

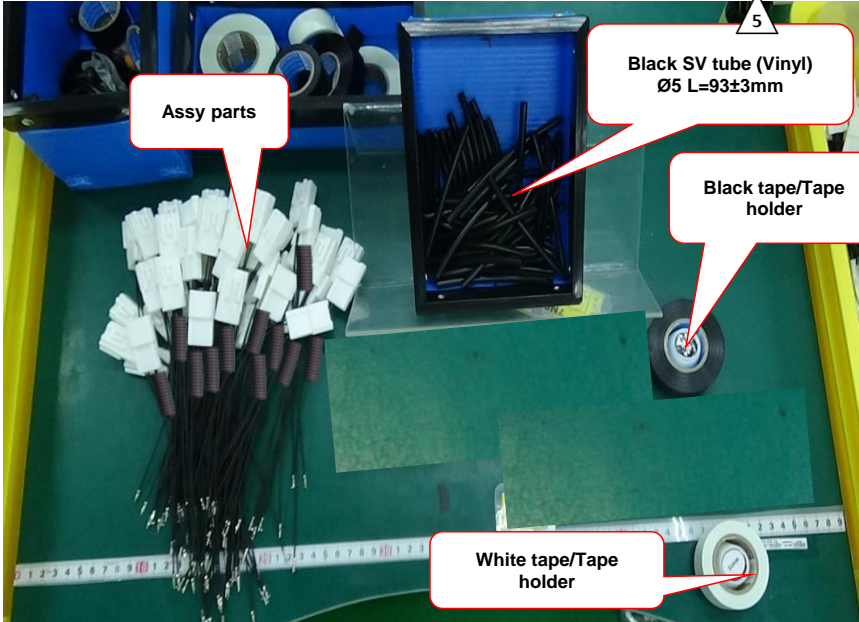
	WORK INSTRUCTION					Effectivity Date:		May 22, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS					Validity Date:		n/a		
	Model code/Part number: 150B / 7N0003-7023		Customer: TRMX	Car Model: TOYOTA COROLLA		Document No.:		WI-ENG-PDE-052		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		5	Page No.:	1 of 7	

PARTS: 		1. Assy parts; Black SV tube (Vinyl) Ø5 L=93±3mm; White tape/Tape holder				JIG:		n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	P1  Table Lay-out	<div>TABLE LAY-OUT</div> 				<div>Safety Instruction</div> <p>Be sure to wear prescribed 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>		1. No missing parts/tools 2. No excess parts/tools	


Revision History						Prepared by		Reviewed by		Approved by		Noted by	
05/22/24	5	Inclusion of all improvements Table lay-out; important reminders and note/s; Document references; Visual inspection. Transfer Wire insertion to black corrugated tube process to Offline assembly process due to process improvement. Change term from Vinyl tube to SV tube (Vinyl). Inclusion of Car model "TOYOTA-COROLLA". Improved Measurement process.				D.Castillo	C. Villanueva	A. Arañes	n/a				
07/13/21	4	Revised due to removal of marking in process.				M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
03/22/21	3	Update pictures and apply some improvements.				M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	October 17, 2018		





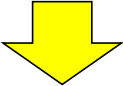
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PARTS: 		1. Assy parts 2. Black SV tube (Vinyl) Ø5 L=93±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	<div> P1</div> Wire insertion to Black SV tube (Vinyl) Ø5 L=93±3mm	<div><div>1. Get Black SV tube (Vinyl) Ø5 L=93±3mm using right hand then insert the B-B wires.</div></div>		n/a	1. No wrong usage of parts 2. No deformed terminal


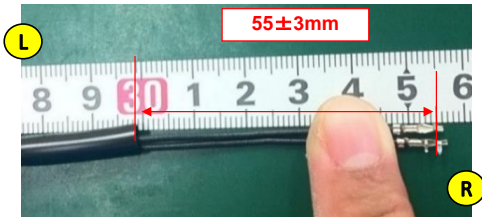
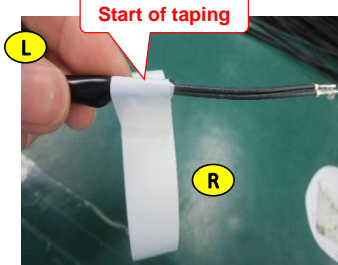
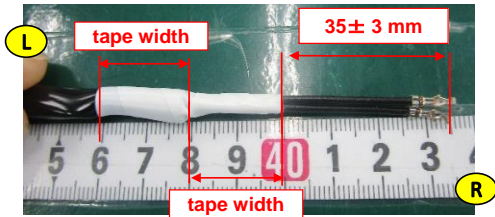

