



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 15, 2024

Process Name/Title:

Model code/Part number:

780B / 7R0102-7023B

Customer:

TRMX

Car Model:

TOYOTA TUNDR

Validity Date:

n/a

Document No.:

WI-PDE-1101B

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1. Assy parts; Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

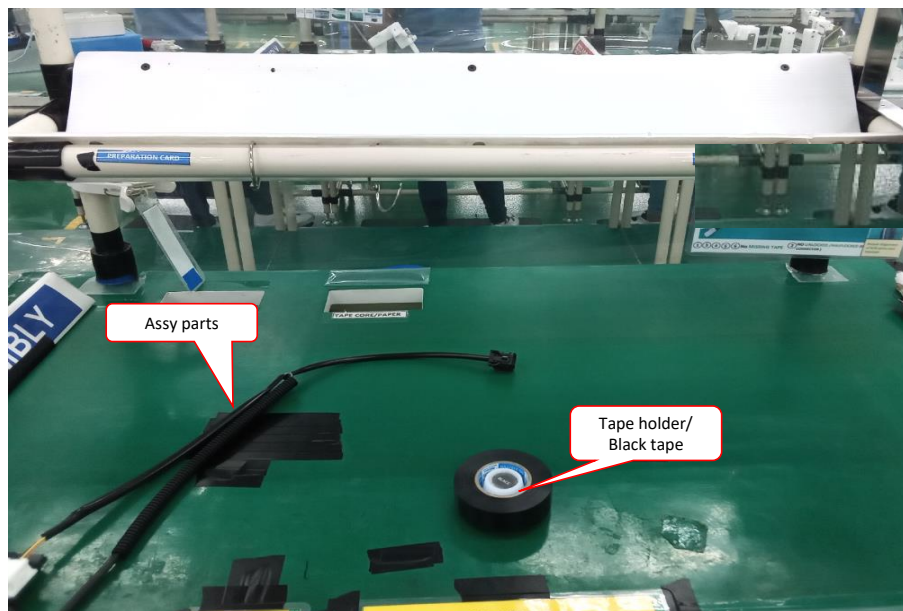
QUALITY POINTERS

1

P2

Table Lay-out

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.

Important reminders/Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.

1. No peel-off tape
2. No flip out tape
3. No loose tape
4. No wrong use of tape

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
10/15/24	1	Change Pre-launch to mass pro	A.Hernandez	C. Villanueva	A. Arañes	n/a	A.Hernandez	C. Villanueva	A. Arañes	n/a
10/14/24	0	Initial issue.	A.Hernandez	C. Villanueva	A. Arañes	n/a	A.Hernandez	C. Villanueva	A. Arañes	n/a

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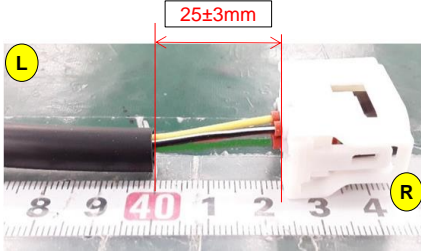

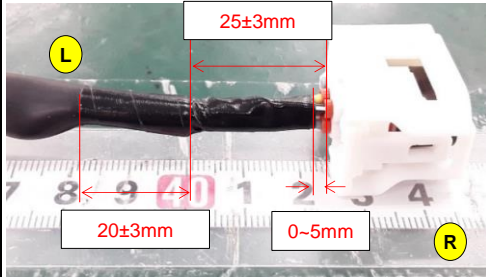

MASSPRO

Revision No.:

1

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PARTS:		1. Black tape 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 1 Vinyl tube to wire near connector	<div></div> <div>1. Hold the Vinyl tube using left hand. Measure the end of Vinyl up to the connector 25±3mm using right hand.</div> <div></div> <div>2. Hold the Vinyl tube using left hand. Get the Black tape using right hand and start taping. <i>Refer to WI-PRO-ASY-001 for taping procedure.</i></div> <div></div> <div>3. After taping, check the measurement and taping condition.</div>		MEASURING TAPE 	Important reminders/Note/s: <i>1. Please use calibrated/verified measuring tape when getting the measurement.</i> 1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape

