



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model Code/Part number

011B

/

7M0366-7020B

Customer:

TRJ

Car Model:

TOYOTA-CAMRY

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

July 14, 2023

Validity Date:

n/a

Document No.:

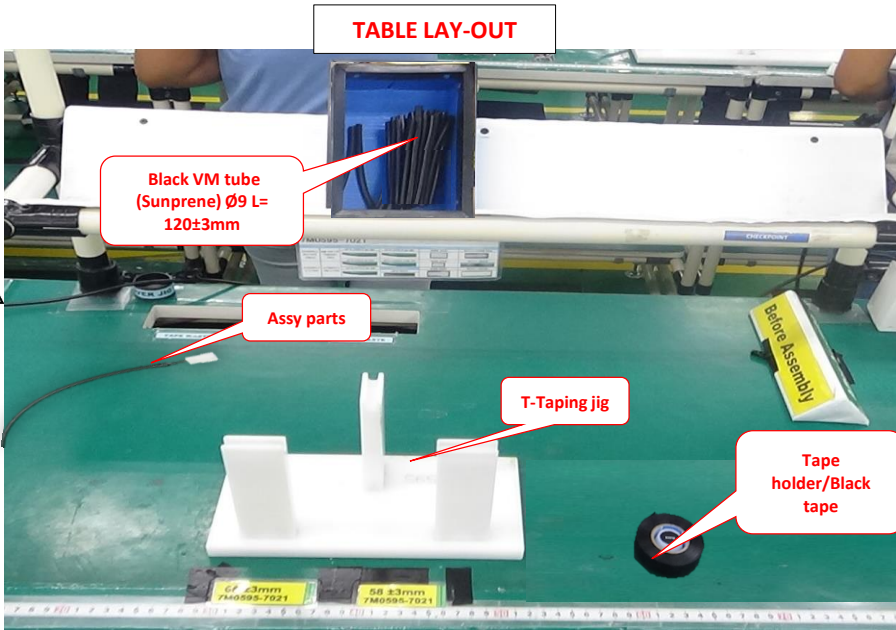
WI-ENG-PDE-177B

Revision No.:

4

Page No.:

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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) Ø9 L= 120±3mm		3. Black tape		JIG:	1. T-Taping jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS	
1	P2	Table lay-out	<div><div>TABLE LAY-OUT</div><div>Black VM tube (Sunprene) Ø9 L= 120±3mm</div><div>Assy parts</div><div>T-Taping jig</div><div>Tape holder/Black tape</div></div>				<div><div>Safety Instruction</div><div>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div></div> <div><div>Housekeeping</div><div>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div></div> <div><div>Alert level</div><div>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>	1. No missing parts/tools. 2. No excess parts/tools.

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
07/14/23	4	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				
04/27/21	3	Put assy parts on pg. 1, 3, 4 and 5. Add measuring tape illustration and instruction on Y-taping pg.5	J. Loterte	C. Villanueva	A. Shimamura	A.Arañes				
09/30/20	2	Change process owner from Production (WI-PRO-ASY-020) to Engineering (WI-ENG-PDE-177B); Apply some improvements/update pictures	J. Loterte	R. Peñaloza	A. Shimamura	A.Arañes				

Details of Change

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PARTS:

4

1. Black VM tube (Sunprene) $\varnothing 9$ L= 120 \pm 3mm
2. Black tape

3. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

- 4
- Wire insertion to VM tube (Sunprene) $\varnothing 9$ L= 120 \pm 3mm



4

1. Get the Black VM tube (Sunprene) $\varnothing 9$ L= 120 \pm 3mm using right hand and insert the wires using left hand.

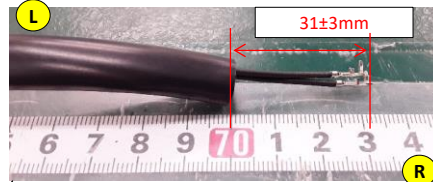
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1. No wrong use of parts
2. No deformed terminal

3

P2

- 4
- Taping 1 COT to VM tube (Sunprene)

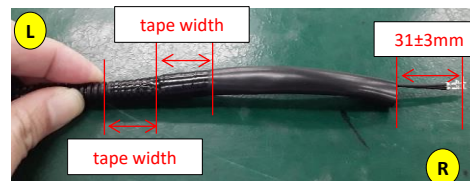


4

1. Hold the assy parts using left hand. Measure from VM tube (Sunprene) to terminal pointed tip 31 \pm 3mm.



2. Hold the assy parts using left hand. Get the Black tape and start taping using right hand.



3. After taping, check the measurement and taping condition.

MEASURING TAPE



- 4
- Important Reminders/Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.

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Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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Page No.:

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PARTS:

1. Black tape
2. Assy parts

JIG

1. T-taping jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

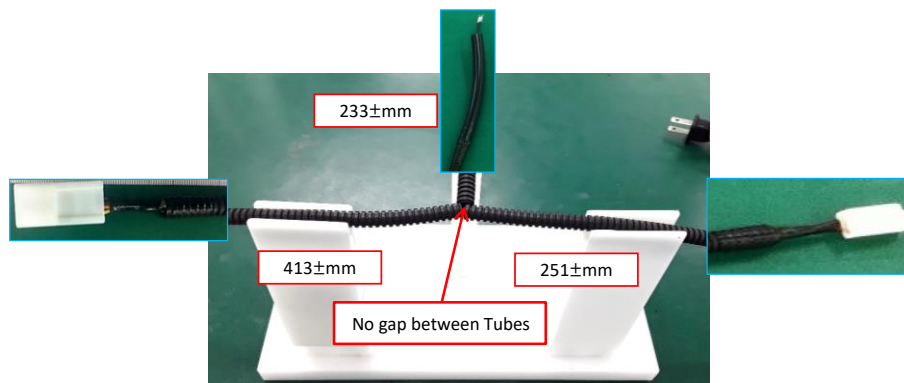
TOOLS/PPE

QUALITY POINTERS

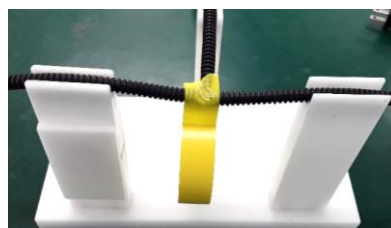
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P2

