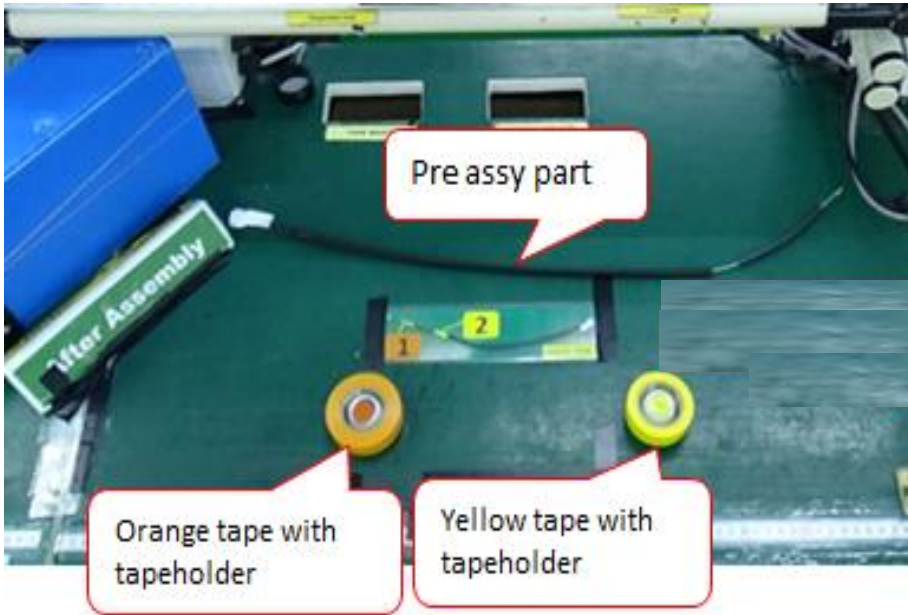
	<b>WORK INSTRUCTION</b>				Effectivity Date:	June 11, 2024		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>102D / 7L0121-7024</b>		Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA-RAV4</b>	Document No.:	<b>WI-ENG-PDE-424B</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	1 of 5

<b>PARTS:</b>	1. Assy parts: Yellow tape [1pc.]; Orange tape [1pc.]			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
1	P2	<p style="text-align: center;">Table Lay-out</p> 		<p><b>Safety Instruction</b> Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p><b>Document reference/s:</b> <b>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b></p> <p>1. No missing parts/tools 2. No excess parts/tools</p>

Revision History				Prepared by	Reviewed by	Approved by	Noted by
06/11/24	0	Initial issue.		D. Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: June 11, 2024

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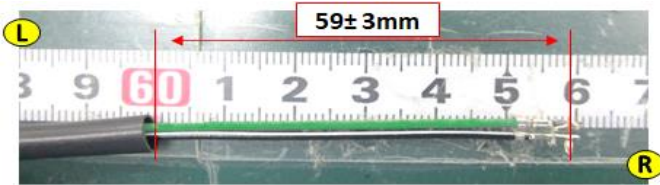
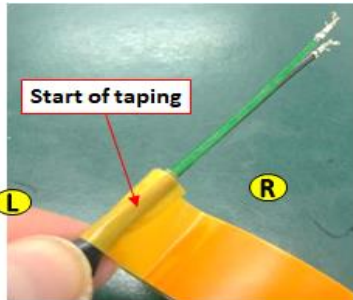
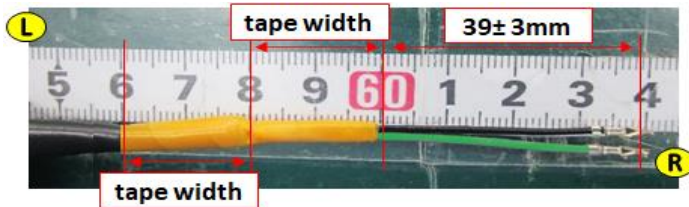

