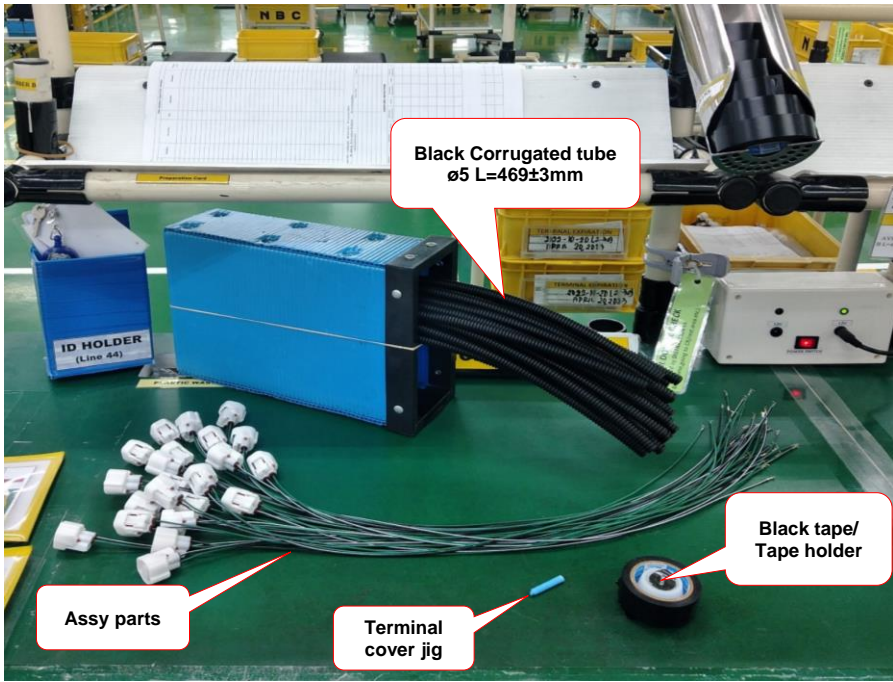


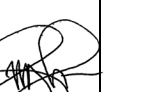

	<b>WORK INSTRUCTION</b>				Effectivity Date:		August 15, 2024	
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Model code/Part number: <b>177D / 7L0129-7020A</b>		Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA COROLLA</b>	Document No.:		<b>WI-ENG-PDE-350</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		5	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	5	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>	<div>Document reference/s:</div> <p>1. Refer to <b>WI-ENG-PDE-1004</b> for <b>Offline assembly process</b></p> <p>1. No missing parts/tools 2. No excess parts/tools</p>

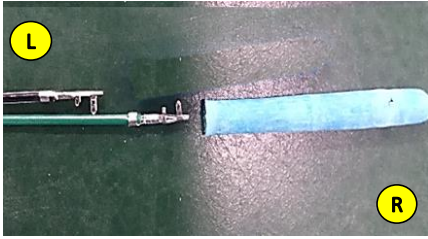

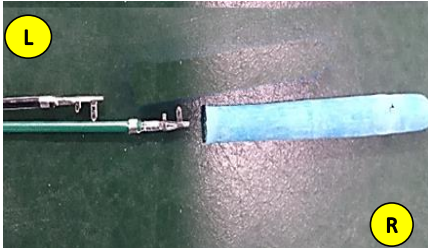

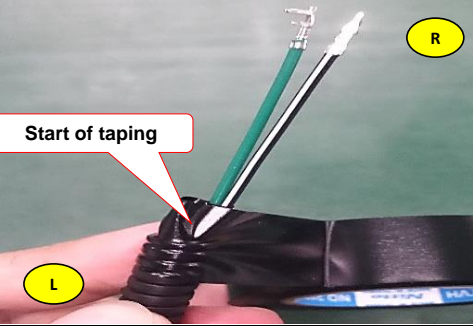

Revision History							Prepared by	Reviewed by	Approved by	Noted by
08/15/24	5	Separate Connector setting and wire insertion to connector process to Offline assembly process due to process improvement. Inclusion of car model "TOYOTA-COROLLA" and Measurement. Update table lay-out.	D.Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
05/12/23	4	Inclusion of quality checkpoints; inclusion of important reminders/Note/s on pg. 5 & document reference/s on pg.6	J. Loterte	C. Villanueva	A. Arañes	n/a				
09/30/22	3	Change of tolerance from 34+/-3mm to 34 (+3/-1mm) as countermeasure for encountered NG dimension from end of tape up to terminal tip. Improve work procedure/ Illustration on process no.2, 3, 4, 5 and 6	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 26, 2021		

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	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>August 15, 2024</b>					
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	<b>n/a</b>					
	Process Name/Title:		Model code/Part number: <b>177D / 7L0129-7020A</b>		Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA COROLLA</b>	Document No.:	<b>WI-ENG-PDE-350</b>			
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:	5	Page No.:

<b>PARTS:</b>	1. Black corrugated tube ø5 L= 469±2mm (no slit) 2. Assy parts				3. Black tape	JIG:	1. Terminal cover jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
2	P1  Wire insertion to corrugated tube ø5 L=469±2mm (no slit)	<div>   </div> <div> <p>1. Get the terminal cover jig using right hand then insert the <b>G-B/W wires</b> using left hand.</p> </div> <div>  <p>2. Get the Black Corrugated tube <b>ø5 L=469±2mm (no slit)</b> using right hand and insert to <b>G-B/W wires</b> using left hand.</p> <p>3. After insertion, remove the terminal cover jig using right hand.</p> </div>			<div> <b>TERMINAL COVER JIG</b>  </div>	1. No wrong usage of parts 2. No deformed terminal	
3	Taping 1 Black COT to wire near terminal	<div>  <p>Start of taping</p> </div> <div> <p>1. Hold the COT using left hand, get the <b>black tape</b> using right hand then start pre-taping using both hands.</p> </div>			<div> <b>MEASURING TAPE</b>  </div>	<b>Document reference/s:</b> 1. Refer to <b>WI-PRO-ASY-001</b> for taping procedure  <b>Important reminders/ Note/s:</b> 1. Please use calibrated/verified measuring tape when getting the measurement.  1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape	

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## WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Model code/Part number:

177D / 7L0129-7020A

Customer:

TRQSS

Car Model:

TOYOTA COROLLA

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

August 15, 2024

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n/a

Document No.:

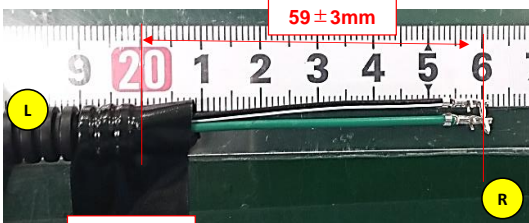

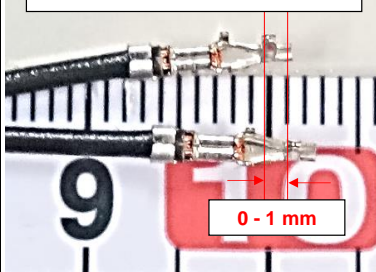
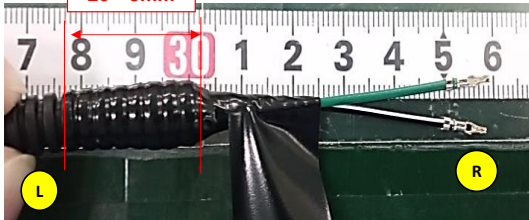
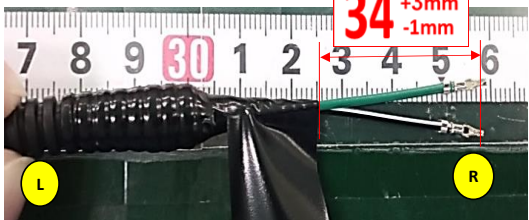
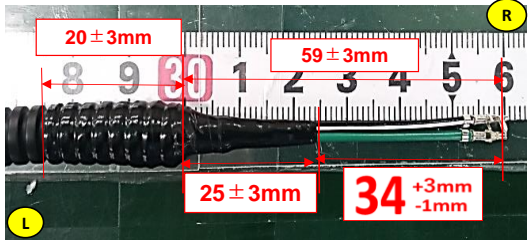
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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
3	P1  Taping 1 Black COT to wire near terminal (Continuation)				  <b>Document reference/s:</b> 1. Refer to <b>WI-PRO-ASY-001</b> for taping procedure  <b>Important reminders/ Note/s:</b> 1. Please use calibrated/verified measuring tape when getting the measurement.  1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape	
						<b>0 - 1 mm</b>
						
						

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**WORK INSTRUCTION**

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**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**August 15, 2024**

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**177D / 7L0129-7020A**

Customer:

**TRQSS**

Car Model:

**TOYOTA COROLLA**

Document No.:

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Purpose:



☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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

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**WORK INSTRUCTION**

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**TAPING ASSEMBLY PROCESS**

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TRQSS

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PARTS:

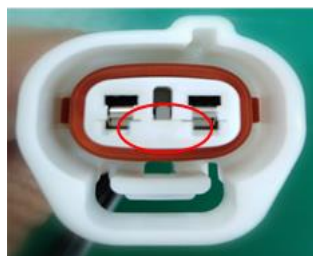
1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING-P1****7L0129-7020A**

1

**GOOD****NO GOOD**

1

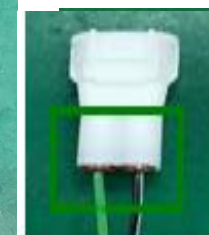
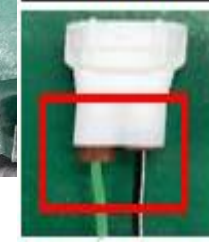
2

① No **Unlocked/ Half-Locked Connector**② No **Wrong Insert**

3

③ No **Missing tape**④ No **Terminal Backing Out**

4

**GOOD****NO GOOD**

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