



## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

August 20, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

920B / 7R0117-7025

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Document No.:

WI-ENG-PDE-982C

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

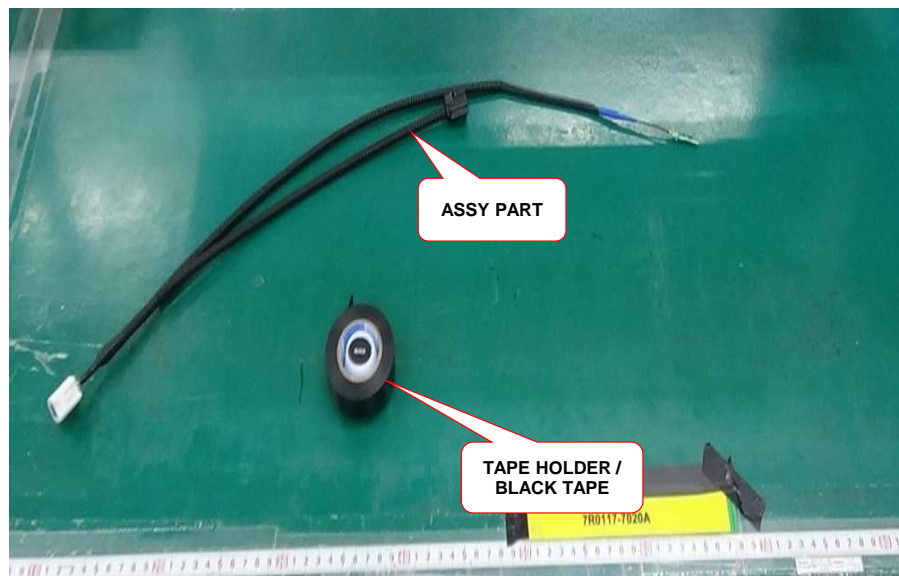
QUALITY POINTERS

1

P3

Table Lay-out

## TABLE LAYOUT



ASSY PART

TAPE HOLDER /  
BLACK TAPE

## Safety Instruction

Be sure to wear required 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

Prepared by

Reviewed by

Approved by

Noted by

8/20/24 1 Change purpose from Pre-launch to Masspro.

M.Ariola

C.Villanueva

A.Arañes

n/a

07/19/24 0 Initial issue.

M.Ariola

C.Villanueva

A.Arañes

n/a

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

July 19, 2024

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☐ PRE-LAUNCH


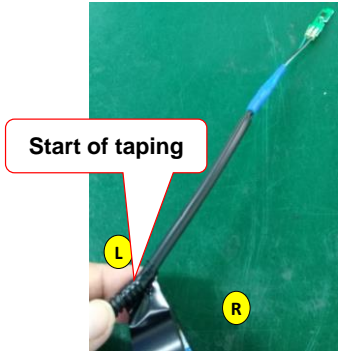
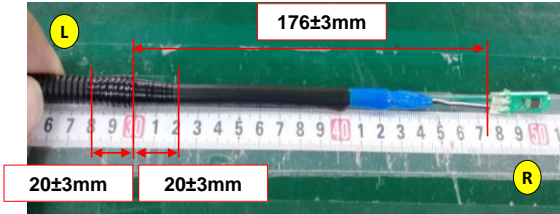

☒ MASSPRO

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1

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P3 Taping 3 COT to Black VM tube (Sunprene) near PCB	 <p>1. Measure from end of COT up to PCB <b>176±3mm</b> then start the taping process using both hands.</p>  <p>2. Hold the COT using left hand, get the <b>Black tape</b> using right hand then start pre-taping using both hands.</p>  <p>3. After taping, check the measurement and taping condition.</p>		<p><b>MEASURING TAPE</b></p> 	<p><b>Important reminders and Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></p> <p><b>Document reference/s:</b> <b>1. Refer to WI-PRO-ASY-001 for taping procedure.</b></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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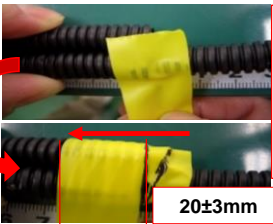

