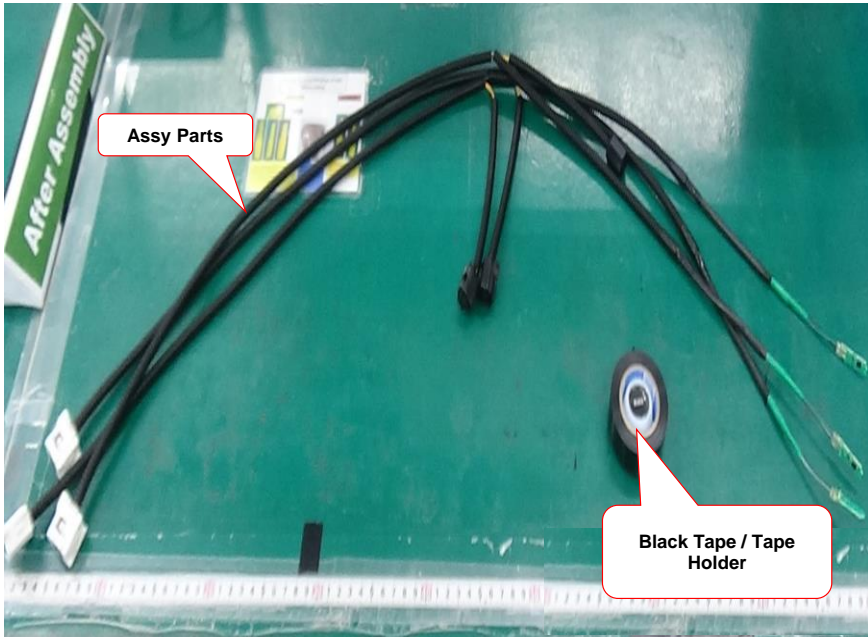



	WORK INSTRUCTION				Effectivity Date:		June 24, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 920B / 7R0118-7023		Customer: TRMX	Car Model: TOYOTA TACOMA	Document No.:		WI-ENG-PDE-654C	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		2	Page No.: 1 of 5


PARTS:		1. Assy parts: Black tape [1pc.]			JIG:		n/a	
NO.	PROCESS NAME	<div style="text-align: center;">2</div> WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE		QUALITY POINTERS	
1	P3	<div style="text-align: center;">Table Lay-out</div> 			<div style="border: 1px dashed red; padding: 5px;"> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div style="border: 1px dashed red; padding: 5px;"> <b>Housekeeping</b>            1. Maintain and always practice 5's.            2. Personal things on the workplace is prohibited. Keep it in your locker.         </div> <div style="border: 1px dashed red; padding: 5px;"> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>		1. No missing parts/tools 2. No excess parts/tools	


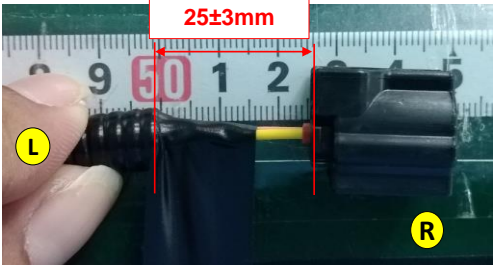
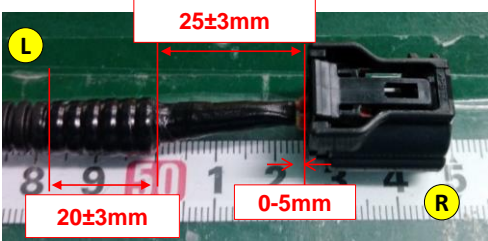


  

Revision History								Prepared by		Reviewed by		Approved by		Noted by					
06/24/24	2	Transfer Taping 3 and Y-taping from P2 (WI-ENG-PDE-654B). Separate Clamp setting and Clamp assembly to Clamp assembly process. Update Table lay-out, Measurement and Visual inspection/Quality checkpoints. Inclusion of car model "TOYOTA-TACOMA".						D.Castillo	C.Villanueva	A. Arañes	N/A	 D. Castillo		 C. Villanueva		 A. Arañes		N/A	
05/24/23	1	Change document from pre-launch to masspro. Additional table lay-out. Change clamp assembly jig from temporary to permanent jig.						D.Castillo	J.Loterte	C.Villanueva	A. Arañes								
03/21/23	0	Initial issue.						D.Castillo	J.Loterte	C.Villanueva	A. Arañes								
Eff. Date	Rev. No	Details of Change						Revised	Reviewed	Approved	Noted	Est. Date:		March 21, 2023					

