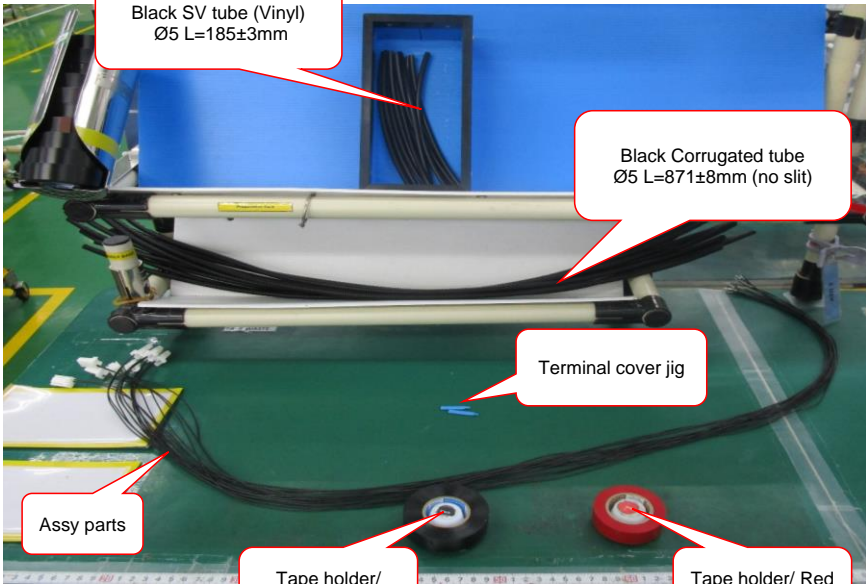








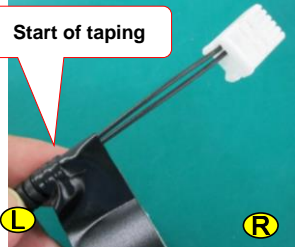
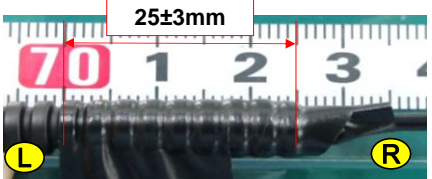
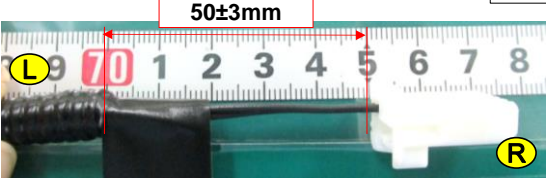
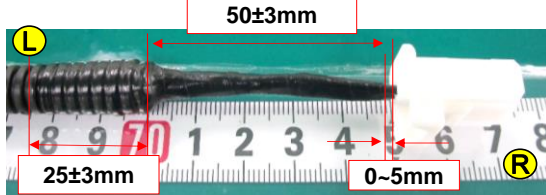

	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date:	October 17, 2024		
	Process Name/Title:				Validity Date:	n/a		
	Model code/Part number: 840B / 7N0120-7021		Customer: TRJ	Car Model: TOYOTA-SIENTA	Document No.:	WI-ENG-PDE-616		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		2	Page No.:	1 of 6	


PARTS:		1. Assy parts; Black Corrugated tube Ø5 L=871±8mm (no slit); Black SV Tube (Vinyl) Ø5 L=185±3mm		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1	<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 WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to WI-ENG-PDE-615 for Offline assembly process</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>

Revision History						Prepared by	Reviewed by	Approved by	Noted by	
10/17/24	2	Change process sequence of 3-5 due to process improvement. Inclusion of car model "TOYOTA-SIENTA" and Measurement. Standardize SV tube (Vinyl) term.	D.Castillo	C.Villanueva	A. Arañes	N/A	 D. Castillo	 C. Villanueva	 A. Arañes	N/A
02/10/23	1	Change purpose from pre-launch to Masspro.	M. Ariola	J.Loterte	C.Villanueva	A. Arañes				
01/17/23	0	Initial issue.	M. Ariola	J.Loterte	C.Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	January 17, 2023		


