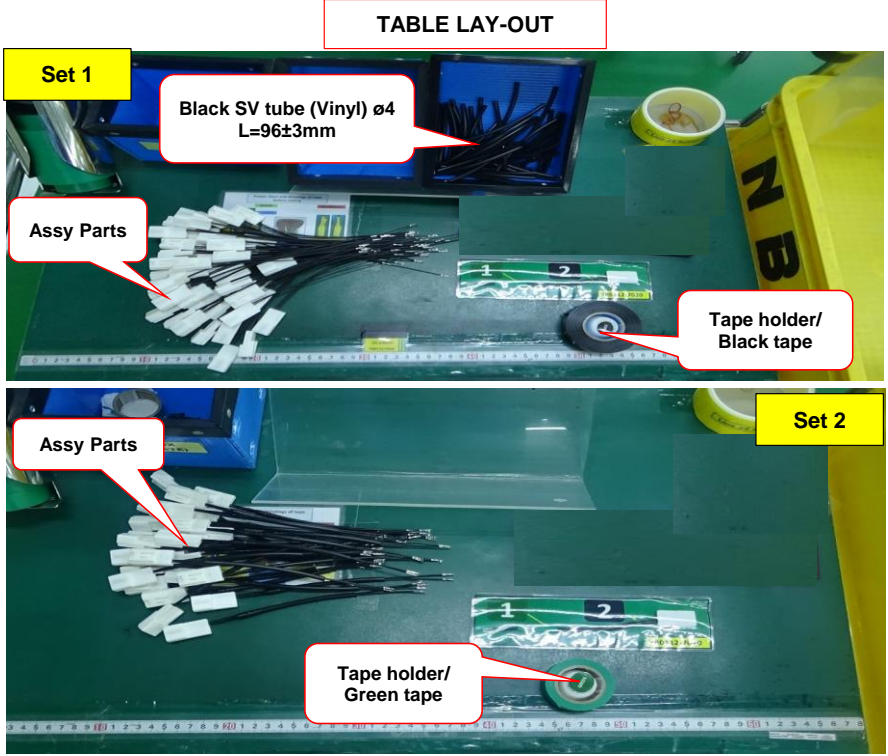


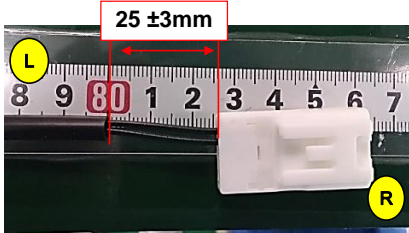
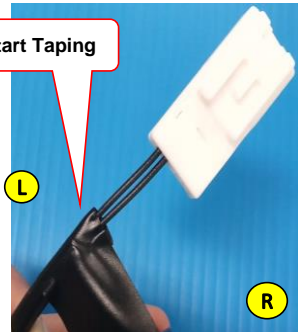
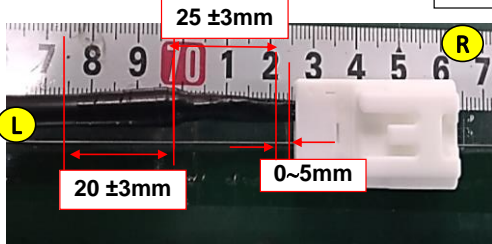

	WORK INSTRUCTION				Effectivity Date:	June 11, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 177D / 7R0112-7020		Customer: TRMX	Car Model: TOYOTA COROLLA	Document No.:	WI-ENG-PDE-338		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.:	1 of 5

PARTS:		1. Assy parts; Black SV tube (Vinly) ø4 L=96±3mm; Black tape; Green tape				JIG:		n/a	
NO.	PROCESS NAME	<div style="text-align: center;"> <div>2</div> WORK PROCEDURE/ ILLUSTRATION </div>				TOOLS/PPE		QUALITY POINTERS	
1	P1	<div> <div>Table Lay-out</div>  </div>				<div> <div> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div> </div>		<div> Document References: 1. Refer to WI-ENG-PDE-337 Offline Assembly Process </div> <div> <div>2</div> Important reminders/note/s: 1. Batching process. Complete Set 1 first (per box) before proceed to Set 2. </div> <div> 1. No missing parts/ tools. 2. No excess parts/ tools. </div>	

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	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		2	Page No.:	2 of 5	

