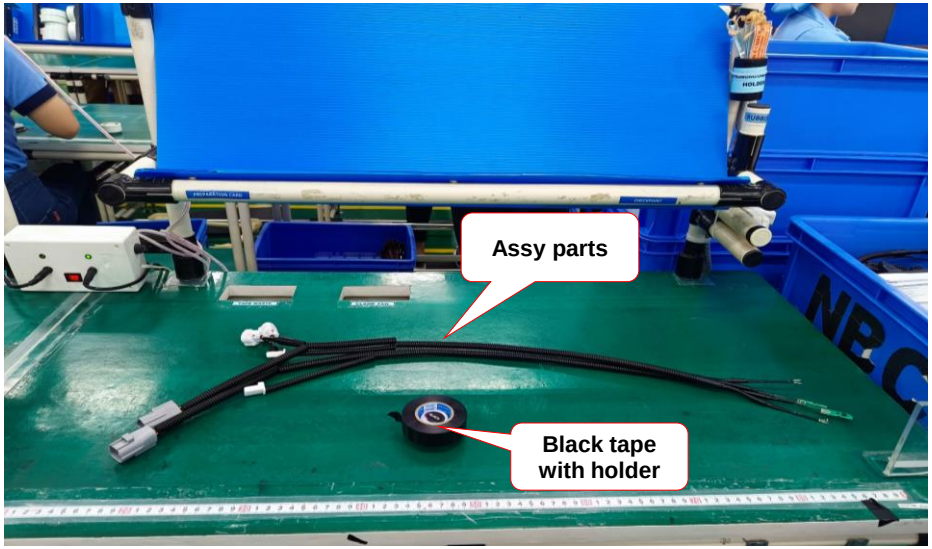
	WORK INSTRUCTION			Effectivity Date:	April 26, 2024	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 930B / 7N0205-7020Ca	Customer: TRJ	Car Model: TOYOTA-4RUNNER	Document No.:	WI-ENG-PDE-877D	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 1	Page No.:	1 of 5

PARTS:	1. Assy parts 2. Black tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P4	TABLE-LAY-OUT	**TABLE LAY-OUT**  	**Safety Instruction** Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) **Housekeeping** 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. **Alert level** For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	1. No missing parts/tools 2. No excess parts/tools 3. No wrong position of parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
04/26/24	1	Change purpose from Pre-launch to Masspro.				
04/23/24	0	Initial issue	M. Ariola	C.Villanueva	A. Arañes	n/a

Prepared by	Reviewed by	Approved by	Noted by
M. Ariola	C.Villanueva	A. Arañes	n/a
Est. Date:	April 23, 2024		

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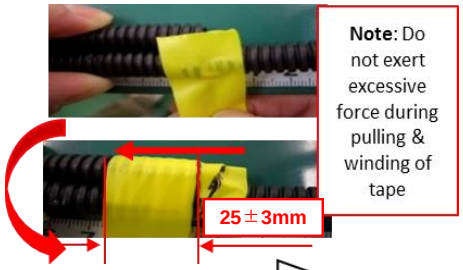
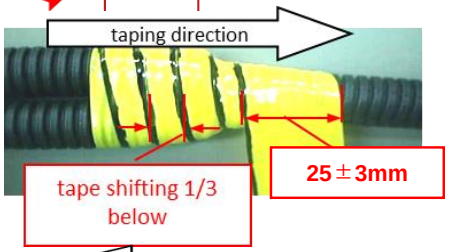
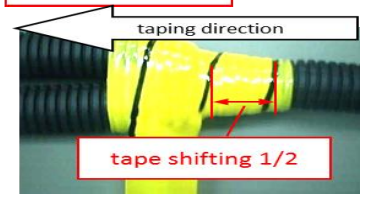
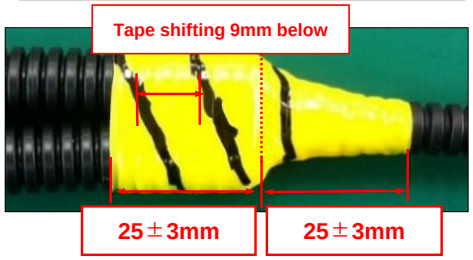
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 1	Page No.: 2 of 5

