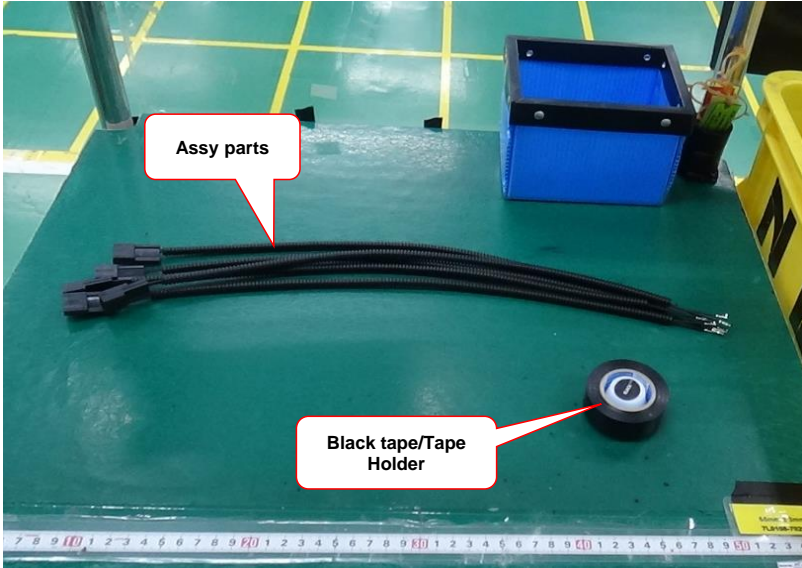


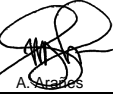
	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date: June 11, 2024	
	Process Name/Title:				Validity Date: n/a	
	Model code/Part number: 660B / 7R0110-7020B		Customer: TRMX	Car Model: TOYOTA-SEQUOIA	Document No.: WI-ENG-PDE-321	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: 4 Page No.: 1 of 4			

PARTS: 1. All parts: Assy parts; Black tape [1pc]		JIG: n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
1	P1 Table Lay-out	<div style="text-align: center;"> <div style="border: 1px solid red; padding: 5px; color: red; margin-bottom: 10px;">TABLE LAY-OUT</div>  </div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>
		QUALITY POINTERS Document references: 1. Refer to WI-ENG-PDE-779 Offline Assembly Process 1. No missing parts/tools 2. No excess parts/tools	

Revision History								Prepared by	Reviewed by	Approved by	Noted by
06/11/24	4	Separate Connector setting to Connector lock process to Offline assembly process (WI-ENG-PDE-779) and Clamp setting to By two's inspection to Clamp assembly process (WI-ENG-PDE-780). Update table lay-out and quality checkpoints. Inclusion of Car model "TOYOTA-SEQUOIA"	D.Castillo	C.Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a	
03/31/23	3	Work instruction improvement: Remove offline process and include in taping assembly process (Page 2-5). Inclusion of batching. Update table lay-out. Inclusion of Quality Checkpoints (Page 12).	D.Castillo	J. Loterte	C.Villanueva	A. Arañes					
9/23/22	2	Change of tolerance from 35+/-3mm to 35(+3/-1mm) as countermeasure of encountered NG dimension from end of tape up to connector. Improve; work procedure/illustration on process no. 1, 2, 3, 4, 5 and 6; Quality pointers and notes on page no. 1, 2, 3, 4, 5, 6 and 7	M. Ariola	J. Loterte	C.Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	August 19, 2021			

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model code/Part number:

660B / 7R0110-7020B

Customer:

TRMX

Car Model:

TOYOTA-SEQUOIA

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

June 11, 2024

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Document No.:

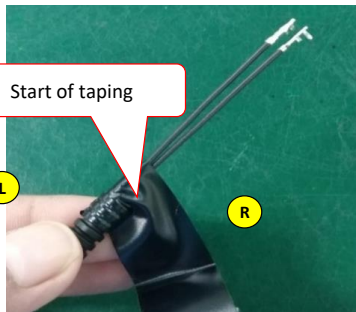
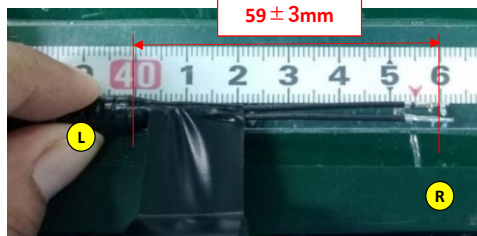