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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 Taping 2 COT to Sunprene	<div><div><div><div><div>L</div><div><div>176±3mm</div></div></div><div><div><div>R</div></div></div></div></div><div><div>1. Hold the COT using left hand. Measure the end of COT up to the edge of hotmelted wire 176±3mm using right hand.</div></div><div><div><div><div><div>L</div><div><div>20±3mm</div></div></div><div><div>176±3mm</div></div><div><div><div>R</div></div></div></div></div><div><div>20±3mm</div></div><div><div>2. After taping, check the measurement and taping condition.</div></div></div><div><div><div><div>L</div><div><div>176±3mm</div></div></div><div><div><div>R</div></div></div></div></div><div><div>2. Hold the COT using left hand. Get the Black tape using right hand and start taping.</div></div></div> <div><div>MEASURING TAPE</div><div></div></div> <div><div>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape</div></div>			

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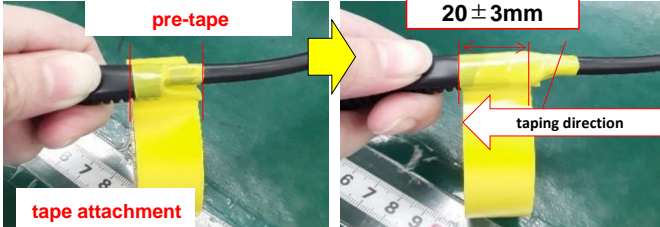
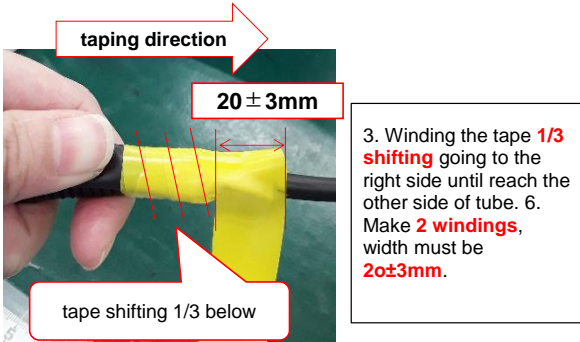
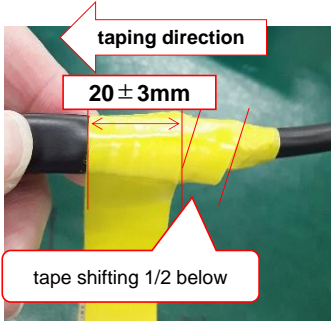

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2 Y-taping	<div><p>CORRECT FACING</p></div> <div><p>pre-tape</p><p>20 ± 3mm</p><p>taping direction</p><p>tape attachment</p></div> <div><p>taping direction</p><p>20 ± 3mm</p><p>tape shifting 1/3 below</p><p>3. Winding the tape 1/3 shifting going to the right side until reach the other side of tube. 6. Make 2 windings, width must be 20±3mm.</p></div> <div><p>taping direction</p><p>20 ± 3mm</p><p>tape shifting 1/2 below</p><p>4. Winding the tape 1/2 shifting going to the left side. Make 2 windings, width must be 20±3mm</p></div> <div><p>1. Fix the 3 corrugated tube. Note: Follow the correct facing. (If need to standard)</p><p>2. Start taping at the middle of combined tubes, attach the tape on the upper tube. Then make pre-tape 2 windings. Winding the tape 1/2 shifting going to the left side. Make 2 windings, width must be 20±3mm. Note: Do not exert excessive force during pulling & winding of tape.</p></div>			<p>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>Important reminders/Note/s: 1. Use yellow tape for easy visualization of tape shifting, but actual should be BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension-out tape 6. No exposed wire 7. No gap between tubes</p> <div><p>ORIENTATION</p></div>

