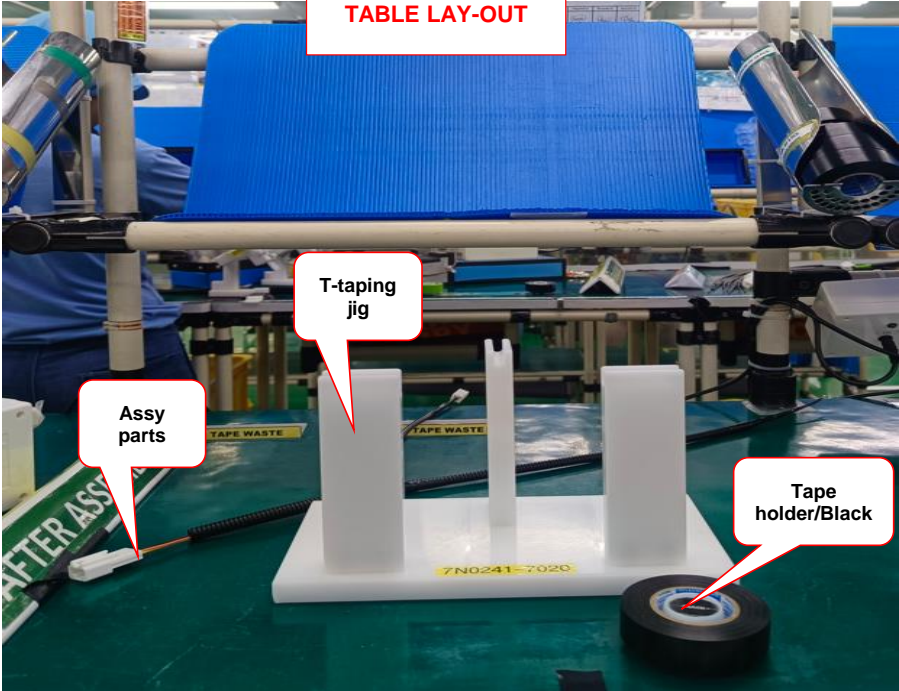
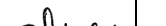


	WORK INSTRUCTION				Effectivity Date:	February 7, 2025	
	TAPING ASSEMBLY PROCESS				Validity Date:	n/a	
	Model code/Part number: 524D / 7N0241-7020		Customer: TRJ	Car Model: TOYOTA-PROBOX	Document No.:	WI-ENG-PDE-1112B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		0	Page No.:	1 of 8

PARTS:		1. Assy parts; Black tape		JIG:	1. T-Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P2	<div> <div>TABLE LAY-OUT</div>  <div>Assy parts</div> <div>T-taping jig</div> <div>Tape holder/Black</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> <ol style="list-style-type: none"> No wrong orientation of the connector No wrong use of connector No damaged connector No wrong insertion of wires No loose insertion One by one insertion No deformed terminal No wrong wire facing </div> <div> Important reminders/Note/s: 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 2. Please hold the wire near terminal </div> <div> Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure. </div>

Revision History							Prepared by	Reviewed by	Approved by	Noted by
							 M. Ariola	 C. Villanueva	 A. Arañes	n/a
02/07/25	0	Initial issue. Excluded process from WI-ENG-PDE-1112. Change Status from Pre-launch to Masspro, Additional table lay-out and Inclusion of Visual Inspection/Quality Checkpoint.			M. Ariola	C. Villanueva				
Eff. Date	Rev. No	Details of Change			Revised	Reviewed	Approved	Noted	Est. Date:	February 7, 2025

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

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Model code/Part number:

524D / 7N0241-7020

Customer: TRJ

Car Model: TOYOTA-PROBOX

Document No.:

WI-ENG-PDE-1112B

Purpose:



