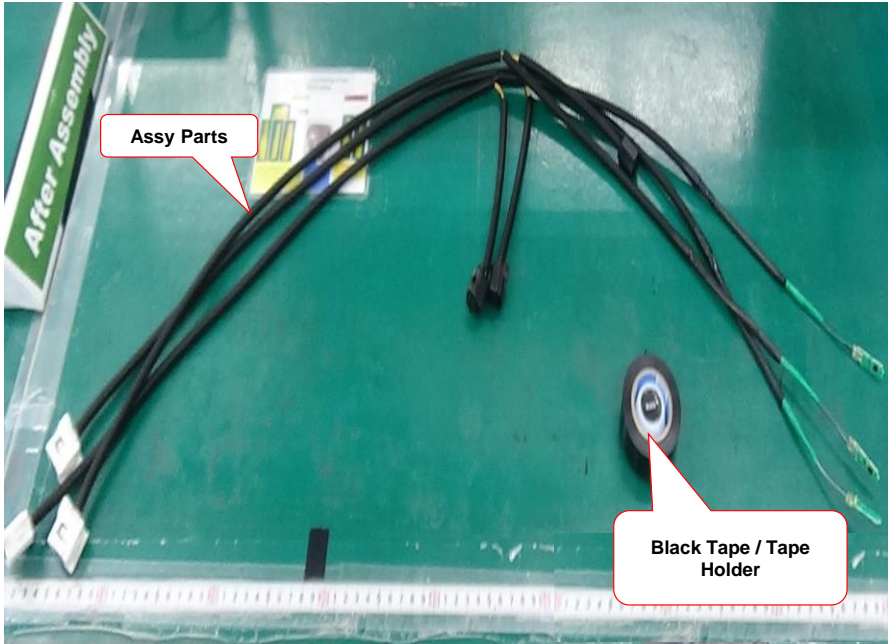

	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>September 10, 2024</b>		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>920B / 7R0118-7025</b>		Customer: <b>TRMX</b>	Car Model: <b>TOYOTA TACOMA</b>	Document No.: <b>WI-ENG-PDE-996C</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	1 of 6


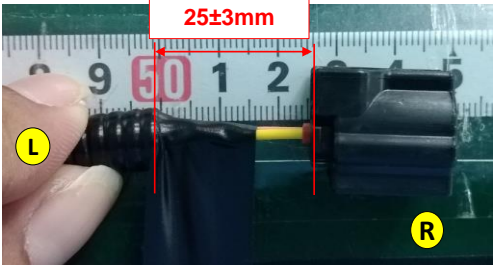
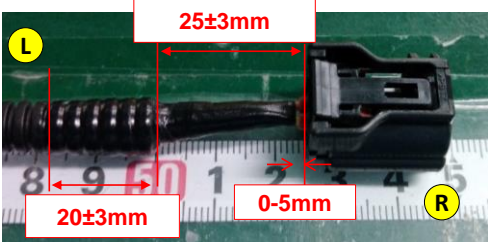

PARTS:	1. Assy parts: Black tape [1pc.]			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P3	Table Lay-out	<div> <div>Table Lay-out</div>  </div>	<div> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div> <b>Housekeeping</b>            1. Maintain and always practice 5's.            2. Personal things on the workplace is prohibited. Keep it in your locker.         </div> <div> <b>Alert level</b>            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

Revision History							Prepared by	Reviewed by	Approved by	Noted by
09/10/24	1	Change from Pre-launch to Masspro. Update Work procedure of Y-taping process. Visual inspection/Quality checkpoints.				D.Castillo	C.Villanueva	A. Arañes	N/A	
08/12/24	0	Initial issue.				D.Castillo	C.Villanueva	A. Arañes	N/A	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date: August 12, 2024

