminal

6

No Terminal Backing out



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