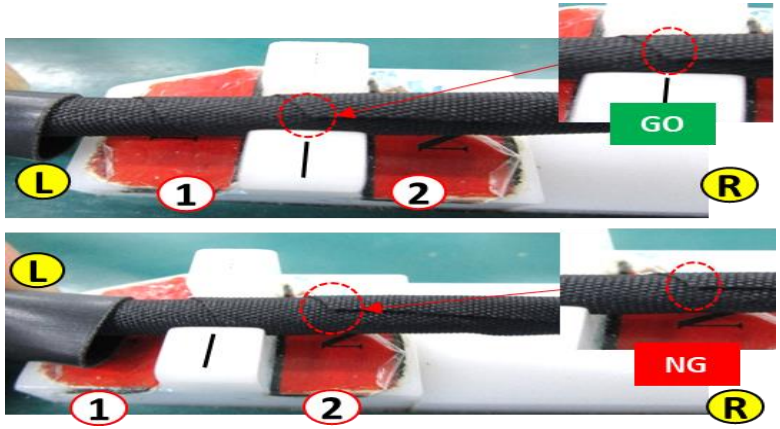
	WORK INSTRUCTION			Effectivity Date:	March 12, 2025		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 560B / 17L544-7050	Customer: TRP	Car Model: TOYOTA-INNOVA	Document No.:	WI-ENG-PDE-268F		
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	9	Page No.:	1 of 7

PARTS:	1. Assy parts	JIG:	1. Measuring jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	9 P6	HIGH Measurement	 1. After taping, check the **END POINT TAPE** using measuring jig.	**Safety Instruction** Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) **Housekeeping** 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. **Alert level** For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	***Important reminders/Note/s:*** ***1. END POINT TAPE should be within the limit GO. If end point tape reaches the location 1 and 2 it will be considered as NG.*** 1. No wrong dimension

Revision History							Prepared by	Checked by	Reviewed by	Approved by
03/12/25	9	Inclusion of Quality improvement measures (based on Mizen Boshi activity). Inclusion of Car model "TOYOTA-COROLLA/ RAV-4/ HIGHLANDER".	D.Castillo	J. Loterte	C. Villanueva	A. Arañes	D. Castillo	J. Loterte	C. Villanueva	A. Arañes
09/01/23	8	Inclusion of procedure 3, 4 and 5 on page 2 process 2.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
08/15/23	7	Update template; Inclusion of **CAR MODEL "TOYOTA-INNOVA".** Transfer process of Measurement from P5 to P6; Additional Reminders/Notes for process no. due to TPS improvements.(Please refer to ENGDRR-146 for Document revision request)	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved	Est. Date:	May 14, 2021		

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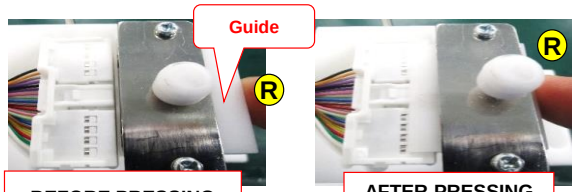
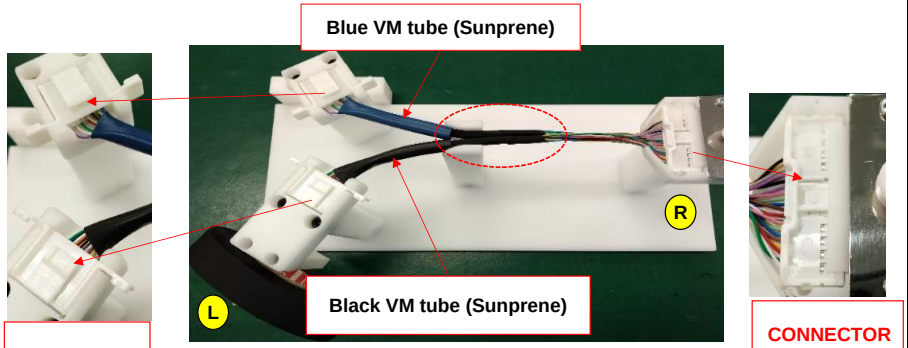
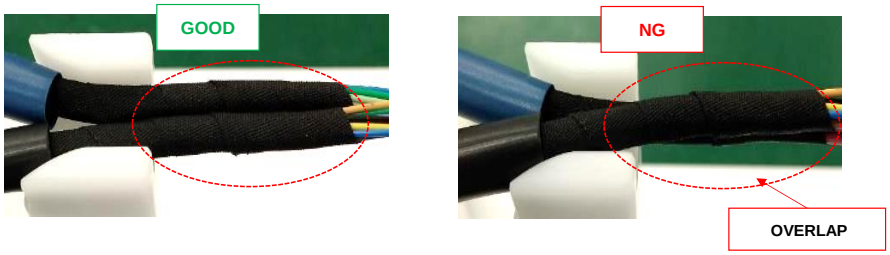
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 9	Page No.:	2 of 7

