



WORK INSTRUCTION

Effectivity Date:

July 12, 2024

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

D10L / 7M0654-7020A

Customer:

TRJ

Car Model:

DAIHATSU-TANTO

Document No.:

WI-ENG-PDE-156B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

5

Page No.:

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PARTS:

1. Assy part; Black tape

JIG:

1. Measuring jig

NO.

PROCESS NAME

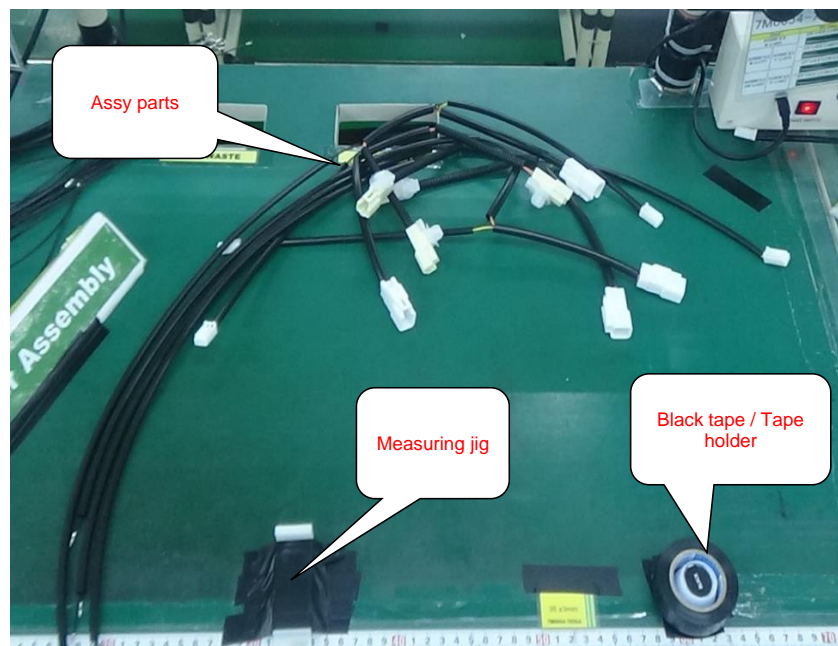
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WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

TABLE LAY-OUT



Safety Instruction

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. No missing parts/tools
2. No excess parts/tools


Revision History

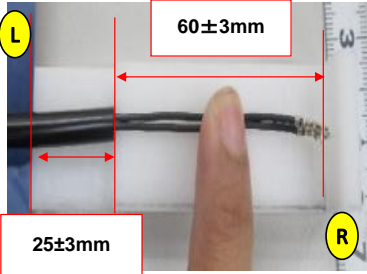
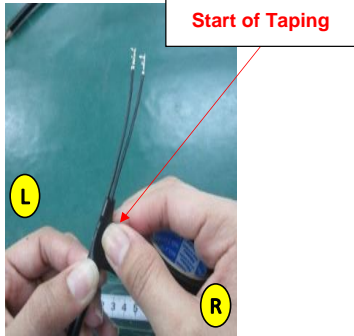
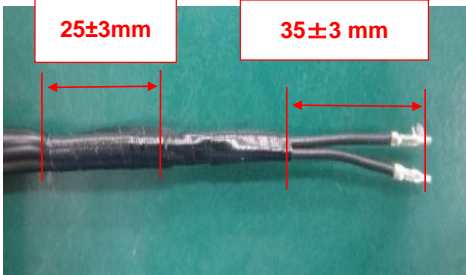


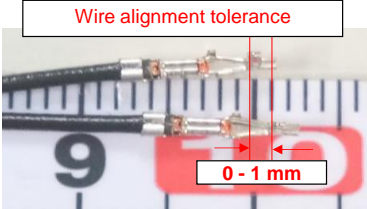
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
07/12/24	5	Transfer Taping 1 from P1 and separate Y-taping 2 to P3 (WI-ENG-PDE-156C) due to process improvement. Inclusion of car model "DAIHATSU-TANTO". Update Table lay-out and Visual inspection/Quality checkpoints.	D.Castillo	C. Villanueva	A. Arañes	n/a				
06/05/23	4	Improve Quality pointers; Reminders/Notes and references on process no.2. Standardized tube description: SV tube (Vinyl); Inclusion of Quality Checkpoints on last process. Additional table lay-out	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
04/27/21	3	Add assy parts on pg. 2~3 parts section	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 14, 2019		

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	Model code/Part number: D10L / 7M0654-7020A		Customer: TRJ	Car Model: DAIHATSU-TANTO	Document No.: WI-ENG-PDE-156B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	5	Page No.:	2 of 5



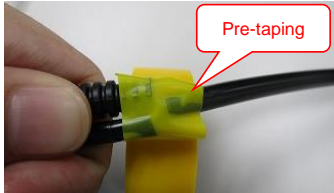
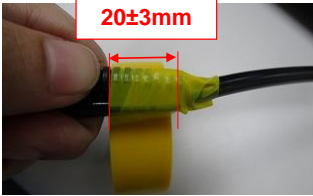

