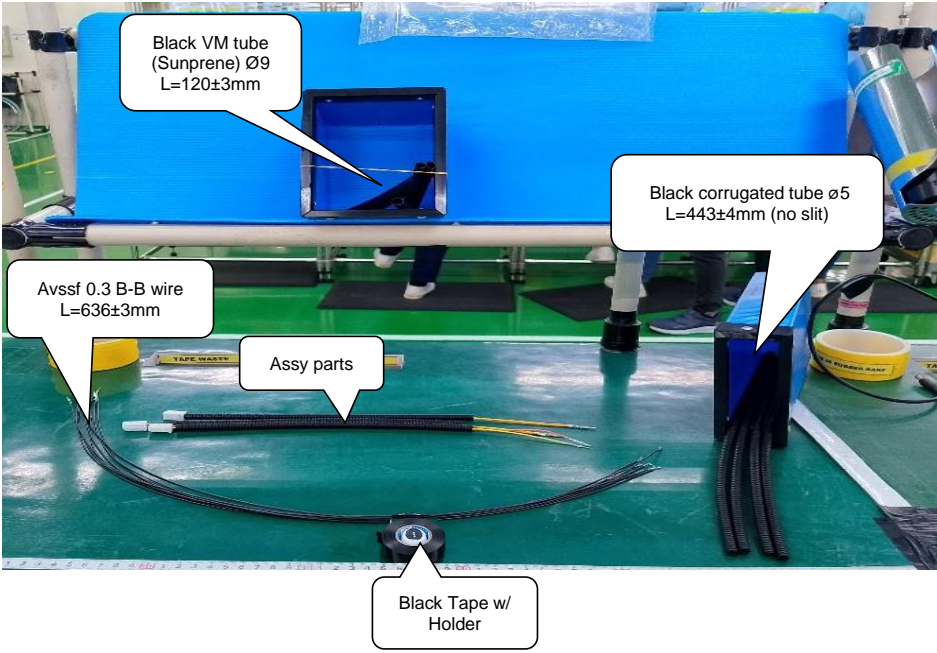




	WORK INSTRUCTION						Effectivity Date:		April 08, 2025		
	TAPING ASSEMBLY PROCESS						Validity Date:		n/a		
	Process Name/Title:		Model code/Part number: 521B / 7M0656-7020		Customer: TRJ		Car Model: TOYOTA CAMRY		Document No.: WI-ENG-PDE-1171A		
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.: 1		
								Page No.: 1		1 of 5	

PARTS:		1. Assy Parts; Black corrugated tube ø5 L=443±4mm (no slit); Black VM tube (Sunprene) Ø9 L=120±3mm; Avssf 0.3 B-B wire L=636±3mm; Black Tape				JIG:		n/a	
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>		<p>1. No missing parts/tools 2. No excess parts/tools</p> <p>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p>	

Revision History								Prepared by		Checked by		Reviewed by		Approved by	
03/08/25	1	Change document purpose from pre-launch to mass pro.						A.Hernandez	J.Loterte	C.Villanueva	A.Arañes				
11/22/24	0	Initial issue.						A.Hernandez	n/a	C.Villanueva	A.Arañes				
Eff. Date	Rev. No	Details of Change						Revised	Checked	Reviewed	Approved	Est. Date:		November 22, 2024	

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521B / 7M0656-7020

Customer: TRJ

Car Model: TOYOTA CAMRY

Document No.:

WI-ENG-PDE-1171A

Purpose:



PROTOTYPE



PRE-LAUNCH



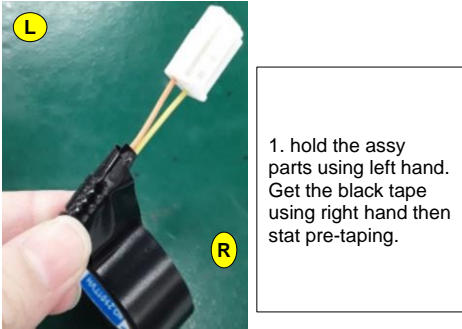

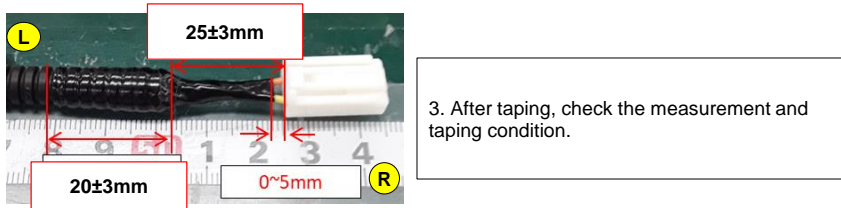


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PARTS:		1. Assy parts 2. Black Tape 3. Black corrugated tube $\varnothing 5$ L=443 $\pm$ 4mm (no slit)		4. Avssf 0.3 B-B wire L=636 $\pm$ 3mm		JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	P1	Taping 1 Black Corrugated tube to Wire near Connector	<div><div></div><div></div><div></div></div>			<div>MEASURING TAPE</div> 	<div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape 7. No insufficient tape</div> <div><b>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></div> <div><b>Document reference/s:</b> <b>1. Refer to WI-PRO-ASY-001A for COT to wire near terminal/connector.</b></div>
3		Wire insertio to Black corrugated tube $\varnothing 5$ L=443 $\pm$ 4mm (no slit)	<div><div></div></div>			n/a	<div>1. No wrong use of parts 2. No deformed terminal</div>