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	2 of 6

<b>PARTS:</b>		1. Assy parts 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>	
2	P3 Taping 3 COT to wire near connector	<div><p>Start of taping</p></div> <div><p>25±3mm</p></div> <div><p>25±3mm 20±3mm 0-5mm</p></div> <div><p>1. Hold the COT then get <b>Black tape</b> using right hand then start taping process using both hands.</p><p>2. Measure from end of COT up to edge of connector <b>25±3mm</b> then continue the taping process using both hands.</p><p>3. After taping, check the measurement and taping condition.</p></div>		<div><b>MEASURING TAPE</b></div> 	<p><b>Important reminders and Note/s:</b></p> <p><b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></p> <p><b>Document reference/s:</b></p> <p><b>1. Refer to WI-PRO-ASY-001 for taping procedure.</b></p> <p>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</p>	

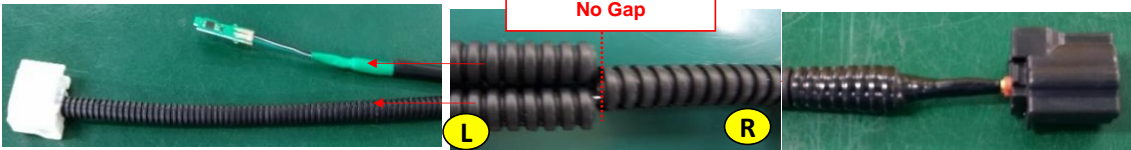
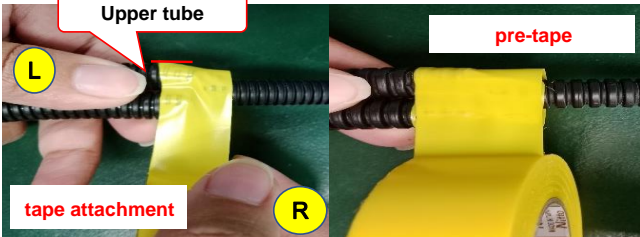
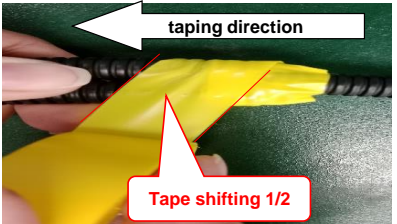
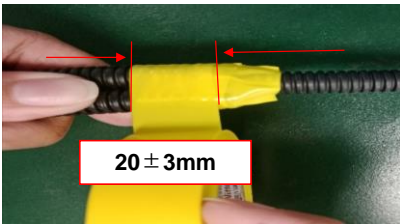
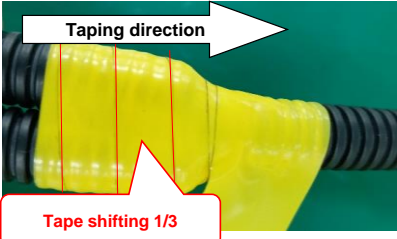
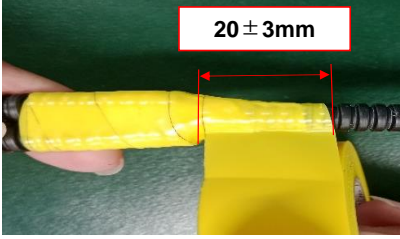
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	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a					
	Process Name/Title:		Model code/Part number: <b>920B / 7R0118-7025</b>		Customer: <b>TRMX</b>	Car Model: <b>TOYOTA TACOMA</b>	Document No.:	WI-ENG-PDE-996C			
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:	1	Page No.:

<b>PARTS:</b>		1. Assy parts 2. Black tape		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<div>1</div> <b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
3	P3	<div>Y-Taping</div> <div>  <p>1. Fix the 3 corrugated tube .</p>  <p>2. Start taping at the middle of combined tubes, attach the tape on the upper tube. Then make pre-tape <b>2 windings</b>. <i>Note: Do not exert excessive force during pulling &amp; winding of tape.</i></p>  <p>3. Winding the tape <b>1/2 shifting</b> going to the left side.</p>  <p>4. Make <b>2 windings</b>, width must be <b>20±3mm</b>.</p>  <p>5. Winding the tape <b>1/3 shifting</b> going to the right side until reach the other side of tube.</p>  <p>6. Make <b>2 windings</b>, width must be <b>20±3mm</b>.</p> </div>		<p><b>Document reference/s:</b></p> <p>1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p><b>Important reminders/Note/s:</b></p> <p>1. Use <u>yellow tape</u> for easy visualization of tape shifting, but actual should be <u>BLACK TAPE</u>. 2. Please use calibrated/verified measuring tape when getting the measurement.</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

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

September 10, 2024

Model code/Part number:

920B / 7R0118-7025

Customer:

TRMX

Car Model:

TOYOTA TACOMA

Document No.:

WI-ENG-PDE-996C

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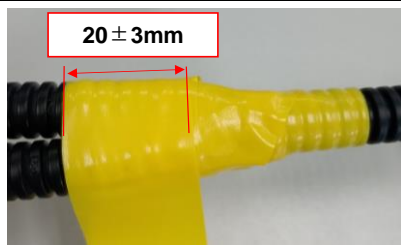
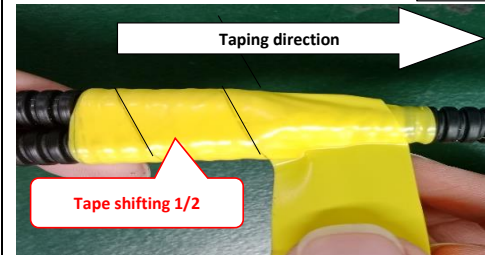
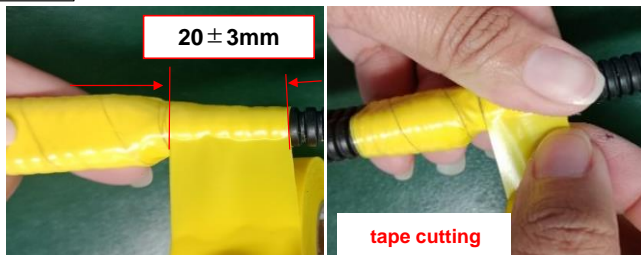
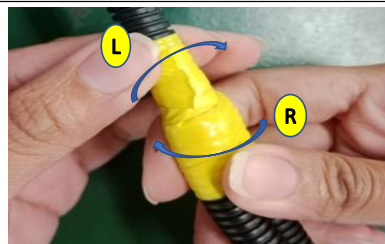
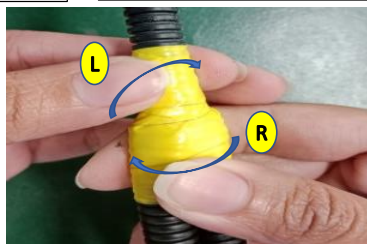
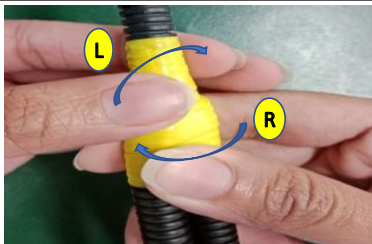
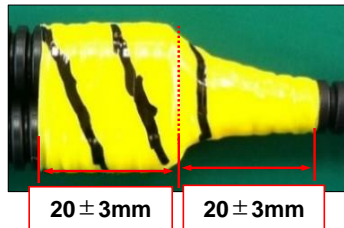
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P3	Y-Taping (Continuation)	<div></div> <div>7. Winding the tape <b>1/2 shifting</b> going to the left side.</div> <div></div> <div>8. Make <b>2 windings</b>, width must be <b>20±2mm</b>.</div>		<p><b>Document reference/s:</b> <b>1. Refer to WI-PRO-ASY-001C for taping procedure (special).</b></p> <p><b>Important reminders/Note/s:</b> <b>1. Use <u>yellow tape</u> for easy visualization of tape shifting, but actual should be <u>BLACK TAPE</u>.</b> <b>2. Please use calibrated/verified measuring tape when getting the measurement.</b></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>
			<div></div> <div>9. Winding the tape <b>1/2 shifting</b> going to the right side until it reach the other side of tube</div> <div></div> <div>10. Make <b>3 winds</b>, width must be <b>20±3mm</b>. Then cut the tape.</div>		
			<div></div> <div>11. conduct proper pressing of end tape using left hand (<b>top part</b>)</div> <div></div> <div>12. conduct proper pressing of end tape using left hand (<b>Middle part</b>)</div> <div></div> <div>13. conduct proper pressing of end tape using left hand (<b>bottom part</b>)</div>		
			<div></div> <div>14. Check the Measurement and condition of tape.</div>		


