



WORK INSTRUCTION

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

Model code/Part number: **920B / 7R0116-7021A** Customer: **TRMX** Car Model: **TOYOTA-TACOMA**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Effectivity Date: **June 24, 2024**

Validity Date: **n/a**

Document No.: **WI-ENG-PDE-650A**

Revision No.: **2** Page No.: **1** of **5**

PARTS: 1. Assy parts; Black SV tube (Vinyl) Ø5 L=139±3mm; Black VM tube (Sunprene) Ø5 L=123±3mm; White tape; Black tape

JIG:

1. Measuring jig

NO.

PROCESS NAME

2

WORK PROCEDURE/ ILLUSTRATION

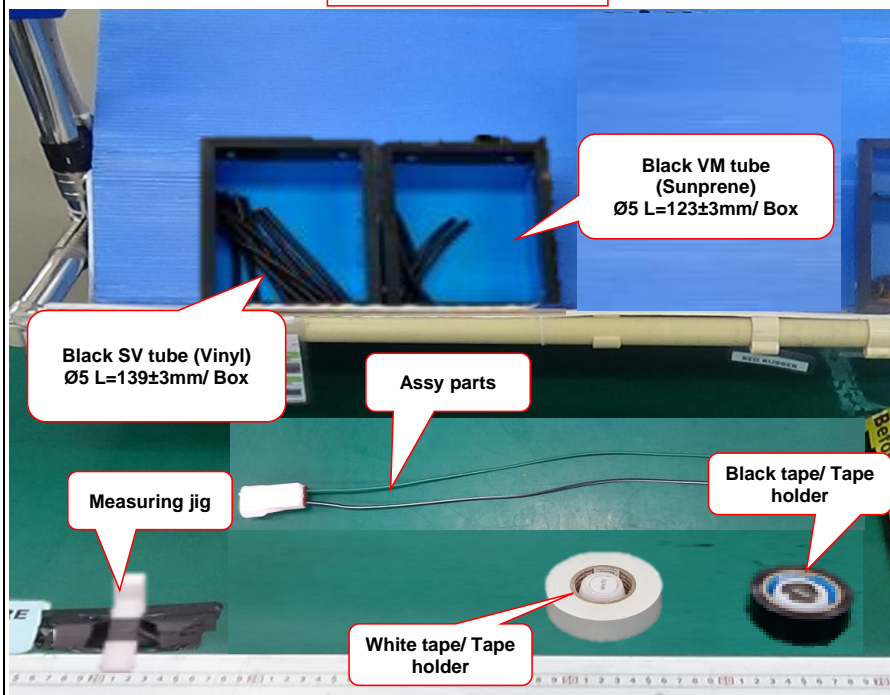
TOOLS/PPE

QUALITY POINTERS

1

P1

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.

Document reference/s:

1. Refer to **WI-ENG-PDE-920** for Offline assembly process

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


Revision History

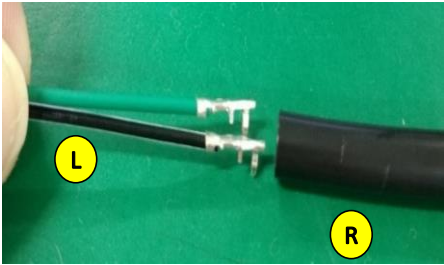

								Prepared by	Reviewed by	Approved by	Noted by
06/24/24	2	Transfer connector setting and wire insertion process to Offline assembly process due to process improvement. Inclusion of car model "TOYOTA-TACOMA". Update Table lay-out and Visual inspection/ Quality checkpoints.	D. Castillo	C. Villanueva	A. Arañes	n/a					
04/17/23	1	Document purpose from prelaunch to masspro. Improve table lay-out. Improve work procedure and illustration due to improvement. Additional quality pointers.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
03/16/23	0	Initial issue.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	March 16, 2023			

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		2	Page No.: 2 of 5

PARTS:		1. Black SV tube (Vinyl) Ø5 L=139±3mm 2. Black VM tube (Sunprene) Ø5 L=123±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	Wire Insertion to Black SV tube (Vinyl) Ø5 L=139±3mm	<div><div>1. Get the Black SV tube (Vinyl) Ø5 L=139±3mm using right hand then insert the G-B/W wires using left hand.</div></div>	n/a	1. No wrong use of parts
3		Wire Insertion to Black VM tube (Sunprene) Ø5 L=123±3mm	<div><div>1. Get the Black VM tube (Sunprene) Ø5 L=123±3mm using right hand then insert the G-B/W wires using left hand.</div></div>		

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☐ PROTOTYPE

☐ PRE-LAUNCH

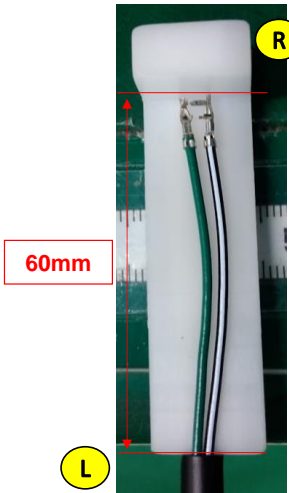
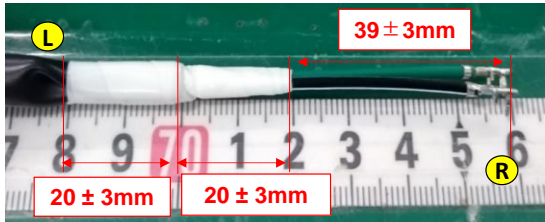
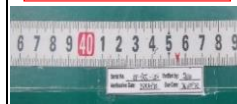