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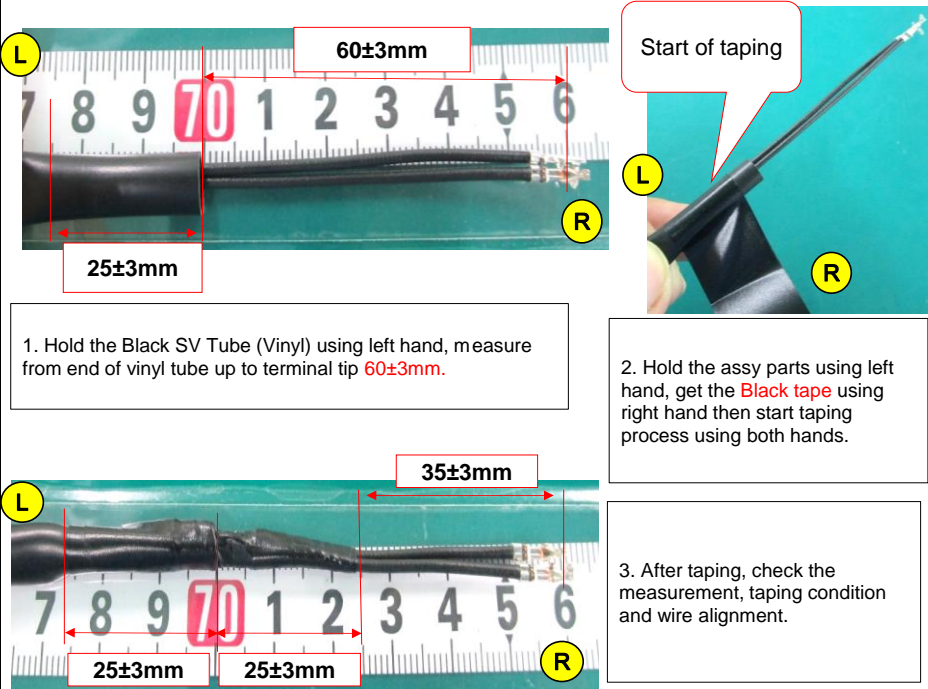

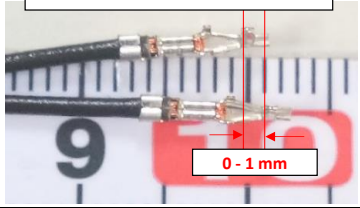
	WORK INSTRUCTION				Effectivity Date:	October 17, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 840B / 7N0120-7021		Customer: TRJ	Car Model: TOYOTA-SIENTA	Document No.:	WI-ENG-PDE-616		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.:	2 of 6

PARTS:		1. Assy parts 2. Black corrugated tube Ø5 L= 871±8mm (no slit)		3. Black tape		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Black corrugated tube Ø5 L=871±8mm (no slit)	<div>    </div> <div> <p>1. Get the terminal cover jig using right hand then insert to B-B wires.</p> <p>2. Get the corrugated tube (no slit) Ø5 L=871±8mm using right hand and insert to B-B wires.</p> <p>3. After insertion, remove the terminal cover jig using right hand.</p> </div>				<div>  </div>	1. No wrong use of parts 2. No deformed terminal
3	<div> <div>2</div> <div>P1</div> </div> Taping 1 Black COT to wire near connector	<div>  <p>1. Hold the assy parts, get the Black tape using right hand then start taping process using both hands.</p>  <p>25±3mm</p>  <p>50±3mm</p>  <p>50±3mm</p> <p>25±3mm</p> <p>0~5mm</p> </div> <div> <p>3. Measure from end of COT up to edge of connector 50±3mm then continue the taping process using both hands.</p> <p>4. After taping, check the measurement and taping condition.</p> </div>				<div>  </div>	<p>Important reminders and Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <p>1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape</p>

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	WORK INSTRUCTION			Effectivity Date:	October 17, 2024		
	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Process Name/Title:			Document No.:	WI-ENG-PDE-616		
	Model code/Part number: 840B / 7N0120-7021		Customer: TRJ	Car Model: TOYOTA-SIENTA	Revision No.: 2 Page No.: 3 of 6		
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO							