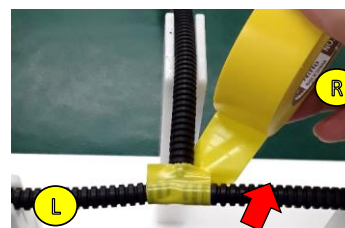
T-Taping



1. Arrange the 3 corrugated tube to form inverted T using left and right hand.



2. Start taping at the middle to fix the 3 corrugated tubes using both hands.



3. Wind the tape from front to back at the right side.

MEASURING TAPE



4

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

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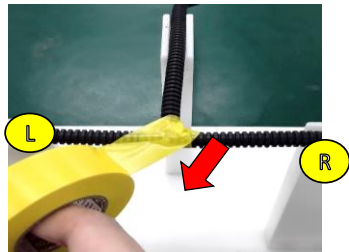
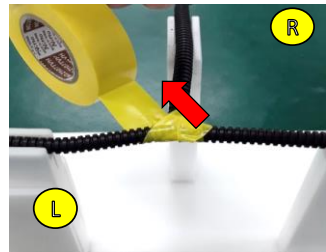
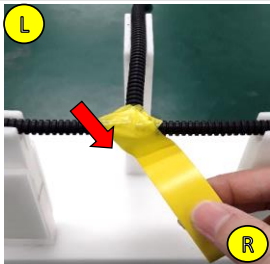
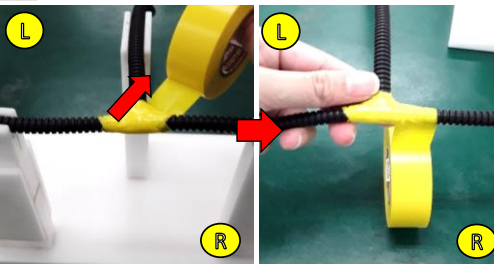
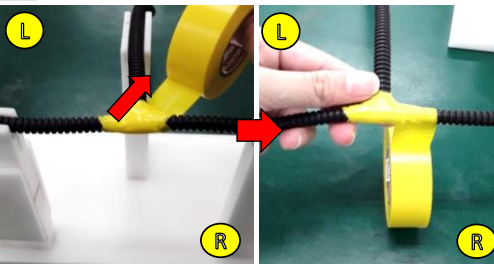
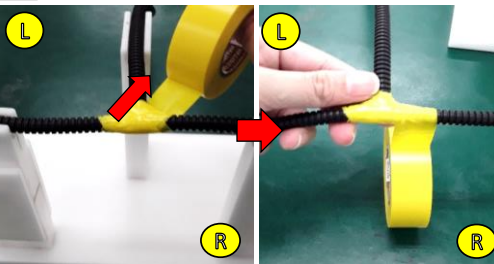
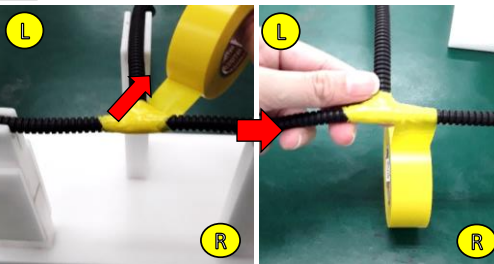
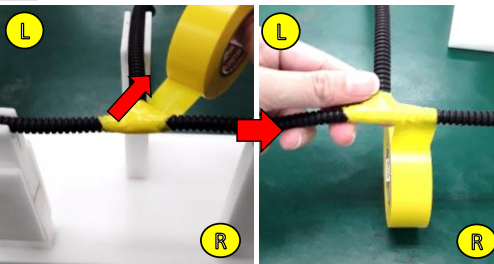
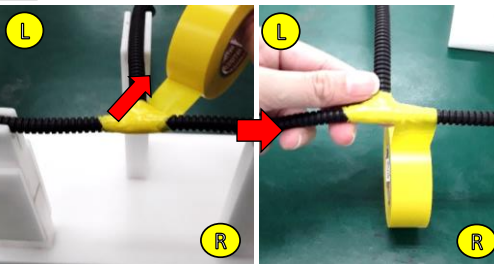
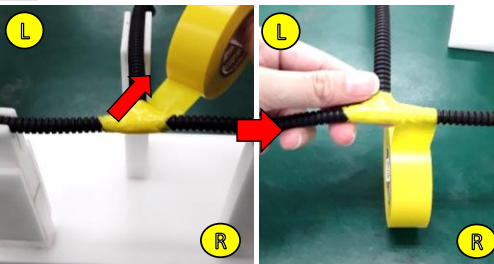
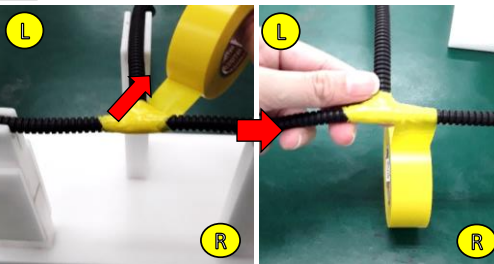
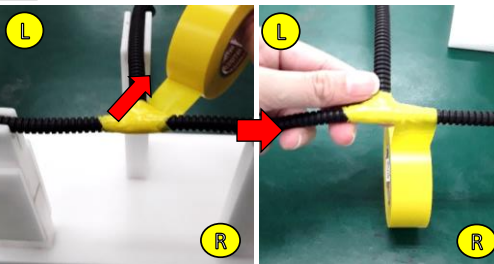
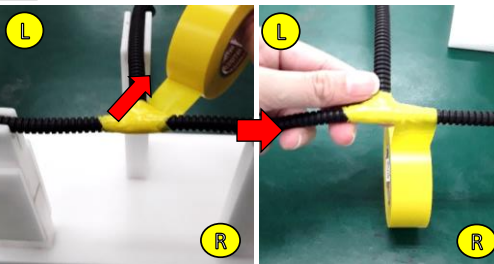
