

**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

June 24, 2024

Validity Date:

n/a

Model code/Part number:

**920B / 7R0117-7023**

Customer:

**TRMX**

Car Model:

**TOYOTA-TACOMA**

Document No.:

**WI-ENG-PDE-653C**

Purpose:

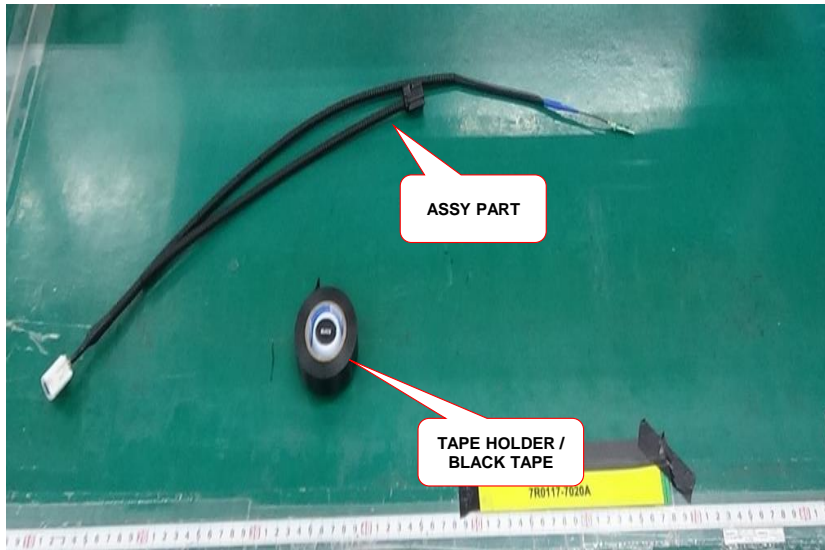
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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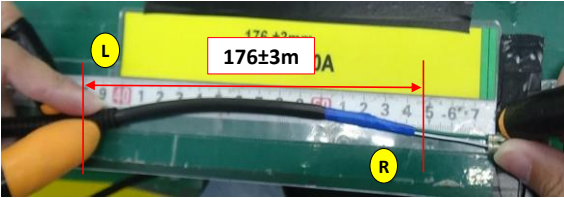
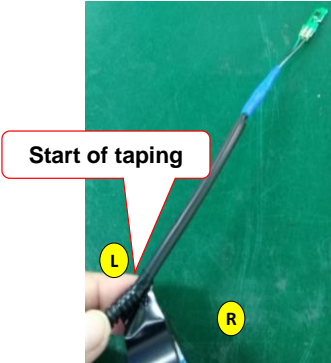
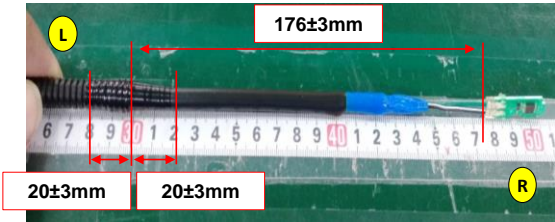

<b>PARTS:</b>		1. Assy parts: Black tape				<b>JIG:</b>		n/a		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>				<b>TOOLS/PPE</b>		<b>QUALITY POINTERS</b>		
1	P3	<div style="text-align: center;"><b>Table Lay-out</b></div> 				<div><b>Safety Instruction</b> Be sure to wear required 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	
06/24/24	4	Separate clamp setting and clamp assembly to Clamp assembly process and transfer COT to VM tube taping and Y-taping from P2 (WI-ENG-PDE-653B) due to process improvement. Inclusio of car model "TOYOTA-TACOMA". Update Table lay-out, Measurment and Visual inspection/Quality checkpoints.				D.Castillo	C.Villanueva	A.Arañes	n/a	
06/08/23	3	Change quantity of Bando Gun from 2 to 1. Used Bando Gun (Modified Nosepiece for the both clamps 82711-12A60(W) and 82711-58020 (W) as improvement. Change Illustration of Bando Gun cutting position (process no.4) Improved receiver base of Clamp 82711				M.Ariola	J.Loterte	C.Villanueva	A.Arañes	
04/12/23	2	Changed of Bando Gun cutting position on page no. 4 applicable only for Clamp 82711-12A60 (W) as countermeasure for encountered minimum tolerance of band Clamp cut.				M.Ariola	J.Loterte	C.Villanueva	A.Arañes	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	
						Est. Date:	March 17,2023			

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	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	4	Page No.:	2 of 5			

<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 Black VM tube (Sunprene) near PCB	<div><p>1. Measure from end of COT up to PCB <b>176±3mm</b> then start the taping process using both hands.</p></div> <div><p>2. Hold the COT using left hand, get the <b>Black tape</b> using right hand then start pre-taping using both hands.</p></div> <div><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>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</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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☐ PROTOTYPE

