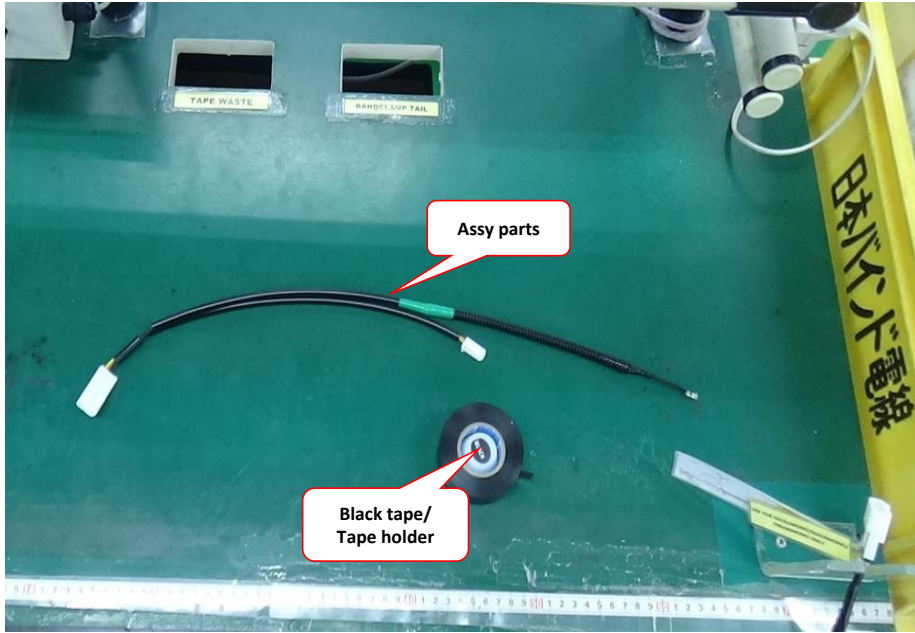
	WORK INSTRUCTION			Effectivity Date:	May 29, 2024		
	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Process Name/Title:			Document No.:	WI-ENG-PDE-453C		
	Model code/Part number: 990B / 7N0142-7020A		Customer: TRJ	Car Model: TOYOTA-PRIUS	Revision No.: 0 Page No.: 1 of 5		
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO							

PARTS:		1. Assy parts; Black tape			JIG:		n/a						
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS					
1	P3	<div>Table Lay-out</div> 				<div><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		1. No missing parts/ tools. 2. No excess parts/ tools.					
Revision History				Prepared by		Reviewed by				Approved by		Noted by	
05/29/24	0	Initial issue. Split type process from P2 Y-taping transfer to P3.				A.Hernandez		C. Villanueva		A.Arañes		n/a	
Eff. Date	Rev. No	Details of Change				Revised		Reviewed		Approved		Noted	
						Est. Date:		May 29, 2024					

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## WORK INSTRUCTION

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Document No.:

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Purpose:



☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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0

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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	P3  Y-Taping	<div><p>No gap between the vinyl</p><p>1. Fix the vinyl tube using both hands.</p><p>Pre-taping.</p><p>2. Hold the SV tube (Vinyl) using left hand and start <b>pre-taping</b> using right hand.</p><p>taping direction</p><p>1/3 shifting</p><p>25±3mm</p><p>1/3 shifting</p><p>taping direction</p><p>3. After pre-taping, make <b>1/3 shifting</b> to the left until tape width. Wind the tape <b>2x</b> before shifting to the right side.</p></div>		<div>Measuring tape</div> 	<p><b>Important reminders/Note/s:</b></p> <p>1. Please use <b>clibrated verified measuring tape</b> when getting the measurement.</p> <p>2. Use <b>YELLOW TAPE</b> for easy visualization of tape shifting, but actual should be <b>BLACK TAPE</b>.</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p>

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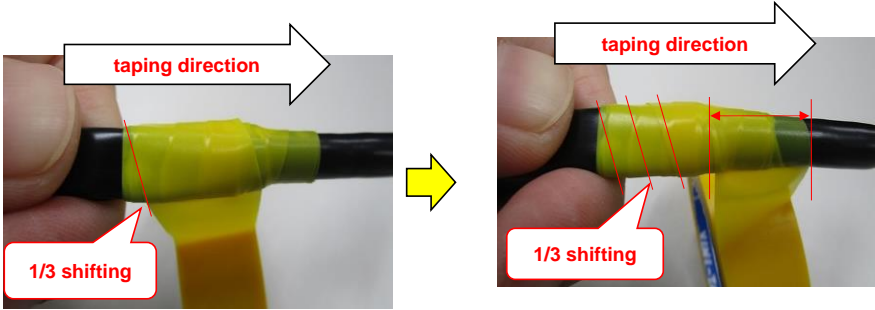
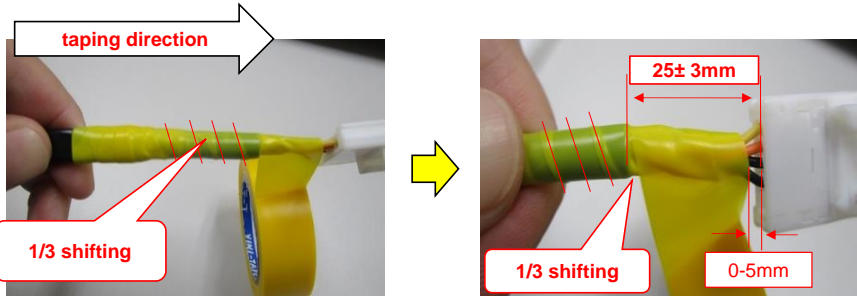