PROTOTYPE



PRE-LAUNCH



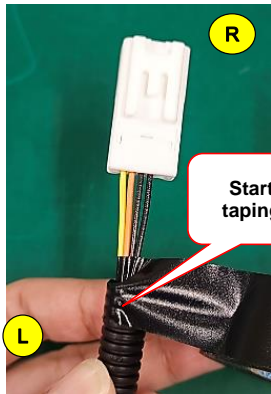
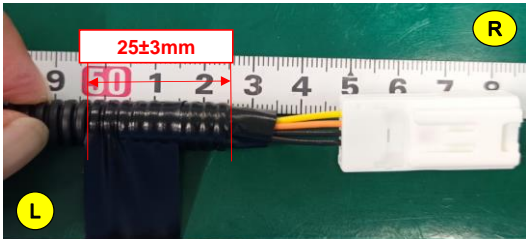
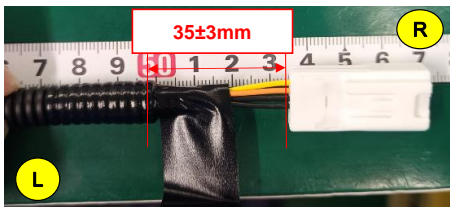
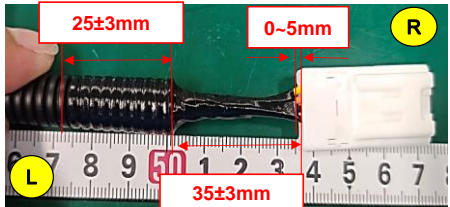

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PARTS:		1. Assy part 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 4 Black Corrugated tube to Wire near Connector	<div><p>Start taping</p></div> <div><p>25±3mm</p><p>2. Confirm measurement of 25±3mm from end of tape up to end of COT then continue the taping process using both hands.</p></div> <div><p>35±3mm</p></div> <div><p>25±3mm</p><p>0~5mm</p><p>35±3mm</p><p>3. Measure from end of COT up to edge of Connector 35±3mm then continue to the process using both hands.</p><p>4. 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>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>

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WI-ENG-PDE-1112B

Purpose:



PROTOTYPE



PRE-LAUNCH



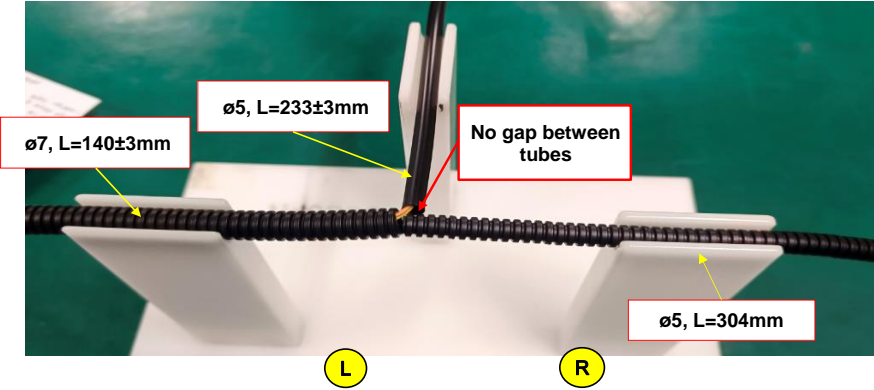
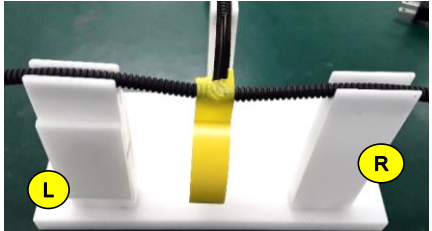
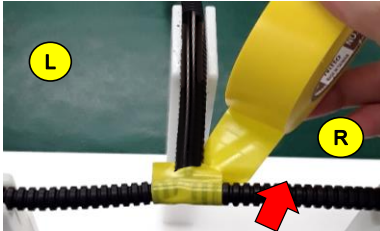
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PARTS:		1. Black tape 2. Assy parts		JIG:	1. T-Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	<div></div> <div>1. Arrange the SV tube (Vinyl) and 2 corrugated tube to form inverted T using left and right hand.</div> <div></div> <div>2. Start taping at the middle to fix the 3 tubes using both hands.</div> <div></div> <div>3. Wind the tape from front to back at the right side.</div>		n/a	<p>Important reminders/Note/s:</p> <p>1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No gap between the COT 5. No exposed wire</p>

