
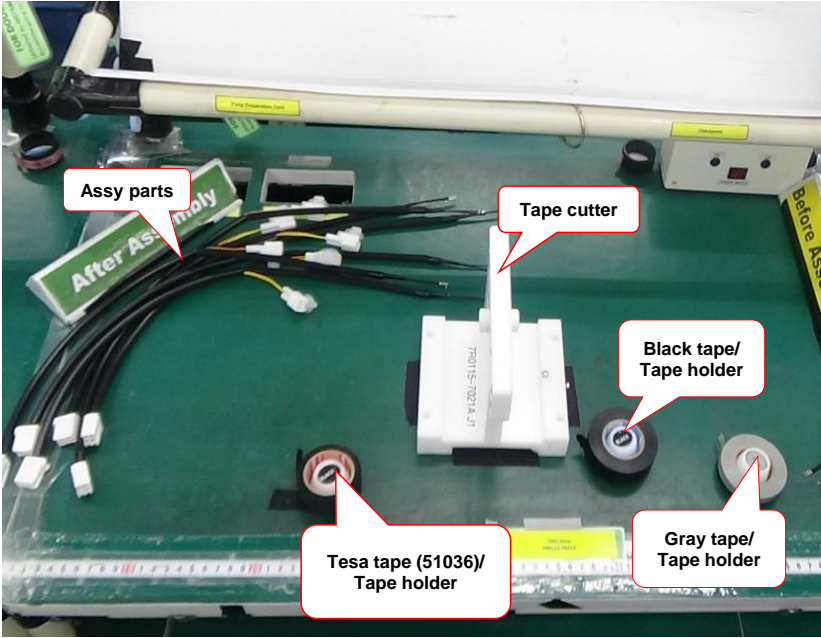


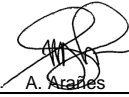


|   |   |  |   |  |                   |  |                              |  |
|---|---|--|---|--|-------------------|--|------------------------------|--|
|  | WORK INSTRUCTION  |  |   |  | Effectivity Date: |  | October 09, 2024             |  |
|   | TAPING ASSEMBLY PROCESS   |  |   |  | Validity Date:    |  | n/a                          |  |
|   | Process Name/Title:   |  | Model code/Part number: 920B / 7R0115-7021A |  | Customer: TRMX    |  | Car Model: TOYOTA-TACOMA     |  |
|   | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO |  | Document No.:                               |  | Revision No.:     |  | 2      Page No.:      1 of 6 |  |


|        |                    |  |  |   |  |   |  |
|--------|--------------------|--|--|---|--|---|--|
| PARTS: |                    | 1. Assy parts; Tesa tape (51036); Gray tape; Black tape  |  | JIG:  |  | 1. Tesa cutter  |  |
| NO.    | PROCESS NAME       | WORK PROCEDURE/ ILLUSTRATION   |  | TOOLS/PPE   |  | QUALITY POINTERS                                      |  |
| 1      | P2<br><div>2</div> | <div>Table Lay-out</div>  |  | <div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's.<br/>2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> |  | 1. No missing parts/tools<br>2. No excess parts/tools |  |

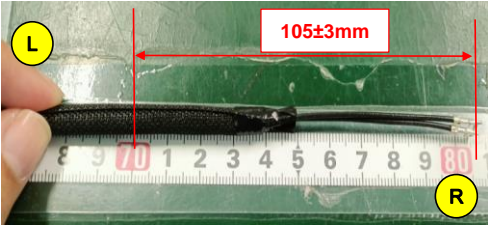

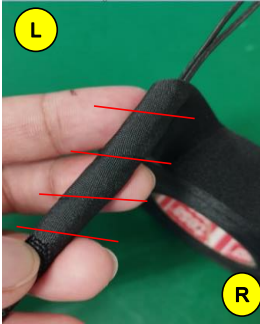



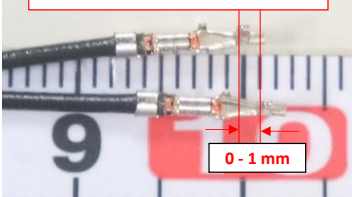
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|------------------|---------|--|--|--|--|------------|--------------|--------------|-----------|---|---|---|-----|------------|----------------|
| Revision History |         |  |  |  |  |            |              | Prepared by  |           | Reviewed by   |   | Approved by   |     | Noted by   |                |
| 10/09/24         | 2       | Transfer Taping 2 and Spot taping 2 from P1 ; Separate Y-taping and clamp assembly due to process improvement. Inclusion of car model "TOYOTA-TACOMA". Improved Table lay-out and Visual inspection/Quality checkpoints. |  |  |  | D.Castillo | C.Villanueva | A. Arañes    | N/A       |  |  |  | n/a | Est. Date: | March 21, 2023 |
| 05/19/23         | 1       | Change document from pre-launch to masspro. Inclusion of table lay-out. Transfer process to Offline assembly process.  |  |  |  | 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     |   |   |   |     |            |                |