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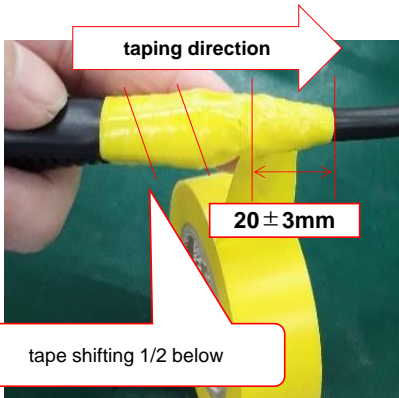
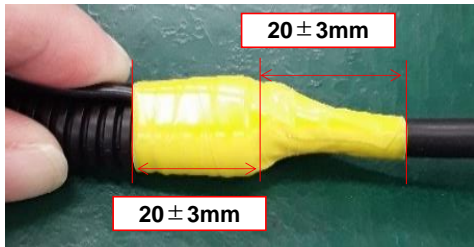
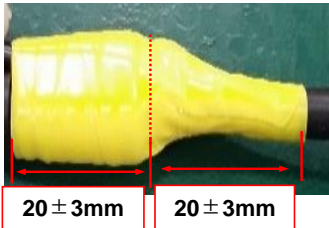
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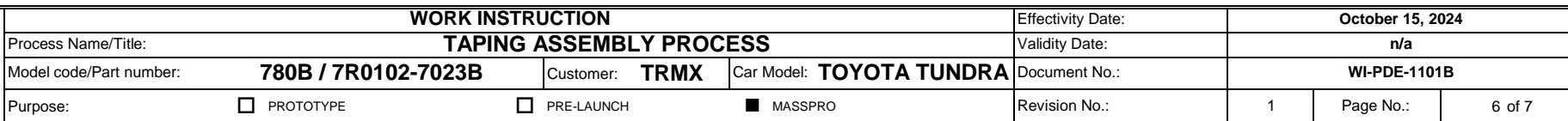
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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2 Y-taping (Continuation)	<div><p>taping direction</p><p>20 ± 3mm</p><p>tape shifting 1/2 below</p></div> <div>5. Winding the tape 1/2 shifting going to the right side until it reach the other side of tube. Make 3 winds, width must be 20±3mm. Then cut the tape.</div>		<div><p>20 ± 3mm</p><p>20 ± 3mm</p></div> <div>6. Check the Measurement and condition of tape.</div>	<p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>Important reminders/Note/s:</p> <p>1. Use yellow tape for easy visualization of tape shifting, but actual should be BLACK TAPE.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none">1. No loose tape2. No flip-out tape3. No peel-off tape4. No wrong use of tape5. No wrong dimension-out tape6. No exposed wire7. No gap between tubes <div><p>20 ± 3mm</p><p>20 ± 3mm</p></div>

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PARTS:

n/a

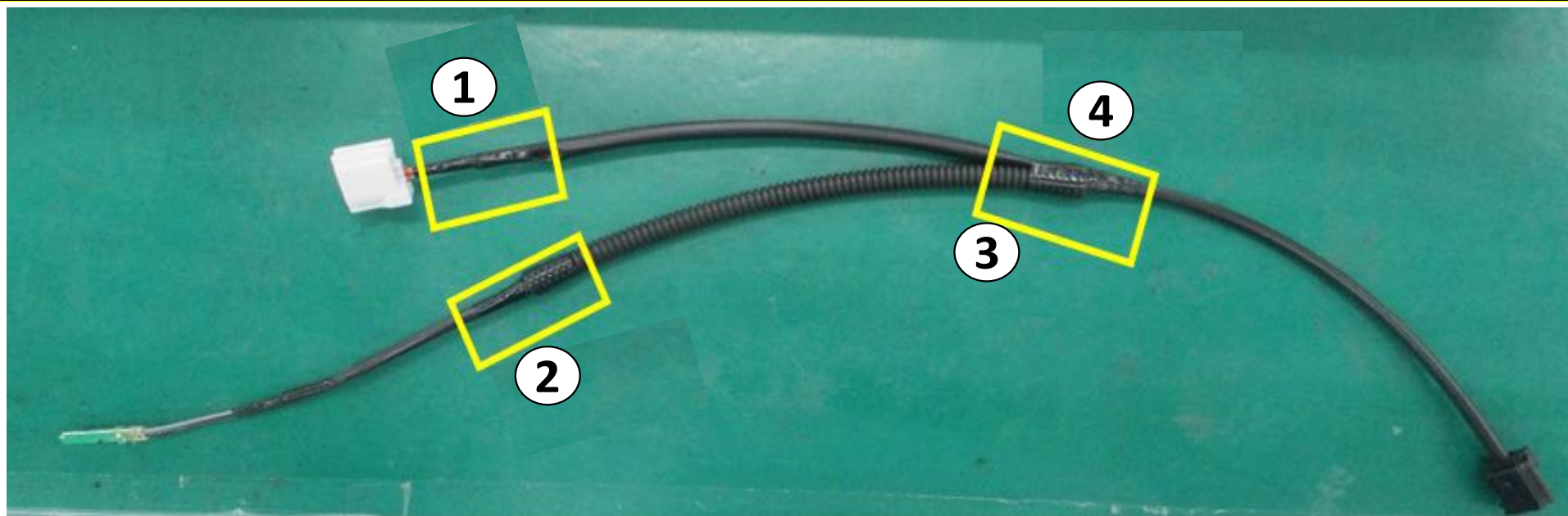
JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING - P2

7R0102-7023B



① ② ③ No Missing TAPE

④ Correct Facing of Y-Taping

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