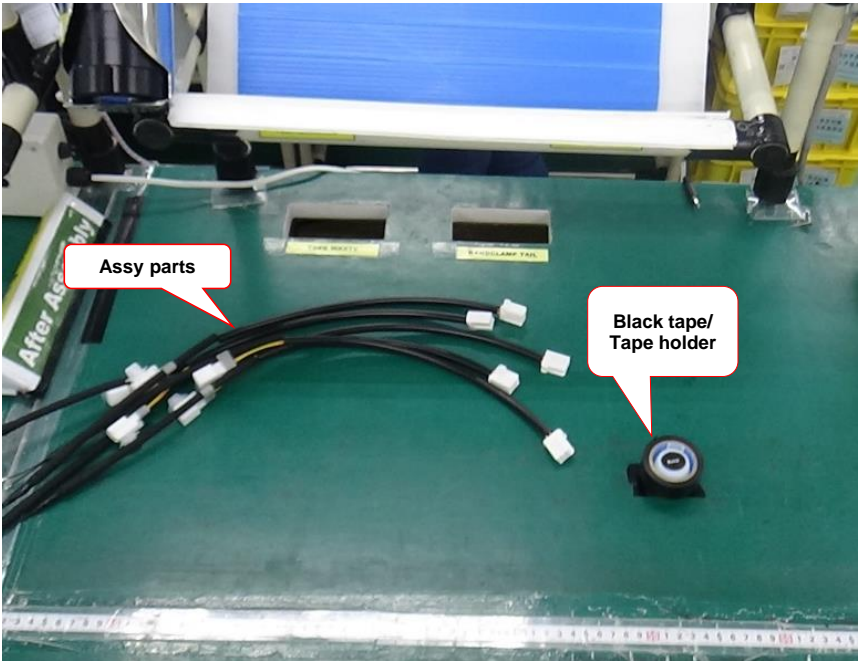


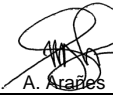

	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date:	October 09, 2024		
	Process Name/Title:				Validity Date:	n/a		
	Model code/Part number: 920B / 7R0115-7021A		Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:	WI-ENG-PDE-655C		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	1 of 5

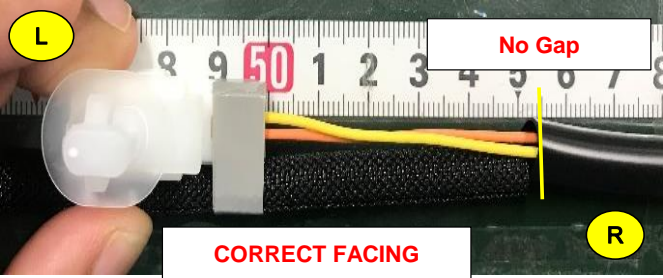

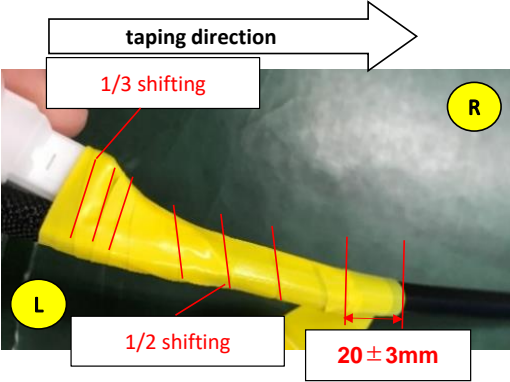
PARTS:	1. Assy parts; Black tape				JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
1	P3	<div style="border: 1px solid red; padding: 5px; text-align: center;">Table Lay-out</div> 			<div style="border: 1px solid red; padding: 5px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px;"> Housekeeping 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 solid red; padding: 5px;"> Alert level! 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
10/09/24	0	Initial issue. Separate Y-taping process from P2.	D. Castillo	C. Villanueva	A. Arañes	n/a			
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 09, 2024	

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	WORK INSTRUCTION			Effectivity Date:	October 09, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	2 of 5

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
2	P3 Y-taping	<div></div> <div></div> <div></div>		<div>1. Hold the assy parts. Must be no gap. Note: Follow the correct facing.</div> <div>2. Get the Black tape and attach the tape above the gray tape. Make 2 winds before 1/3 shifting.</div> <div>3. Winding the tape upward 1/3 shifting , then conduct 1/2 shifting upward until it reach the SV tube (Vinyl). Make 2 windings, width must be</div>	<div>Important reminders/Note/s: 1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE. 2. 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 7. Follow the correct facing</div>	

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920B / 7R0115-7021A

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Document No.:

WI-ENG-PDE-655C

Purpose:



PROTOTYPE



PRE-LAUNCH



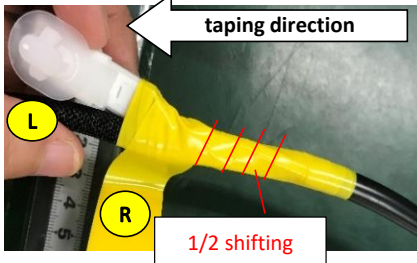
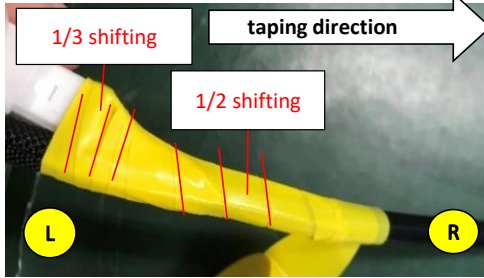
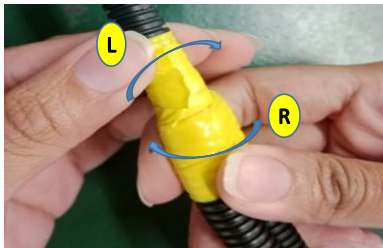