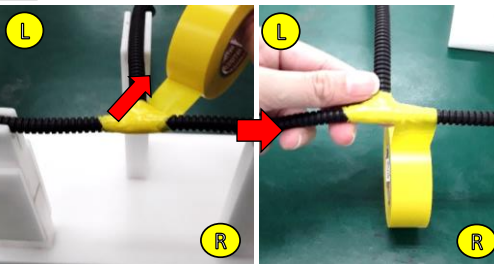
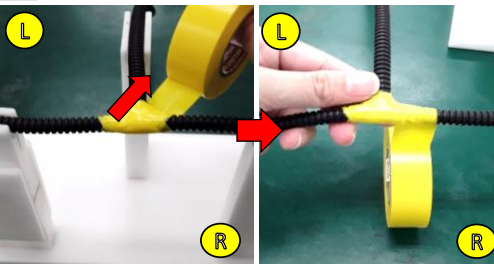
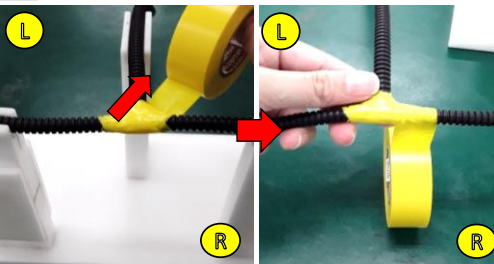
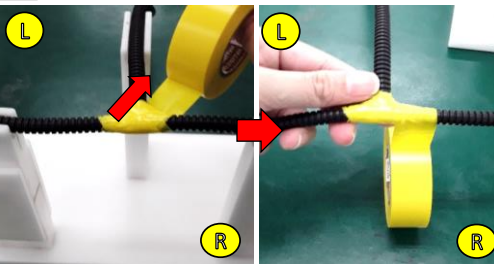
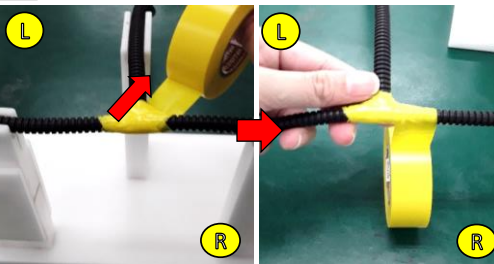
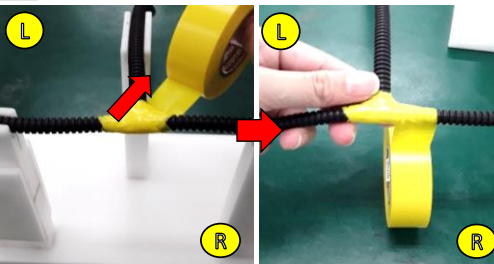
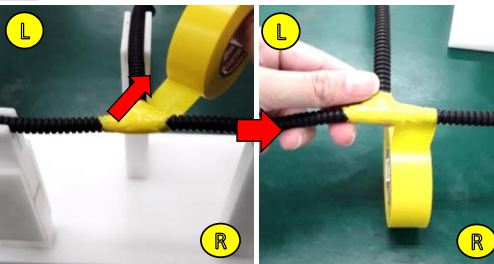
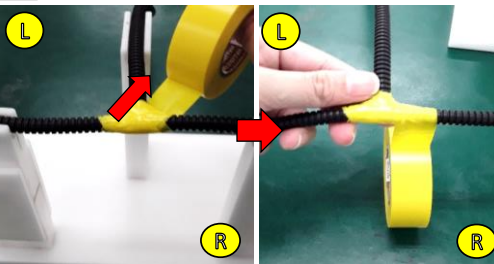
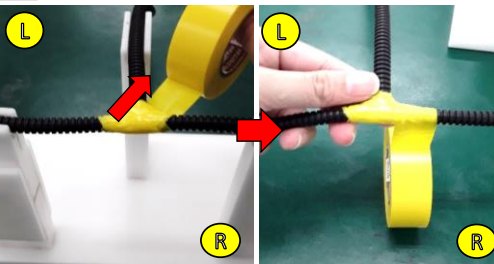
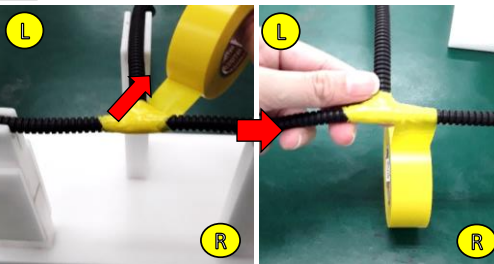
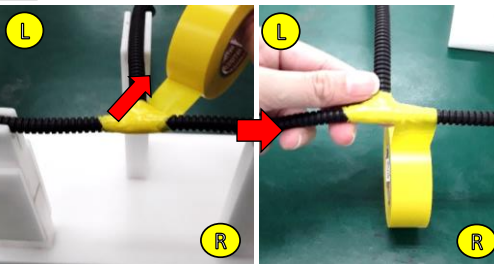
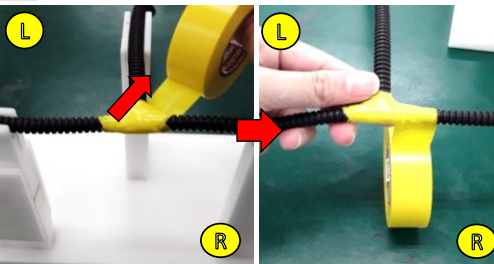
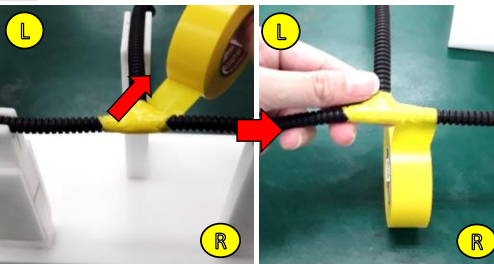
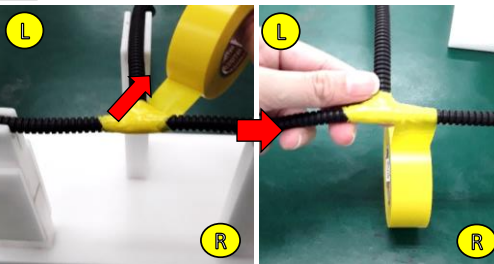
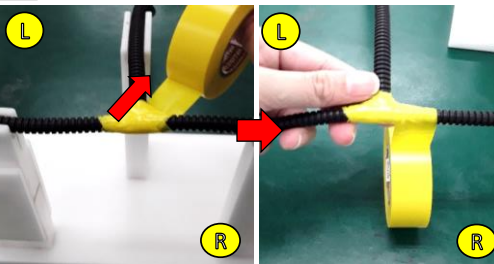
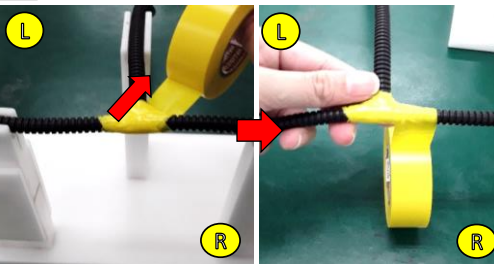
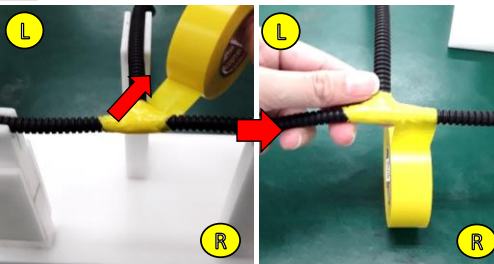
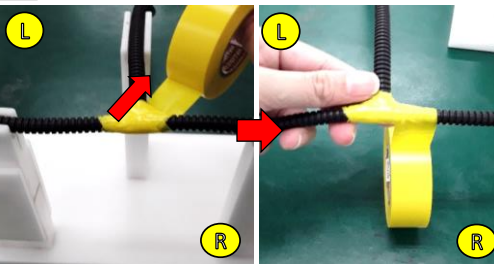
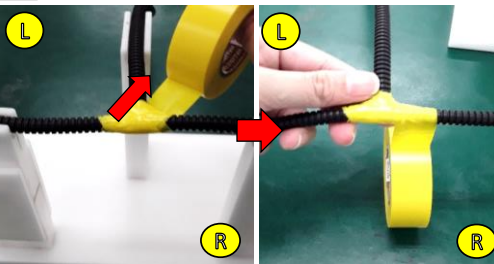
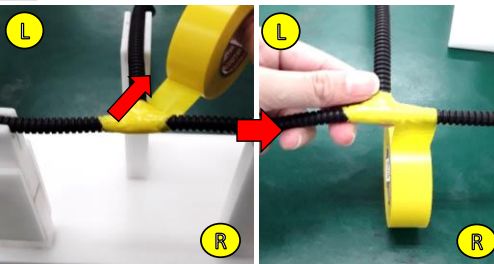
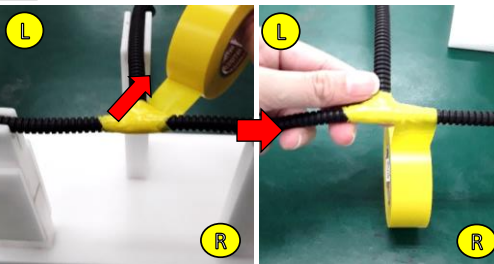
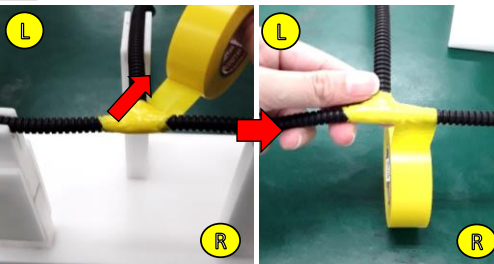