PARTS:	1. Assy parts 2. Tesa tape 51036	JIG:	1. Taping jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P6 9 **HIGH** Taping 3 Wire taping (Tesa)	 BEFORE PRESSING AFTER PRESSING 1. Set the **connector 1827842-1 (W)** then push the guide lock using right index finger.  CONNECTOR SETTING CONNECTOR SETTING 2. Continue to set the harness on Jig 2. *(See picture for the correct setting).*  	 HANDY CUTTER	1. No wrong setting of harness 2. No wrong orientation of connector 3.Wires must allign properly to avoid bend wire .

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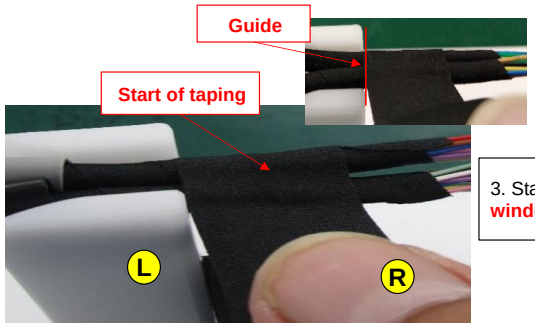
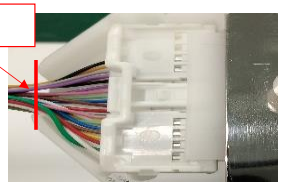
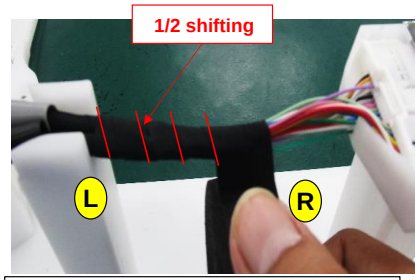
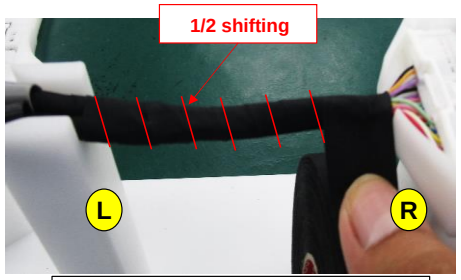
PARTS:	1. Assy parts 2. Tesa tape 51036	JIG:	1. Taping jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P6 (9) **HIGH** Taping 3 Wire taping (Tesa) (Continuation)	 3. Start taping using guide **1 1/2 winding.**   4. Make **1/2 shifting or 6-7 windings** going to the right side until it reach the guide near connector.  5. Make **2 windings** of tape before cut.	 HANDY CUTTER	1. No loose tape 2. No excessive tape winding 3. No damage on parts 4. No peel off tape 5. No bend wire 6. No NG of end tape ***Important reminders/Note/s:*** ***1. No holding/fixing of wire during taping.***