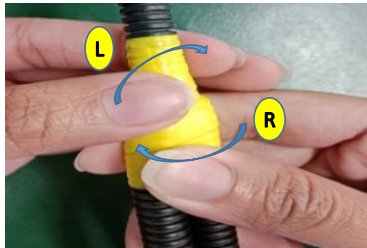
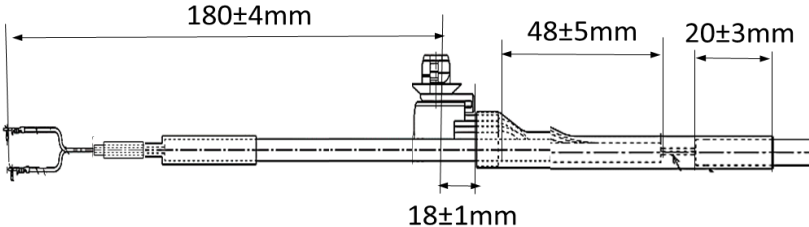
MASSPRO

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P3 Y-taping (Continuation)	<div><p>4. Winding the tape backward until reach the connector 1/2 shifting. Make 2 windings.</p></div> <div><p>5. Wind the tape 1/3 shifting then 1/2 shifting, same shifting to no.3, then cut the tape after 2 winds on SV tube (Vinyl).</p></div> <div><p>6. conduct proper pressing of end tape using left hand (top part). Note: Reference only.</p></div> <div><p>7. conduct proper pressing of end tape using left hand (Middle part). Note: Reference only.</p></div> <div><p>8. conduct proper pressing of end tape using left hand (bottom part). Note: Reference only.</p></div> <div><p>9. Check the Measurement and condition of tape.</p></div>			<p>Important reminders/Note/s:</p> <p>1. Use <u>YELLOW TAPE</u> for easy visualization of shifting lines, but actual should be <u>BLACK TAPE</u>.</p> <p>2. 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 7. Follow the correct facing</p>

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**WORK INSTRUCTION**

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TAPING ASSEMBLY PROCESS

Effectivity Date:

October 09, 2024

Model code/Part number:

920B / 7R0115-7021A

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Document No.:

WI-ENG-PDE-655C

Purpose:



PROTOTYPE



PRE-LAUNCH



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

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PROTOTYPE



PRE-LAUNCH



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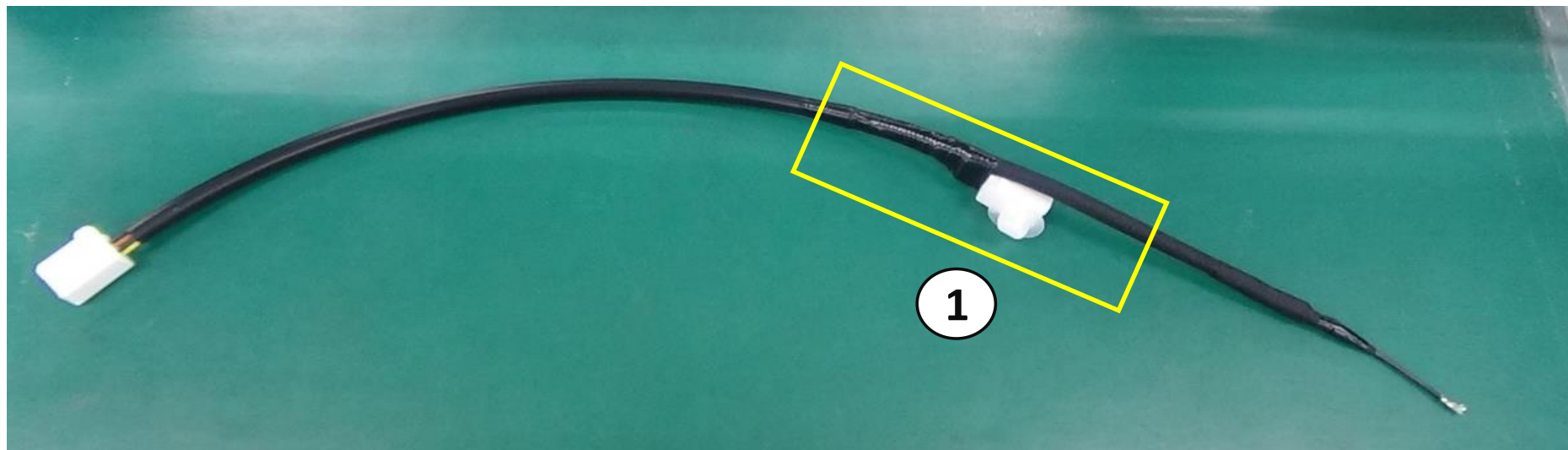
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P3****7R0115-7021A****1****No Wrong orientation of Connector with clip clamp**

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