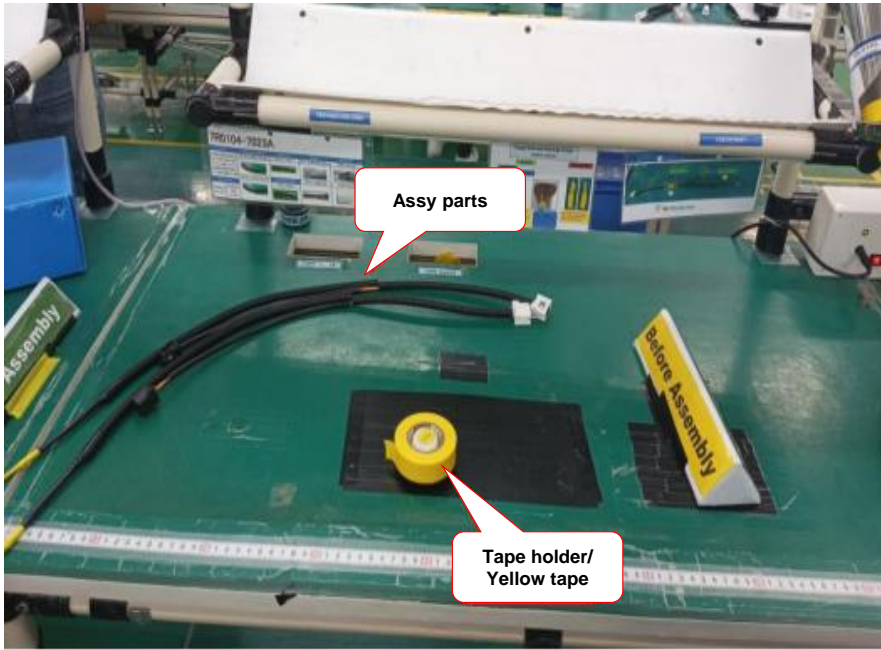
	WORK INSTRUCTION						Effectivity Date:		February 13, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS						Validity Date:		n/a	
	Model code/Part number: 780B / 7R0104-7023A		Customer: TRMX		Car Model: TOYOTA-TUNDRA		Document No.:		WI-ENG-PDE-557C	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.:		4	Page No.: 1 of 5

PARTS:		1. Assy parts; Yellow 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 dashed red; padding: 5px;"> <p>Safety Instruction</p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px dashed red; padding: 5px;"> <p>Housekeeping</p> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> </div> <div style="border: 1px dashed red; padding: 5px;"> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>		<p>1. No missing parts/tools 2. No excess parts/tools</p>	

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
02/13/24	4	Inclusion of Car model "TOYOTA-TUNDRA"						D.Castillo	C. Villanueva	A. Arañes	n/a				
01/19/23	3	Remove taping of Sunprene tube to wire near terminal hotmelted wires then transfer to P1; Transfer process no.7 and 8 from P3 to P2 as DCS countermeasure for missing tape and out of tolerance. Inclusion of Quality Checkpoint.						M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
11/10/22	2	Improve Quality pointers; Reminders/Note/s and references on page no. 1,2,3 and 5 due to document improvement.						M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change						Revised	Reviewed	Approved	Noted	Est. Date:	July 19, 2022		

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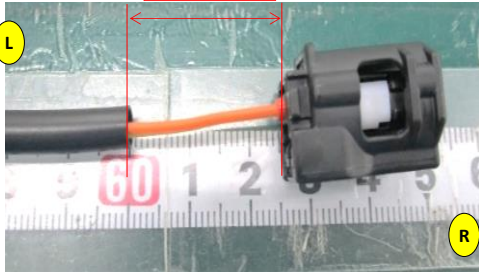

