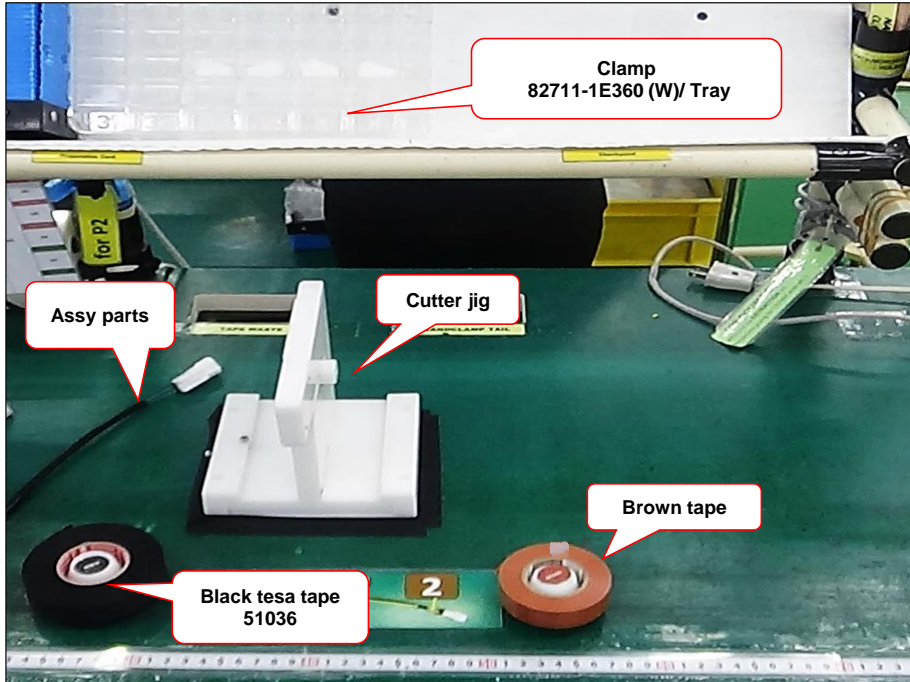

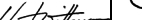



PARTS:	1. Assy parts (Clamp 82711-1E360 (W)); Black tesa tape 51036; Brown tape 20mm		JIG:	1. Tesa Cutter jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Table Lay-out 	<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <hr/> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <hr/> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	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 Mass Production.		A. Hernandez	C. Villanueva	A. Arañes	n/a	 A. Hernandez	 C. Villanueva	 A. Arañes	n/a
08/12/24	0	Initial Issue.		A. Hernandez	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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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

920B / 7R0116-7022

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

September 10, 2024

Validity Date:

n/a

Document No.:

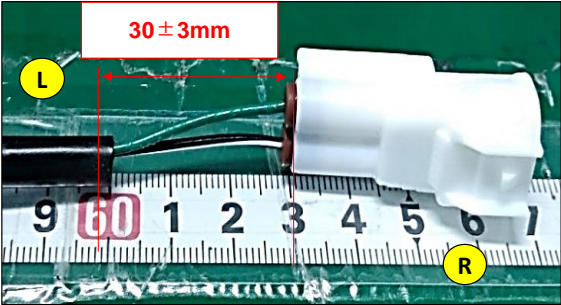
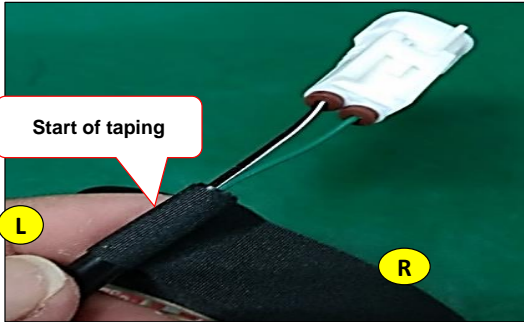

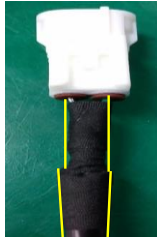

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PARTS:		1. Assy parts 2. Black tesa tape 51036		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 1 SV tube to wire near connector	<div></div> <div>1. Measure from end of Black SV tube (Vinyl) up to edge of connector 30±3mm using both hands.</div> <div></div> <div>2. Hold the tube using left hand, get the Black tesa tape 51036 using right hand then start taping process using both hands.</div>		<div>Measuring tape</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 6. No wrong dimension</div> <div>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>TAPING CONDITION REFERENCE</div> <div><div>GOOD If the taping on wires is align with tube appearance</div><div>NG If the taping on wires is align with tube appearance and loose</div></div>

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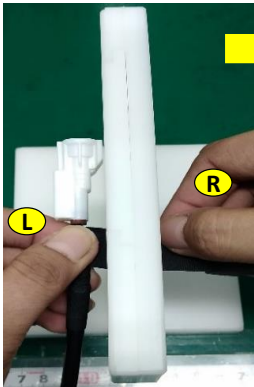
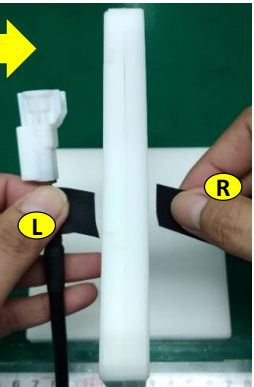
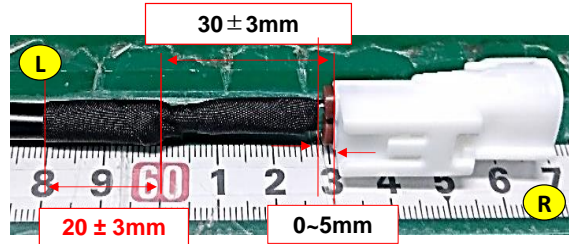


