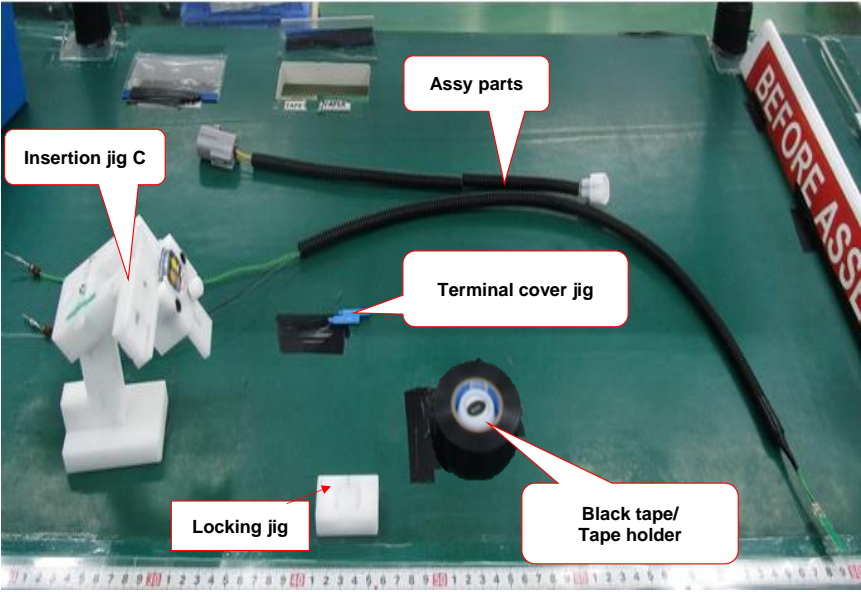



	<b>WORK INSTRUCTION</b>				Effectivity Date: <b>July 18, 2024</b>	
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date: <b>n/a</b>	
	Model code/Part number: <b>178D / 7N0129-7021A</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-COROLLA</b>	Document No.: <b>WI-ENG-PDE-463B</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.: <b>4</b> Page No.: <b>1</b> of <b>9</b>	


<b>PARTS:</b> 1. Assy parts; Black tape [1pc.]		<b>JIG:</b> 1. Insertion jig      3. Terminal cover jig 2. Locking jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>
1	P2 Table Lay-out	<div style="text-align: center;"> <b>Table Lay-out</b> </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>


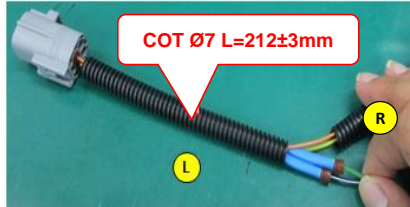
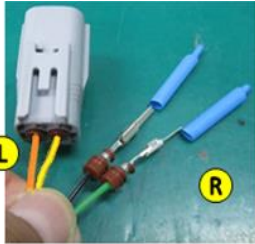

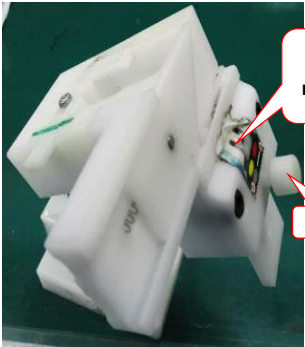
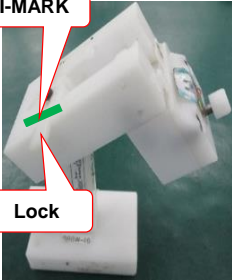
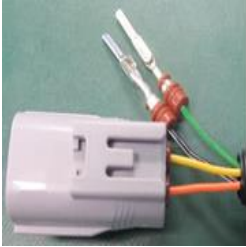
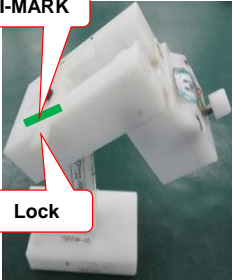
  

Revision History							Prepared by	Reviewed by	Approved by	Noted by
07/18/24	4	Inclusion of car model "TOYOTA-COROLLA" and Measurement.Improved visual inspection/quality checkpoints.	D.Castillo	C.Villanueva	A. Arañes	N/A	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
01/16/23	3	Change of COT measurement from L=214±3mm to L=212±3mm in work procedure. Change taping measurement of COT to wire near connector from L=25±3mm to L=28±2mm to eliminate peeled-off tape. Inclusion of quality checkpoints.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
09/15/22	2	Improve quality pointers: Reminders/notes and references in process no.4,5,6 and 7 due to document improvement.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
04/13/22	1	Change document purpose from Pre-launch to masspro.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted	Est. Date:	April 12, 2022	