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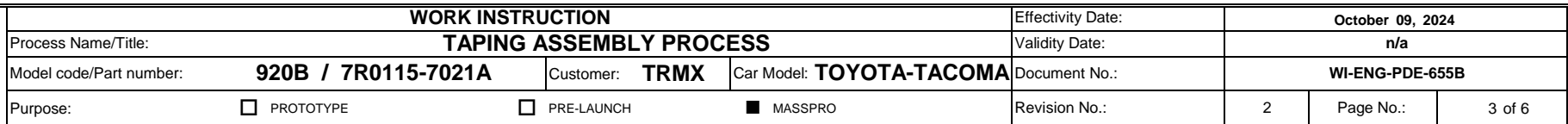
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|---|---|--|-----------------------|---------------------------------|-------------------------|------------------------|--------|
|  | <b>WORK INSTRUCTION</b>   |  |                       | Effectivity Date:               | <b>October 09, 2024</b> |                        |        |
|   | Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>  |  |                       | Validity Date:                  | n/a                     |                        |        |
|   | Model code/Part number: <b>920B / 7R0115-7021A</b>  |  | Customer: <b>TRMX</b> | Car Model: <b>TOYOTA-TACOMA</b> | Document No.:           | <b>WI-ENG-PDE-655B</b> |        |
|   | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO |  |                       | Revision No.:                   | 2                       | Page No.:              | 2 of 6 |

|               |   |   |  |      |   |   |  |  |
|---------------|---|---|--|------|---|---|--|--|
| <b>PARTS:</b> | 1. Assy parts<br>2. Tesa tape (51036)                             |   |  | JIG: | 1. Tesa cutter  |   |  |  |
| <b>NO.</b>    | <b>PROCESS NAME</b>   | <b>WORK PROCEDURE/ ILLUSTRATION</b>   |  |      | <b>TOOLS/PPE</b>  | <b>QUALITY POINTERS</b>   |  |  |
| 2             | P2<br>Taping 2<br>Black twist tube 2420F to<br>Wire near terminal | <div><p>1. Measure from Black twist tube 2420F <b>105±3mm</b> up to terminal tip.</p></div> <div><p>2. Hold the assy parts using left hand . Get <b>Black tesa (51036)</b> using right hand.</p></div> <div><p>3. Make 1 wind before shifting. 1/4 shifting until it reach the wire.</p></div> <div><p>4. Measure from end of Black twisted tube up to terminal tip <b>66±3mm</b> then continue the taping process using both hands.</p></div> |  |      | <div><b>MEASURING TAPE</b><br/></div> <div><b>TAPE CUTTER</b><br/></div> | <p><b>Important reminders/Note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No flip-out tape<br/>2. No peel-off tape<br/>3. No loose tape<br/>4. No missing tape<br/>5. No wrong use of tape<br/>6. No wrong dimension</p> <div><b>Wire alignment tolerance</b><br/></div> |  |  |

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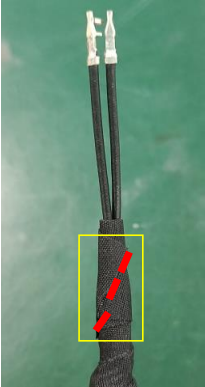
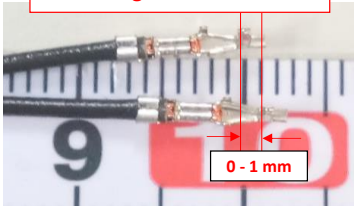
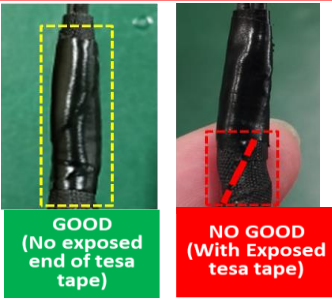