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	<div style="text-align: right;">DCC Stamp</div>	

	<b>WORK INSTRUCTION</b>				Effectivity Date:		June 24, 2024	
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Model code/Part number: <b>920B / 7R0118-7023</b>		Customer: <b>TRMX</b>	Car Model: <b>TOYOTA TACOMA</b>	Document No.:		<b>WI-ENG-PDE-654C</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		2	Page No.:

<b>PARTS:</b>		1. Assy parts 2. Black tape		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
2	P3  Taping 3 COT to wire near connector	<div><p>Start of taping</p></div> <div><p>25±3mm</p></div> <div><p>25±3mm 20±3mm 0-5mm</p></div> <div><p>1. Hold the COT then get <b>Black tape</b> using right hand then start taping process using both hands.</p><p>2. Measure from end of COT up to edge of connector <b>25±3mm</b> then continue the taping process using both hands.</p><p>3. After taping, check the measurement and taping condition.</p></div> <td><div><b>MEASURING TAPE</b></div></td> <td colspan="2"><p><b>Important reminders and Note/s:</b></p><p><b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></p><p><b>Document reference/s:</b></p><p><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></td>	<div><b>MEASURING TAPE</b></div> 	<p><b>Important reminders and Note/s:</b></p> <p><b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></p> <p><b>Document reference/s:</b></p> <p><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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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

June 24, 2024

Validity Date:

n/a

Model code/Part number:

920B / 7R0118-7023

Customer:

TRMX

Car Model:

TOYOTA TACOMA

Document No.:

WI-ENG-PDE-654C

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH



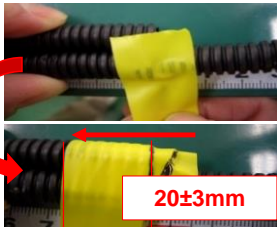
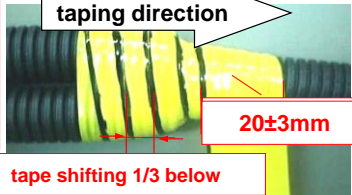

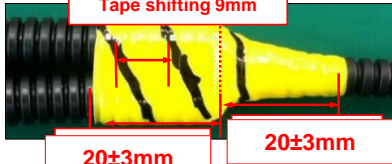
☒ MASSPRO

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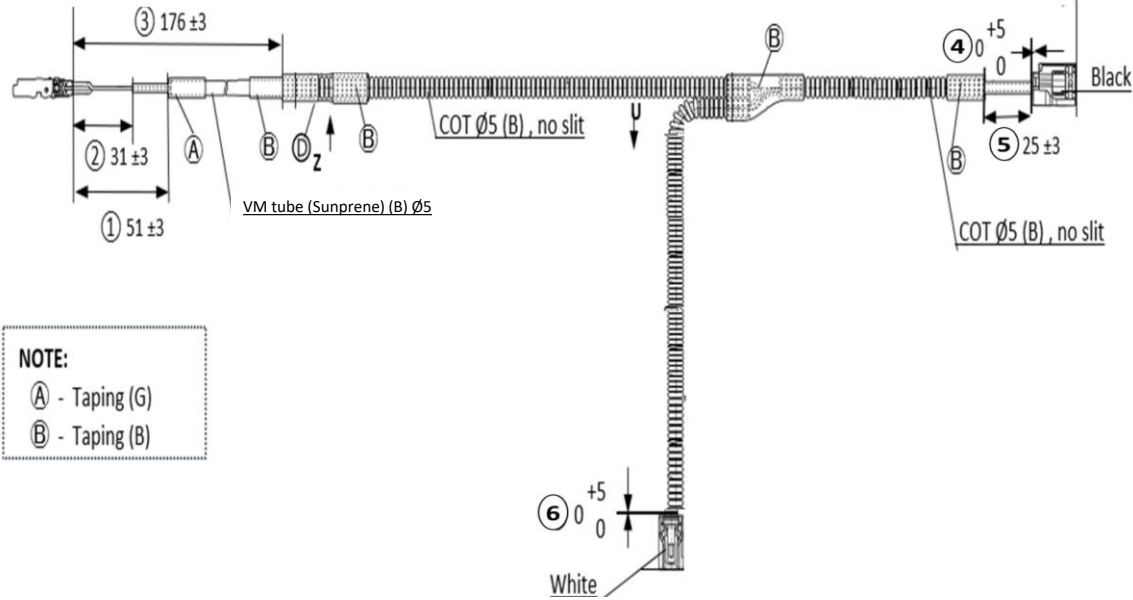