PARTS:	1. Assy parts 2. Black tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P4	Y-taping 1	 1. Fix the corrugated tube .  2. Start taping at the middle of combined Corrugated tubes, then winding the tape going to 2 corrugated tubes, width must be **Tape width.**  3. Winding the tape 1/3 shifting until it reach the other side of corrugated tube, width must be **25mm.**  4.Winding the tape backward 1/2 shifting.  5. Winding the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.	MEASURING TAPE 	***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.*** ***Document references:*** ***1. Refer to WI-PRO-ASY-001 for Taping process*** 1. No wrong usage of parts. 2. No deformed terminal

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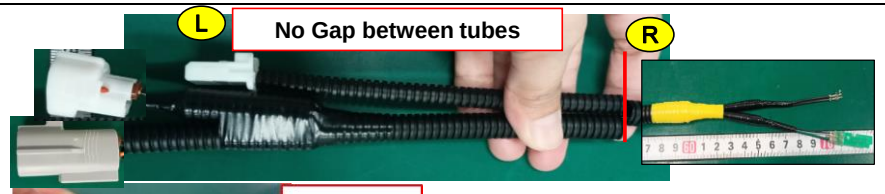
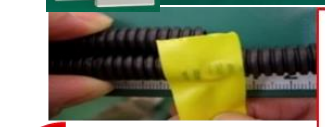
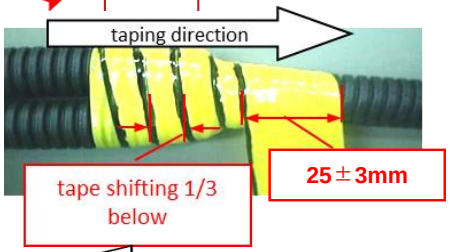
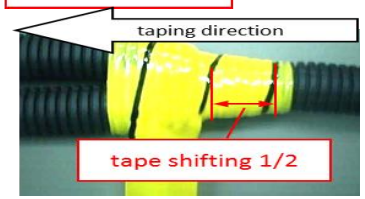
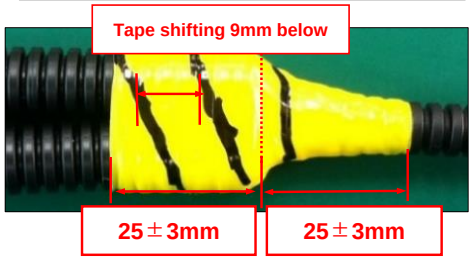
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 930B / 7N0205-7020Ca	Customer: TRJ	Car Model: TOYOTA-4RUNNER	Document No.:	WI-ENG-PDE-877D	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 1	Page No.:	3 of 5

PARTS:	1. Assy parts 2. Black tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P4	Y-taping 2	 1. Fix the corrugated tube .  **Note:** Do not exert excessive force during pulling & winding of tape 2. Start taping at the middle of combined Corrugated tubes, then winding the tape going to 2 corrugated tubes, width must be **Tape width.**  3. Winding the tape 1/3 shifting until it reach the other side of corrugated tube, width must be **25mm.**  4.Winding the tape backward 1/2 shifting.  5. Winding the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.	MEASURING TAPE 	***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.*** ***Document references:*** ***1. Refer to WI-PRO-ASY-001 for Taping process*** 1. No wrong usage of parts. 2. No deformed terminal