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WORK INSTRUCTION

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Purpose:



PROTOTYPE



PRE-LAUNCH



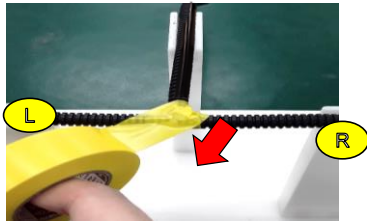
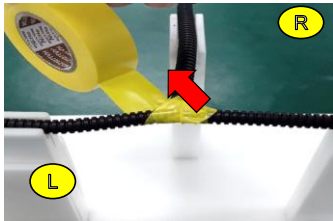
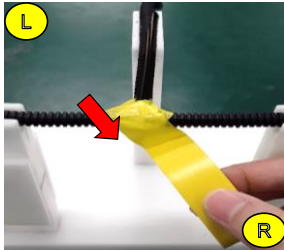
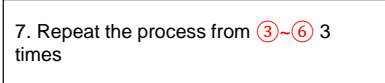
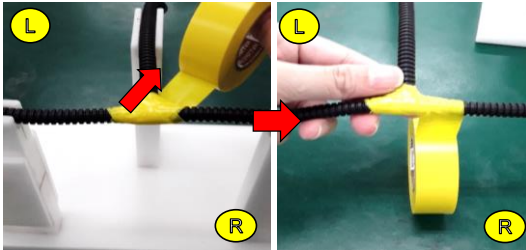

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PARTS:		1. Black tape 2. Assy parts		JIG:	1. T-Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 T-Taping (Continuation)	<div><div></div><div>4. Wind the tape from back to front (cross pattern)</div><div></div><div>5. Wind the tape from front to back at the left side</div><div></div><div>6. Wind the tape from back to front (cross pattern)</div><div></div><div>7. Repeat the process from ③~⑥ 3 times</div><div></div><div>8. Remove the harness for T-taping jig then tape the right side corrugated tube (3 winds), width must be same as tape (25mm)</div></div>		<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s:</p> <p>1. Use <u>YELLOW TAPE</u> for easy visualization of shifting lines, but actual should be <u>BLACK TAPE</u>.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No gap between the COT 5. No exposed wire</p>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

February 7, 2025

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Model code/Part number:

524D / 7N0241-7020

Customer: TRJ

Car Model: TOYOTA-PROBOX

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1112B

Purpose:



PROTOTYPE



PRE-LAUNCH



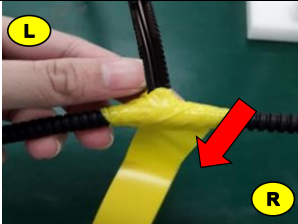
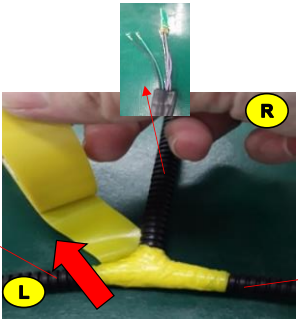
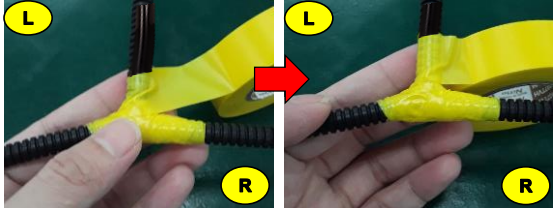
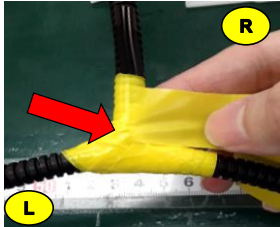