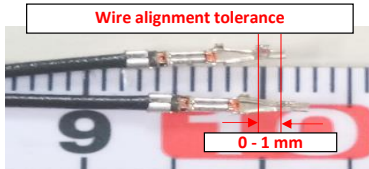
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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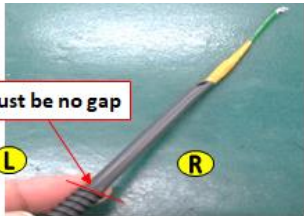
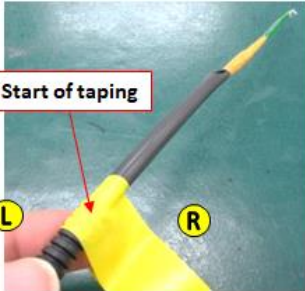
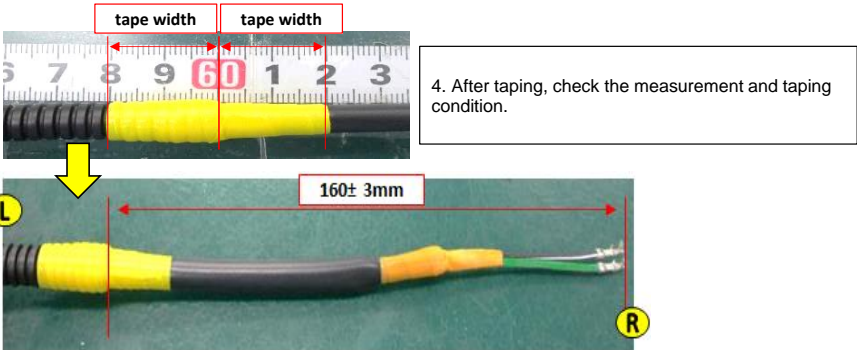
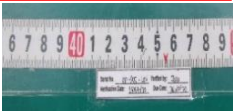
PARTS:		1. Assy parts 2. Orange tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2  Taping 1 Black VM tube (Sunprene) to wire near terminal	<div><p>59± 3mm</p></div> <div><p>1. Measure from end of VM tube (Sunprene) up to end of the terminal pointed tip <b>59mm</b> using both hands.</p></div> <div><p>Start of taping</p></div> <div><p>2. Hold the VM tube (Sunprene) using left hand, get the <b>Orange tape</b> then start taping process using both hands.</p></div> <div><p>tape width 39± 3mm</p><p>tape width</p></div> <div><p>3. After taping, check the taping condition, measurement and wire alignment.</p></div>		<div><p>MEASURING TAPE</p></div> <div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div> <div><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><p><b>Important reminders/Note/s:</b></p><p>1. Use <b>ORANGE TAPE</b> only. 2. Please use <b>calibrated/verified measuring tape</b> when getting the measurement.</p><p><b>Document reference/s:</b></p><p>1. Refer to <b>WI-PRO-ASY-001</b> for taping procedure.</p></div>	

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	Model code/Part number: <b>102D / 7L0121-7024</b>		Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA-RAV4</b>	Document No.: <b>WI-ENG-PDE-424B</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	3 of 5


<b>PARTS:</b>	1. Assy parts 2. Yellow tape			JIG:	n/a		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>			
3	P2 Taping 2 Black corrugated tube to Black VM tube (Sunprene) near terminal	<div><p>160± 3mm</p><p>1. Measure from end of corrugated tube up to terminal pointed tip <b>160mm</b> using both hands.</p></div> <div><p>Must be no gap</p><p>2. Fix the corrugated tube and sunprene tube using both hands.</p></div> <div><p>Start of taping</p><p>3. Hold the corrugated tube and VM tube (Sunprene) using left hand, get the <b>Yellow tape</b> then start taping process using both hands.</p></div> <div><p>tape width    tape width</p><p>160± 3mm</p><p>4. After taping, check the measurement and taping condition.</p></div>	<div><b>MEASURING TAPE</b></div> 	<p><b>Important reminders/Note/s:</b></p> <p>1. Use <b>YELLOW TAPE</b> only</p> <p>2. 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 use of tape 6. No wrong dimension</p>			

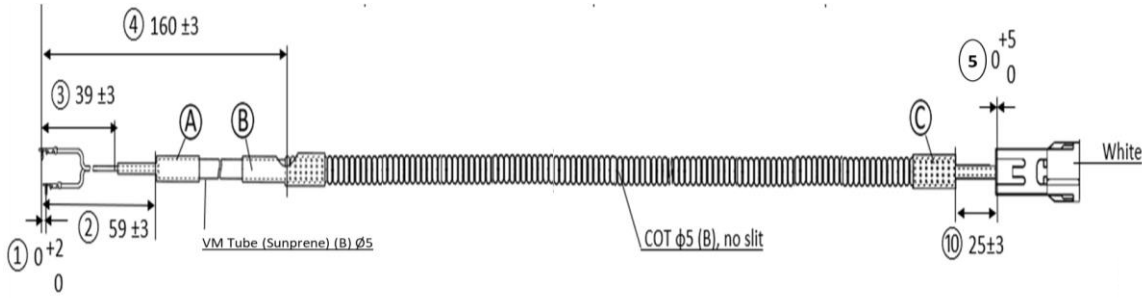

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		0	Page No.:

<b>PARTS:</b>		1. Assy parts		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
4	P2	Measurement  <div><b>NOTE:</b> A - Taping (OR) B - Taping (Y) C - Taping (B)</div>	<div>MEASURING TAPE</div> 	<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>	

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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P2****7L0121-7024****1****No Unlock/Halflock  
Connector****2****No Wrong Insert/  
Terminal Backing Out****3****No Missing Tape (COT to Sunprene  
tube near terminal) (Y)****4****No Missing Tape ( Sunprene tube  
to wire near terminal) (OR)****5****No Deformed terminal**

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