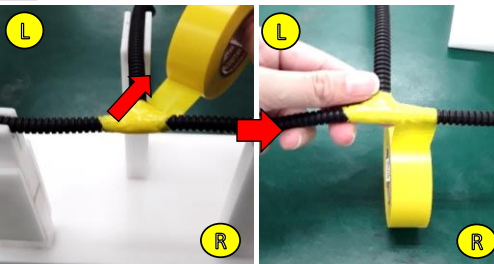
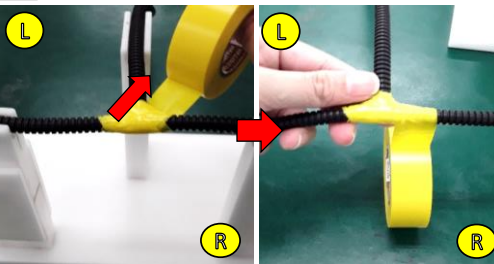
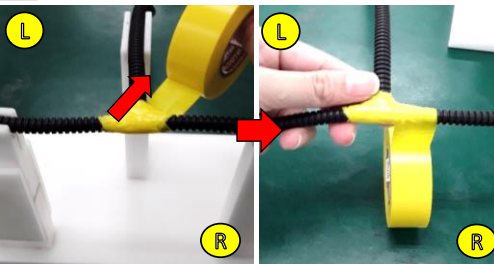
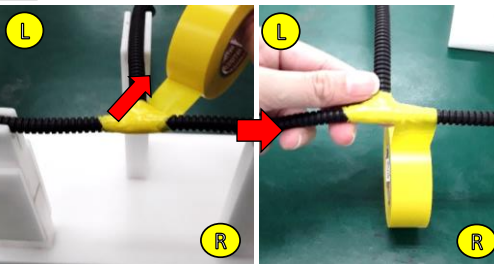
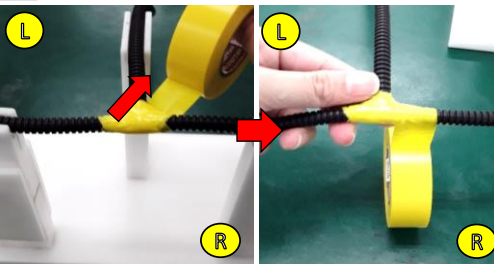
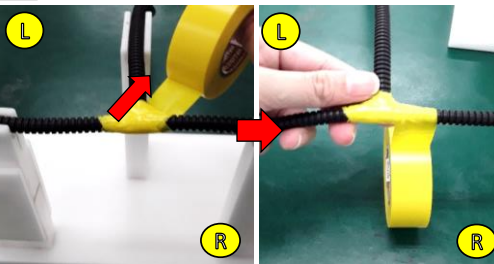
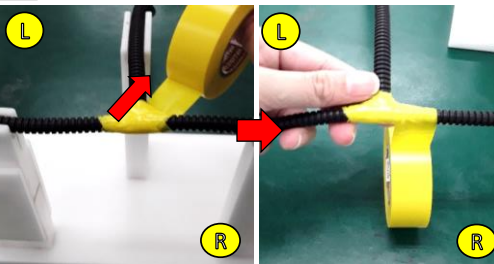
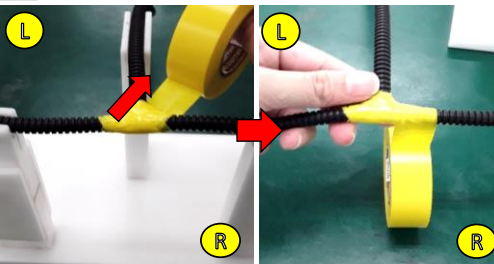
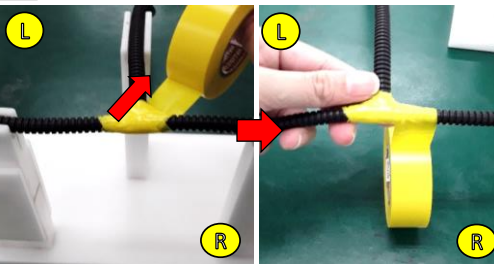
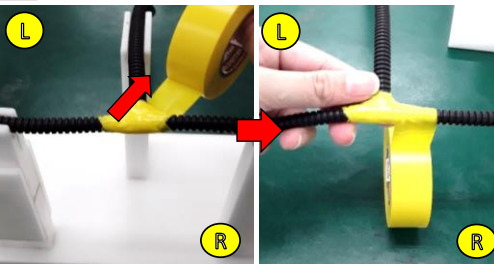
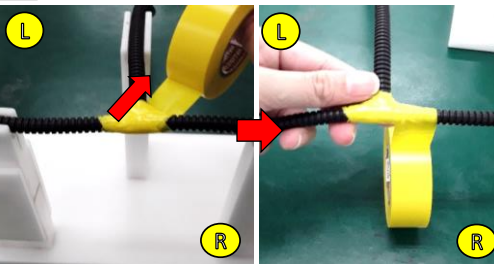
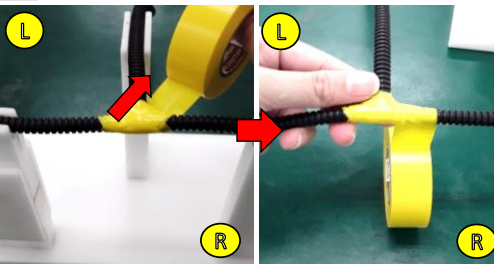
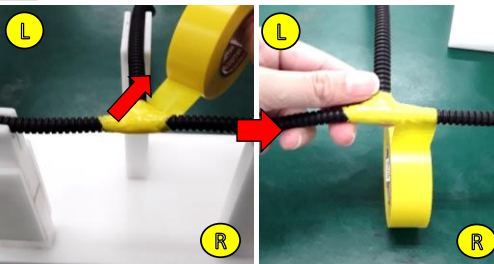
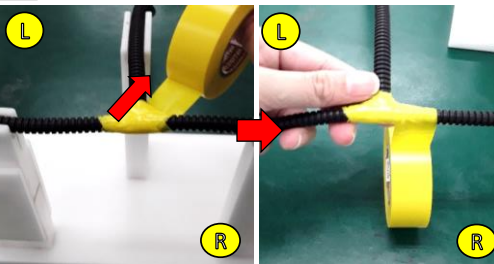
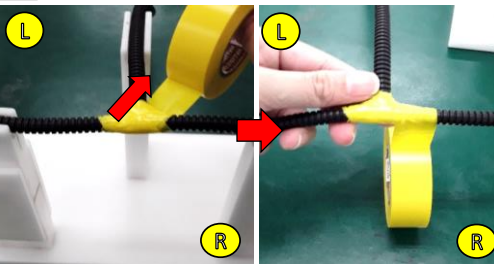
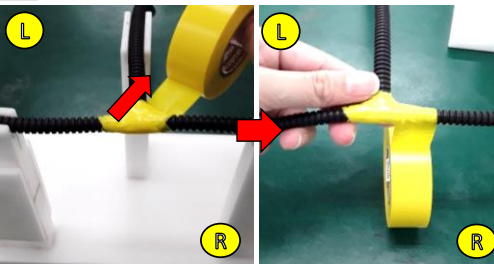
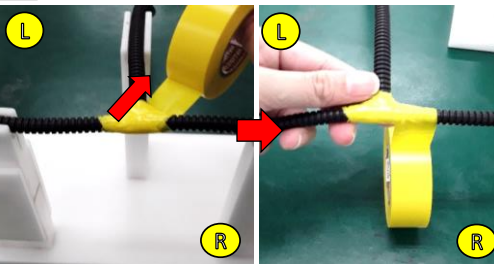
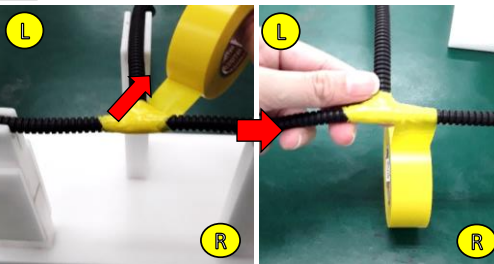
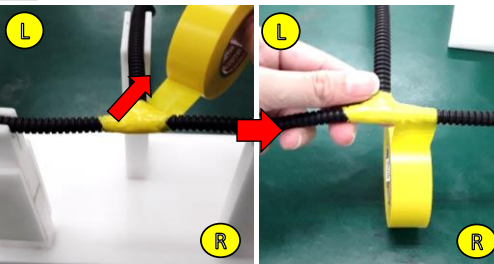
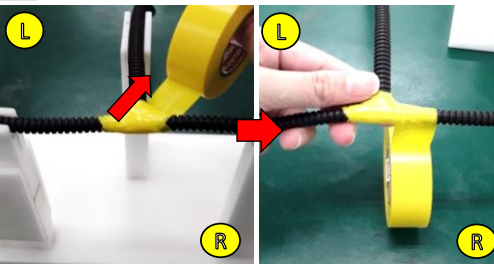
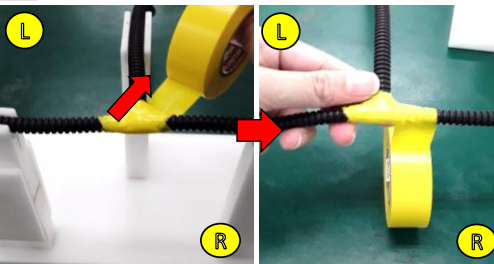
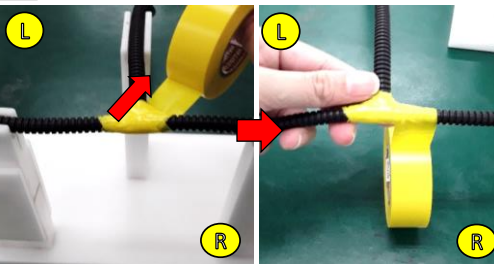
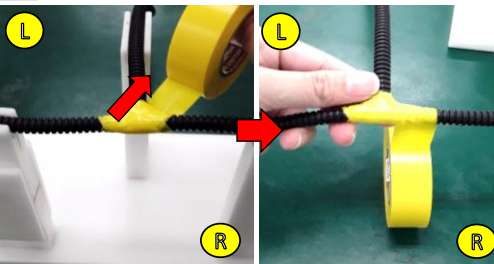
