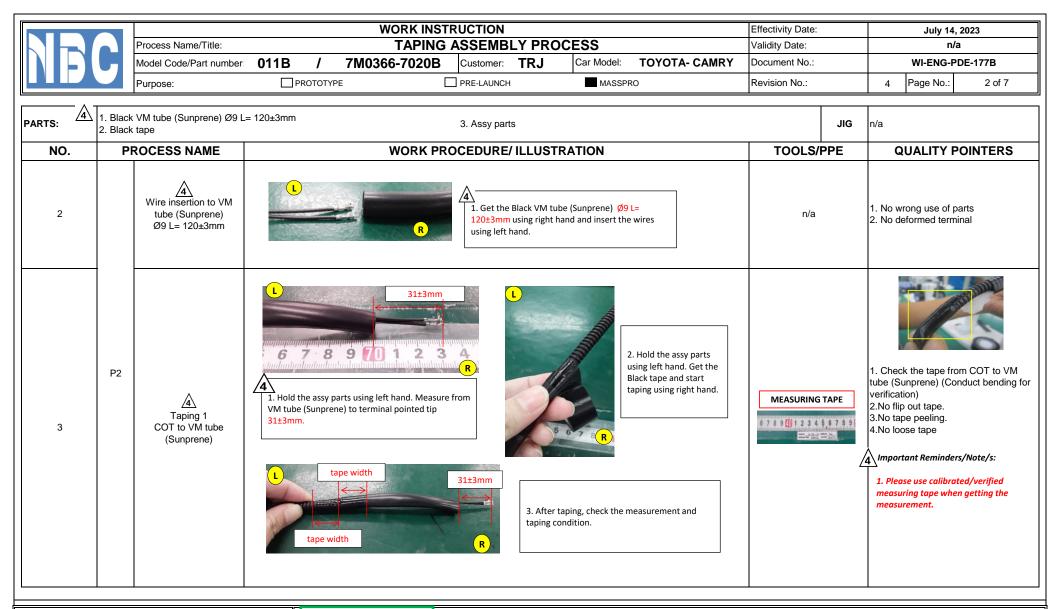
Process NameFille: TAPING ASSEMBLY PROCESS Model Code-Plan number 0118 / 7M0366-7020 Dusiner TRJ Call Model: TOYOTA-CAMRY Document No: We-BNO-PBE-178 Propose: Pro				WORK INSTRUCTION							Effec	ctivity Date:		July 14, 2023			
PARTS: 1. Asay parts 2. Black With the (Surprene) 69 L= 120zbrmm 3. Black tape NO. PROCESS NAME WORK PROCEDURE/ILLUSTRATION TOOLS/PPE QUALITY POINTERS TABLE LAY-OUT Safety Instruction Be sure to wear prescribed personal protective equipment. during operation (joves, first your locker) Surprene) 69 L= 120zbrmm TABLE LAY-OUT Process NAME Tools/PPE Table (syrout) Revision No: 1. No missing parts/tools. 2. No excess parts/tools. 3. No excess parts/tools. 4. No excess parts/tools. 5. No excess parts				Process Name/Title:		T.A	APING ASSEMBLY F	PROCESS			Valid	lity Date:			n/a		
PARTS: 1. Actory parts 2. Black VM tube (Sunprene) GR L= 120x3mm NO. PROCESS NAME WORK PROCEDURE/ILLUSTRATION TOOLS/PPE Safety Instruction Fe sure 10 wave prescribed personal full rung operation (gloves, finger cots, etc.) Housekeeping 1. Marietan and always prescribed personal full rung operation (gloves, finger cots, etc.) Housekeeping 2. No excess partshooks. 2. No excess partshooks. 2. No excess partshooks. 3. No missing partshooks. 3. No excess partshooks. 3. No excess partshooks. 4. No excess partshooks. 5. No excess partshooks. 6. No excess partshooks. 6. No excess partshooks. 7. Traping Ig Uddised templace includes includes in the description. VM labe (Surprene) gp. 1 4. Uddised templace includes includes included in the description. VM labe (Surprene) gp. 1 4. Uddised templace includes includes included in the description. VM labe (Surprene) gp. 1 4. Uddised templace includes included in the description. VM labe (Surprene) gp. 1 4. Uddised templace includes included in the description. VM labe (Surprene) gp. 1 5. Longer C. Ubanaco A Agains 6. Wilkeren A. Bilmanus 6. Alternation 6. Alternation 7. Parts assy parts on pp. 1. 3. 4 and 5. Add measuring lape illustration of Quality chackpoints [pg. 7] 8. Longer C. Ubanaco 6. Alternation 7. Alternation 8. Partshooks 8. Desired Charge process covered from Production in Production (VI NAPO ASY COX) is Engineering (WI-NAPO E-1773). Apply 9. Longer R. Partshooks 8. Longer R. Partshooks				Model Code/Part number	011B /	/ 7M0366-7	'020B Customer: TR	Car Model:	TOYO	TA-CAMR	Y Doci	ument No.:			WI-ENG-PDE-1	77B	
NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS TABLE LAY-OUT Safety Instruction Be sure to wear personal protective cougnment, using operation (gloves, finger cots, etc.) Ingression of the sure				Purpose:	PROT	ОТУРЕ	PRE-LAUNCH	MASS	PRO		Revi	sion No.:	4		Page No.:	1 of 7	
NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS TABLE LAY-OUT Safety Instruction Be sure to wear personal protective cougnment, using operation (gloves, finger cots, etc.) Ingression of the sure																	
TABLE LAY-OUT Be sure to wear prescribed personal protective equipment during operation (gives, finger cots, etc.) Housekeeping 1. Maintain and always practice 5; 2. Personal things on the 2. No excess participates 1. No missing participates 1. No m	PARTS:			Black VM tube (Sunprene) Ø9 L= 120±3mm								JIG:	1. T-T:	1. T-Taping jig			
