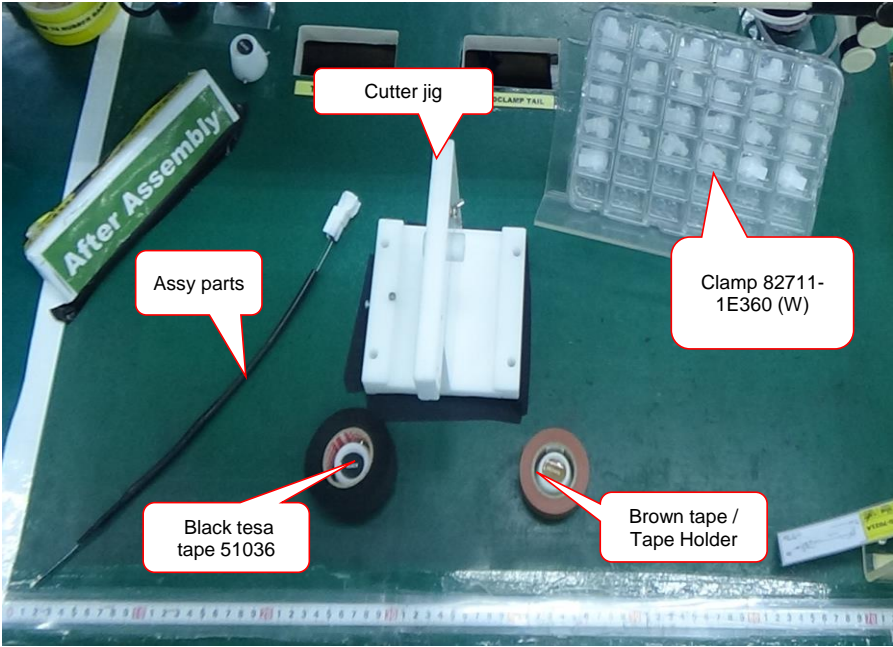



	WORK INSTRUCTION			Effectivity Date:		August 15, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:		n/a		
	Model code/Part number: 920B / 7R0120-7022		Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:		WI-ENG-PDE-978B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:		1	Page No.:	1 of 6

PARTS:		1.Assy parts ; Clamp 82711-1E360 (W); Black tesa tape 51036; Brown tape		JIG:	1.Cutter jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P2	Table Lay-out 		<div>Safety Instruction Be sure to wear required 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

Revision History						Prepared by	Reviewed by	Approved by	Noted by
08/15/24	1	Change Pre Launch to Mass Production.	A.Hernandez	C. Villanueva	A. Arañes	n/a			
08/08/24	0	Initial issue	A.Hernandez	J. Loterte	C. Villanueva	A. Arañes	A.Hernandez	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	August 08, 2024	

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☐ PROTOTYPE

☐ PRE-LAUNCH

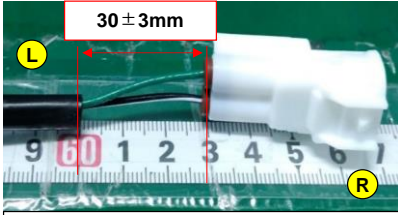
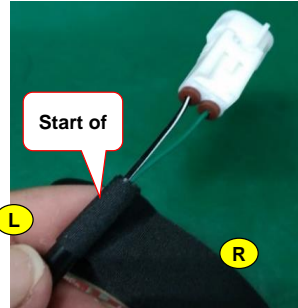
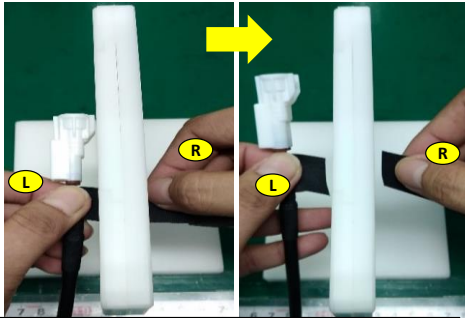
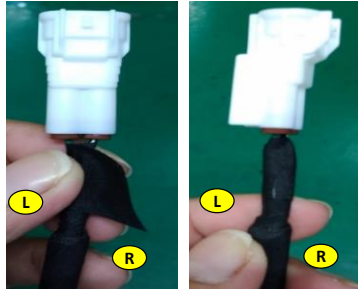
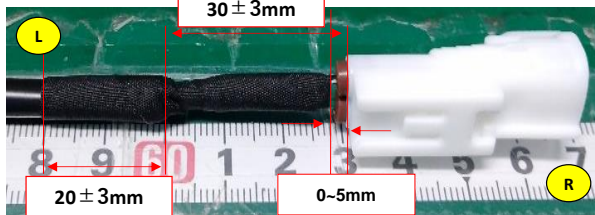