PARTS:	1. Assy parts 2. Black Tape			JIG:	n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
4	<div>2</div> Wire insertion to Black SV Tube (Vinyl) Ø5 L=185±3mm	 <div>1. Get the Black SV Tube (Vinyl) Ø5 L=185±3mm using right hand then insert the B-B wires.</div>		n/a	1. No wrong use of parts 2. No deformed terminal		
5	<div>2</div> P1 Taping 2 VM tube to wire near terminal	 <div>1. Hold the Black SV Tube (Vinyl) using left hand, measure from end of vinyl tube up to terminal tip 60±3mm.</div> <div>2. Hold the assy parts using left hand, get the Black tape using right hand then start taping process using both hands.</div> <div>3. After taping, check the measurement, taping condition and wire alignment.</div>		<div>Measuring tape</div>  <div>Wire alignment tolerance</div> 	<div>1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape</div> <div>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</div>		

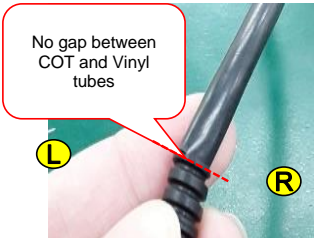
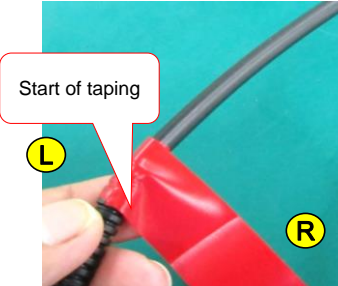
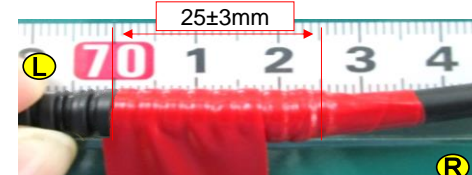
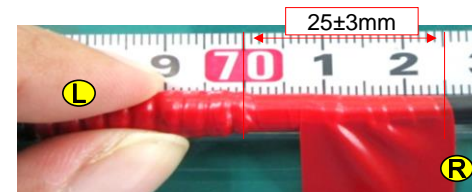
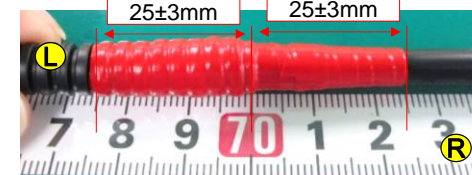

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	WORK INSTRUCTION			Effectivity Date:	October 17, 2024		
	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Process Name/Title:			Document No.:	WI-ENG-PDE-616		
	Model code/Part number: 840B / 7N0120-7021		Customer: TRJ	Car Model: TOYOTA-SIENTA	Revision No.: 2 Page No.: 4 of 6		
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO							

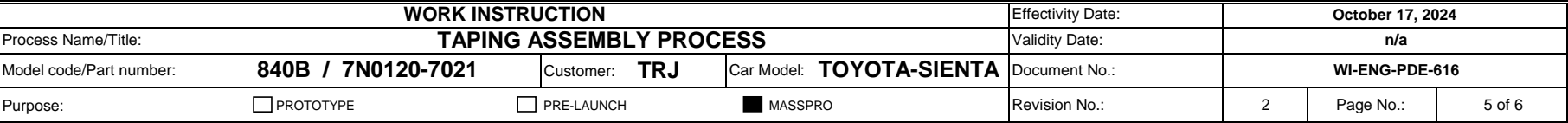
PARTS:		1. Assy parts 2. Red tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
6	P1 Wire insertion to Black VM tube (Sunprene) Ø9 L=120±3mm	<div><p>No gap between COT and Vinyl tubes</p><p>1. Fix the COT and vinyl tube using both hands.</p></div> <div><p>Start of taping</p><p>2. Hold the assy parts, get the Red tape using right hand then start taping process using both hands.</p></div> <div><p>25±3mm</p><p>3. Confirm measurement of 25±3mm from end of tape up to end of COT then continue the taping process using both hands.</p></div> <div><p>25±3mm</p><p>4. Confirm measurement of 25±3mm from end of COT up to end of tape using both hands.</p></div> <div><p>25±3mm 25±3mm</p><p>5. After taping, check the measurement and taping condition.</p></div>	<div>Measuring tape</div> 	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. Use RED TAPE only</p> <p>3. Must be no gap between COT and Vinyl tube.</p> <p>Document reference/s:</p> <p>1. Please refer to WI-PRO-ASY-001 for taping procedure</p> <p>1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape</p>	