Table lay-out P2 Table lay-out Table la	N	Ю.	PROCESS NAME WORK PROCEDURE/ ILLUSTRATION								TOOLS/PPE		QUALITY POINTERS				
Updated template; Inclusion of CAR MODEL "TOYOTA-CAMRY"; Standardized tube description: VM tube (Sunprene) pg. 1 and 2; Improve Quality pointers; Reminders/notes and references (pg. no.1-6); Inclusion of Quality checkpoints (pg.7) M. Ariola J. Loterte C. Villanueva A. Arañes O4/27/21 3 Put assy parts on pg. 1, 3, 4 and 5. Add measuring tape illustration and instruction on Y-taping pg.5 Updated template; Inclusion of CAR MODEL "TOYOTA-CAMRY"; Standardized tube description: VM tube (Sunprene) pg. 1 M. Ariola J. Loterte C. Villanueva A. Shimamura A. Arañes J. Loterte R. Peñaloza A. Shimamura A. Arañes M. Ariola J. Loterte C. Villanueva A. Shimamura A. Arañes M. Ariola J. Loterte C. Villanueva A. Shimamura A. Arañes M. Ariola J. Loterte J.		1	P2	Table lay-out		(Sunprene) Ø9 L= 120±3mm	y parts T-	8		lder/Black tape	p du	Be sure to wear prescribed person rotective equipmering operation (glofinger cots, etc.) Housekeeping Maintain and alw practice 5's. Personal things on orkplace is prohibicep it in your lock Alert level or any trouble, inforce Assembly Assist pervisor or Line Ler immediate correct	al ent ves,				
and 2; Improve Quality pointers; Reminders/notes and references (pg. no.1-6); Inclusion of Quality checkpoints (pg.7) M. Ariola J. Loterte C. Villanueva A.Arañes O4/27/21 3 Put assy parts on pg. 1, 3, 4 and 5. Add measuring tape illustration and instruction on Y-taping pg.5 D9/30/20 2 Change process owner from Production (WI-PRO-ASY-020) to Engineering (WI-ENG-PDE-177B); Apply someimprovements/update pictures J. Loterte R. Peñaloza A. Ahrañes J. Loterte R. Peñaloza A. Ahrañes M. Ariola J. Loterte A. Arañes M. Ariola J. Loterte J. Loterte R. Peñaloza A. Ahrañes M. Ariola J. Loterte J. Lo		1				Revision H	listory	ı	1	1		Prepared by	Reviewed b	y	Approved by	Noted by	
09/30/20 2 Change process owner from Production (WI-PRO-ASY-020) to Engineering (WI-ENG-PDE-177B); Apply someimprovements/update pictures Eff. Date Rev. No Details of Change Revised Revis	07/14/23	4)	J. Loterte	C. Villanueva	A.Arañes						
09/30/20 2 Change process owner from Production (WI-PRO-ASY-020) to Engineering (WI-ENG-PDE-177B); Apply someimprovements/update pictures J. Loterte R. Peñaloza A. Ahimamura A. Arañes M. Ariōla J. Loterte C. Villanueva A. Arañes Seff. Date Revised	04/27/21	3	Put assy	parts on pg. 1, 3, 4 and 5. Add	measuring tape il	llustration and instruction	on on Y-taping pg.5	J. Loterte	C. Villanueva	A. Shimamura	A.Arañes	Ol na.			, / / • "	(ALAX)	
Eff. Date Rev. No Details of Change Revised Reviewed Approved Noted Est. Date July 10, 2017	09/30/20	2			(WI-PRO-ASY-02	20) to Engineering (WI-	ENG-PDE-177B); Apply					M. Ariola	J. Louerte		C. Villanueva	A. Arabes	
Details of Change	Eff. Date				Deta	ils of Change						Est. Date:	July 10, 2017				
		Deta	ails of Ch	ange													



			WORK INSTRUCTION								Effectivity Date:		July 14, 2023		
		Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:			n/a						