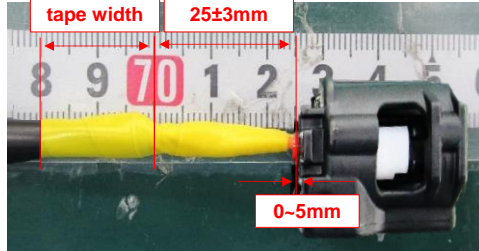

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Yellow tape [1pc]		JIG:	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P3 Taping 4 Black SV tube (Vinyl) to wire near connector	<div><div><div><div><div><div></div><div>25±3mm</div></div><div><div>L</div><div></div><div><div>R</div></div></div></div><div><div>1. Hold the SV tube (Vinyl) using left hand. Measure from end of vinyl tube up to connector 25±3mm using both hands.</div></div></div><div><div><div><div><div><div></div><div>Start of taping</div></div><div><div>L</div><div></div><div><div>R</div></div></div></div><div><div>2. Hold the SV tube (Vinyl) using left hand. Get the Black tape using right hand and start taping process using both hands.</div></div></div><div><div><div><div><div><div></div><div>tape width</div></div><div><div>25±3mm</div></div><div><div>0~5mm</div></div></div><div><div></div><div><div>3. After taping, check the measurement and taping condition.</div></div></div></div></div></div></div></div></div></div>		<div>MEASURING TAPE</div> <div></div>	<div>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension</div> <div>Important reminders/note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Set aside the assy part after assembly. 3. Use YELLOW TAPE only.</div> <div>Document references: 1. Please refer to WI-PRO-ASY-001 for taping procedure.</div>

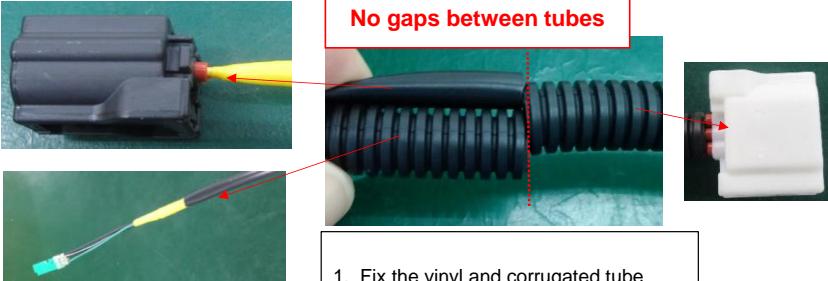
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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		4	Page No.: 3 of 5

PARTS:			1. Assy parts 2. Yellow tape [1pc]		JIG:	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS		
3	P3	Y-Taping	N/A	<div>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension</div> <div>Important reminders/note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Use YELLOW TAPE only. 3. Must be no gap between the Corrugated tube and Vinyl.</div> <div>Document references: 1. Please refer to WI-PRO-ASY-001 for taping procedure.</div>		



No gaps between tubes

1. Fix the vinyl and corrugated tube using both hands.
See illustration for correct facing of connector.



2. Start taping at the middle of combined Corrugated tubes & vinyl tube, make **1 winding** pre-tape before shifting.

3. Make 1 wind going to Vinyl tube & corrugated tube , width must be same with tape **(19mm)**.


tape width

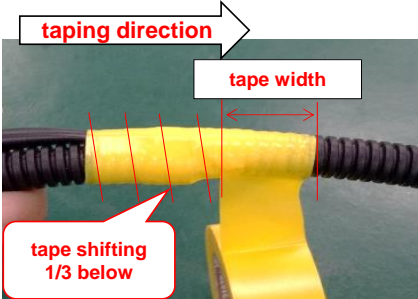
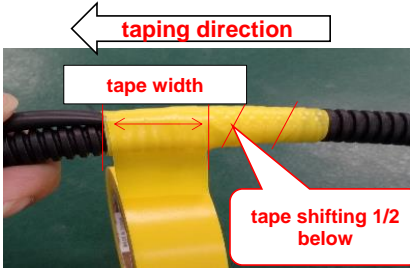
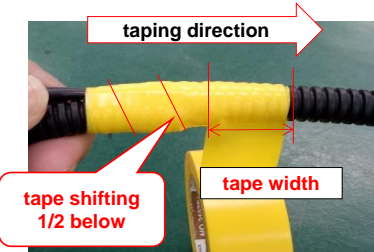
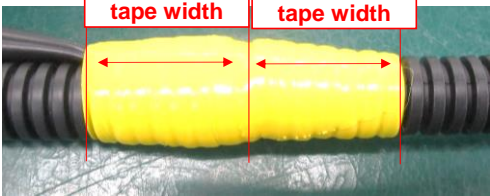