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	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>July 18, 2024</b>					
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a					
	Process Name/Title:		Model code/Part number: <b>178D / 7N0129-7021A</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-COROLLA</b>		Document No.:	<b>WI-ENG-PDE-463B</b>		
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:	4	Page No.:

<b>PARTS:</b>	1. Assy parts			JIG:	1. Terminal cover jig 2. Insertion jig			
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
2	Wire insertion to assy parts	<div><p>1. Get the <b>MRSW CP G-B/W wires L=822±3mm</b> using both hands then insert the terminal cover jig using right hand.</p></div> <div><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>MRSW CP 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><b>TERMINAL COVER JIG</b></div> 	1. No wrong usage of parts 2. No damaged rubber seal 3. No exposed rubber seal during insertion		
3	Connector setting to insertion jig 6188-0066 (GR) (Assy parts)	<div><p><b>Visual reference</b></p></div> <div><p><b>I-MARK</b> <b>Lock</b></p></div> <div><p><b>CONNECTOR ORIENTATION</b></p></div> <div><p><b>INSERTION JIG ORIENTATION</b></p></div>			n/a	1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector		

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## WORK INSTRUCTION

Effectivity Date:

July 18, 2024

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

178D / 7N0129-7021A

Customer:

TRJ

Car Model:

TOYOTA-COROLLA

Document No.:

WI-ENG-PDE-463B

Purpose:


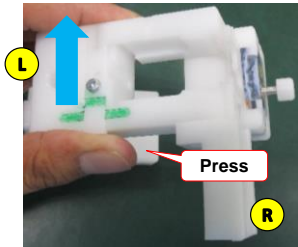
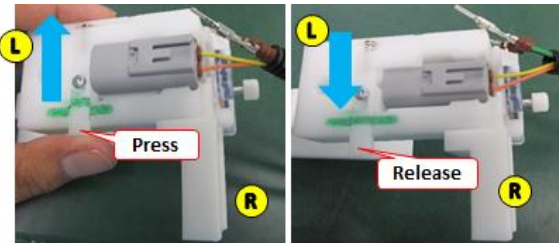
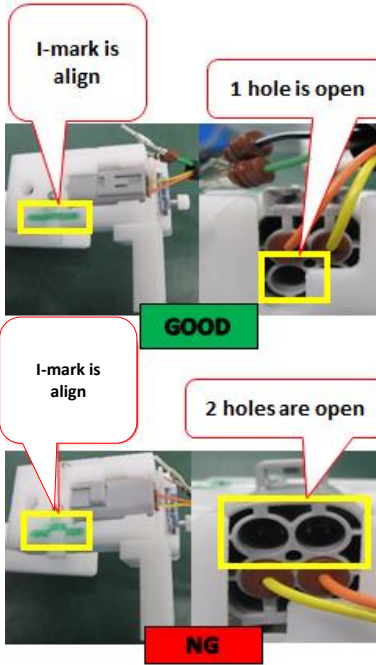
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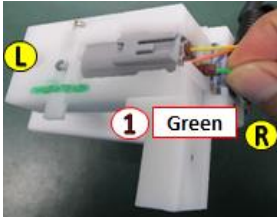

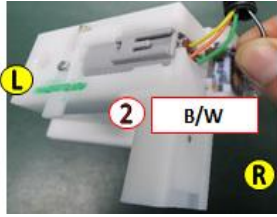
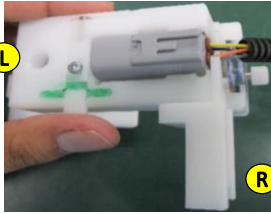

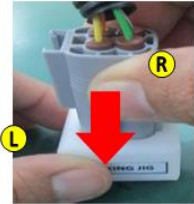
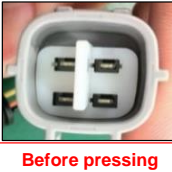
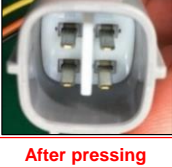










PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2  Connector setting to insertion jig 6188-0066 (GR) (Assy parts) (Continuation)	<div><p>Hole</p><p>1. Push the lower wire guide upward using right thumb. Slot for <b>Green wire</b>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