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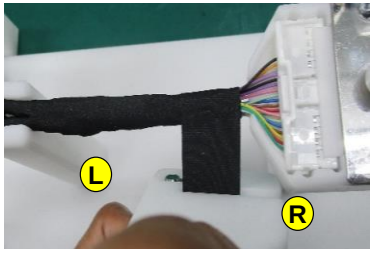
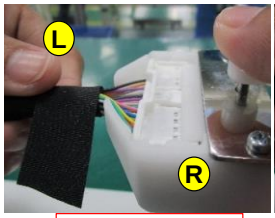
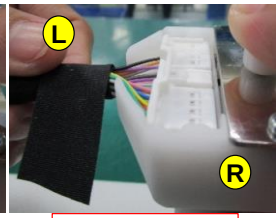
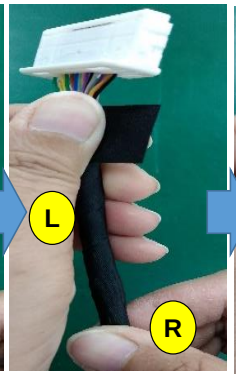
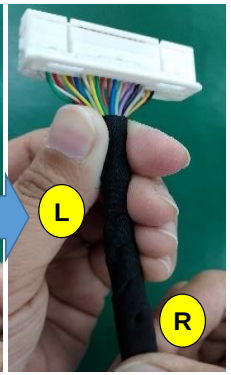
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	9	Page No.:	4 of 7

PARTS:	1. Assy parts 2. Tesa tape 51036	JIG:	1. Taping jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P6	9 **HIGH** Taping 3 Wire taping (Tesa) (Continuation)	 6. Cut the tape using provided cutter only using both hands.  BEFORE PRESSING  AFTER PRESSING 7. Hold the assy parts then press the lock button using right thumb. Remove the harness from jig.   8. Press the end tape using left hand. Do not touch the adhesive		1. No loose tape 2. No excessive tape winding 3. No damage on parts 4. No peel off tape 5. No bend wire 6. No NG of end tape

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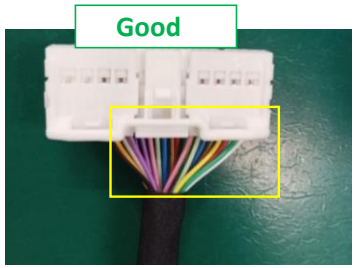
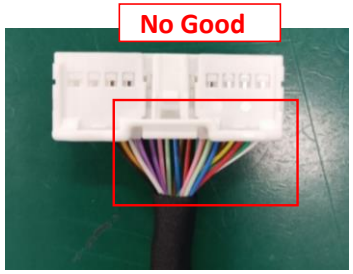
PARTS:	1. Assy parts	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P6	9 **Medium** Taping 3 Wire taping (Tesa) (Continuation)	  9. After taping, check the alignment and condition of tape. 10. Proceed to **Continuity checking** of a product and follow the instructions. 11. After checking of continuity of a product, proceed to **End tape pressing** process and follow the instructions.	n/a	1. No loose tape 2. No excessive tape winding 3. No damage on parts 4. No peel off tape 5. No bend Wire ***Important reminders/Note/s:*** ***1. All wires must be properly allign and not tangled to avoid bend wire . (see picture for refference)*** ***2. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.*** ***Document references:*** ***1. Refer to WI-ENG-PDE-010 Continuity Testing*** ***2. Refer to WI-ENG-PDE-001 Sub Assembly Treatment on Lever Con Continuity Checker NG if encountered any defect/NG product*** ***3. Refer to WI-ENG-PDE-096 End tape pressing process*** ***4. Refer to IS-QAD-QAC-014 Inspection Standard 17L544-7050***