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**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 17, 2024

Model code/Part number:

840B / 7N0120-7021

Customer:

TRJ

Car Model:

TOYOTA-SIENTA

Document No.:

WI-ENG-PDE-616

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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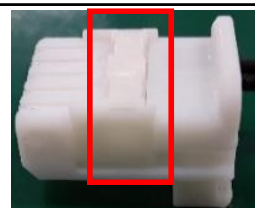
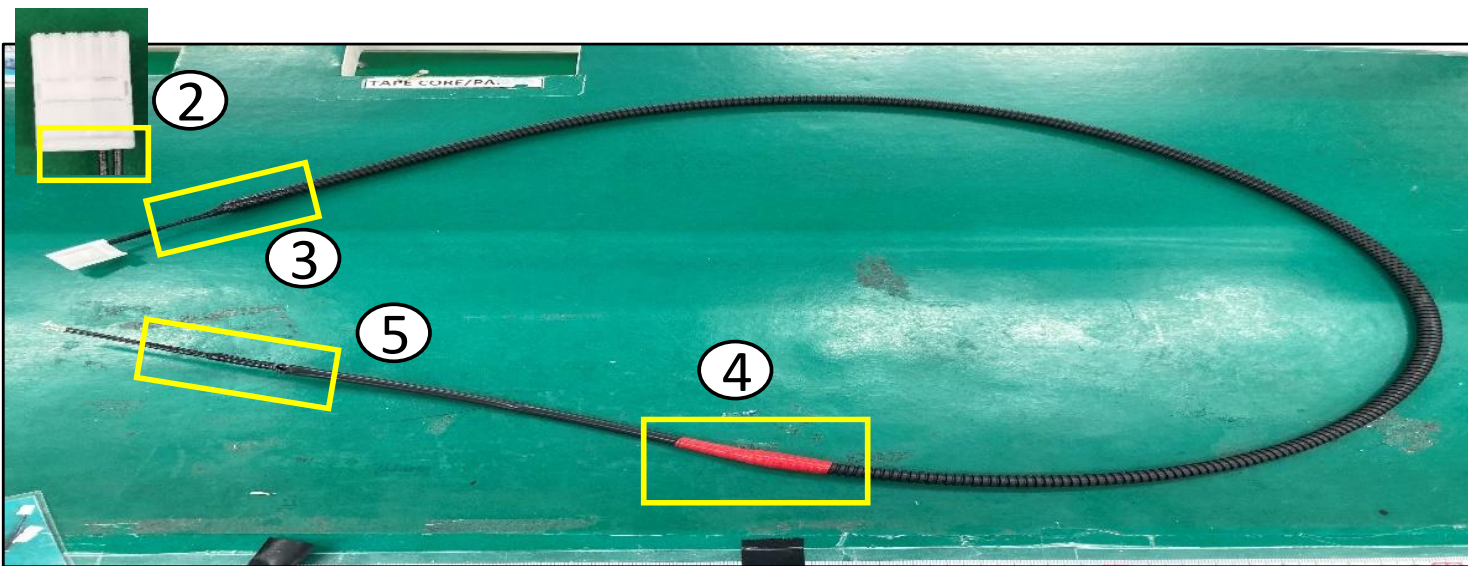
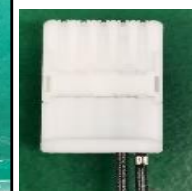
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**P1****7N0120-7021****①****GOOD****NO GOOD****②****⑥****GOOD****NO GOOD****①** No **Unlocked/ Half-Locked****④** No **wrong use of tape (red)****②** No **Wrong Insert****⑥** No **Terminal Backing Out****③** **⑤** No **Missing Tape**

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