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PROTOTYPE



PRE-LAUNCH



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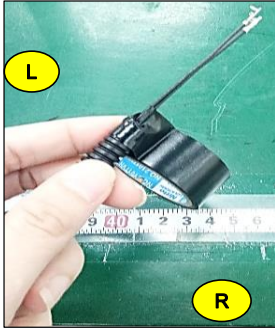
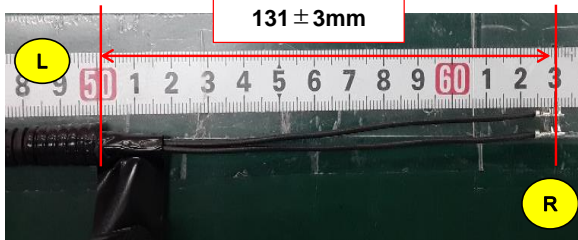
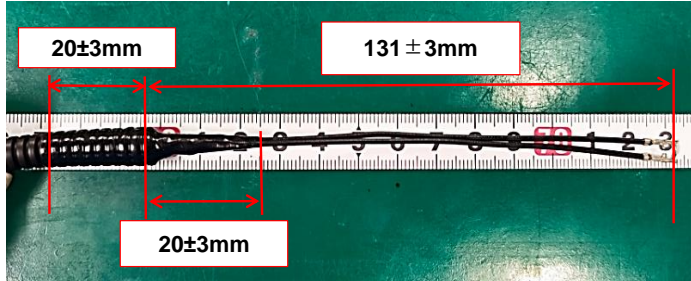

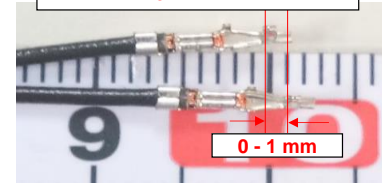
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PARTS:		1. Assy parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 Taping Corrugated tube to wire near terminal	<div></div> <div></div> <div></div> <div>1. Hold the assy parts using left hand. Get the <b>Black tape</b> using right hand then start taping between COT to wire using both hands.</div> <div>2. Measure form end of COT up to terminal pointed tip <b>131±3mm</b> then continue the taping process using both hands</div> <div>3. After taping, check the measurement, terminal alignment and taping condition.</div>		<div><b>MEASURING TAPE</b></div> 	<p><b>Important reminders/Note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p><b>Document references:</b></p> <p>1. Refer to WI-PRO-ASY-001A for Taping process</p> <ul style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No wrong dimension</li><li>5. No wrong use of tape</li><li>6. No missing tape</li><li>7. No insufficient tape</li></ul> <div></div>

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## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

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April 08, 2025

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521B / 7M0656-7020

Customer: TRJ

Car Model: TOYOTA CAMRY

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Purpose:



PROTOTYPE



PRE-LAUNCH




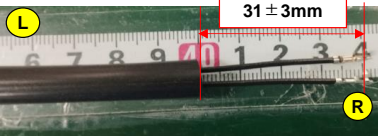

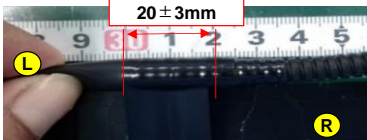
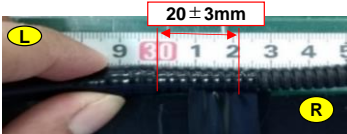
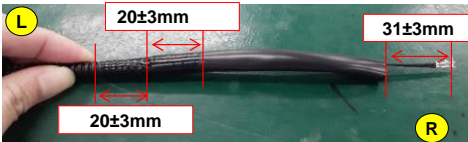


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PARTS:		1. Assy parts 2. Black tape 3. Black VM tube (Sunprene) Ø9 L=120±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1	Wire insertion to Black VM tube (Sunprene) Ø9 L=120±3mm	<div></div> <div>1. Get the Black VM tube (Sunprene) Ø9 L=120±3mm using right hand then insert the assy parts using left hand.</div>	n/a	1. No wrong use of parts 2. no deformed terminal
6		Taping 3 COT to VM tube (Sunprene)	<div><div><div>1. Measure from end of tube up to terminal pointed tip 31±3mm using both hands.</div></div><div><div>2. Hold the Assy parts using left hand, get the Black tape using right hand then start pre-taping using both hands.</div></div><div><div><div>3. Confirm measurement of 20±3mm from end of tape up to end of tube then continue the taping process using both hands.</div></div><div><div>4. Confirm measurement of 20±3mm from end of tube up to end of tape then continue the taping process using both hands.</div></div><div><div><div>5. After taping, check the measurement, terminal appearance and taping condition.</div></div></div><div><div>MEASURING TAPE</div></div></div></div>	1. Check the tape from COT to VM tube (Sunprene) (Conduct bending for verification) 2. No flip out tape. 3. No tape peeling. 4. No loose tape 5. No insufficient tape  <b>Important reminders/Note/s:</b> 1. Please use calibrated/verified measuring tape when getting the measurement.  <b>Document references:</b> 1. Refer to WI-PRO-ASY-001B for VM Tube taping process  	

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PROTOTYPE



PRE-LAUNCH



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PARTS:

n/a

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P1****7M0656-7020**

**1 No Missing Tape (COT to wire near terminal/connector)**

**2 No Missing Tape (COT to VM tube (Sunprene))**

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