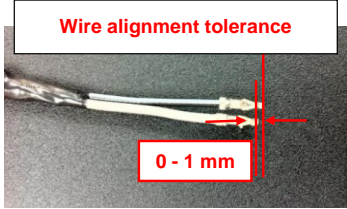
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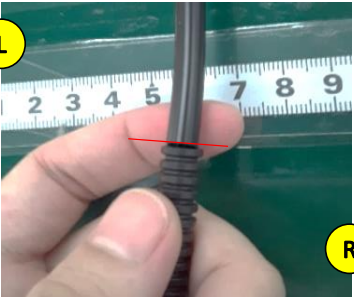
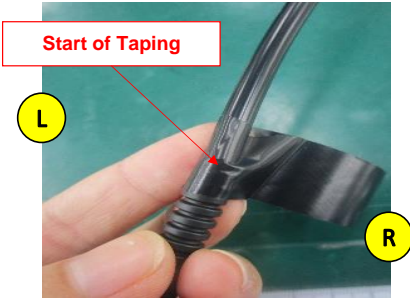
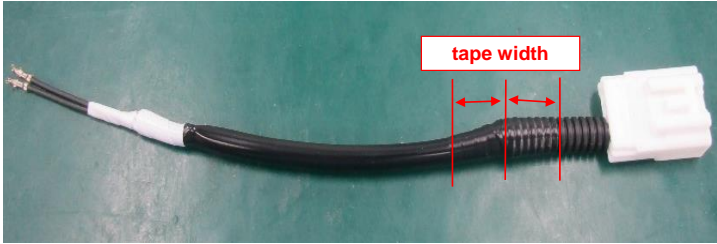

PARTS:	1. Assy parts 2. White tape			JIG:	n/a			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
3	P1 <div> Taping 1 Black SV tube (Vinyl) to wire near terminal</div>	<div></div> <div><p>1. Measure from end of the SV tube (vinyl) up to terminal tip 55±3mm using both hands.</p></div> <div></div> <div><p>2. Hold the SV tube (Vinyl) using left hand, get the White tape then start taping using both hands.</p></div> <div></div> <div><p>3. After taping, check the condition of tape, measurement and wire alignment.</p></div>			<div></div>	<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></div> <div><p>Important reminders and Note/s:</p><p>1. Please use calibrated/verified measuring tape when getting the measurement.</p><p>2. USE WHITE TAPE ONLY.</p></div> <div></div> <div><p>Document references:</p><p>1. Please refer to WI-PRO-ASY-001 for taping procedure.</p></div>		

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PARTS:	1. Assy parts 2. Black tape			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
4	P1 <div>5</div> Taping 2 Black corrugated tube to Black SV tube (Vinyl)	<div><div>L</div><div>R</div></div> <div>1. Fix the corrugated tube and Black SV tube (Vinyl) using both hands.</div> <div><div>L</div><div>R</div></div> <div>2. Get the Black tape then begin the taping process using both hands.</div> <div></div> <div>3. After taping, check the taping condition and measurement.</div>	<div>MEASURING TAPE</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> Important reminders and Note/s: <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> Document references: <div>1. Please refer to WI-PRO-ASY-001 for taping procedure.</div>	