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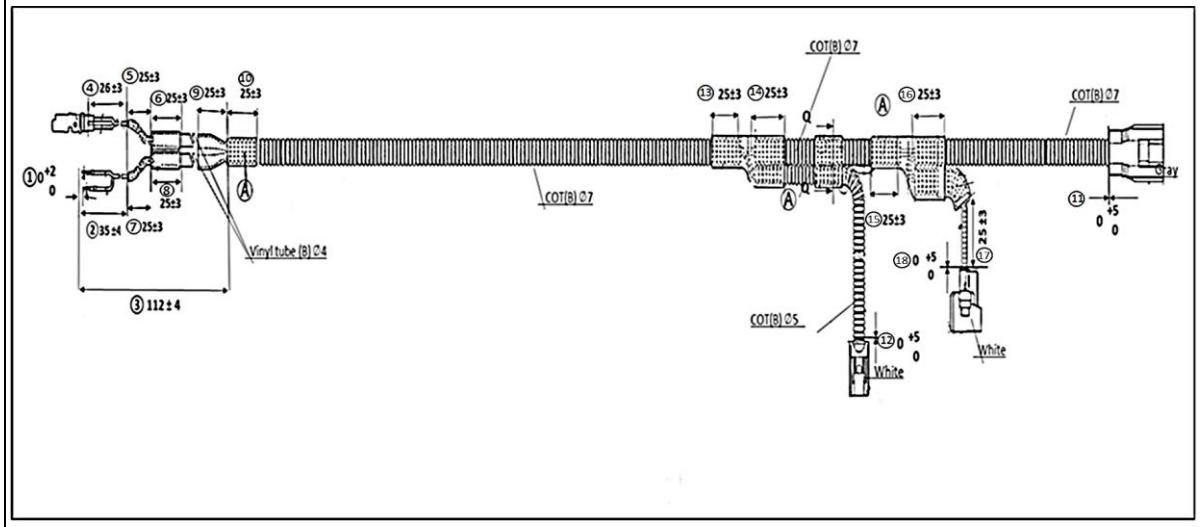
	Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	1	Page No.:	4 of 5

PARTS:	n/a	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P4	Measurement			1. No wrong dimension

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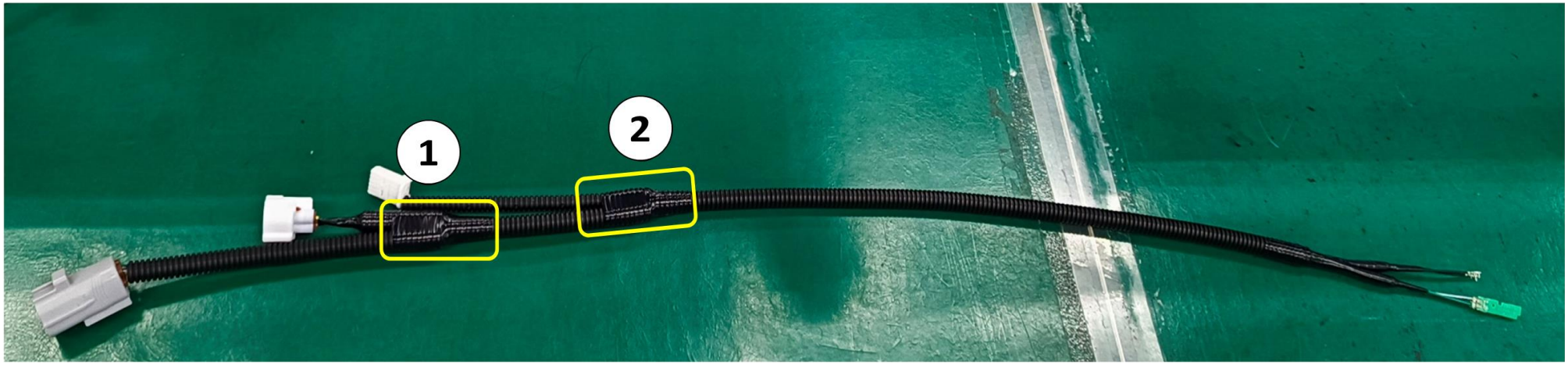
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.: 1	Page No.: 5 of 5

PARTS:	n/a	JIG:	n/a

QUALITY CHECKPOINTS

P4 7N0205-7020Ca



1 **No Missing Tape**
(Y-TAPING)

2 **No Wrong Facing**
(Y-TAPING)

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