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PARTS:		1. Black tape 2. Assy parts		JIG:	1. T-Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 T-Taping (Continuation)	<div><p>9. From the right side, wind the tape 2/3 shifting going to center</p></div> <div><p>10. Wind the tape from front to back side (cross pattern)</p></div> <div><p>11. Tape the top side SV tube (Vinyl) (3 winds), width must be same as tape (25mm)</p></div> <div><p>12. From the top side, wind the tape 2/3 shifting going to center</p></div>		<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.2. Please use calibrated/verified measuring tape when getting the measurement. <ol style="list-style-type: none">1. No peel-off tape2. No flip out tape3. No loose tape4. No gap between the COT5. No exposed wire

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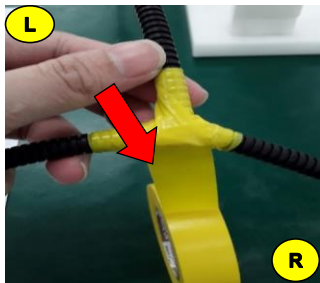
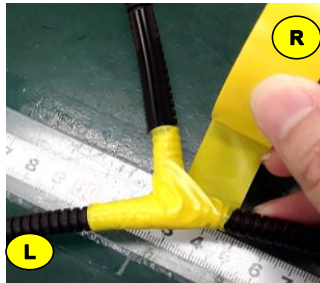
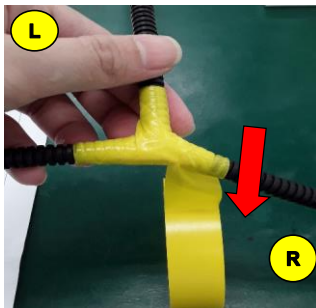
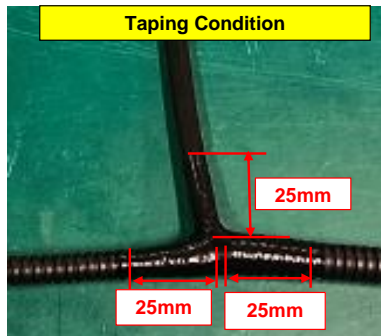
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PARTS:		1. Black tape 2. Assy parts		JIG:	1. T-Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	T-Taping (Continuation)		<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s:</p> <p>1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No gap between the COT 5. No exposed wire</p>
		<div><p>13. Wind the tape going to front side(cross pattern)</p></div> <div><p>14. Wind the tape from front to back side (cross pattern)</p></div> <div><p>15. Tape the right side corrugated tube (3 winds), width must be same as tape (25mm)</p></div> <div><p>16. After taping, check the measurement and condition of tape.</p></div>			

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**WORK INSTRUCTION**

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Customer:

TRJCar Model: **TOYOTA-PROBOX**

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PROTOTYPE



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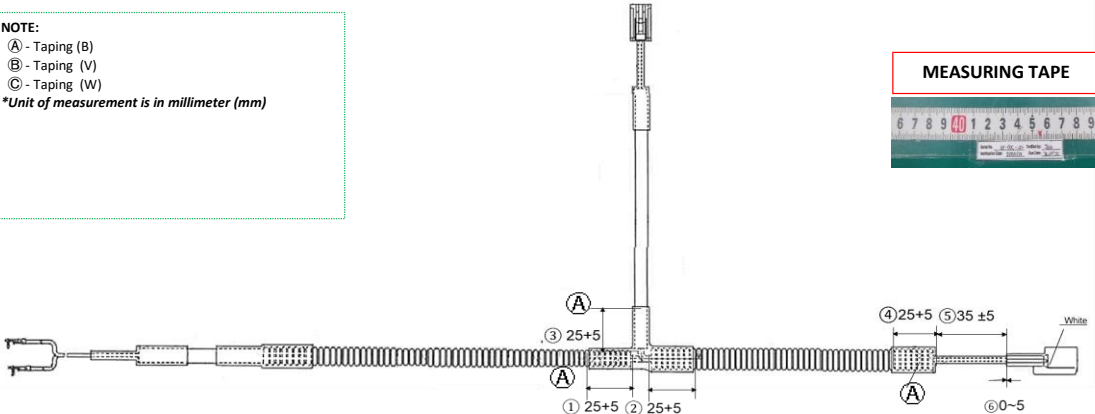
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2	Measurement	<div><div>NOTE:</div><div><div>(A) - Taping (B)</div><div>(B) - Taping (V)</div><div>(C) - Taping (W)</div></div><div><div>*Unit of measurement is in millimeter (mm)</div></div></div> <div></div>	<div>MEASURING TAPE</div> <div><div>1. No wrong dimension</div><div><div>Important reminders/Notes</div><div><div>1. Please use calibrated/verified measuring tape when fetting the measurement.</div><div>2. For Hatsumono, Nakamono and Owarimono</div></div><div><div>Document reference/s:</div><div><div>1. Please refer to WI-PRO-ASY-056 for Sub-Assy Hatsumono, Nakamono and Owarimono inspection.</div></div></div></div></div>