PARTS:	1. Assy parts 2. Black SV tube (Vinly) ø4 L=96±3mm 3. Black tape			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Black SV tube (Vinly) ø4 L=96±3mm	 <p>1. Get the SV tube (Vinly) ø4 L= 96±3mm using right hand then insert the B-B wires using left hand.</p>		n/a	1. No wrong usage of parts 2. No deformed terminal
3	<div>P1</div> <div>2</div> <div>Taping 1 SV tube (Vinyl) to wire near connector</div>	 <p>1. Measure from end of SV tube (Vinyl) to connector 25±3mm using both hands.</p>  <p>2. Get the Black Tape using right hand then start taping process using both hands.</p>  <p>3. After taping, check the measurement and taping condition</p>		<div>Measuring tape</div> 	<p>Important reminders/note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>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</p> <p>Documents reference/s:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and strip length tolerance.</p> <p>2. Refer to WI-PRO-ASY-001 for Taping prodeuce.</p>

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177D / 7R0112-7020

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Document No.:

WI-ENG-PDE-338

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

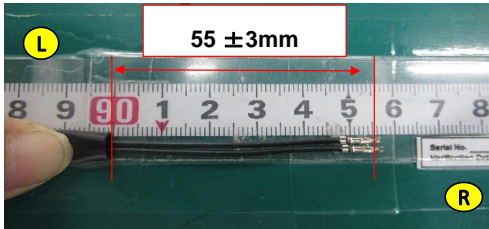

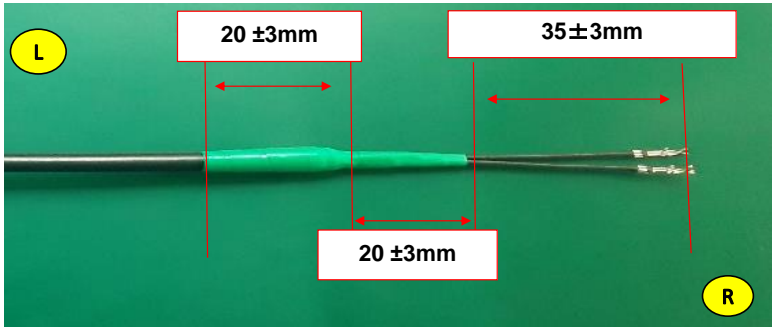

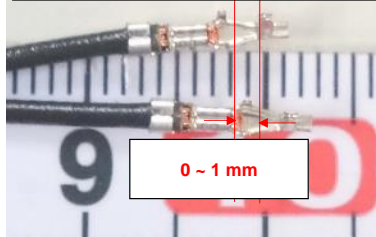
☒ MASSPRO

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PARTS:		1. Assy parts 2. Green tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 Taping 2 SV Tube (Vinyl) to wire near connector	<div><div><div><div><div>L</div><div>55 ±3mm</div><div>R</div></div></div><div><div>1. Measure from end of the SV tube (Vinly) up to the terminal tip 55mm using both hands.</div></div></div><div><div><div><div>L</div><div>Start Taping</div><div>R</div></div></div><div><div>2. Get the GREEN TAPE using right hand then start taping using both hand.</div></div></div><div><div><div><div>L</div><div>20 ±3mm</div><div>35±3mm</div><div>20 ±3mm</div><div>R</div></div></div><div><div>3. After taping, check the condition of tape, measurement and wire alignment.</div></div></div></div>		<div><div>Measuring tape</div></div>	<div><div>Important reminders/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><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</div><div><div>Wire alignment tolerance</div></div></div>

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4 of 5**PARTS:**

1. Assy parts

JIG:

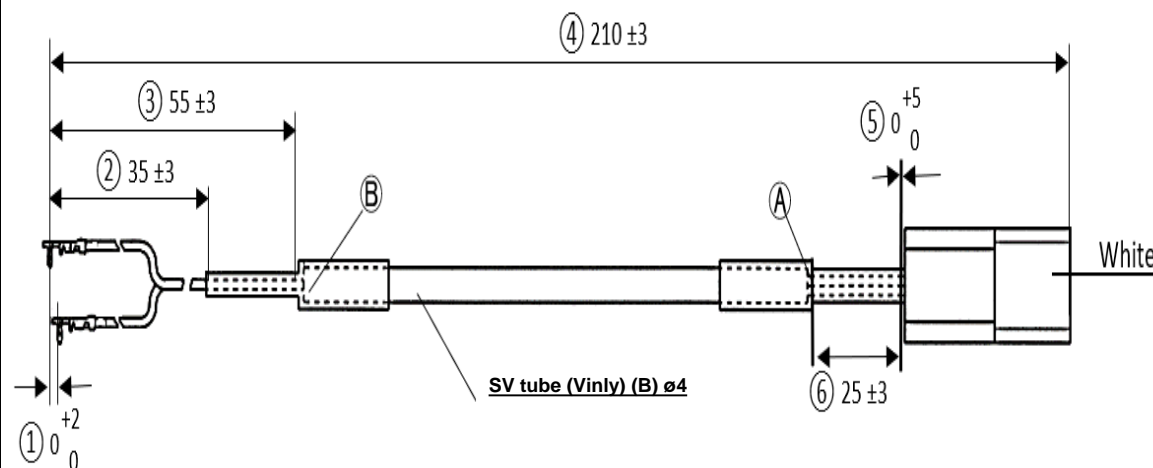
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NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

5

P1

Measurement

**NOTE:**

A - Taping (B)

B - Taping (G)

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:

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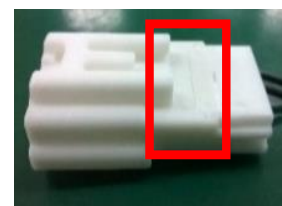
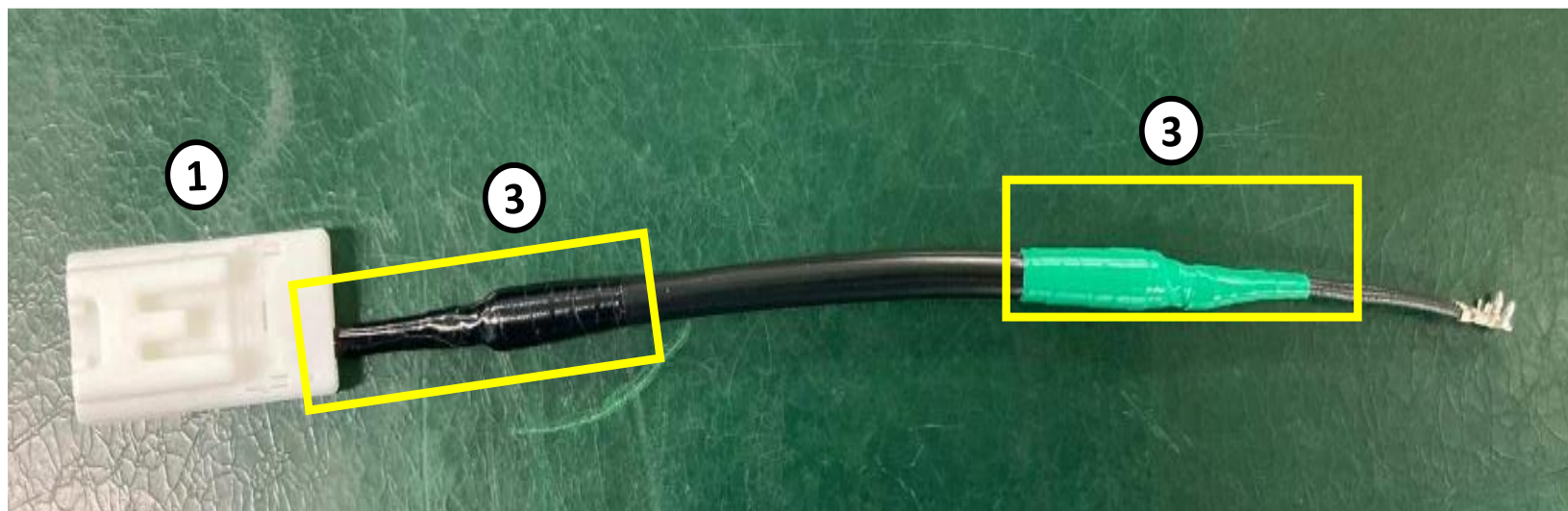
Page No.:

5 of 5**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P1****7R0112-7020****GOOD****NO GOOD****① No Deformed Terminal****② No Unlocked/Half-locked Connector****③ No Missing Tape and No Wrong use of tape**

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