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	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>July 18, 2024</b>		
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>178D / 7N0129-7021A</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-COROLLA</b>	Document No.:	<b>WI-ENG-PDE-463B</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	4	Page No.:	4 of 9

<b>PARTS:</b>	1. Assy parts			JIG:	1. Insertion jig 2. Locking 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><p>1 Hold the <b>G wire</b> then insert to terminal slot <b>1</b> using right hand.</p></div> <div><p><b>WIRE FACING</b></p></div> <div><p>2 Press the button using right thumb. The slot for <b>B/W wire</b> will be opened.</p></div> <div><p>3 Hold the <b>B/W wire</b> then insert to terminal slot <b>2</b> using right hand.</p></div> <div><p>4. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</p></div>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <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. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</p>									
5	Connector Lock	<div><p>1. Put the connector into locking jig using both hands and then conduct <b>2x</b> pressing. Check the connector if properly locked.</p></div> <div><p><b>Before pressing</b></p></div> <div><p><b>After pressing</b></p></div> <div><p><b>Coupler Cross Sectional View</b></p><table><tr><td><b>NG</b></td><td><b>NG</b></td><td><b>GOOD</b></td></tr><tr><td></td><td></td><td></td></tr><tr><td>Unlock</td><td>Half Lock Condition</td><td>Full Lock Condition</td></tr></table></div>		<b>NG</b>	<b>NG</b>	<b>GOOD</b>				Unlock	Half Lock Condition	Full Lock Condition	<p><b>LOCKING JIG</b></p> 	<p>1. Use the provided locking jig per model 2. No unlock/half-locked connector 3. No damaged lock</p> <p><b>Important reminders/Note/s:</b></p> <p>1. <b>MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR.</b></p>
<b>NG</b>	<b>NG</b>	<b>GOOD</b>												
														
Unlock	Half Lock Condition	Full Lock Condition												


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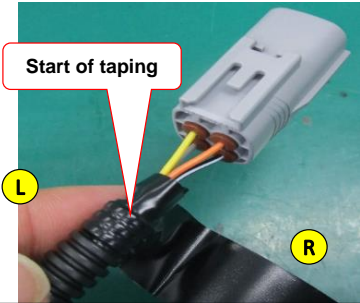
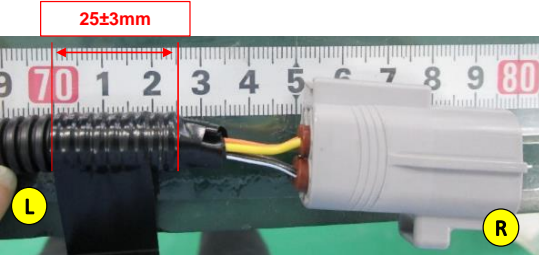
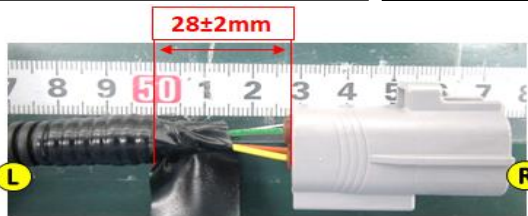
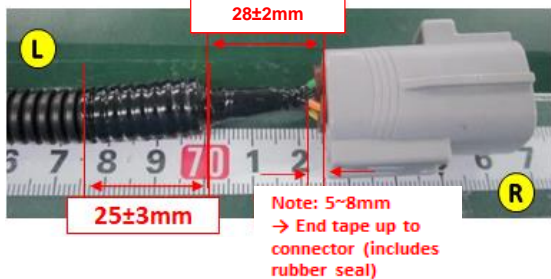

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	Process Name/Title:			Model code/Part number:	178D / 7N0129-7021A	Customer:	TRJ	Car Model:	TOYOTA-COROLLA	Document No.:	WI-ENG-PDE-463B	
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:	4	Page No.:	5 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>	
6	P2 Taping 1 Black corrugated tube to wire near connector	<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>28±2mm</b> then continue the taping process using both hands.</p></div> <div><p>3. After taping, check the measurement and taping condition.</p><p>Note: 5~8mm → End tape up to connector (includes rubber seal)</p></div>		<div><b>Measuring tape</b></div> 	<p><b>Important reminders and 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. Refer to WI-PRO-ASY-001 for taping procedure.</p> <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>	


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	Process Name/Title:		Model code/Part number: <b>178D / 7N0129-7021A</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-COROLLA</b>		Document No.:	<b>WI-ENG-PDE-463B</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO		Revision No.:	4	Page No.:

<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><div>No gap between Corrugated Tubes</div><div><div><div>L</div><div>R</div></div><div>1. Fix the corrugated tube</div></div><div><div>Note: Do not exert excessive force during pulling &amp; winding of tape</div><div><div>tape shifting 1/3 below</div><div>taping direction</div></div></div><div><div>30±3mm</div><div>3. Confirm 30±3mm measurement from end of tape up to end of corrugated tube then continue the taping process using both hands.</div></div></div><div><div>Measuring tape</div></div></div>	<div><div><b>Important reminders/Note/s:</b></div><div>1. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines, but actual should be <b>BLACK TAPE</b>.</div><div>2. Please use calibrated/verified measuring tape when getting the measurement.</div><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</div></div>	

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## WORK INSTRUCTION

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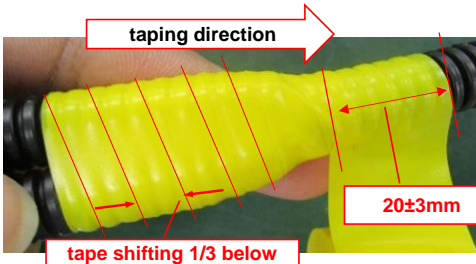
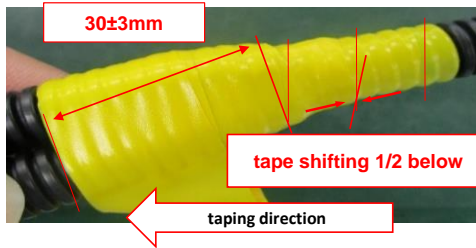
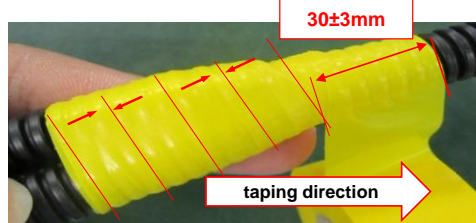
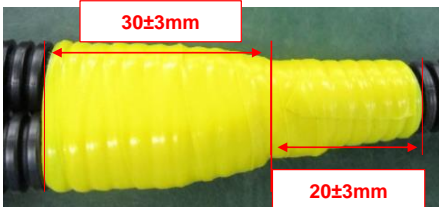

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P2 Y-Taping (Continuation)	 <p>4. Wind the tape <b>1/3 shifting</b> until it reach the other side of corrugated tube (must be tape width).</p>  <p>5. Make <b>2 windings</b> of tape then wind <b>1/2 shifting</b> going to other side.</p>  <p>6. Make <b>2 windings</b> of tape then wind the tape <b>1/2 shifting</b> going to other side of corrugated tube then make <b>3 windings</b> of tape and cut.</p>  <p>7. After taping, check the measurement and tape condition.</p>			<p><b>Important reminders/Note/s:</b></p> <p>1. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines, but actual should be <b>BLACK TAPE</b>.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <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>

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**TAPING ASSEMBLY PROCESS**

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**178D / 7N0129-7021A**Customer: **TRJ**Car Model: **TOYOTA-COROLLA**

Document No.:

**WI-ENG-PDE-463B**

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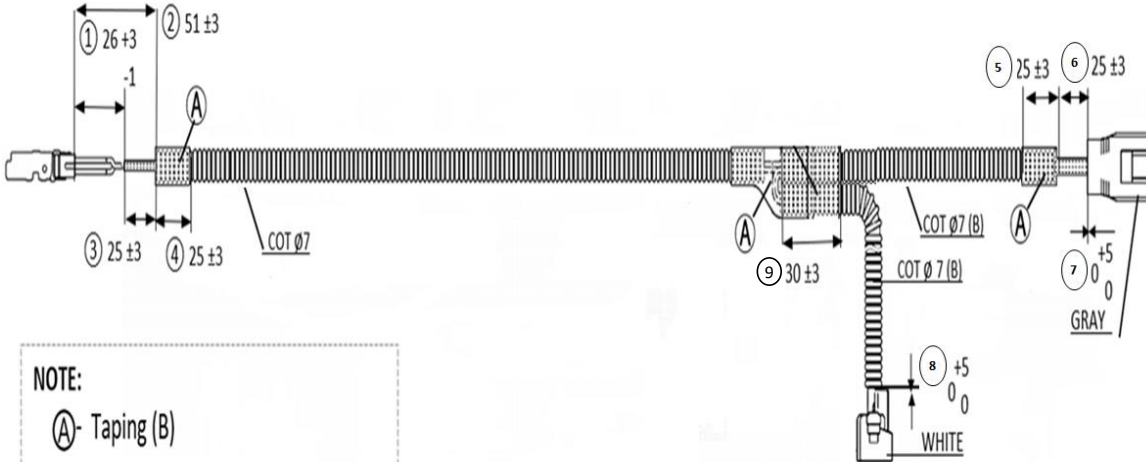

