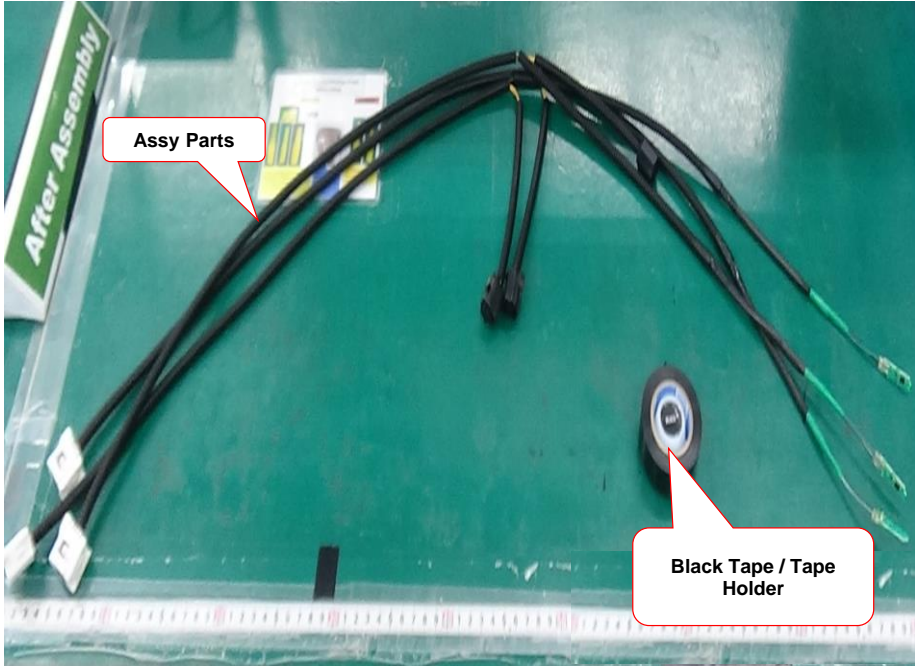



	WORK INSTRUCTION				Effectivity Date:		August 08, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 920B / 7R0118-7024		Customer: TRMX	Car Model: TOYOTA TACOMA	Document No.:		WI-ENG-PDE-962C	
	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO				Revision No.:		0	Page No.: 1 of 5


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>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	


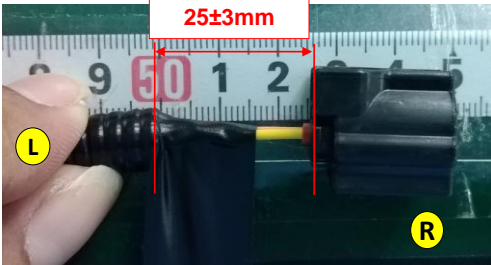
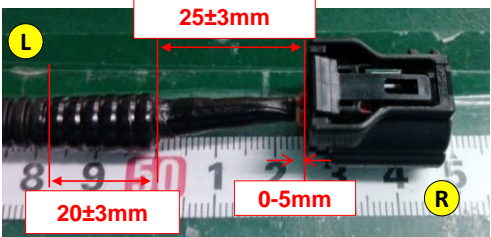

Revision History								Prepared by		Reviewed by		Approved by		Noted by								
								 D. Castillo	 C. Villanueva	 A. Arañes												
08/08/24	0	Initial issue.				D.Castillo	C.Villanueva									A. Arañes	N/A					
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:		August 08, 2024										

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	Model code/Part number: <b>920B / 7R0118-7024</b>		Customer: <b>TRMX</b>	Car Model: <b>TOYOTA TACOMA</b>	Document No.:		<b>WI-ENG-PDE-962C</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO				Revision No.:		0	Page No.:

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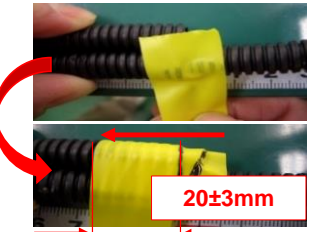
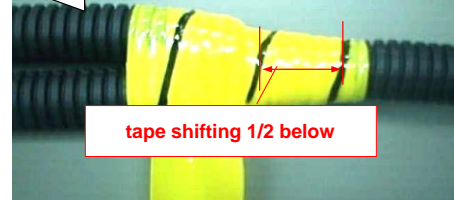
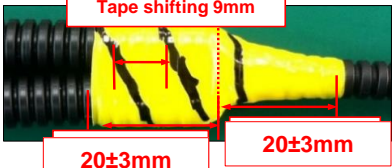
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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P3	Y-Taping	<div><div><p>No gap between tubes</p></div><div><p>20±3mm</p></div><div><p>taping direction</p><p>tape shifting 1/2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