PARTS:	1. Assy parts 2. Black tape			JIG:	1. Measuring jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
2	P2 Taping 1 SV tube (Vinyl) to wire near terminal	<div><p>1. Get the assy part and measure the end of the SV tube (Vinyl) up to the terminal tip 60mm. Then, measure 25mm from the end of SV tube (Vinyl) using measuring jig.</p></div> <div><p>2. Hold the SV tube (Vinyl) using left hand and get the Black tape then start taping using right hand.</p></div> <div><p>3. After taping, check the condition of tape, measurement and wire alignment.</p></div>	<div><p>MEASURING JIG</p></div> <div><p>MEASURING TAPE</p></div>	<p>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <div><p>Wire alignment tolerance</p></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</p>			

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	Car Model:		DAIHATSU-TANTO		Document No.:	WI-ENG-PDE-156B				
Purpose:				<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	5	Page No.:	3 of 5

PARTS:		1. Black tape 2. Assy parts		JIG:	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	Y-taping 1		n/a	<div>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No gap between SV tube (Vinyl) and COT</div> <div>Important reminders/Note/s: 1. Use <u>YELLOW TAPE</u> for easy visualization of tape shifting nut actual should be <u>BLACK TAPE</u> 2. Please use calibrated/verified measuring tape when getting the measument.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</div> <div>CONNECTOR FACING </div>
		<div><p>No gap between tubes</p></div> <div><p>Pre-taping</p></div> <div>1. Fix the COT and SV tube (Vinyl). Make sure no gap in between.</div> <div>2. Get the tape and fix the COT SV tube (Vinyl). Make 1 wind pre-taping before shifting.</div> <div><p>20±3mm</p></div> <div>3. Make 1 shifting to the left until tape width then wind the tape 2x.</div>			

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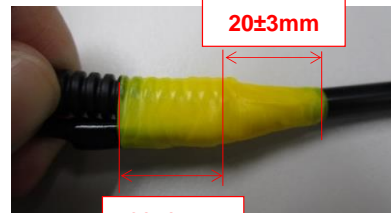

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Black tape 2. Assy parts	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 Y-taping 1 (Continuation)	<div></div> <div></div> <div></div> <div></div>	n/a	<p>Important reminders/Note/s:</p> <p>1. Use <u>YELLOW TAPE</u> for easy visualization of tape shifting nut actual should be <u>BLACK TAPE</u> 2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <p>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No gap between SV tube (Vinyl) and COT</p> <p>CONNECTOR FACING</p> 

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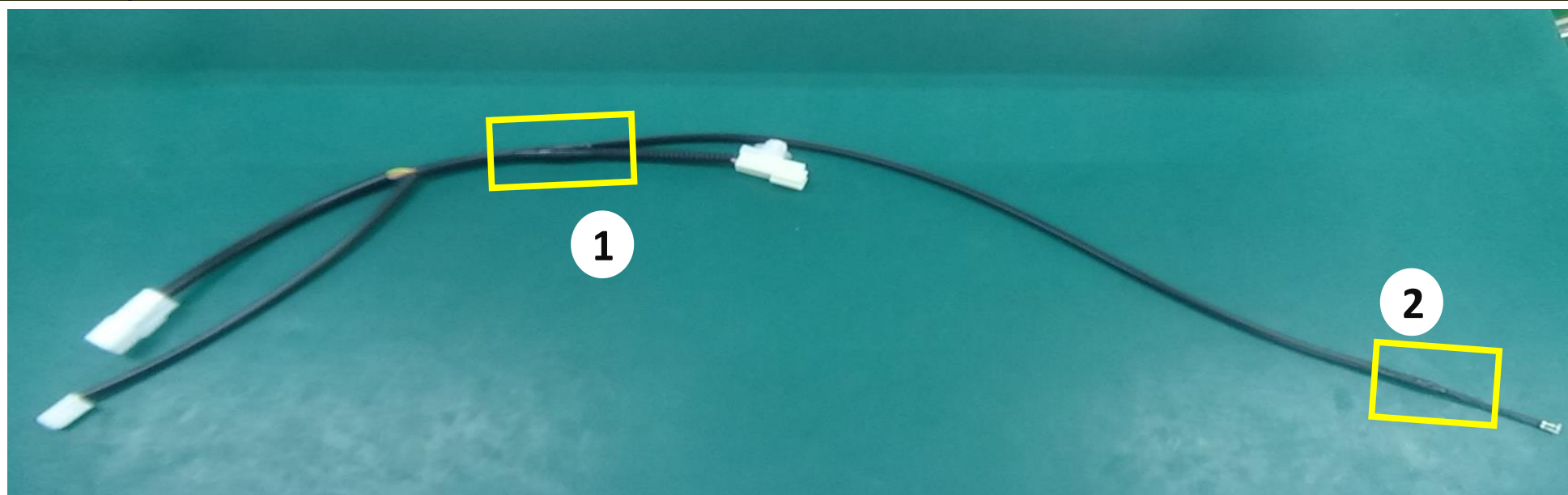
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P2****7M0654-7020A****① ② No Missing Tape**

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