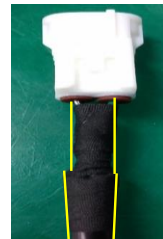
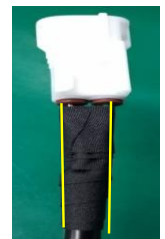
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tesa tape 51036		JIG:	1. Cutter jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 Taping 1 Black tesa tape 51036 to wire near connector (Continuation)	<div></div> <div></div> <div></div> <div>3. Cut the tape using tape cutter using both hands.</div> <div>4. After cut, conduct pressing of end tape using both hands.</div> <div>5. Check the taping condition, measurement and wire alignment.</div>		<div>MEASURING TAPE</div>  <div>TAPE CUTTER</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 6. No wrong dimension</div> <div>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>TAPING CONDITION REFERENCE</div> <div><p>GOOD If the taping on wires is align with tube appearance</p></div> <div><p>NG If the taping on wires is align with tube appearance and loose</p></div>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

920B / 7R0116-7022

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Effectivity Date:

September 10, 2024

Validity Date:

n/a

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

n/a

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Effectivity Date:

September 10, 2024

Process Name/Title:

Validity Date:

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920B / 7R0116-7022

Customer:

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TOYOTA-TACOMA

Document No.:

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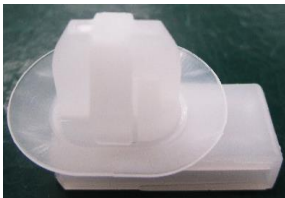
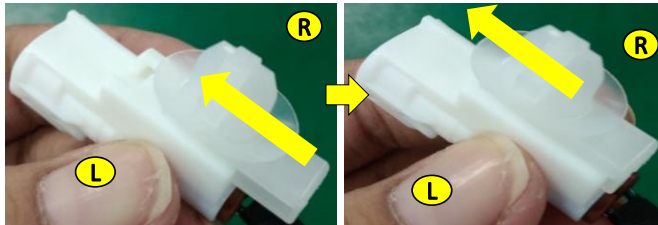
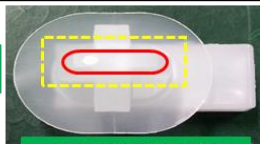
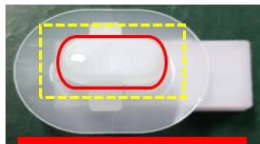
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PARTS:	1. Clamp 82711-1E360 (W)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2	<div><div>CLAMP ORIENTATION</div></div> <div></div> <div>1. Hold the connector using left hand, get the Clamp 82711-1E360 (W) then insert using right hand.</div>		<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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Car Model:

TOYOTA-TACOMA

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Purpose:

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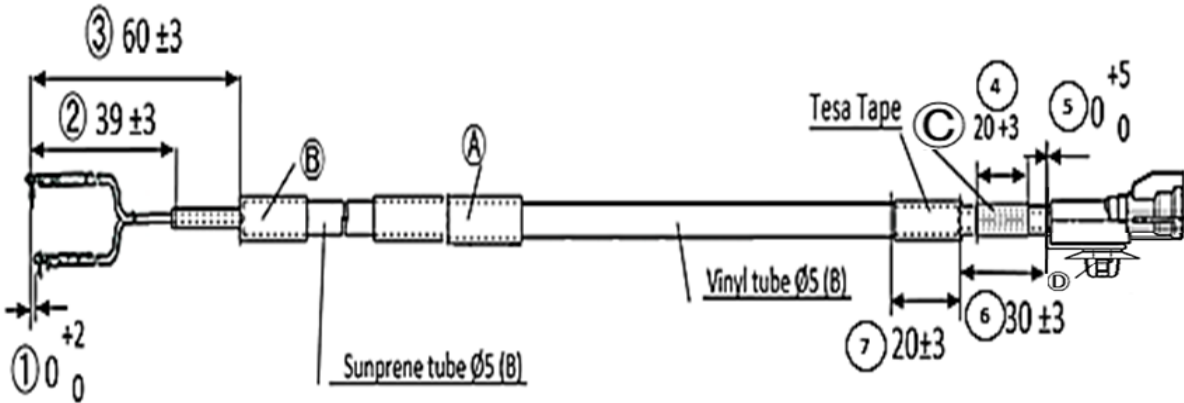
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P2 Measurement	<div><div>Measuring tape</div></div>  <div>NOTE: ④ - Taping (W) ⑥ - Taping (B) ⑦ - Spot Tape (BR) covering end of Tesa Tape ⑧ - Clamp (W)</div>		1. No wrong dimension 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

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7 of 7**PARTS:**

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING- P2****7R0116-7022****1 No Missing Clip Attachment****3 No Missing Brown Spot tape****2 No Missing Black Tesa tape (51036)**

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