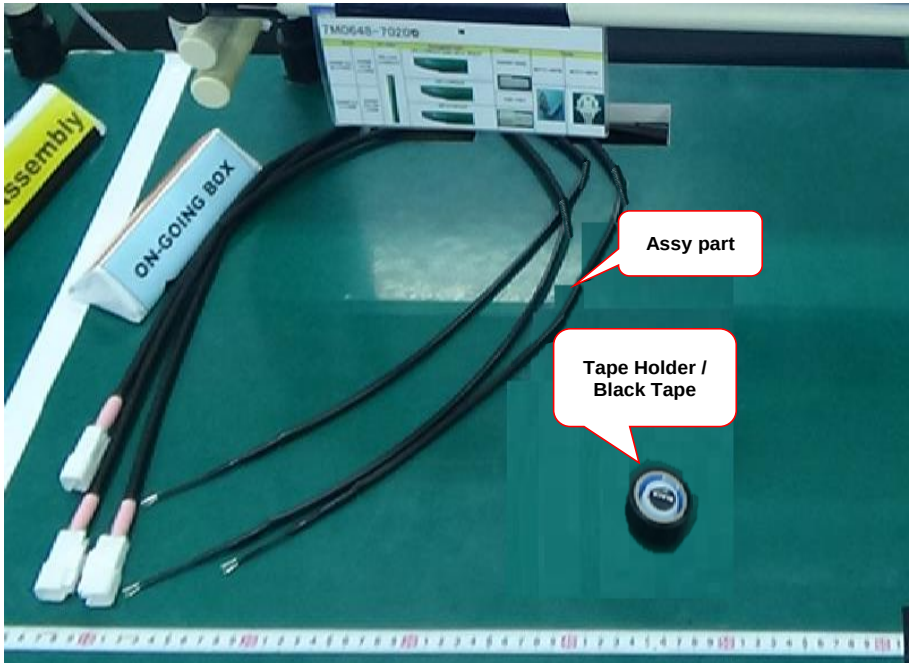
| | WORK INSTRUCTION | | | Effectivity Date: | January 22, 2025 | |
|---|---|---|---|---|---|---|
| | Process Name/Title: | TAPING ASSEMBLY PROCESS | | Validity Date: | n/a | |
| | Model code/Part number: D01L / 7M0648-7020D | Customer: TRJ | Car Model: DAIHATSU-TANTO | Document No.: | WI-ENG-PDE-095D | |
| | Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO | | | Revision No.: | 3 | Page No.: 1 of 5 |

| PARTS: | 1. Assy parts; Black tape | JIG: | 1. Measuring jig |
|---|---|---|---|

| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|---|---|---|---|---|---|
| 1 | P4 | Table lay-out | **TABLE LAY-OUT**<br>  <br> | **Safety Instruction**<br>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)<br><br>**Housekeeping**<br>1. Maintain and always practice 5's.<br>2. Personal things on the workplace is prohibited. Keep it in your locker.<br><br>**Alert level**<br>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. | 1. No missing parts/tools<br>2. No excess parts/tools |

Revision History

| Eff. Date | Rev. No | Details of Change | Revised | Reviewed | Approved | Noted |
|---|---|---|---|---|---|---|
| 01/22/25 | 3 | Separate clamp assembly. Transfer Y-taping from P3. Inclusion of Car model "DAIHATSU-TANTO". Improved Table lay-out, Measurement and Visual inspection/Quality checkpoint. | D.Castillo | C. Villanueva | A. Arañes | n/a |
| 05/10/23 | 2 | Inclusion of quality checkpoints | J. Loterte | C. Villanueva | A. Arañes | n/a |
| 10/26/22 | 1 | Transfer process no. 3 Taping 3: Black corrugated tube to vinyl tube from P2 to P4 due to process improvement. | M. Ariola | J. Loterte | C. Villanueva | A. Arañes |

| Prepared by | Reviewed by | Approved by | Noted by |
|---|---|---|---|
| D.Castillo | C. Villanueva | A. Arañes | n/a |
| Est. Date: | October 20, 2022 | | |

