



WORK INSTRUCTION

Process Name/Title: **TAPING ASSEMBLY PROCESS**

Model code/Part number: **920B / 7R0122-7022** Customer: **TRMX** Car Model: **TOYOTA-TACOMA**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Effectivity Date: **September 19, 2024**

Validity Date: **n/a**

Document No.: **WI-ENG-PDE-721B**




Revision No.: **2** Page No.: **1** of **6**

PARTS: 1. Assy parts: Black tape; Tesa tape (51036)

JIG: 1. Tesa cutter

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Table lay-out	<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	1. No missing parts/tools 2. No excess parts/tools


Revision History

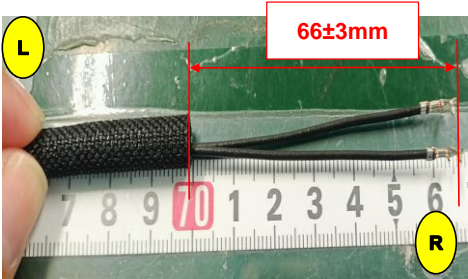



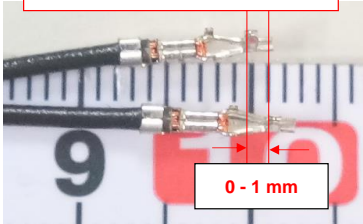
							Prepared by	Reviewed by	Approved by	Noted by
09/19/24	2	Improved Visual inspection/Quality checkpoint.	D.Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
09/06/23	1	Change purpose from pre-launch to mass pro.	M. Manalac	J. Lotere	C. Villanueva	A. Arañes				
09/01/23	0	Initial issue.	M. Manalac	J. Lotere	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 01, 2023		

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	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 920B / 7R0122-7022		Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.: WI-ENG-PDE-721B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	2	Page No.:	2 of 6

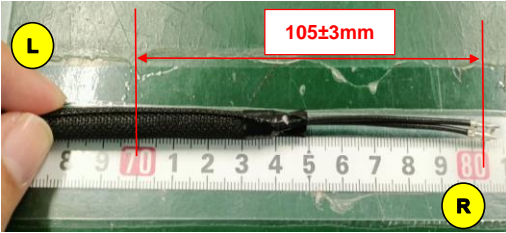




PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
2	P2	Spot taping 2 <div><div>1. Measure from Black twist tube 2420F 66±3mm up to terminal tip.</div><div>2. Hold the assy parts using left hand. Get the Black tape using right hand then start of taping</div><div>3. After taping, Check the measurement taping condition and wire alignment.</div></div>	<div>MEASURING TAPE</div> 	<div>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</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>Wire alignment tolerance</div>  <div>0 - 1 mm</div>	

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PARTS:		1. Assy parts 2. Tesa tape (51036)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	P2 Taping 1 Black twist tube 2420F to Wire near terminal	<div><p>1. Measure from Black twist tube (2420F) 105±3mm up to terminal tip.</p></div> <div><p>2. Hold the assy parts using left hand. Get Black tesa (51036) using right hand.</p></div> <div><p>3. Make 1 wind before shifting. 1/3 shifting until it reach the wire.</p></div> <div><p>4. Measure from end of Black twisted tube up to terminal tip 66±3mm then continue the taping process using both hands.</p></div>	<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <ul style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape	


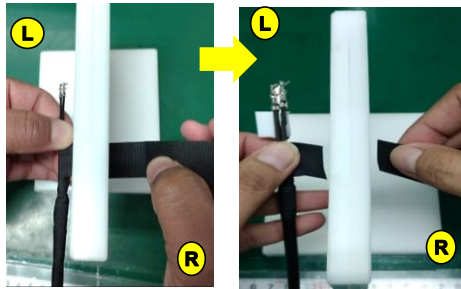
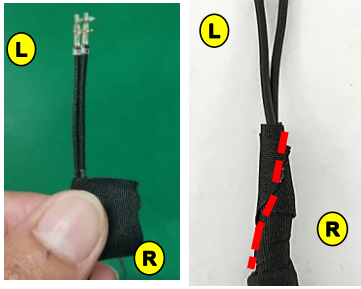
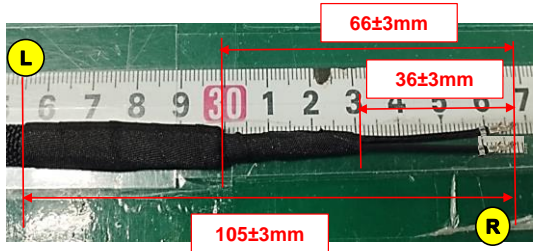


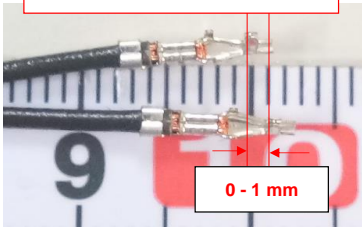
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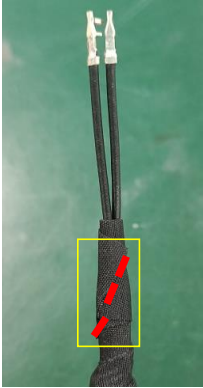




PARTS:	1. Assy parts 2. Tesa tape (51036)			JIG:	1. Tape cutter			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
3	P2 Taping 1 Black twist tube 2420F to Wire near terminal (Continuation)	<div><p>5. Measure from end of Black twisted tube up to terminal tip 36±3mm then continue the taping process using both hands.</p></div> <div><p>6. Cut the tape using provided tape cutter when reach the 1 1/2 wind using both hands.</p></div> <div><p>7. After cut, conduct pressing of end tape using both hands. <i>Note: End tape appearance should be slanted.</i></p></div> <div><p>8. After taping, Check the measurement, taping condition and wire alignment.</p></div>			<div><p>TAPE CUTTER</p></div> <div><p>MEASURING TAPE</p></div>	<p>Important reminders/Note/s: 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> <div><p>Wire alignment tolerance 0 - 1 mm</p></div>		

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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	<div><div></div><div></div><div></div><div><p>1. Hold the assy part using left hand then get the Black tape using right hand. then start taping process using both hands.</p><p>2. Conduct windings of tape until it covers the end of tesa tape then make 2 windings of tape before end of tape using both hands.</p><p>3. After spot taping, check the taping condition and alignment of wires. <i>Note: End of tesa tape must not be visible</i></p></div></div>	n/a	<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 6. No wrong dimension</p><div><div>SPOT TAPING APPEARANCE</div><div></div><div><p>GOOD (No exposed end of tesa tape)</p><p>NO GOOD (With Exposed tesa tape)</p><p>Spot taping range should be from 20~25mm only</p></div></div></div>		

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PROTOTYPE



PRE-LAUNCH



MASSPRO

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6 of 6**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P2****7R0122-7022****1****No Missing Spot tape (Black tape)**

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