
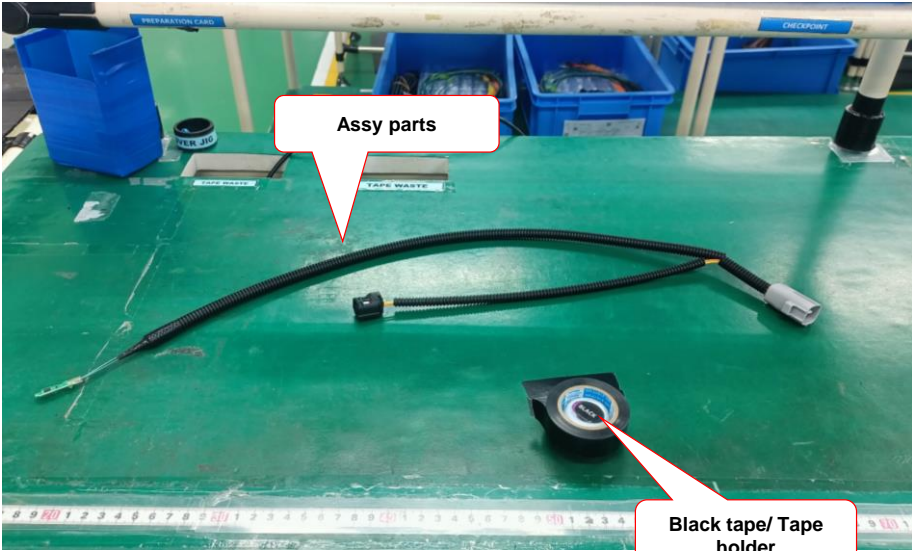


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|---|---|--|---------------|--|----------------------------|-------------------|---------------|-------------------|-----------------|-----------|
|  | WORK INSTRUCTION | | | | | Effectivity Date: | | November 18, 2024 | | |
| | Process Name/Title: TAPING ASSEMBLY PROCESS | | | | | Validity Date: | | n/a | | |
| | Model code/Part number: 930B / 7N0204-7020C | | Customer: TRJ | | Car Model: TOYOTA-4 RUNNER | | Document No.: | | WI-ENG-PDE-875B | |
| | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO | | | | | | Revision No.: | | 1 | Page No.: |


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

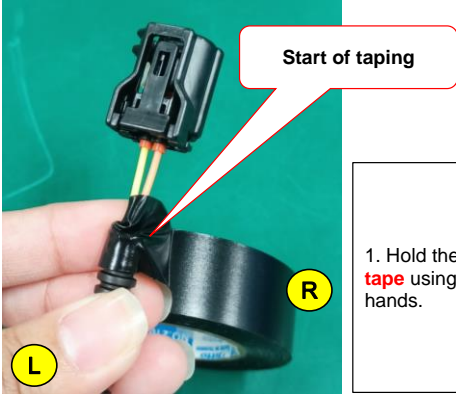
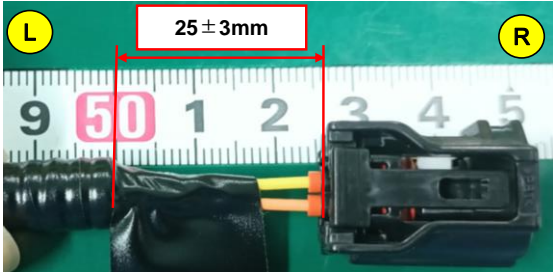
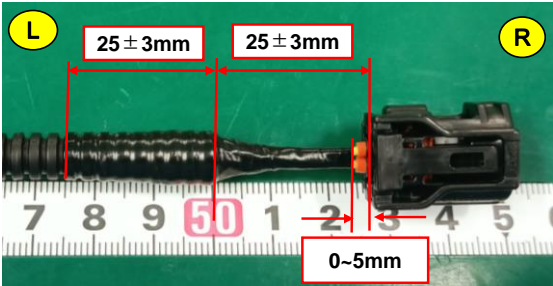

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|------------------|---------|-----------------------------------|--|--|--|--|--|-------------|---------------|-------------|-------|-------------|----------------|----------|--|--|
| Revision History | | | | | | | | Prepared by | | Reviewed by | | Approved by | | Noted by | | |
| 11/18/24 | 1 | Change from Pre-launch to Masspro | | | | | | D.Castillo | C. Villanueva | A. Arañes | n/a | | | | | |
| 04/16/24 | 0 | Initial issue | | | | | | D.Castillo | C. Villanueva | A. Arañes | n/a | | | | | |
| Eff. Date | Rev. No | Details of Change | | | | | | Revised | Reviewed | Approved | Noted | Est. Date: | April 16, 2024 | | | |