		Model Code/Part number:	011B	1	7M0366-7020B	Custome			Car Model:	TOYOTA-CAMRY	Document No.:		WI-ENG	3-PDE-1	77B
		Purpose:	PR	ОТОТҮРЕ	: [☐ PRE-LAUN	ICH	I	MASSPRO)	Revision No.:		4 Page No	.:[3 of 7
PARTS:	1. Black 2. Assy											JIG	1. T-taping jig		
NO.	PI	ROCESS NAME			WORK PRO	OCEDUR	E/ IL	LUSTRA	TION		TOOLS/	PPE	QUALITY POINTERS		
3	P2	T-Taping		aping at th	a corrugated tube to form in	gap between	Tubes	and right hand	om front to bac	k at the right	MEASURIN 6 7 8 9 10 1 2 3	4 5 6 7 8 9	Important Rema 1. Used YELLOW visualize the tap should be BLACA 1. No flip-out tape 2. No Peel-off tap 3. No loose tape 4. No missing tap 5. No wrong use 6. no wrong dime	TAPE to be shifting (TAPE.	easily

			WORK INSTRUCTION	Effectivity Date:	July 14, 2023		
		Process Name/Title:	TAPING ASSEMBLY PROCESS	Validity Date:	n/a		
		Model Code/Part number:	011B / 7M0366-7020B Customer: TRJ Car Model:	TOYOTA-CAMRY Document No.:	WI-ENG-PDE-177B		
		Purpose:	□ PROTOTYPE □ PRE-LAUNCH ■ MASSPE	RO Revision No.:	4 Page No.: 4 of 7		
				-			
PARTS:	1. Assy 2. Black			JIG	1. T-taping jig		
NO.	Р	ROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS		
3	P2	T-taping (continuation)	4. Wind the tape from back to front (cross pattern) 5. Wind the tape from front to be side 6. Wind the tape from back to front (cross pattern) 8. Remove the harness for T-taping jig ther side corrugated tube (3 winds), width must (19mm) 7. Repeat the process from ③~⑥ 3 times	measuring Tape 6789@123466789	Important Reminders/Note/s: 1. Used YELLOW TAPE to easily visualize the tape shifting.But actual should be BLACK TAPE. 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		

			WORK INSTRUCTION Effectivity	Date:	July 14, 2023	
		Process Name/Title:	TAPING ASSEMBLY PROCESS Validity Da	ite:	n/a	
		Model Code/Part number:	011B / 7M0366-7020B Customer: TRJ Car Model: TOYOTA-CAMRY Document	No.:	WI-ENG-PDE-177B	
		Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO Revision N	lo.:	4 Page No.: 5 of 7	
		<u> </u>				
PARTS:	1. Assy 2. Black			JIG	1. T-taping jig	
NO.	Р	ROCESS NAME	WORK PROCEDURE/ ILLUSTRATION TOO	OLS/PPE	QUALITY POINTERS	
3	P2	T-taping (continuation)	9. From the right side, wind the tape 2/3 shifting 10. Wind the tape from front to back side (cross	SURING TAPE	Important Reminders/Note/s: 1. Used YELLOW TAPE to easily visualize the tape shifting.But actual should be BLACK TAPE. 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	

			WORK INSTRUCTION		Effectivity Date:		July 14,	2023	
		Process Name/Title: TAPING ASSEMBLY PROCESS					n/a		
		Model Code/Part number:	1B / 7M0366-7020B Customer: TRJ	Car Model: TOYOTA-CAMRY	Document No.:		WI-ENG-P	DE-177B	
		Purpose:	PROTOTYPE PRE-LAUNCH	MASSPRO	Revision No.:		4 Page No.:	6 of 7	
	ı				1				
PARTS:	1. Assy 2. Black					JIG	1. T-taping jig		
NO.	Р	ROCESS NAME	WORK PROCEDURE/ ILLUSTRA	ATION	TOOLS/F	PPE	QUALITY F	QUALITY POINTERS	
3	P2	T-taping (continuation)	pattern) Ta R 19r	From front to back side (cross ping Condition 19mm 19mm 19mm	6 7 8 9 10 1 2 3 4	\$ 6 7 8 9 (Important Remin 1. Used YELLOW TA visualize the tapes should be BLACK TA 1. No flip-out tape 2. No Peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of t 6. no wrong dimension	APE to easily hifting.But actual APE.	