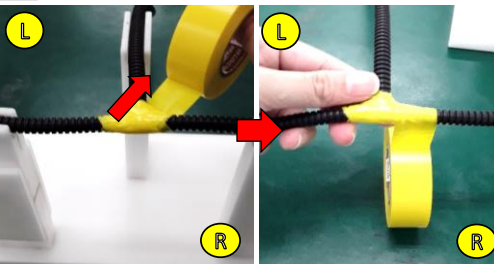
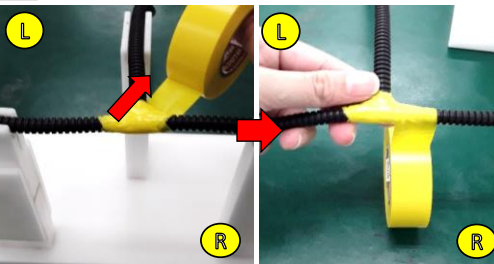
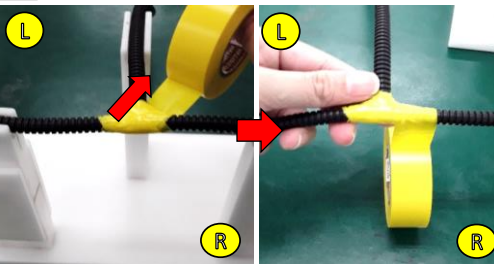
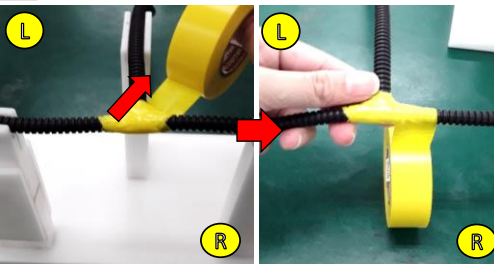
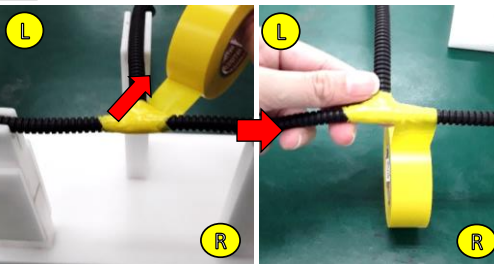
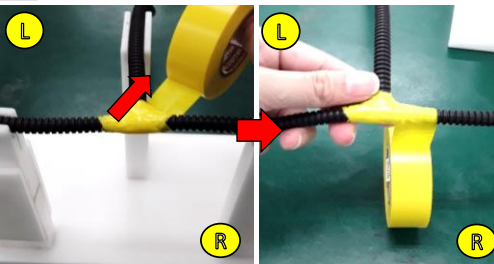
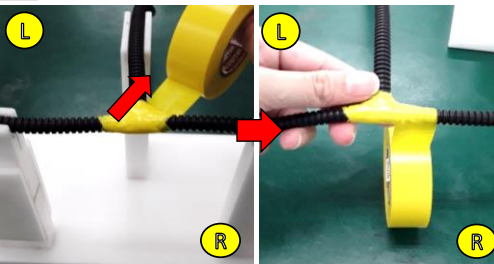
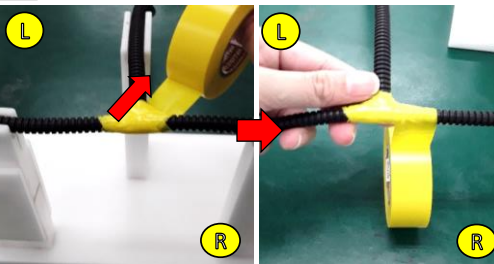
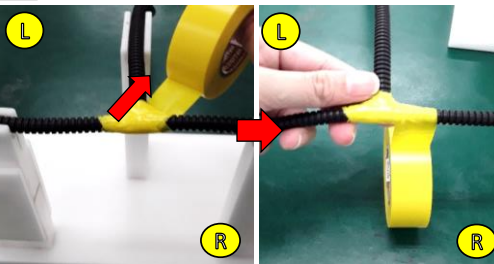
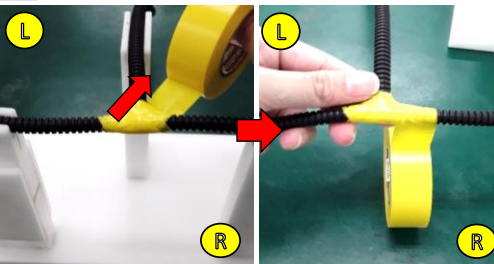
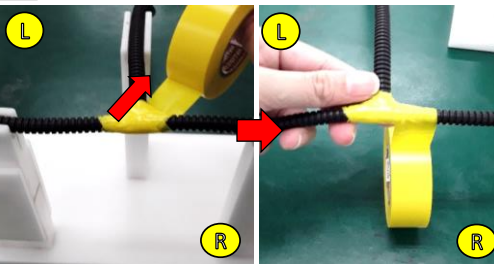
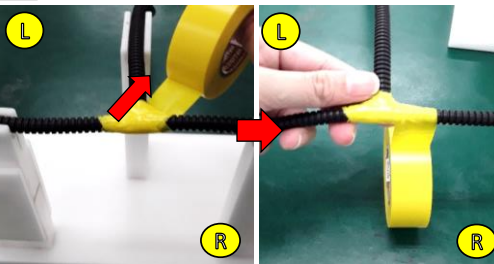
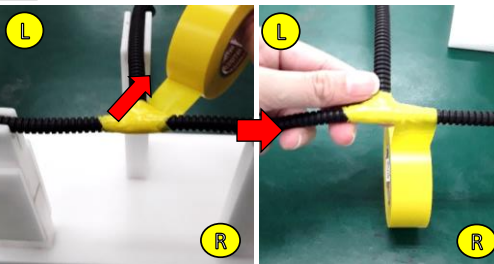
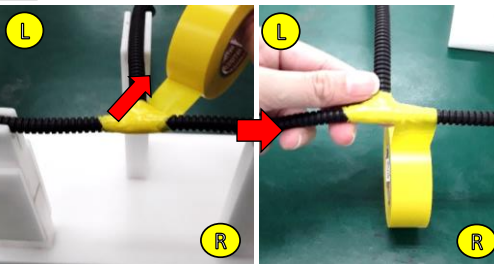
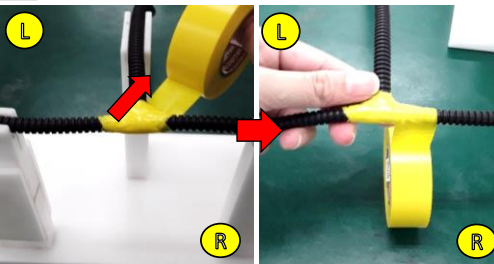
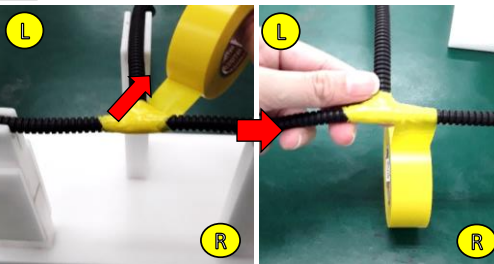
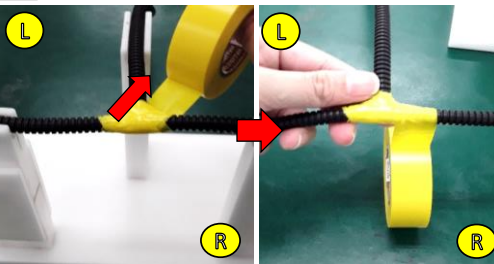
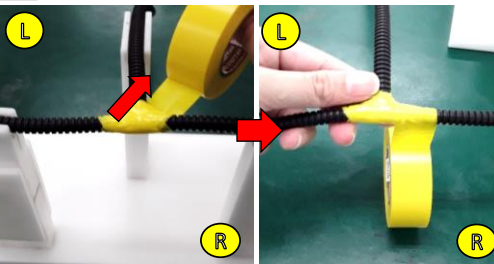
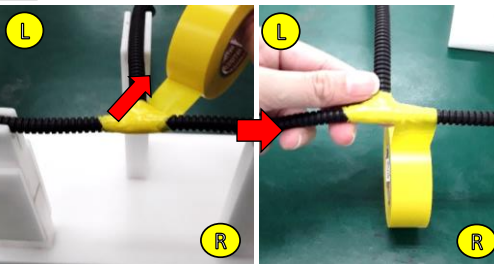
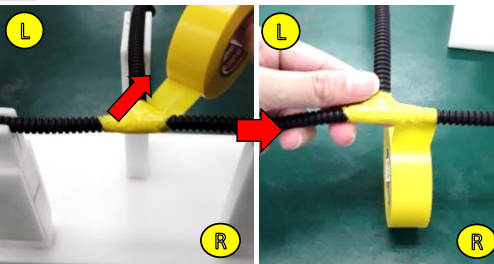
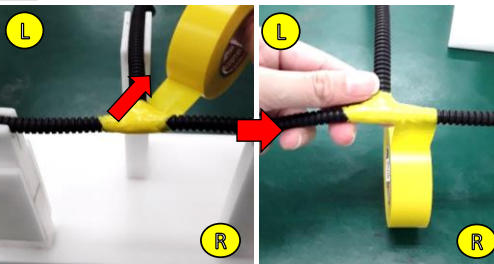
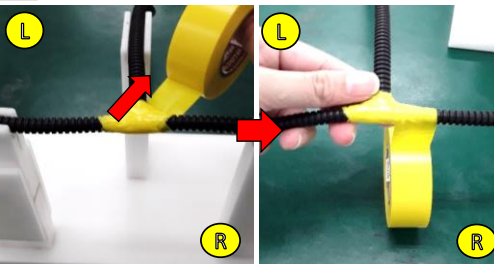