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|  | WORK INSTRUCTION | | | | Effectivity Date: | November 18, 2024 | | |
| | Process Name/Title: TAPING ASSEMBLY PROCESS | | | | Validity Date: | n/a | | |
| | Model code/Part number: 930B / 7N0204-7020C | | Customer: TRJ | Car Model: TOYOTA-4 RUNNER | Document No.: | WI-ENG-PDE-875B | | |
| | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO | | | | Revision No.: | 1 | Page No.: | 2 of 6 |


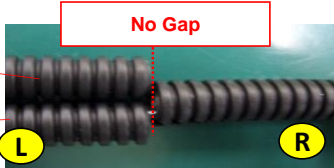
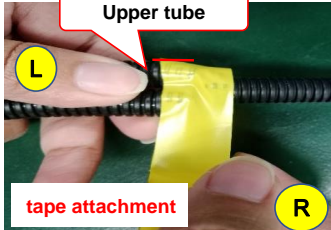

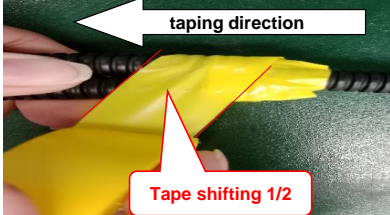
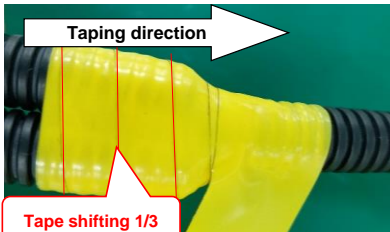
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|---------------|---|---|--|--|--|--|
| PARTS: | | 1. Assy parts 2. Black tape [1pc] | | JIG: | n/a | |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS | |
| 2 | P2 Taping 2 COT to wire near connector | <div><p>1. Hold the corrugated tube using left hand, get the Black tape using right hand then start pre-taping using both hands.</p></div> <div><p>2. Measure from end of the corrugated tube up to connector 25±3mm then continue the taping process using both hands.</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div> | | <div>MEASURING TAPE</div>  | <p>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document references: 1. Refer to WI-PRO-ASY-001 for Taping process</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</p> | |


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|  | WORK INSTRUCTION | | | | Effectivity Date: | November 18, 2024 | | |
| | Process Name/Title: TAPING ASSEMBLY PROCESS | | | | Validity Date: | n/a | | |
| | Model code/Part number: 930B / 7N0204-7020C | | Customer: TRJ | Car Model: TOYOTA-4 RUNNER | Document No.: | WI-ENG-PDE-875B | | |
| | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO | | | | Revision No.: | 1 | Page No.: | 3 of 6 |

| | | | | |
|---|--------------|------------------------------|--|---|
| PARTS: 1. Assy parts 2. Black tape [1pc] | | JIG: | | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
| 3 | P2 | Y-taping | <div>  <p>CONNECTOR CORRECT FACING</p> </div> <div>  <p>No Gap</p> </div> <div>  <p>tape attachment</p> </div> <div>  <p>pre-tape</p> </div> <div>  <p>taping direction Tape shifting 1/2</p> </div> <div>  <p>Taping direction Tape shifting 1/3</p> </div> <div> <p>1. Fix the 3 corrugated tube. Note: Follow the connector correct facing.</p> <p>2. Start taping at the middle of combined tubes, attach the tape on the upper tube. Then make pre-tape 2 windings. Note: Do not exert excessive force during pulling & winding of tape.</p> <p>3. Winding the tape 1/2 shifting going to the left side.</p> <p>4. Make 2 windings, width must be - 25±3mm.</p> <p>5. Winding the tape 1/3 shifting going to the right side until reach the other side of tube.</p> <p>6. Make 2 windings, width must be 25±3mm.</p> </div> <td> <p>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>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.</p> <p>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</p> </td> | <p>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>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.</p> <p>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</p> |

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

November 18, 2024

Model code/Part number:

930B

/

7N0204-7020C

Customer:

TRJ

Car Model:

TOYOTA-4 RUNNER

Document No.:

WI-ENG-PDE-875B

Purpose:

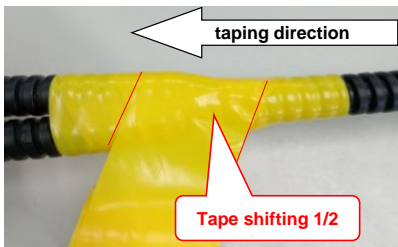
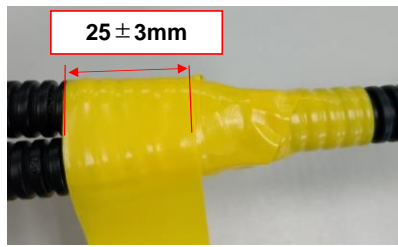
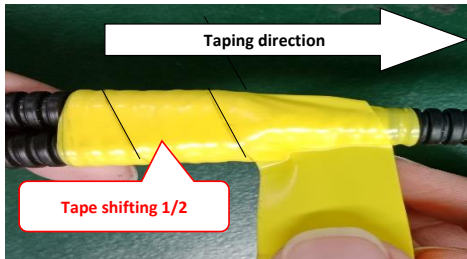
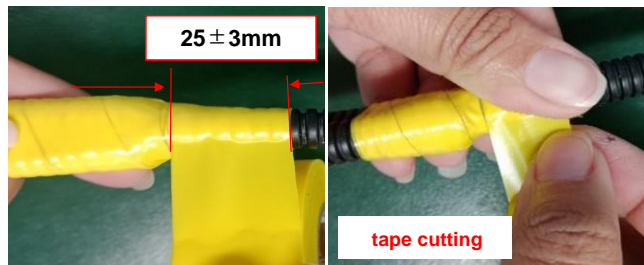
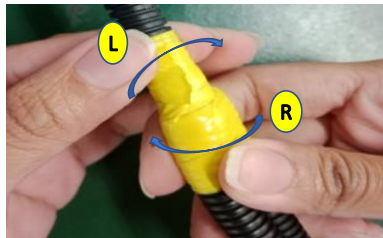

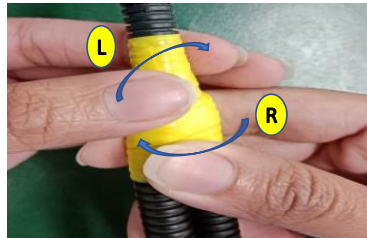
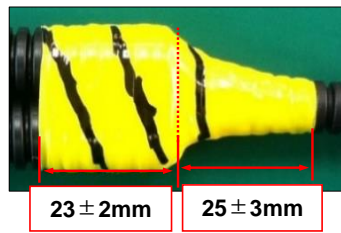
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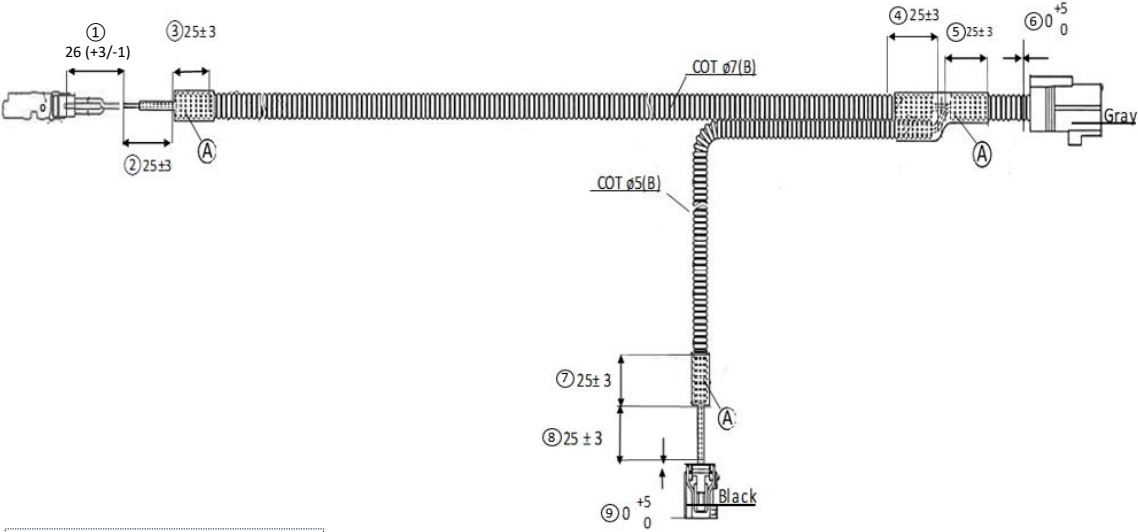