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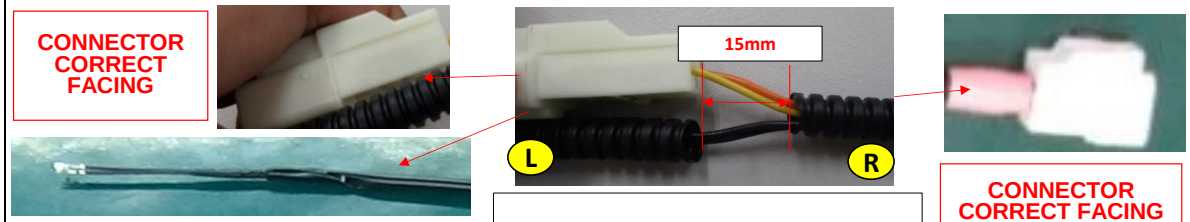
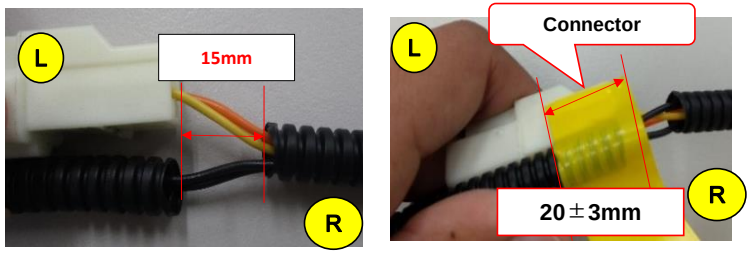
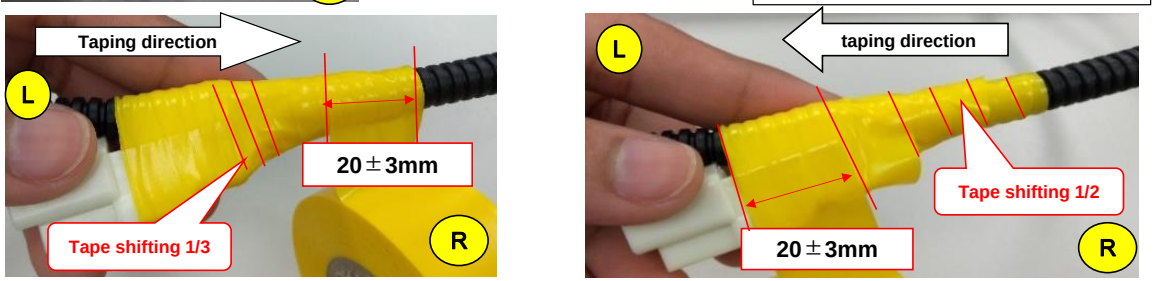
| | Model code/Part number: D01L / 7M0648-7020D | Customer: TRJ | Car Model: DAIHATSU-TANTO | Document No.: | WI-ENG-PDE-095D | |
| | Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO | | | Revision No.: | 3 | Page No.: 2 of 5 |

| PARTS: | 1. Assy parts<br>2. Black tape | JIG: | n/a |
|---|---|---|---|

| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|---|---|---|---|---|---|
| 2 | 3 P4 | Y-taping |  <br>1. Fix the connector and corrugated tube.<br>**Note: Follow the connector correct facing.**<br>  <br>2. Measure combined connector and COT to COT **15mm**. Attach the tape on the connector. Then make pre-tape **2 windings.**<br>***Note**: Do not exert excessive force during pulling & winding of tape.*<br>  <br>3. Winding the tape **1/3 shifting** going to the other side of tube. Make **2 windings**, width must be 20**±3mm.**<br>4. Winding the tape **1/2 shifting** going to the left side until reach the other side of tube. Make **2 windings**, width must be 20**±3mm**. | | ***Important reminders/Note/s:***<br>***1. Use yellow tape for easy visualization of tape shifting, but actual should be BLACK TAPE.***<br>***2. Please use calibrated/verified measuring tape when getting the measurement.***<br>1. No loose tape<br>2. No flip-out tape<br>3. No peel-off tape<br>4. No wrong use of tape<br>5. No wrong dimension-out tape<br>6. No exposed wire<br>7. No gap between tubes |

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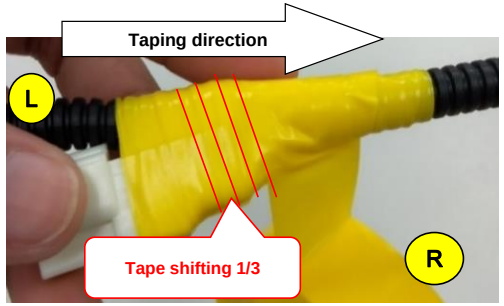
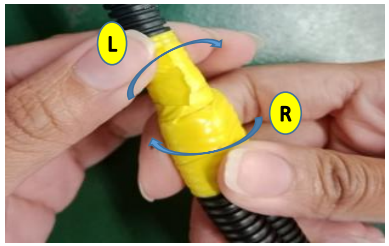
| | Model code/Part number: D01L / 7M0648-7020D | Customer: TRJ | Car Model: DAIHATSU-TANTO | Document No.: | WI-ENG-PDE-095D | | |
| | Purpose: ☐ PROTOTYPE | ☐ PRE-LAUNCH | ■ MASSPRO | Revision No.: | 3 | Page No.: | 3 of 5 |

| PARTS: | 1. Assy parts<br>2. Black tape | JIG: | n/a |
|---|---|---|---|

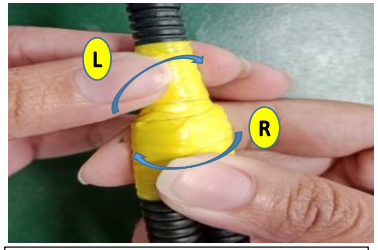
| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|---|---|---|---|---|---|
| 2 | 3<br>P4 | Y-taping<br>(Continuation) | | | |



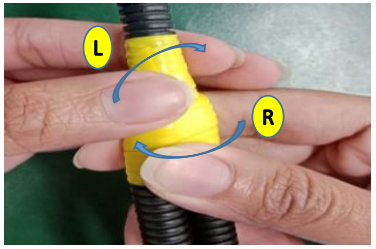

5. Winding the tape **1/3 shifting** going to the right side until reach the other side of tape. Make **3 windings**, width must be **20±3mm**. Then cut the tape.