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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0

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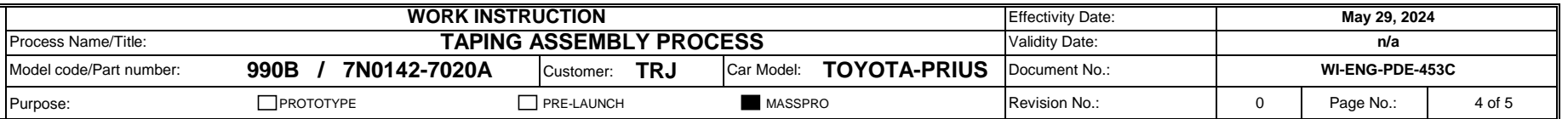
3 of 5

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P3 Y-Taping (Continuation)	 <p>4. Make <b>1/3 shifting</b> going to the right side.</p>  <p>5. Make <b>1/3 shifting</b>, cover the SV tube (Vinyl) and wire. Measure vinyl tube up to connector <b>25± 3mm</b> then make <b>3 winds</b> in wire before cutting of tape. <b>Note: No folding of SV tube (Vinyl) .</b></p>		<b>Measuring tape</b> 	<b>Important reminders/Note/s:</b>  <b>1. Please use calibrated verified measuring tape when getting the measurement.</b> <b>2. Use YELLOW TAPE for easy visualization of tape shifting, but actual should be BLACK TAPE.</b>  1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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PARTS:

n/a

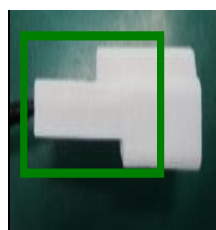
JIG:

n/a

### VISUAL INSPECTION/QUALITY CHECKPOINTS

P3

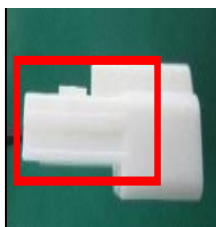
7N0142-7020A



GOOD



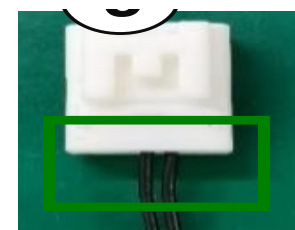
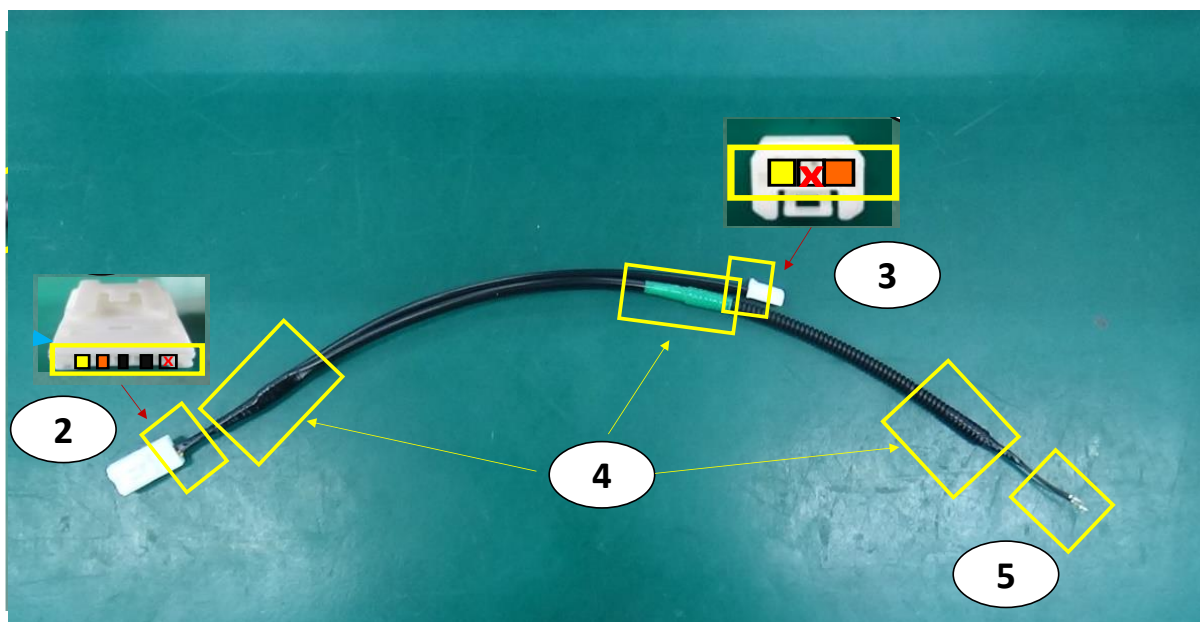
GOOD



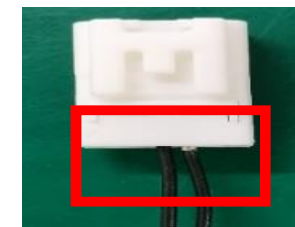
NO GOOD



NO GOOD



GOOD



NO GOOD

1 No Unlock / Halflock Connector

2 3 No Wrong Insert

4 No Missing / Wrong used of tape

5 No Defomed Terminal

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