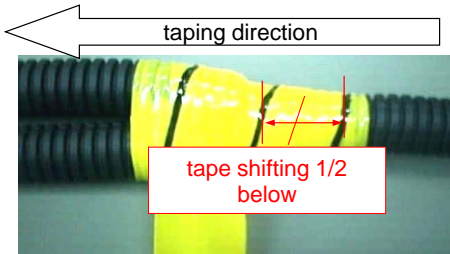
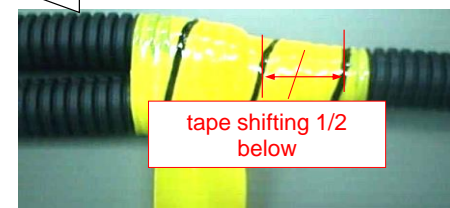
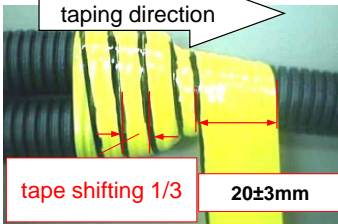
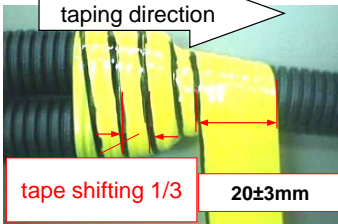
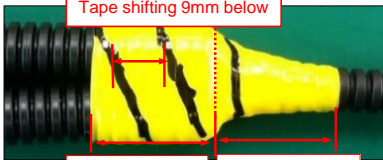
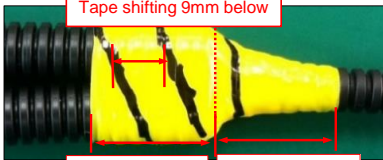
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**3 of 5****PARTS:**

1. Assy parts
2. Black tape

JIG:

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3 Y-Taping	<p><b>No gap in between tubes</b></p>  <p>1. Fix the corrugated tube .</p>  <p><b>Note:</b> Do not exert excessive force during pulling &amp; winding of tape</p>  <p><b>20±3mm</b></p> <p>2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side, width must be 20±3mm</p>  <p><b>taping direction</b></p>  <p><b>tape shifting 1/2 below</b></p> <p>4. Wind the tape backward 1/2 shifting</p>  <p><b>tape shifting 1/3</b></p>  <p><b>20±3mm</b></p> <p>3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be 20±3mm)</p>  <p><b>Tape shifting 9mm below</b></p>  <p><b>20±3mm</b> <b>20±3mm</b></p> <p>5. Wind the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.</p> 	n/a	<p><b>Important reminders/Note/s:</b></p> <p><b>1. Use <u>YELLOW TAPE</u> for easy visualization of shifting lines, but actual should be <u>BLACK TAPE</u>.</b></p> <ol 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 missing tape</li><li>5. No wrong dimension</li><li>6. No wrong use of tape</li></ol>

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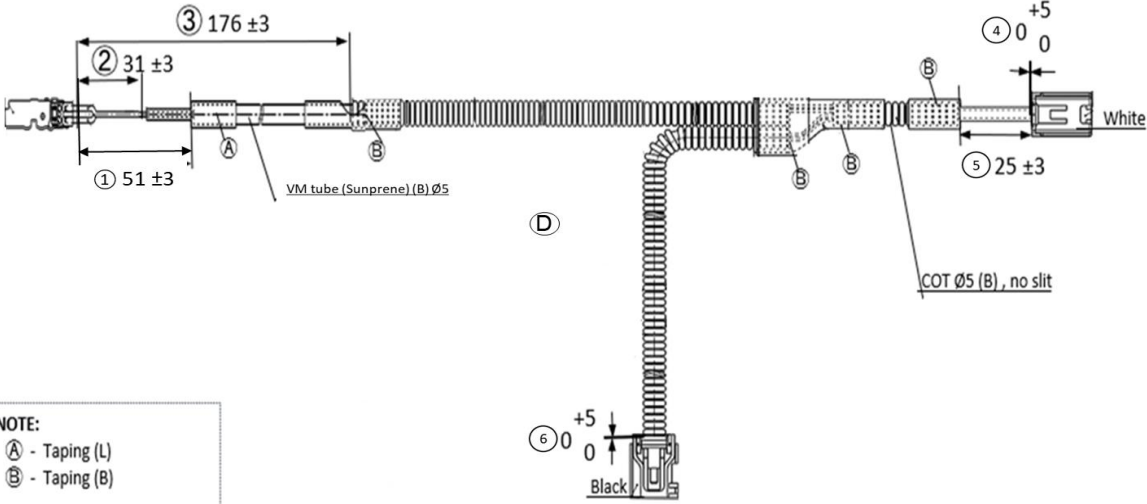

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P3	Measurement	<div><div>MEASURING TAPE</div><div></div><div>NOTE: A - Taping (L) B - Taping (B)</div></div>		<div><b>Important reminders and note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b> <b>2. For Hatsumono, Nakamono and Owarimono.</b>  <b>Document reference/s:</b> <b>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</b></div> <div>1. No wrong dimension</div>

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**5 of 5****PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P3****7R0117-7025****1****3****No MISSING TAPE****2****Correct Facing of Y-taping**

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