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P3  Measurement	<div><div><div>③ 176 ±3</div><div>② 31 ±3</div><div>① 51 ±3</div><div>A</div><div>B</div><div>Øz</div><div>B</div><div>VM tube (Sunprene) (B) Ø5</div><div>COT Ø5 (B), no slit</div><div>B</div><div>④ 0 +5 0</div><div>⑤ 25 ±3</div><div>B</div><div>COT Ø5 (B), no slit</div><div>Black</div><div>⑥ 0 +5 0</div><div>White</div></div><div><div>NOTE:</div><div>Ⓐ - Taping (G)</div><div>Ⓑ - Taping (B)</div></div></div>	<div>MEASURING TAPE</div> <div></div>	

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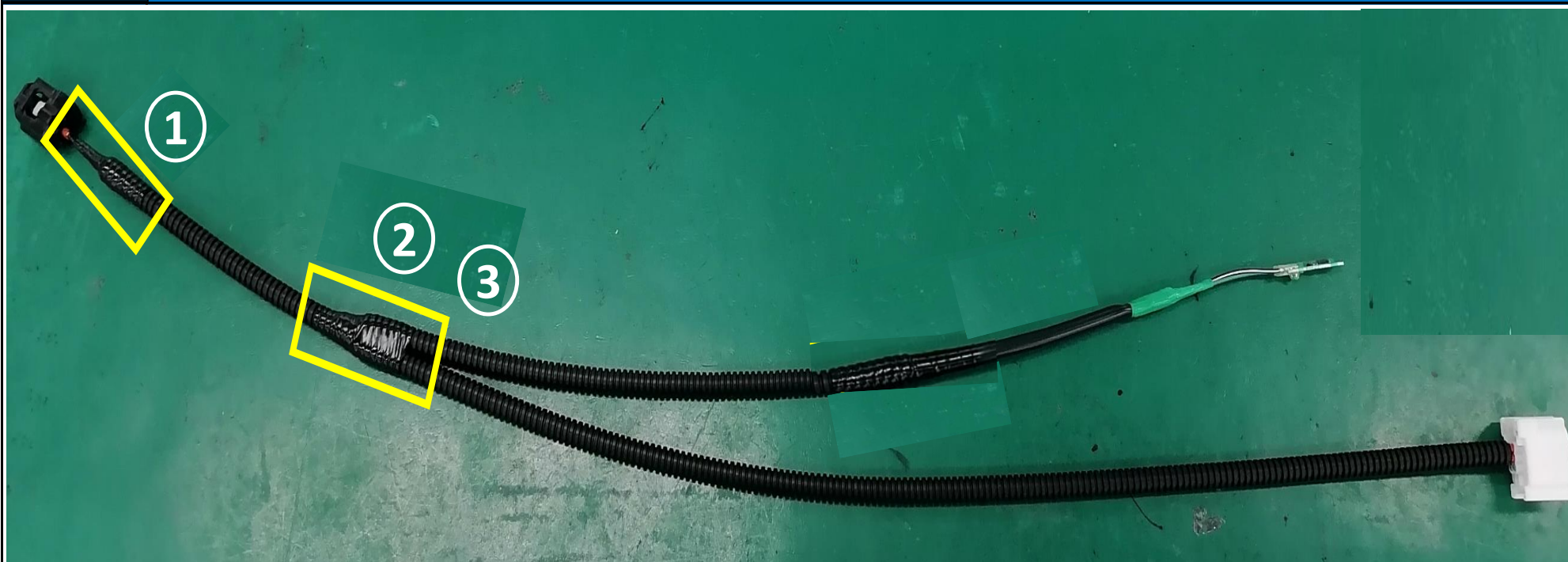
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P3****7R0118-7024****1****2****No MISSING TAPE****3****Correct Facing of Y-taping**

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