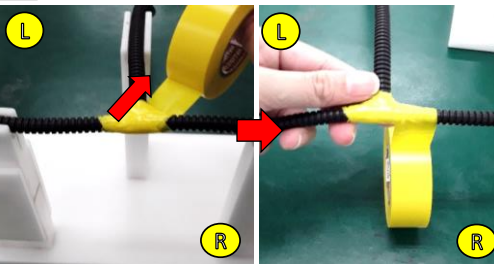
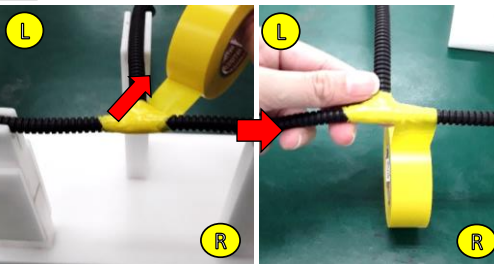
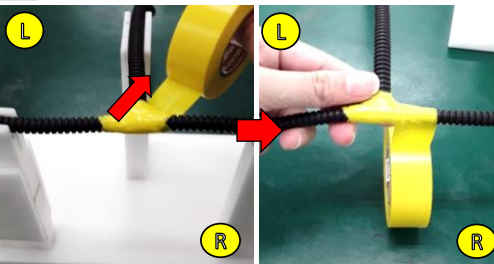
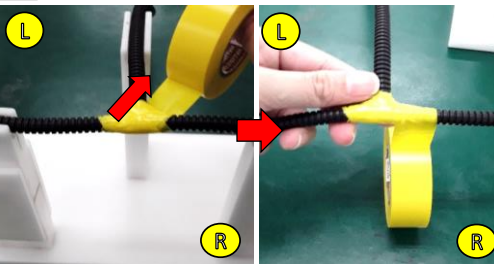
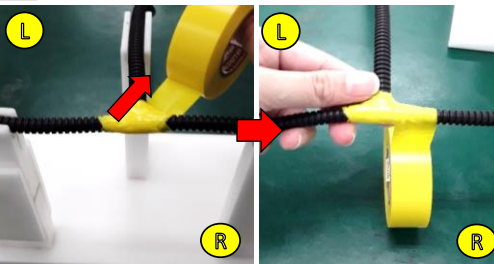
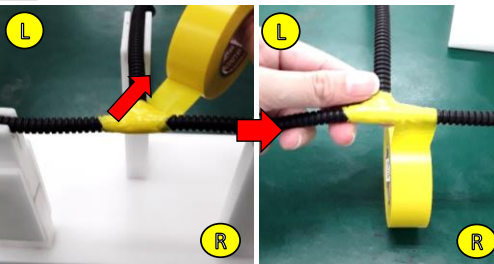
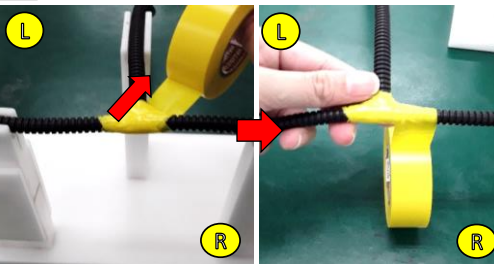
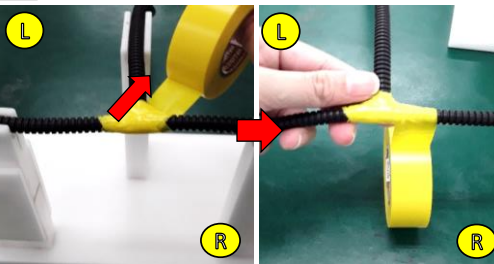
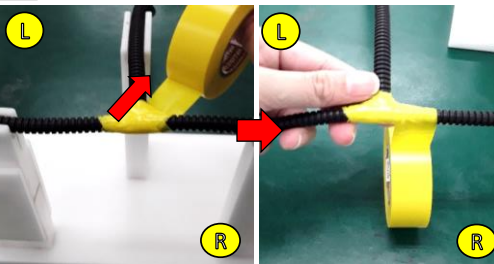
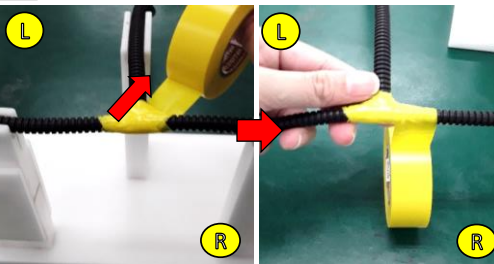
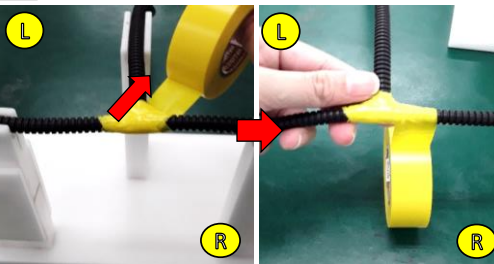
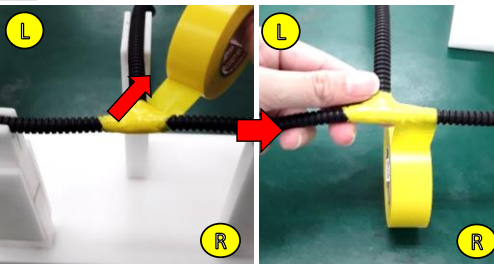
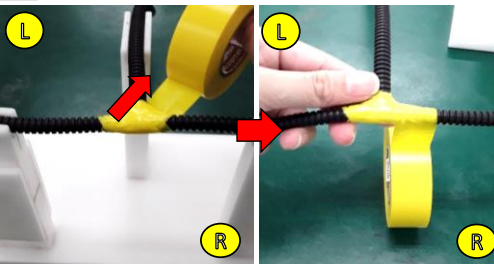
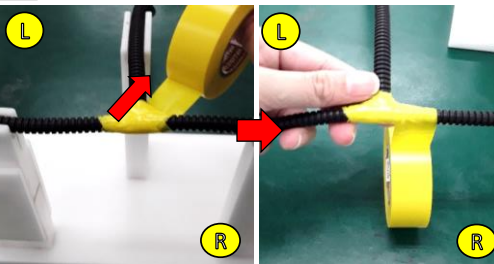
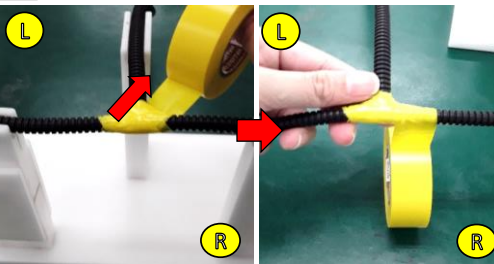
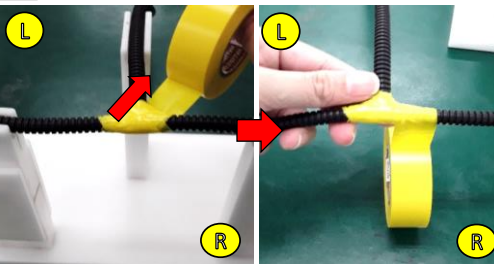
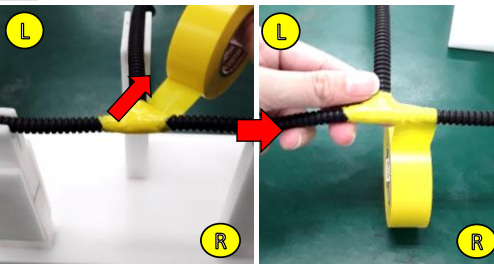
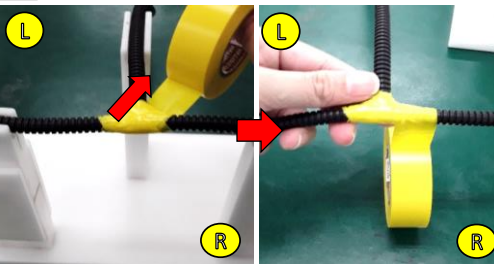
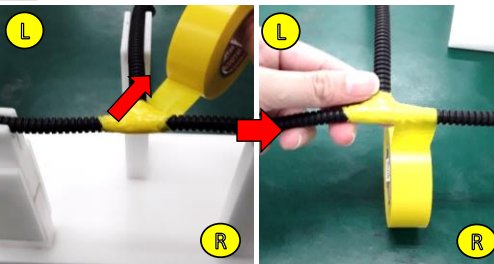
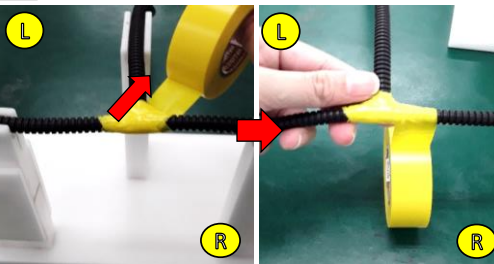
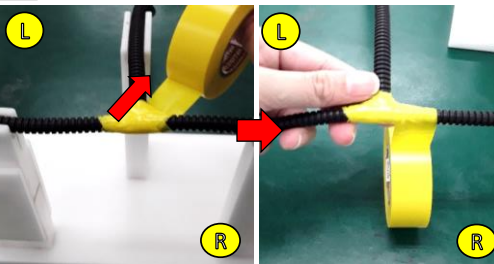
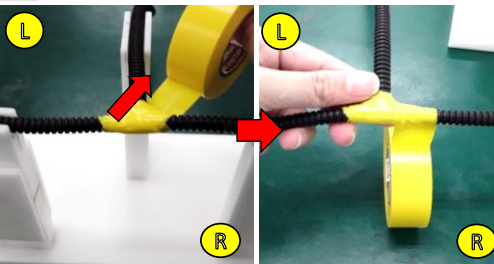
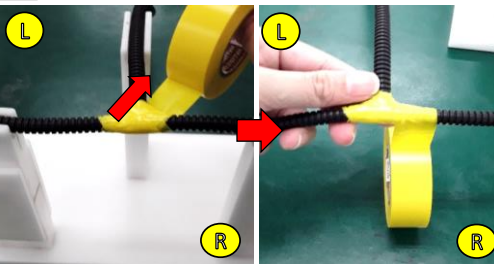