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|--------|--------------|--------------------------------------|---|---|---|--|--|
| PARTS: | | 1. Assy parts 2. Black tape [1pc] | | JIG: | n/a | | |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS | | |
| 3 | P2 | Y-taping (Continuation) | <div></div> <div>7. Winding the tape 1/2 shifting going to the left side.</div> <div></div> <div>8. Make 2 windings, width must be 25±2mm.</div> | | <p>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>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.</p> <ol style="list-style-type: none">1. No loose tape2. No flip-out tape3. No peel-off tape4. No wrong use of tape5. No wrong dimension-out tape6. No exposed wire7. No gap between tubes | | |
| | | | <div></div> <div>9. Winding the tape 1/2 shifting going to the right side until it reach the other side of tube</div> <div></div> <div>10. Make 3 winds, width must be 25±3mm. Then cut the tape.</div> | | | | |
| | | | <div></div> <div>11. conduct proper pressing of end tape using left hand (top part). Note: Reference only.</div> | <div></div> <div>12. conduct proper pressing of end tape using left hand (Middle part). Note: Reference only.</div> | | <div></div> <div>13. conduct proper pressing of end tape using left hand (bottom part). Note: Reference only.</div> | <div></div> <div>14. Check the Measurement and condition of tape.</div> |

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|  | WORK INSTRUCTION | | | | Effectivity Date: | November 18, 2024 | | |
| | Process Name/Title: TAPING ASSEMBLY PROCESS | | | | Validity Date: | n/a | | |
| | Model code/Part number: 930B / 7N0204-7020C | | Customer: TRJ | Car Model: TOYOTA-4 RUNNER | Document No.: | WI-ENG-PDE-875B | | |
| | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO | | | | Revision No.: | 1 | Page No.: | 5 of 6 |

| | | | | | |
|---------------|---------------------|---|--|--|-------------------------|
| PARTS: | 1. Assy parts | | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 4 | P2 | <div>Measurement</div> <div></div> <div><div>MEASURING TAPE</div></div> | | <div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension</div> | |

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**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**

Effectivity Date:

November 18, 2024Model code/Part number: **930B / 7N0204-7020C** Customer: **TRJ** Car Model: **TOYOTA-4 RUNNER**

Validity Date:

n/a

Purpose:

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Document No.:

WI-ENG-PDE-875B

Revision No.:

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Page No.:

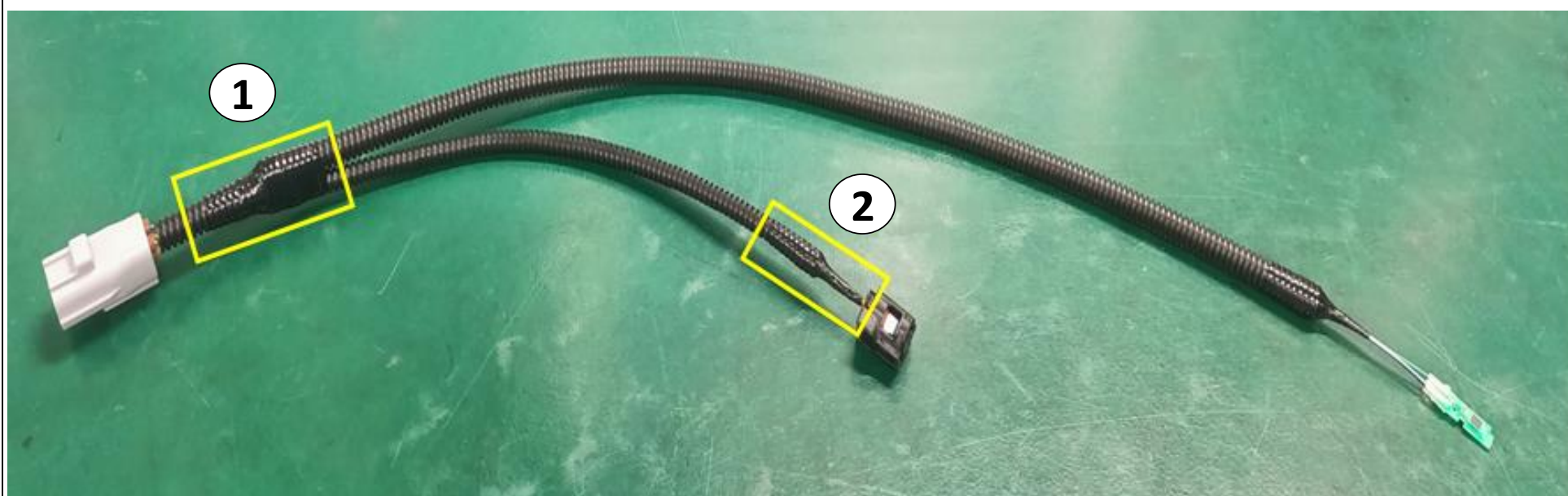
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PARTS:

1. Assy parts

JIG:

n/a

QUALITY CHECKPOINT/ VISUAL INSPECTION**TAPING - P2****7N0204-7020C****1****2****No Missing tape**

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