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PARTS:		1.Assy part 2.Black tesa tape 51036		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 1 Black tesa tape 51036 to wire near connector	<div><p>30 ± 3mm</p><p>1. Measure from end of Black SV tube (Vinyl) up to edge of connector 30±3mm using both hands.</p></div> <div><p>Start of</p><p>2. Hold the tube using left hand, get the Black tesa tape 51036 using right hand then start taping process using both hands.</p></div> <div><p>3. Cut the tape using tape cutter using both hands.</p></div> <div><p>4. After cut, conduct pressing of end tape using both hands.</p></div> <div><p>30 ± 3mm</p><p>20 ± 3mm</p><p>0~5mm</p><p>5. Check the taping condition, measurement and wire alignment.</p></div>		<div>MEASURING TAPE </div> <div>TAPE CUTTER </div>	<div><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><p>Important reminders/Note/s: <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p><div>TAPING CONDITION REFERENCE</div><div><p>GOOD If the taping on wires is NOT align with tube appearance</p></div><div><p>NG If the taping on wires is align with tube appearance and loose</p></div></div>

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☐ PRE-LAUNCH

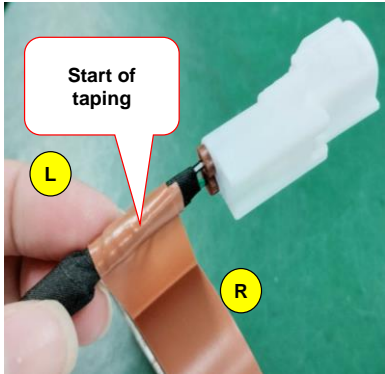
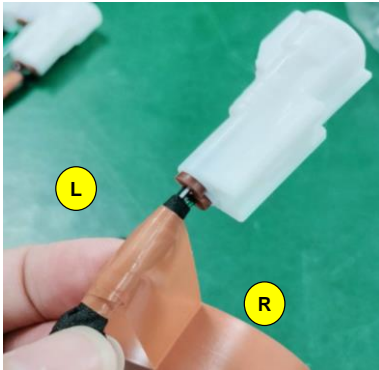
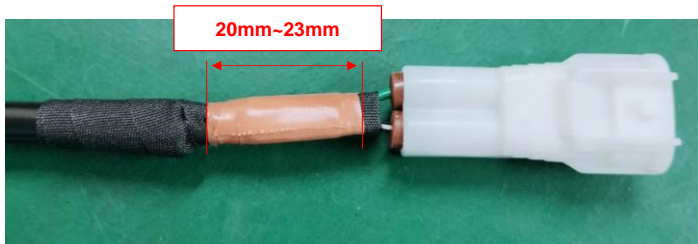
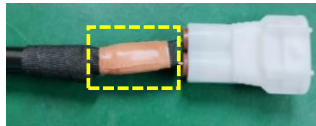
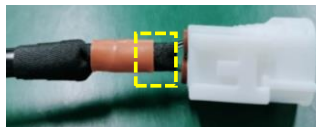
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PARTS:		1. Assy parts 2. Brown Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	Spot taping	<div><div><p>1. Hold the assy parts using left hand, get the Brown tape using right hand then start taping process using both hands.</p></div><div><p>2. Conduct windings of tape until it covers the end of tesa tape then conduct 2 windings of tape before cut using both hands.</p></div><div><p>3. After taping, check the taping condition. Spot taping must be from 20mm~23mm only.</p></div></div>	n/a	<div><div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape</div><div><p>GOOD NO EXPOSED END OF TESA TAPE</p></div><div><p>NG WITH EXPOSED END OF TESA TAPE</p></div></div>