☐ PRE-LAUNCH



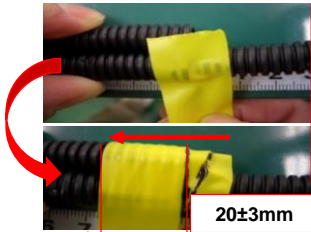
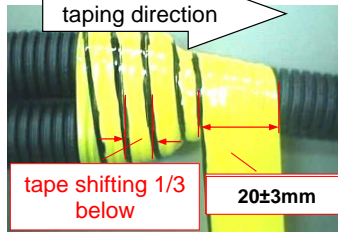
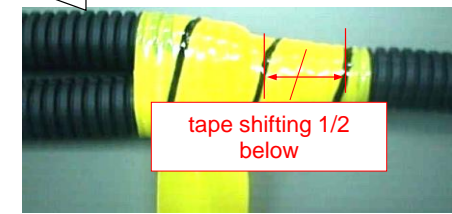
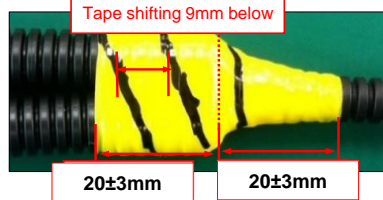
☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P3	Y-Taping	<div><div><div><div><div><p>No gap in between tubes</p></div><div><p>1. Fix the corrugated tube .</p></div></div></div><div><div><div><div><p>Note: Do not exert excessive force during pulling &amp; winding of tape</p><p>20±3mm</p></div><div><p>2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side, width must be 20±3mm</p></div></div></div><div><div><div><div><p>taping direction</p><p>tape shifting 1/3 below</p><p>20±3mm</p></div><div><p>3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be 20±3mm)</p></div></div></div><div><div><div><div><p>taping direction</p><p>tape shifting 1/2 below</p></div><div><p>4. Wind the tape backward 1/2 shifting</p></div></div></div><div><div><div><div><p>Tape shifting 9mm below</p><p>20±3mm 20±3mm</p></div><div><p>5. Wind the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.</p></div></div></div></div></div><div>n/a</div><div><p><b>Important reminders/Note/s:</b></p><p>1. Use <u>YELLOW TAPE</u> for easy visualization of shifting lines, but actual should be <u>BLACK TAPE</u>.</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></div></div>		

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
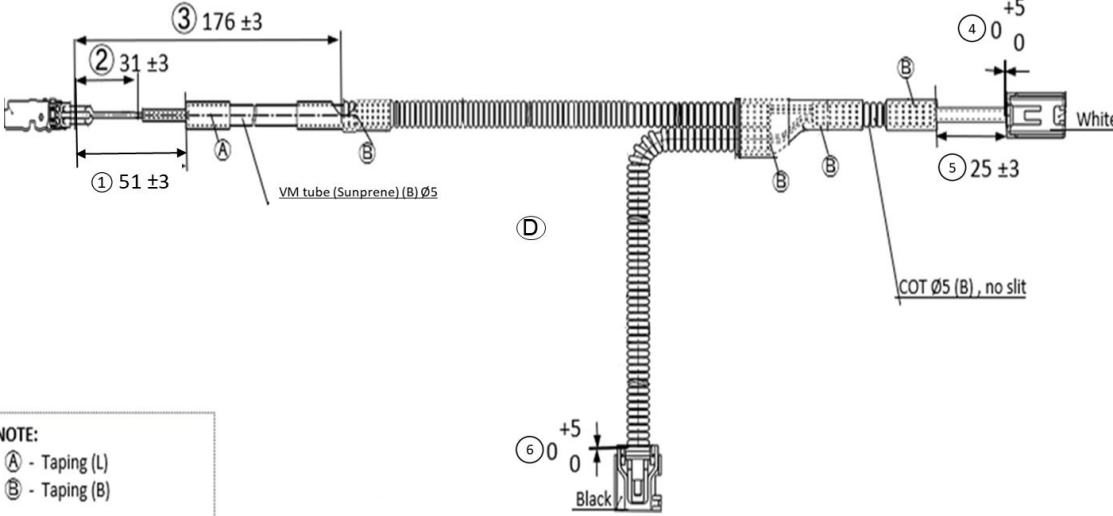

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	4  WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
4	CLAMP ASSY	<p data-bbox="376 842 488 866">Measurement</p>  <p data-bbox="566 1066 689 1145"><b>NOTE:</b> A - Taping (L) B - Taping (B)</p>	<p data-bbox="1525 395 1671 448"><b>MEASURING TAPE</b></p> 	<p data-bbox="1742 379 2051 403"><b>Important reminders and note/s:</b></p> <p data-bbox="1742 403 2051 467">1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p data-bbox="1742 491 2063 539">2. For Hatsumono, Nakamono and Owarimono.</p> <p data-bbox="1742 587 1995 611"><b>Document reference/s:</b></p> <p data-bbox="1742 611 2074 683">1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p data-bbox="1731 842 1933 866">1. No wrong dimension</p>	

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PARTS:

1. Assy parts

JIG:

n/a



### VISUAL INSPECTION/ QUALITY CHECKPOINTS

# P3

# 7R0117-7023



① ③ No MISSING TAPE

② Correct Facing of Y-taping

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