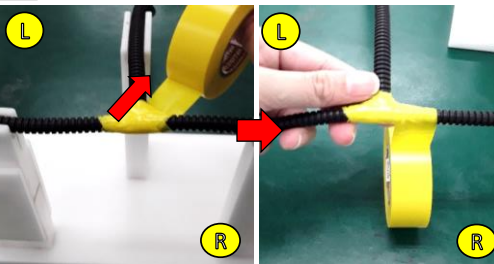
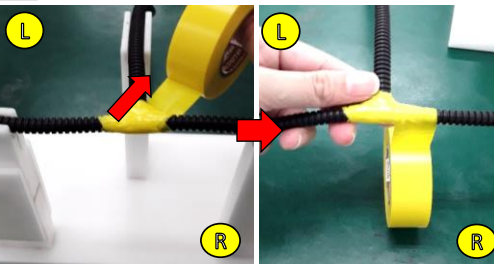
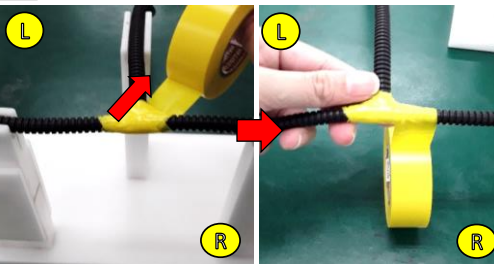
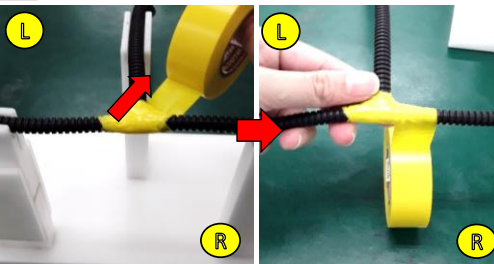
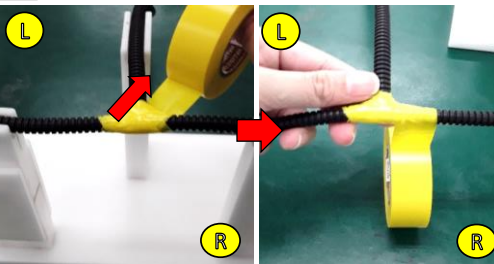
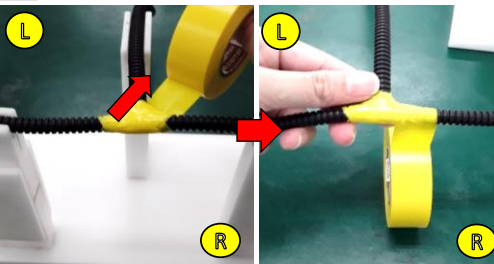
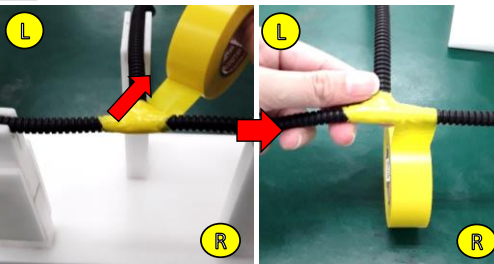
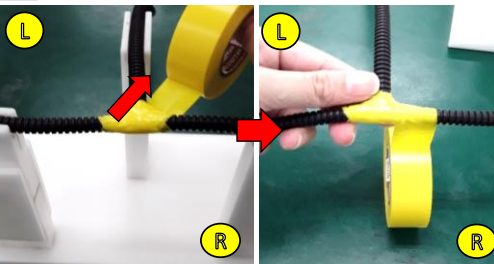
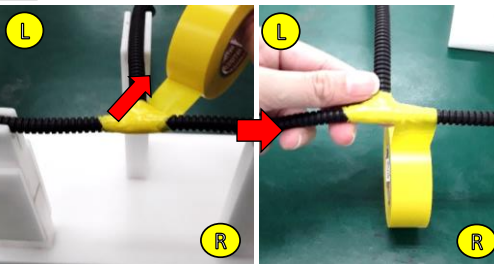
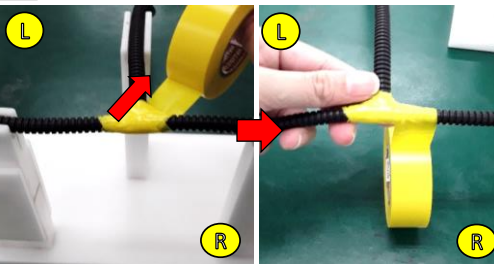
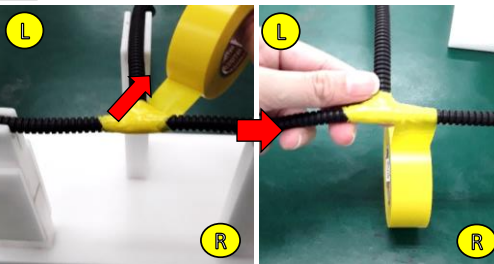
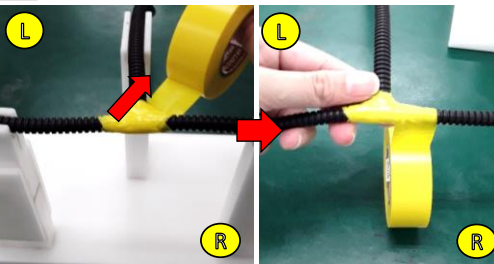
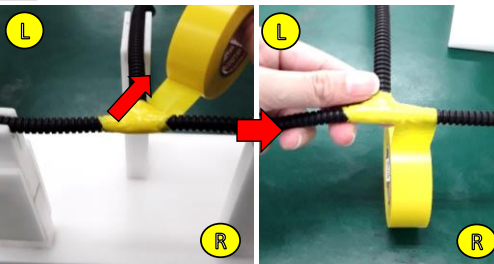
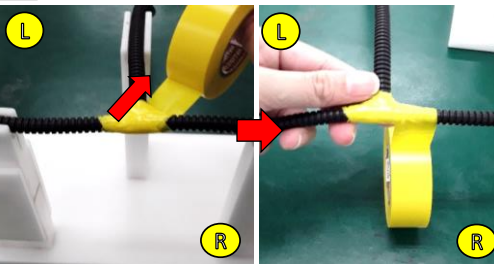
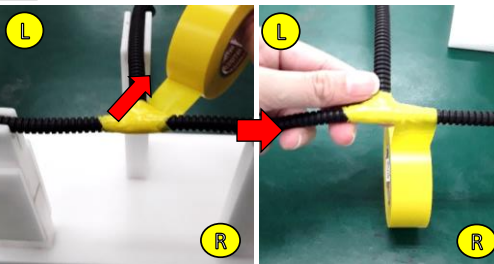
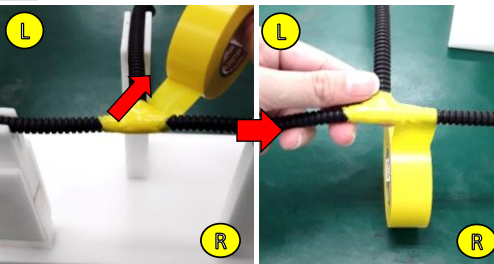
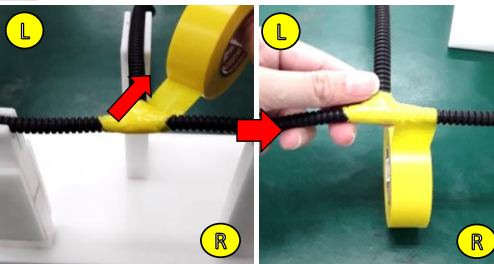
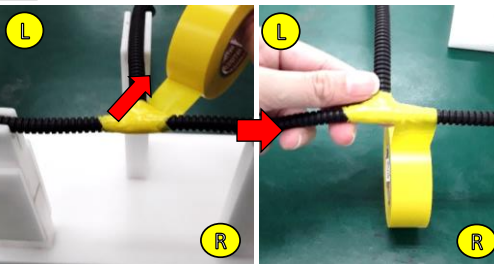
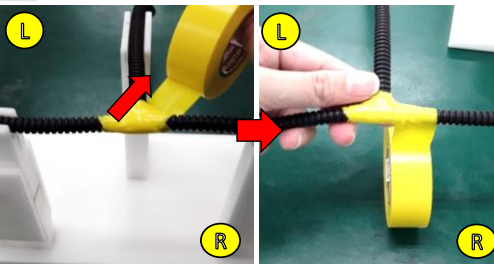
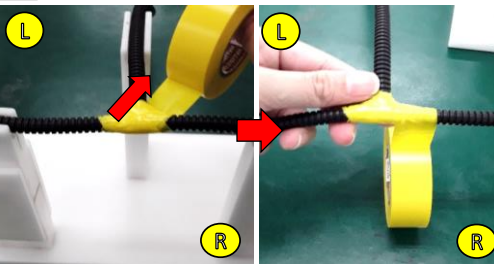
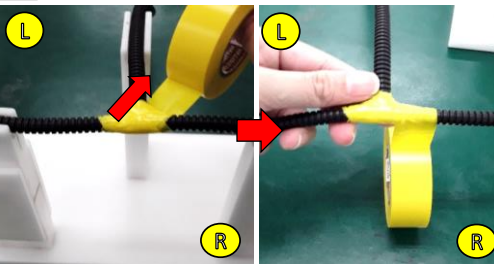
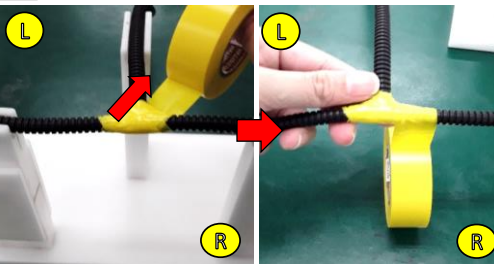
☒ MASSPRO