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|---|--------------------------------|--|------------------------------------|-------------------------------------|---|---------------|-------------|------------|----------------------|---------------|------------------------|--|
|  | <b>WORK INSTRUCTION</b>        |  |                                    | Effectivity Date:                   | <b>October 09, 2024</b>                     |               |             |            |                      |               |                        |  |
|   | <b>TAPING ASSEMBLY PROCESS</b> |  |                                    | Validity Date:                      | n/a   |               |             |            |                      |               |                        |  |
|   | Process Name/Title:            |  |                                    | Model code/Part number:             | <b>920B / 7R0115-7021A</b>                  | Customer:     | <b>TRMX</b> | Car Model: | <b>TOYOTA-TACOMA</b> | Document No.: | <b>WI-ENG-PDE-655B</b> |  |
|   | Purpose:                       |  | <input type="checkbox"/> PROTOTYPE | <input type="checkbox"/> PRE-LAUNCH | <input checked="" type="checkbox"/> MASSPRO | Revision No.: |             | 2          | Page No.:            | 4 of 6        |                        |  |

|               |   |   |  |                  |  |  |
|---------------|---|---|--|------------------|--|--|
| <b>PARTS:</b> |   | 1. Assy parts<br>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>  |  |
| 3             | P2<br> | <div></div> <div>1. Hold the assy part using left hand then get the Black tape using right hand. then start taping process using both hands.</div> <div>2. Conduct <b>windings of tape until it covers the end of tesa tape</b> then make <b>2 windings</b> of tape before end of tape using both hands.</div> <div>3. After spot taping, check the taping condition and alignment of wires.<br/><b>Note: End of tesa tape must not visible</b></div> |  | n/a              | <div>1. No flip-out tape<br/>2. No peel-off tape<br/>3. No loose tape<br/>4. No missing tape<br/>5. No wrong use of tape<br/>6. No wrong dimension</div> <div><b>Important reminders/Note/s:</b><br/><i>1. Please use calibrated/verified measuring tape when getting the measurement.</i></div> <div><b>Wire alignment tolerance</b><br/></div> <div><b>SPOT TAPING APPEARANCE</b><br/></div> |  |


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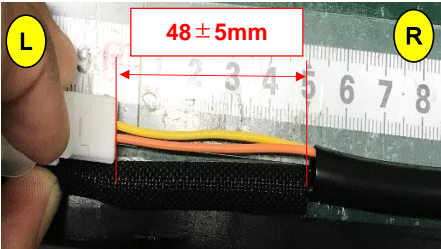

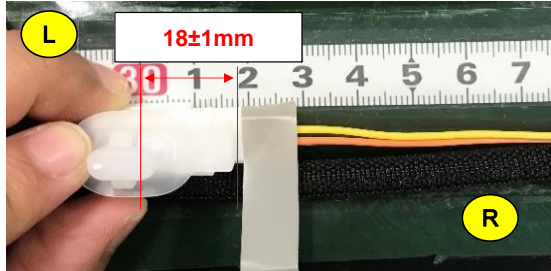
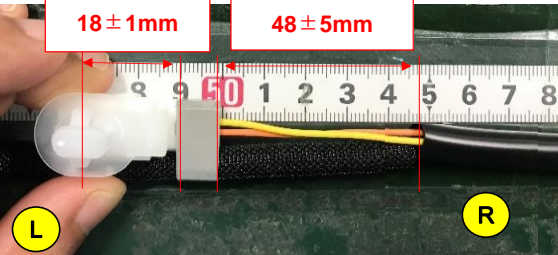
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|---|---|--|----------------|--------------------------|------------------|-----------------|--------|
|  | WORK INSTRUCTION  |  |                | Effectivity Date:        | October 09, 2024 |                 |        |
|   | Process Name/Title: TAPING ASSEMBLY PROCESS   |  |                | Validity Date:           | n/a              |                 |        |
|   | Model code/Part number: 920B / 7R0115-7021A   |  | Customer: TRMX | Car Model: TOYOTA-TACOMA | Document No.:    | WI-ENG-PDE-655B |        |
|   | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO |  |                | Revision No.:            | 2                | Page No.:       | 5 of 6 |