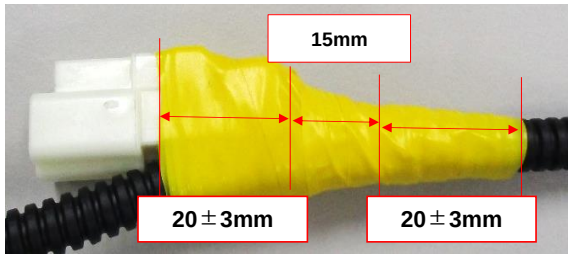

6. conduct proper pressing of end tape using left hand **(top part).**
***Note: Reference only.***




7. conduct proper pressing of end tape using left hand **(Middle part).**
***Note: Reference only.***




8. conduct proper pressing of end tape using left hand **(bottom part).**
***Note: Reference only.***

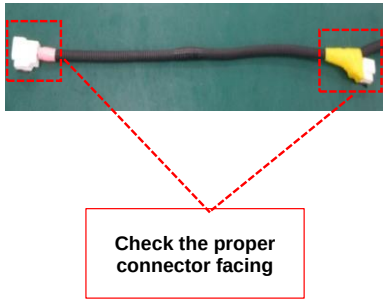



9. After taping, check the condition of tape, measurement and the connector facing.

***Important reminders/Note/s:***

***1. Use yellow tape for easy visualization of tape shifting, but actual should be BLACK TAPE.***
***2. Please use calibrated/verified measuring tape when getting the measurement.***

1. No loose tape
2. No flip-out tape
3. No peel-off tape
4. No wrong use of tape
5. No wrong dimension-out tape
6. No exposed wire
7. No gap between tubes

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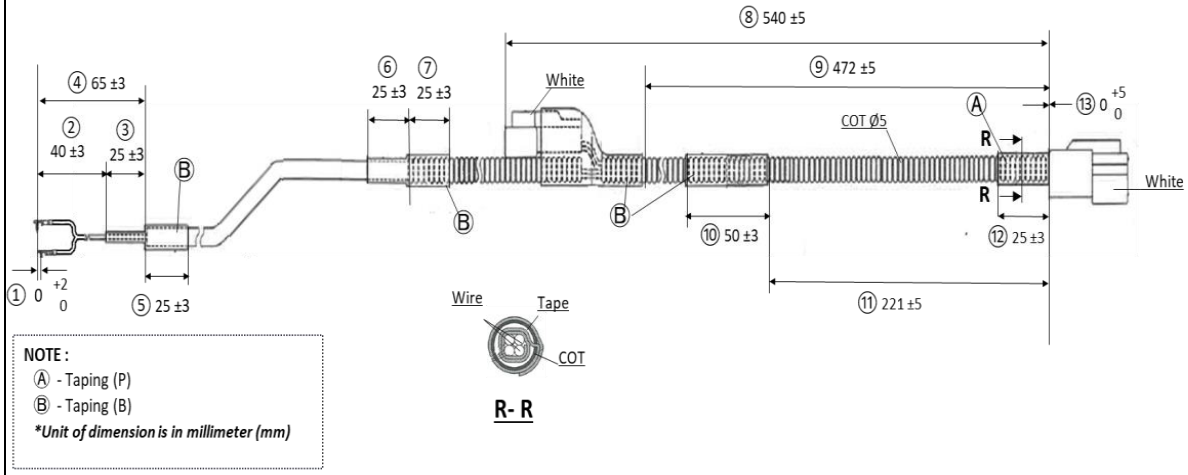
| | Purpose: | ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO | | Revision No.: | 3 — Page No.: 4 of 5 |

| PARTS: | 1. Assy parts | JIG: | n/a |
|---|---|---|---|

| NO. | PROCESS NAME | | 3 WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|---|---|---|---|---|---|
| 3 | P4 | Measurement |  | MEASURING TAPE | ***Important reminders and note/s:*** ***1. Please use calibrated/verified measuring tape when getting the measurement.*** ***2. For Hatsumono, Nakamono and Owarimono.*** ***Document reference/s:*** *1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection* 1. No wrong dimension |

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| | Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO | | | Revision No.: | 3 | Page No.: | 5 of 5 |

| | | | |
|---|---|---|---|
| **PARTS:** | 1. Assy parts | JIG: | n/a |

3 **VISUAL INSPECTION/ QUALITY CHECKPOINTS**

# TAPING - P4 7M0648-7020D

1 **No Wrong facing of connector in Y-taping**

2 **No Missing Tape/ No Wrong color of tape**

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