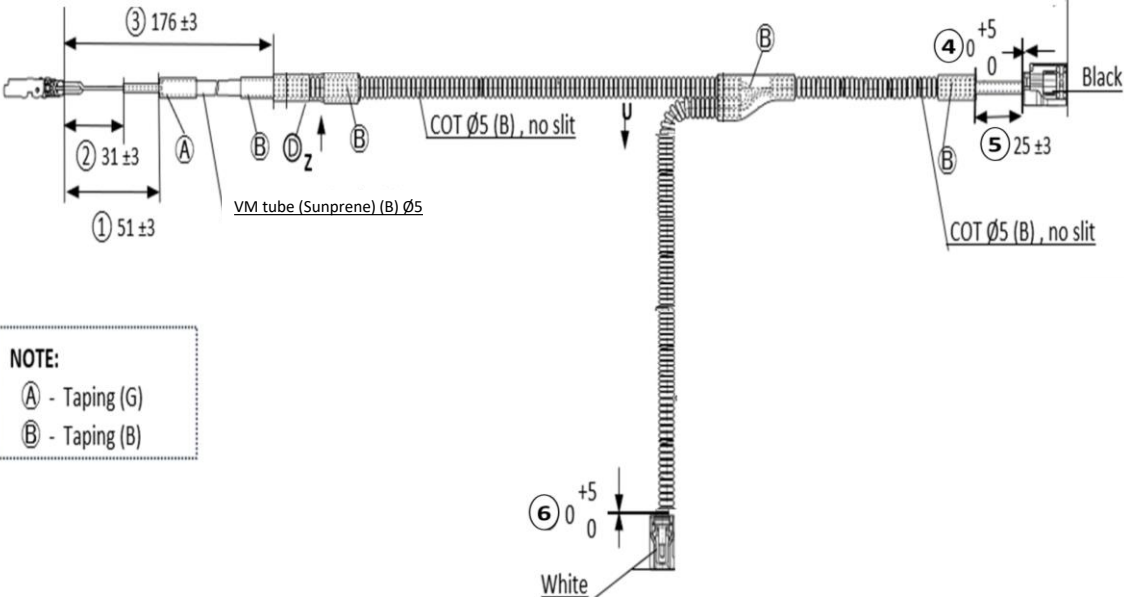
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	Model code/Part number: <b>920B / 7R0118-7025</b>		Customer: <b>TRMX</b>	Car Model: <b>TOYOTA TACOMA</b>	Document No.:	<b>WI-ENG-PDE-996C</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	5 of 6

<b>PARTS:</b>		1. Assy parts		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
4	P3	Measurement	<div><div>MEASURING TAPE</div></div>  <div>NOTE: A - Taping (G) B - Taping (B)</div>	<div><b>Important reminders and note/s:</b> 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.</div> <div><b>Document reference/s:</b> 1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension</div>	

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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P3****7R0118-7025****1****No MISSING TAPE****2****No WRONG FACING OF  
Y-TAPING**

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