|        |              |  |  |   |   |  |
|--------|--------------|--|--|---|---|--|
| PARTS: |              | 1. Assy parts<br>2. Gray tape (10mm)   |  | JIG:  | n/a   |  |
| NO.    | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION   |  | TOOLS/PPE   | QUALITY POINTERS  |  |
| 4      | P2           | Spot taping 3  |  | <div>MEASURING TAPE</div>  | <div>1. No flip-out tape<br/>2. No peel-off tape<br/>3. No loose tape<br/>4. No missing tape<br/>5. No wrong use of tape<br/>6. No wrong dimension<br/>7. Follow the correct facing</div> <div>Important reminders/Note/s:<br/>1. Please use calibrated/verified measuring tape when getting the measurement.</div> |  |
|        |              | <div><div>1. Fix the Connector and the twisted tube.<br/><i>Note: Alignment of twisted tube must be beside the Connector. Follow the correct facing</i></div><div>2. Measure from end of connector up to end of twisted tube <b>48±5mm</b> using both hands.<br/><i>Note: Must be no gap between tubes</i></div></div> <div><div>3. Measure <b>18±1mm</b> from end of clamp up to connector using both hands, get the <b>Gray tape (10mm)</b> and position the tape in combined connector and tube then start taping using right hand. Make <b>2 windings</b> of tape using both hands.</div></div> <div><div>3. After taping, check the measurement and taping condition.</div></div> |  |   |   |  |

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

October 09, 2024

Validity Date:

n/a

Model code/Part number:

**920B / 7R0115-7021A**

Customer:

**TRMX**

Car Model:

**TOYOTA-TACOMA**

Document No.:

**WI-ENG-PDE-655B**

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

2

Page No.:

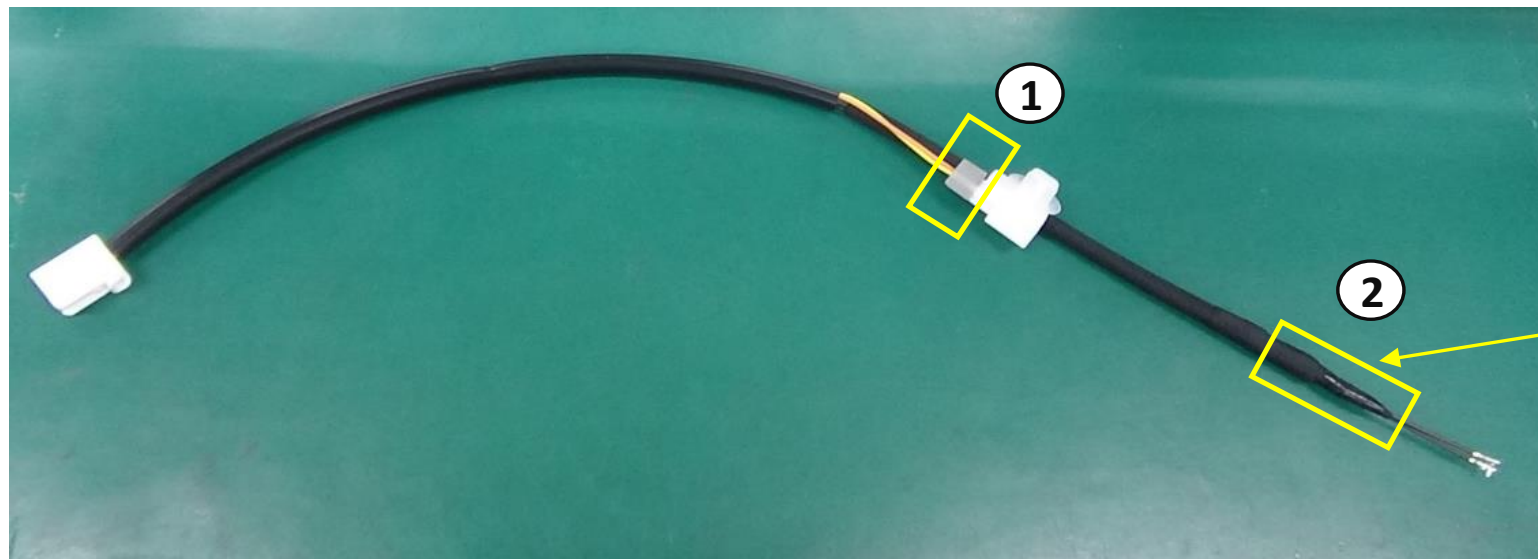
6 of 6

**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P2****7R0115-7021A****1 No Missing Spot tape (Gray tape)****2 No Missing Spot tape (Black tape)**

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