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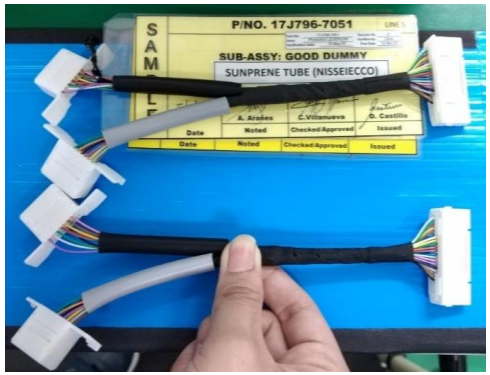
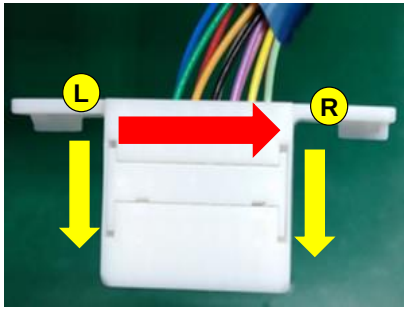
PARTS:	1. Assy parts	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	9 P6	Medium Visual inspection	 1. After test of a product, compare to **Master sample** by tapping. *LEGEND:* First way checking of connector lock Second way checking of connector lock BLUE VM TUBE (SUNPRENE)  2. Ensure that connector is in locked condition by slide touching the connector lock from **LEFT to RIGHT** using right thumb. 3. Ensure that connector is in locked condition by touching the **LEFT SIDE** of connector lock from **TOP to BOTTOM** using right thumb. 4. Ensure that connector is in locked condition by touching the **RIGHT SIDE** of connector lock from **TOP to BOTTOM** using right thumb.	n/a	1. No loose tape 2. No excessive tape winding 3. No damage on parts 4. No peel off tape 5. No bend wire 6. No NG of end tape 7. No damaged double lock 8. No half-locked connector

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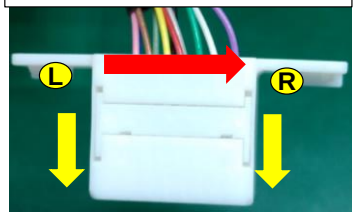
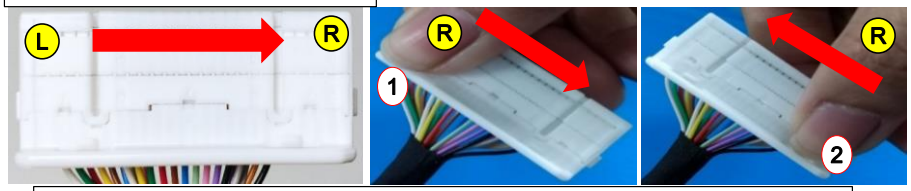
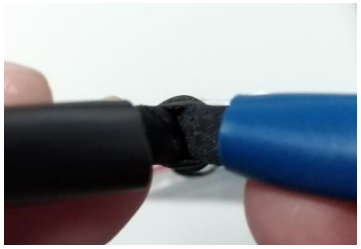
PARTS:	1. Assy parts	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P6 ▲9	**Medium** Visual inspection (Continuation)	LEGEND: First way checking of connector lock Second way checking of connector lock 5. Ensure that connector is in locked condition by slide touching the connector lock from **LEFT to RIGHT** using right thumb. BLACK VM TUBE (SUNPRENE)  6. Ensure that connector is in locked condition by touching the **LEFT SIDE** of connector lock from **TOP to BOTTOM** using right thumb. 7. Ensure that connector is in locked condition by touching the **RIGHT SIDE** of connector lock from **TOP to BOTTOM** using right thumb. WAY OF CHECKING CONNECTOR LOCK  8. Ensure that connector is in locked condition by slide touching the connector lock from **left to right** sing right thumb based on the sequence illustrated.  9. Check the taping condition, must be **no exposed end tape** inside.	n/a	1. No loose tape 2. No excessive tape winding 3. No damage on parts 4. No peel off tape 5. No bend wire 6. No NG of end tape 7. No damaged double lock 8. No half-locked connector

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