
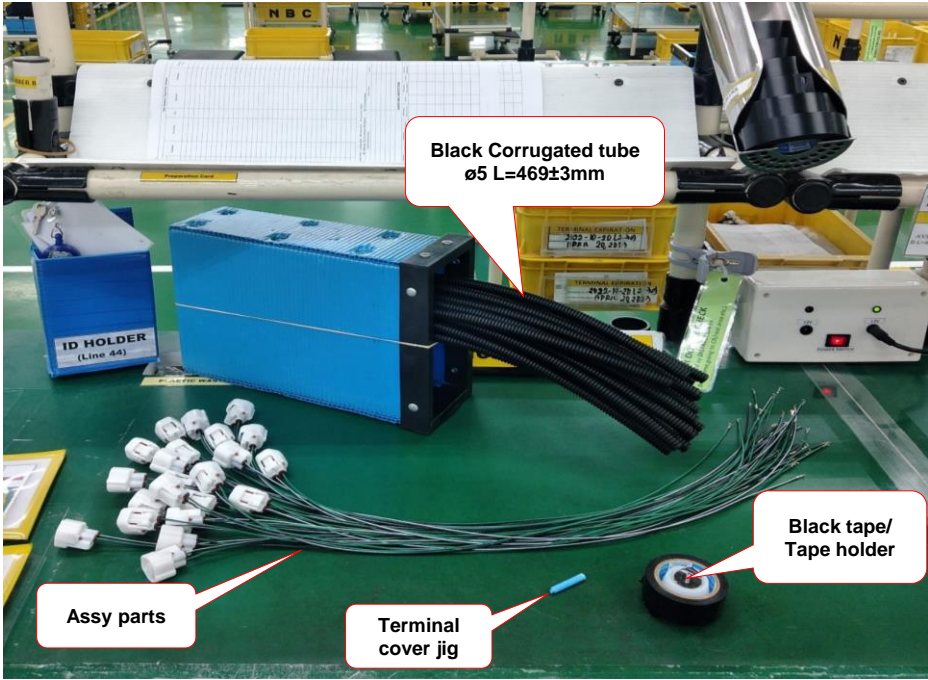
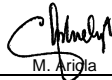

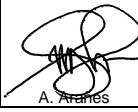


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|---|---|----------------------------|------------------------|----------------------------------|--------------------|------------------------|--------|
|  | WORK INSTRUCTION | | | Effectivity Date: | September 12, 2024 | | |
| | Process Name/Title: TAPING ASSEMBLY PROCESS | | | Validity Date: | n/a | | |
| | Model code/Part number: | 177D / 7L0129-7020B | Customer: TRQSS | Car Model: TOYOTA COROLLA | Document No.: | WI-ENG-PDE-1049 | |
| | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO | | | Revision No.: | 1 | Page No.: | 1 of 5 |

| PARTS: | 1. Assy parts; Black corrugated tube ø5 L= 469±2mm (no slit); Black tape | | | JIG: | 1. Terminal cover jig |
|--------|--|------------------------------|--|---|--|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 1 | P1 | Table Lay-out | <div>TABLE LAY-OUT</div>  | <div>Safety Instruction</div> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) <div>Housekeeping</div> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. <div>Alert level</div> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. | <div>Document reference/s:</div> 1. Refer to WI-ENG-PDE-1004 for Offline assembly process 1. No missing parts/tools 2. No excess parts/tools |

| Revision History | | | | | | | Prepared by | Reviewed by | Approved by | Noted by |
|------------------|---------|------------------------------------|-----------|---------------|-----------|-------|--|--|--|----------|
| | | | | | | |  M. Ariola |  C. Villanueva |  A. Arañes | n/a |
| 09/12/24 | 1 | Change from Pre-Launch to Masspro. | M. Ariola | C. Villanueva | A. Arañes | n/a | | | | |
| 09/11/24 | 0 | Initial issue. | M. Ariola | C. Villanueva | A. Arañes | n/a | | | | |
| Eff. Date | Rev. No | Details of Change | Revised | Reviewed | Approved | Noted | Est. Date: | September 11, 2024 | | |

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

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177D / 7L0129-7020B

Customer:

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Car Model:

TOYOTA COROLLA

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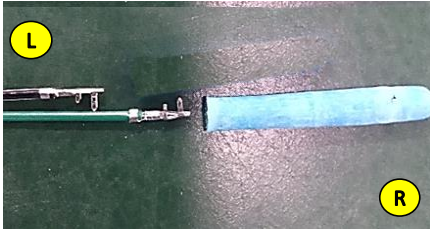
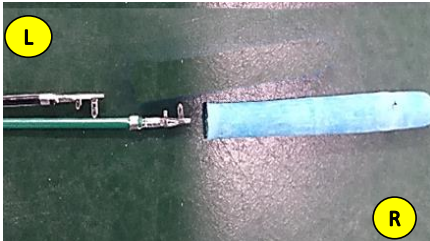