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524D / 7N0241-7020Customer: **TRJ**Car Model: **TOYOTA-PROBOX**

Document No.:

WI-ENG-PDE-1112B

Purpose:

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PROTOTYPE

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PRE-LAUNCH

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PARTS:

n/a

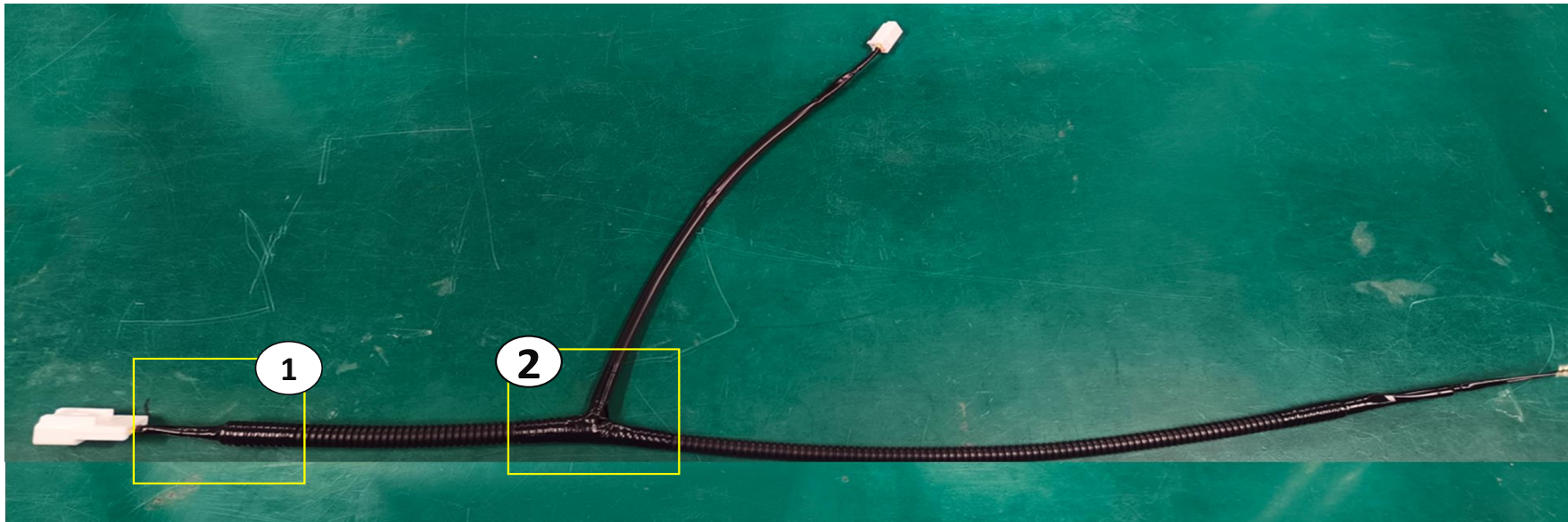
JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING - P2

7N0241-7020



①

No missing tape

②

No wrong facing of T-taping

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