Revision No.:

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Page No.:

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PARTS:		1. Assy parts 2. Black tape		JIG	1. T-taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 T-taping (continuation)	<div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div>			



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

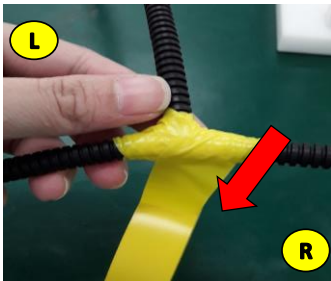
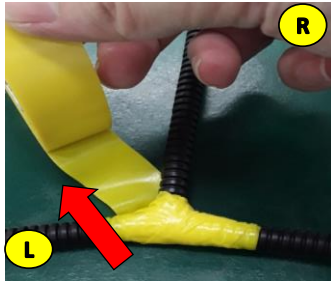
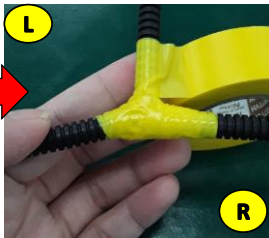
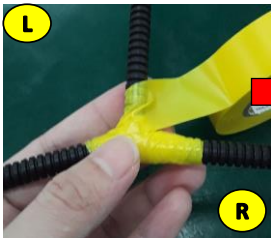
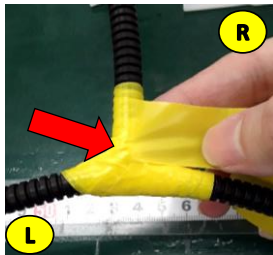

☒ MASSPRO

Revision No.:

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Page No.:

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PARTS:		1. Assy parts 2. Black tape		JIG	1. T-taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 T-taping (continuation)	<div><p>9. From the right side, wind the tape 2/3 shifting going to center</p></div> <div><p>10. Wind the tape from front to back side (cross pattern)</p></div> <div><p>11. Tape the top side corrugated tube (3 winds), width must be same as tape (19mm)</p></div> <div><p>12. From the top side, wind the tape 2/3 shifting going to center</p></div>		<div>MEASURING TAPE</div> 	<div>4 Important Reminders/Note/s:</div> <p>1. Used YELLOW TAPE to easily visualize the tape shifting. But actual should be BLACK TAPE.</p> <ol style="list-style-type: none">1. No flip-out tape2. No Peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. no wrong dimension

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

July 14, 2023

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

☒ MASSPRO

Revision No.:

4

Page No.:

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PARTS:

1. Assy parts
2. Black tape

JIG

1. T-taping jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

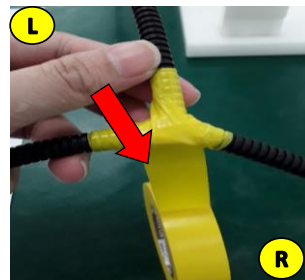
TOOLS/PPE

QUALITY POINTERS

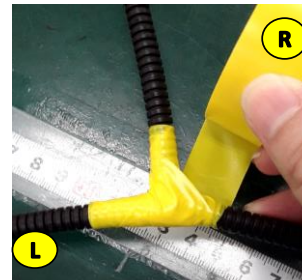
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P2

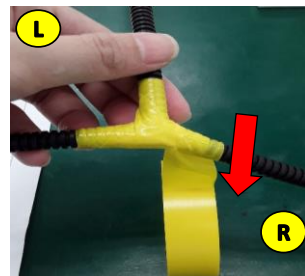
T-taping
(continuation)



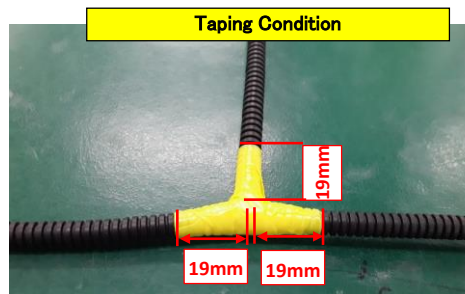
13. Wind the tape going to front side (cross pattern)



14. Wind the tape from front to back side (cross pattern)



15. Tape the right side corrugated tube (3 winds), width must be same as tape (19mm)



16. After taping, check the measurement and condition of tape.

MEASURING TAPE



4

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

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**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

July 14, 2023

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☒ MASSPRO

Revision No.:

4

Page No.:

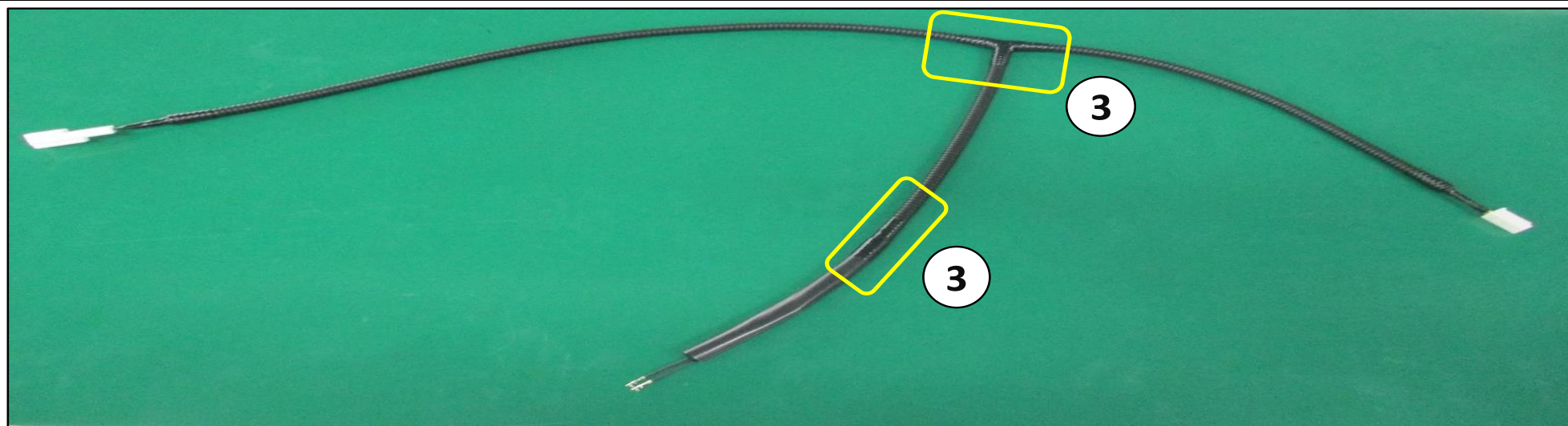
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PARTS:

n/a

JIG

n/a

**QUALITY CHECKPOINTS****P2****7M0366-7020B****1****No Missing Tape****on t-taping and taping to VM tube (Sunprene)**

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