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		4	Page No.: 4 of 5

PARTS:		1. Assy parts 2. Yellow tape		JIG:	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	P3 Y-Taping (Continuation)	<div></div> <div></div> <div></div> <div></div> <div><p>4. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width).</p><p>5. Wind the tape backward 1/2 shifting.</p><p>6. Wind the tape 1/2 shifting going to other side of corrugated tube then cut the tape.</p><p>7. After taping, check the measurement and taping condition.</p></div>	<div>MEASURING TAPE</div> 	<p>Important reminders/note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. Use YELLOW TAPE only.</p> <p>3. Must be no gap between the Corrugated tube and Vinyl.</p> <p>Document references:</p> <p>1. Please refer to WI-PRO-ASY-001 for taping procedure.</p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension</p>	

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PARTS:

N/A

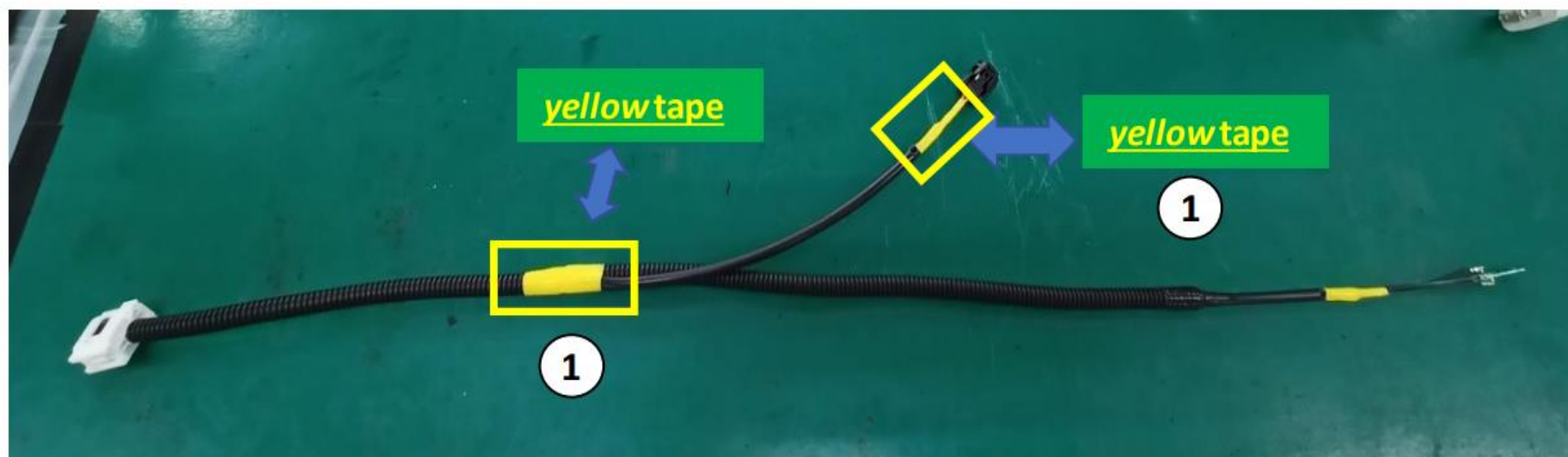
JIG:

N/A

QUALITY CHECKPOINTS

P3

7R0104-7023A



1 No Missing tape

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