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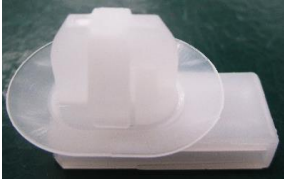
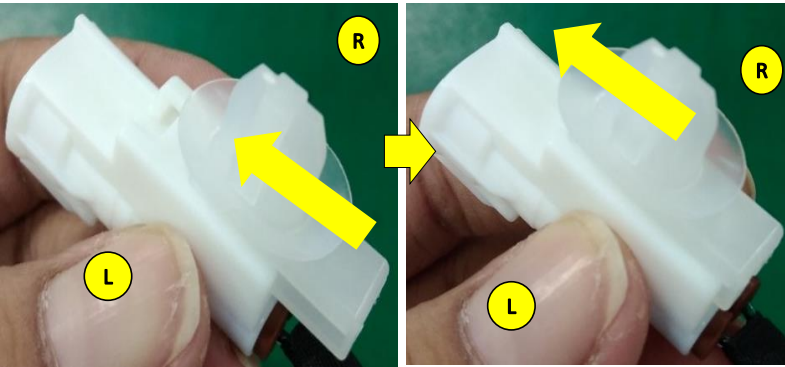
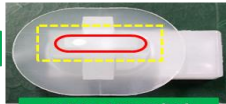
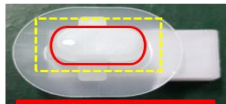
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Brown Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2 Clip attachment 82711-1E360 (W)	<div></div> <div>CLAMP ORIENTATION</div> <div></div> <div>1. Hold the connector using left hand, get the Clamp 82711-1E360 (W) then insert using right hand.</div>		n/a	<div>CLIP CLAMP ILLUSTRATION</div> <div><div>GOOD</div><div>82711-1E360 (W)</div></div> <div><div>NG</div><div>82711-12B10 (W)</div></div> <div>1. No wrong use of clamp 2. No damaged clamp 3. No missing clamp</div>

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PARTS:

n/a

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

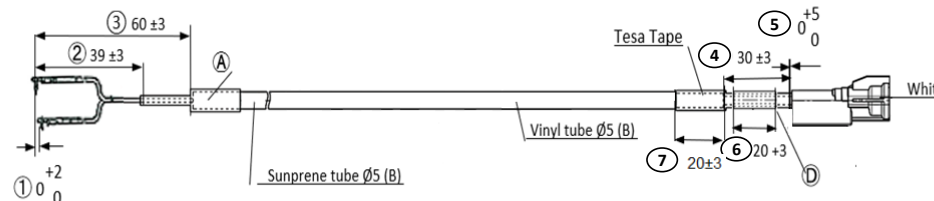
QUALITY POINTERS

5

P2

Measurement

Illustration:



NOTE:

Ⓐ - Taping (B)

Ⓓ - Taping (BR) *** Check the presence of spot tape

WIRE TYPE TABLE

No.	Color	Wire Type
1	G	TVSS 0.3f
2	B/W	TVSS 0.3f

Important reminders and note/s:

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

2. For Hatsumono, Nakamono and Owarimono.

Document reference/s:

1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection.

1. No wrong dimension

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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS

P2

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1 No Locked Connector

3 No Missing / Wrong Use of Tape

5 No Missing Clamp

2 No Wrong Insert

4 No Terminal Backing Out

6 No Deformed Terminal

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