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P3 <div>2</div> Y-Taping	<div><div><p>No gap between tubes</p></div><div><p>1. Fix the corrugated tube .</p></div><div><div><p>20±3mm</p></div><div><p>Note: Do not exert excessive force during pulling &amp; winding of tape</p><p>taping direction</p><p>20±3mm</p><p>tape shifting 1/3 below</p></div><div><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>taping direction</p><p>tape shifting 1/2 below</p></div><div><p>Tape shifting 9mm</p><p>20±3mm</p><p>20±3mm</p><p>3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be 20±3mm)</p><p>4. Wind the tape backward 1/2 shifting</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></div></div></div>		n/a	<p><b>Important reminders/Note/s:</b></p> <p>1. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines, but actual should be <b>BLACK TAPE</b>.</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>

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	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>June 24, 2024</b>		
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>920B / 7R0118-7023</b>		Customer: <b>TRMX</b>	Car Model: <b>TOYOTA TACOMA</b>	Document No.:	<b>WI-ENG-PDE-654C</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.:	4 of 5

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

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

June 24, 2024

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n/a

Model code/Part number:

**920B / 7R0118-7023**

Customer:

**TRMX**

Car Model:

**TOYOTA TACOMA**

Document No.:

**WI-ENG-PDE-654C**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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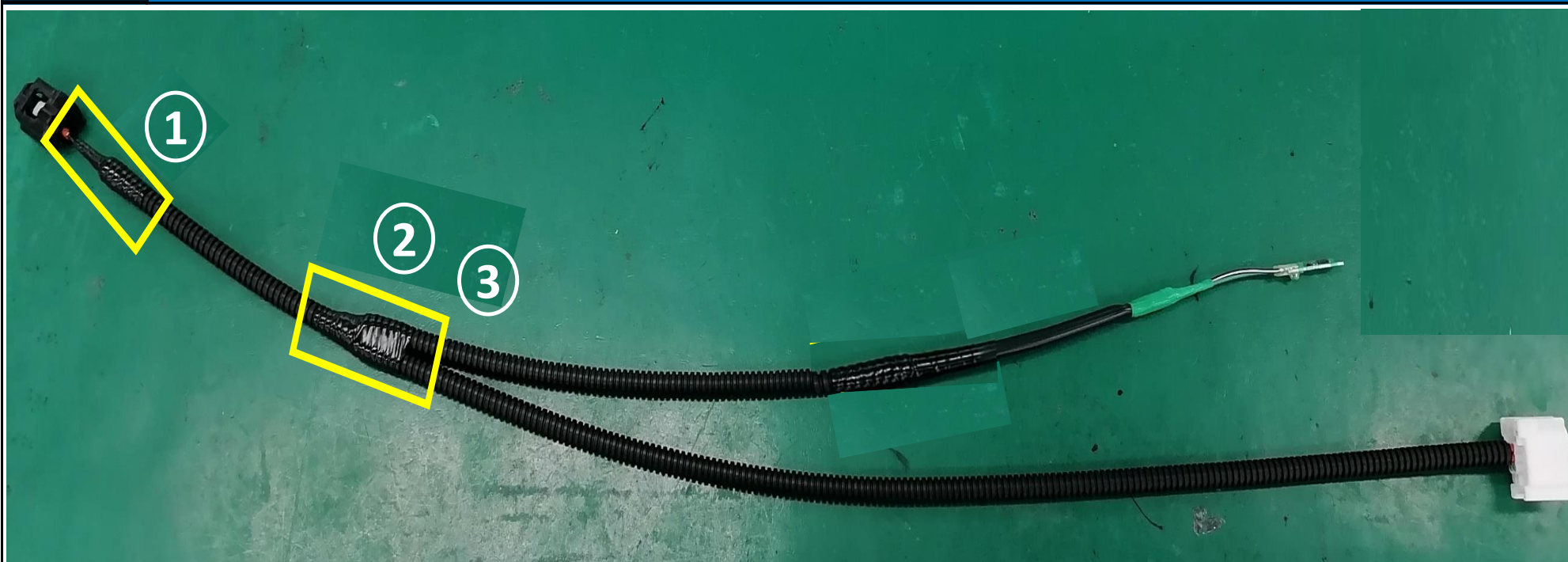
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P3****7R0118-7023****1****2****No MISSING TAPE****3****Correct Facing of Y-taping**

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