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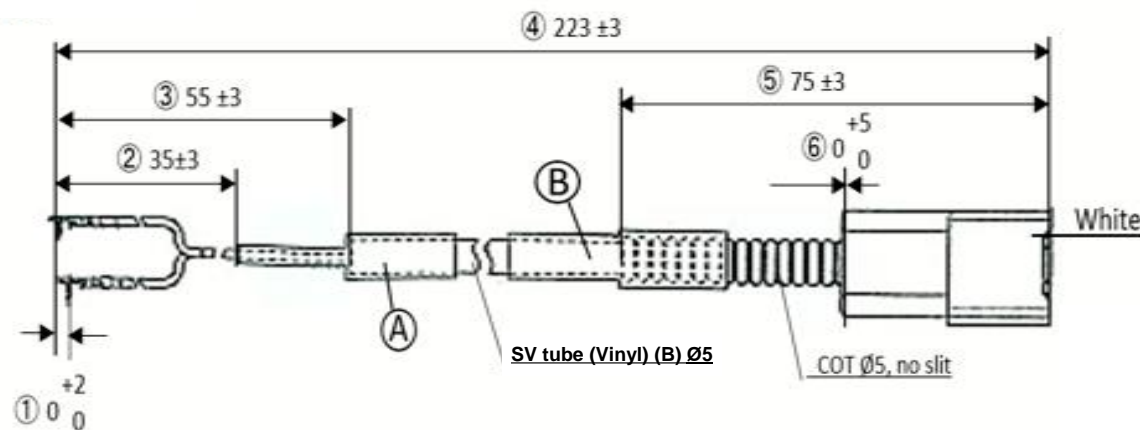
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	5 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1	Measurement	<div>MEASURING TAPE</div> 	<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>

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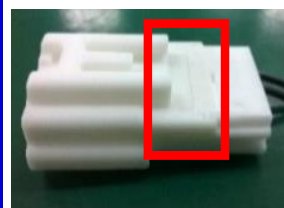
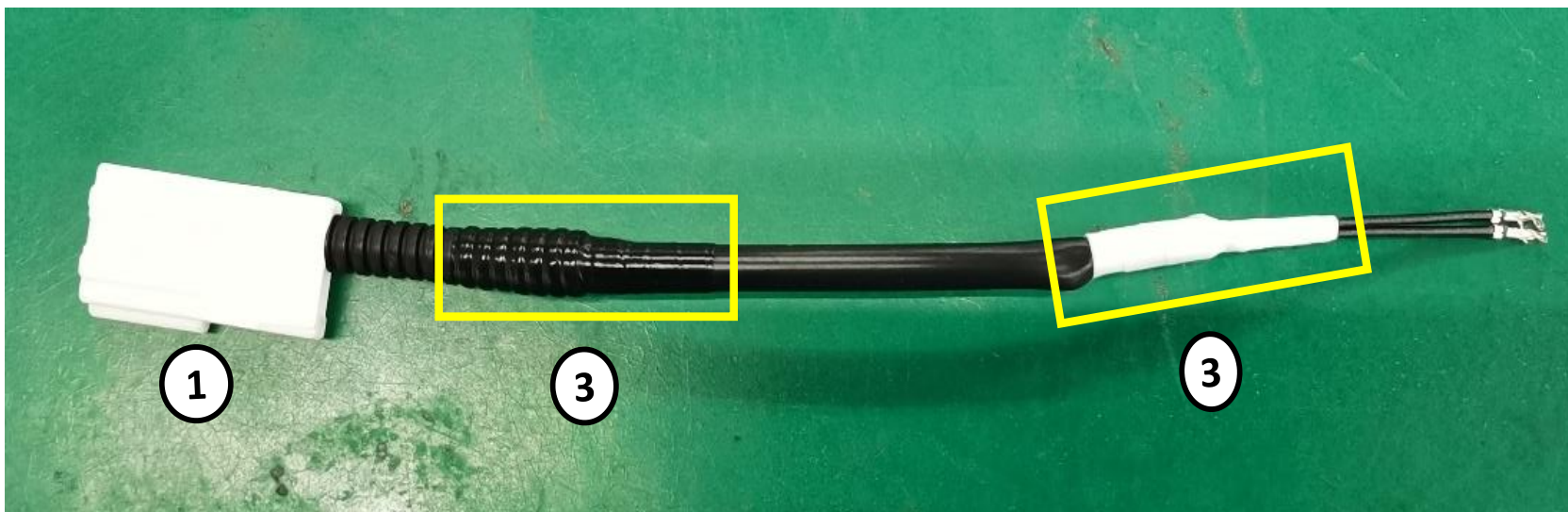
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P1****7N0003-7023****GOOD****NO GOOD****① No Deformed Terminal****② No Unlocked/Half-locked Connector****③ No Missing Tape and No Wrong use of tape**

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