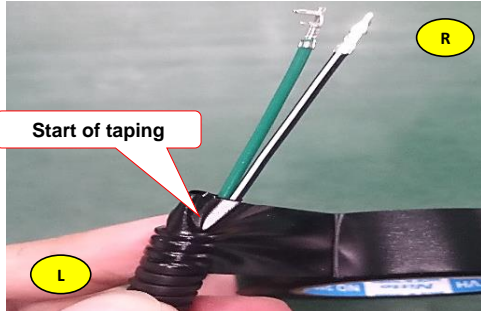

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

2 of 5

| PARTS: | | 1. Black corrugated tube $\varnothing 5$ L= 469 \pm 2mm (no slit) 2. Assy parts 3. Black tape | | JIG: | 1. Terminal cover jig |
|--------|---|--|--|--|--|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 2 | P1 | <div><div></div><div></div></div> <div>1. Get the terminal cover jig using right hand then insert the G-B/W wires using left hand.</div> <div>2. Get the Black Corrugated tube $\varnothing 5$ L=469\pm2mm (no slit) using right hand and insert to G-B/W wires using left hand.</div> <div>3. After insertion, remove the terminal cover jig using right hand.</div> | | <div>TERMINAL COVER JIG</div>  | 1. No wrong usage of parts 2. No deformed terminal |
| 3 | Taping 1 Black COT to wire near terminal | <div></div> <div>1. Hold the COT using left hand, get the black tape using right hand then start pre-taping using both hands.</div> | | <div>MEASURING TAPE</div>  | Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure Important reminders/ Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. No peel-off tape 3. No flip out tape 4. No loose tape 5. No wrong use of tape 6. No missing tape |

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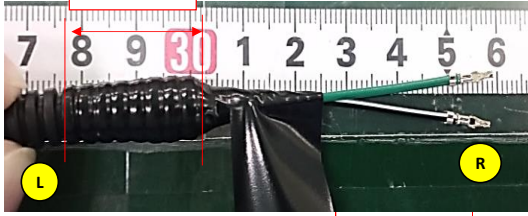
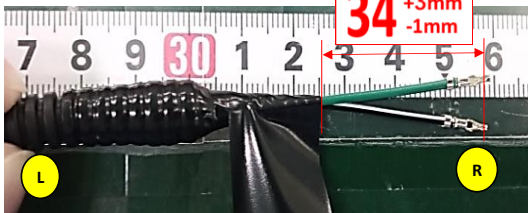
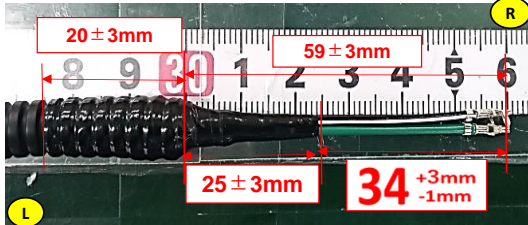

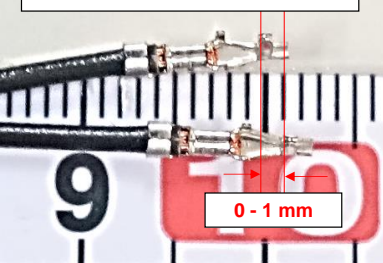
WI-ENG-PDE-1049

Revision No.:

1

Page No.:

3 of 5

| | | | | | |
|--------|--|---|--|---|--|
| PARTS: | | 1. Assy parts 2. Black tape | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 3 | P1 Taping 1 Black COT to wire near terminal (Continuation) | <div><p>2. Measure from end of COT up to terminal pointed tip 59±3mm then continue the taping process using both hands.</p></div> <div><p>3. Confirm measurement from end of tape up to end of COT (must be tape width) then continue the taping process using both hands.</p></div> <div><p>4. Measure from end of tape up to terminal pointed tip 34(+3/-1mm) then continue the taping process using both hands.</p></div> <div><p>5. After taping, check the measurement, wire alignment and taping condition.</p></div> | | <div>MEASURING TAPE</div>  | <div>Wire alignment tolerance</div>  <p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure</p> <p>Important reminders/ Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <ul style="list-style-type: none">1. No peel-off tape2. No flip out tape3. No loose tape4. No wrong use of tape5. No wrong dimension6. No missing tape |

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WI-ENG-PDE-1049

Purpose:


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

4 of 5

| | | | | |
|--------|---------------|------------------------------|--|---|
| PARTS: | 1. Assy parts | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
| 4 | P1 | Measurement | <div>MEASURING TAPE</div>  <div>NOTE: (A) - Taping (B)</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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WI-ENG-PDE-1049

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

5 of 5

PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P1****7L0129-7020B****① No MISSING TAPE**

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