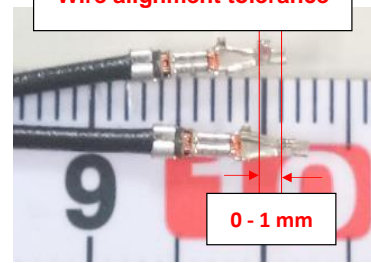
☒ MASSPRO

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PARTS:		1. Assy parts 2. White tape	JIG:	1. Measuring jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1 Taping 1 Black VM tube (Sunprene) to wire near terminal	<div><p>60mm</p><p>Start of taping</p><p>2. Hold the tube using left hand, get the White tape using right hand then start taping process using both hands.</p><p>1. Conduct measurement of 60mm from end of sunprene tube up to end of the terminal pointed tip using both hands.</p><p>39 ± 3mm</p><p>20 ± 3mm</p><p>20 ± 3mm</p><p>3. After taping, check the taping condition, measurement and wire alignment.</p></div>	<div><p>Measuring tape</p></div> <div><p>MEASURING JIG</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> <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> <p>Wire alignment tolerance</p>  <p>0 - 1 mm</p>

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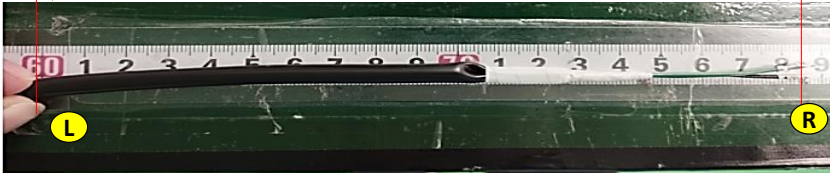

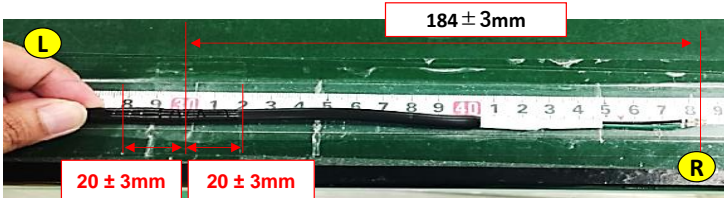

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1 Taping 2 Black SV tube (Vinyl) to Black VM tube (Sunprene) near terminal	<div><div><div>184 ± 3mm</div></div><div><div>1. Measure from end of corrugated tube up to terminal pointed tip 184±3mm using both hands.</div></div><div><div>Start of taping</div></div><div><div>2. Hold the corrugated tube and sunprene tube using left hand, get the Black tape then start taping process using both hands.</div></div><div></div><div><div>3. After taping, check the taping condition, measurement and wire alignment.</div></div></div>	<div>Measuring tape</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> <ul style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension

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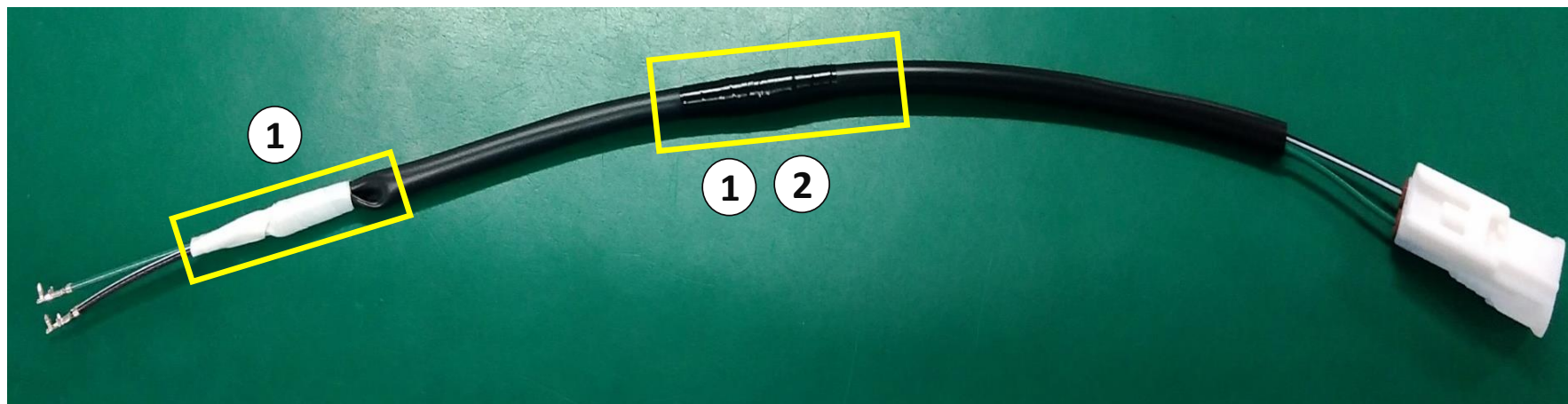
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5 of 5**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION****TAPING- P1****7R0116-7021A****1****No Wrong use of tape (White tape)****2****No Missing tape****3****No Deformed Terminal**

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