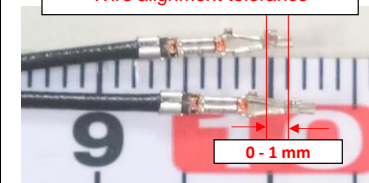

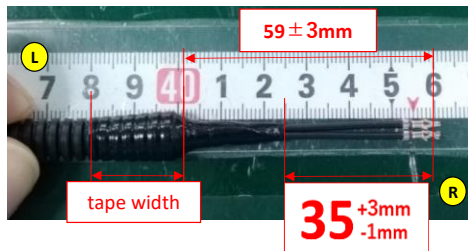
WI-ENG-PDE-321

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PARTS:		1. Assy parts 2. Black tape [1pc]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	Taping of Black COT to wire near terminal	<div><p>Start of taping</p></div> <div><p>59 ± 3mm</p></div> <div><p>1. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.</p></div> <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>MEASURING TAPE</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>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p><p>Document references: 1. Refer to WI-ENG-PDE-588 for Tape and tube end standard tolerance 2. Refer to WI-PRO-ASY-001 for Taping process</p><div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div></div>
			<div><p>35 +3mm -1mm</p></div> <div><p>3. Confirm measurement of 35 (+3/-1mm) from end of tape up to terminal pointed tip then continue the taping process using both hands.</p></div> <div><p>59 ± 3mm</p><p>tape width</p><p>35 +3mm -1mm</p></div> <div><p>4. After taping, check the measurement, taping condition and terminal appearance.</p></div>		

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**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 11, 2024

Model code/Part number:

660B / 7R0110-7020B

Customer:

TRMX

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Document No.:

WI-ENG-PDE-321

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:

1. Assy parts

JIG:

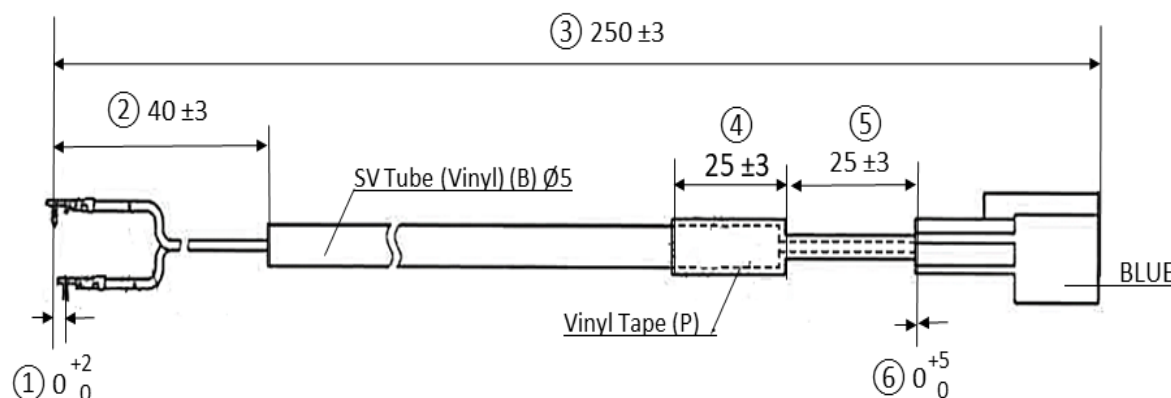
n/a

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

3

P1

Measurement

**MEASURING
TAPE****Important reminders and note/s:****1. Please use calibrated/verified measuring tape when getting the measurement.****2. For Hatsumono, Nakamono and Owarimono.****Document reference/s:****1. Refer to *WI-PRO-ASY-056* for Sub-assembly Hatsumono Nakamono Owarimono Inspection**

1. No wrong dimension

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Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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Page No.:

4 of 4**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P1****7R0110-7020B****1****No Missing Tape (COT to wire)**

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