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PARTS:		1. Assy parts 2. Black tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P2 <div>4</div>	<div>Measurement</div> <div></div> <div>NOTE: A- Taping (B)</div>	<div>MEASURING TAPE</div> <div></div>	<div>Important reminders/Note/s:</div> <div>1. FOR <b>HATSUMONO</b> AND <b>OWARIMONO</b>.</div> <div>2. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection.</div> <div>1.No wrong dimension</div>

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# WORK INSTRUCTION

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## TAPING ASSEMBLY PROCESS

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Purpose:

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PARTS:

1. Assy parts

JIG:

n/a



### VISUAL INSPECTION/ QUALITY CHECKPOINTS

P2

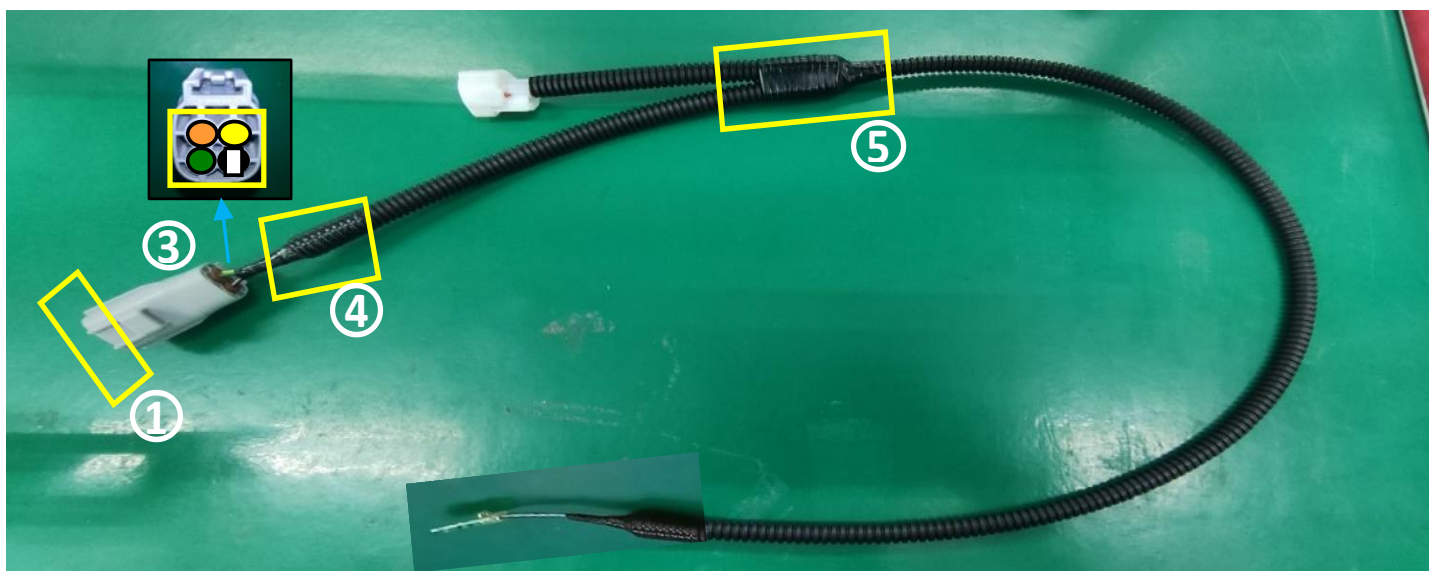
7N0129-7021A



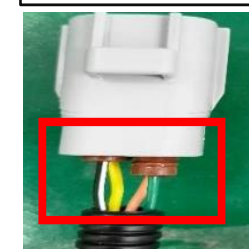
NO GOOD



GOOD



GOOD



NO GOOD

① No Unlock/ Half Lock Connector

② No Wrong Insert

③ ④ No Missing Tape

⑤ No Terminal Backing Out

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