



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

September 10, 2024

Model code/Part number:

920B / 7R0116-7022

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-957A

Revision No.:

1

Page No.:

1 of 5

PARTS:

1. Assy parts; Black SV tube (Vinyl) Ø5 L=139±3mm; Black VM tube (Sunprene) Ø5 L=123±3mm; White tape 20mm; Black tape 20mm

JIG:

1. Measuring jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

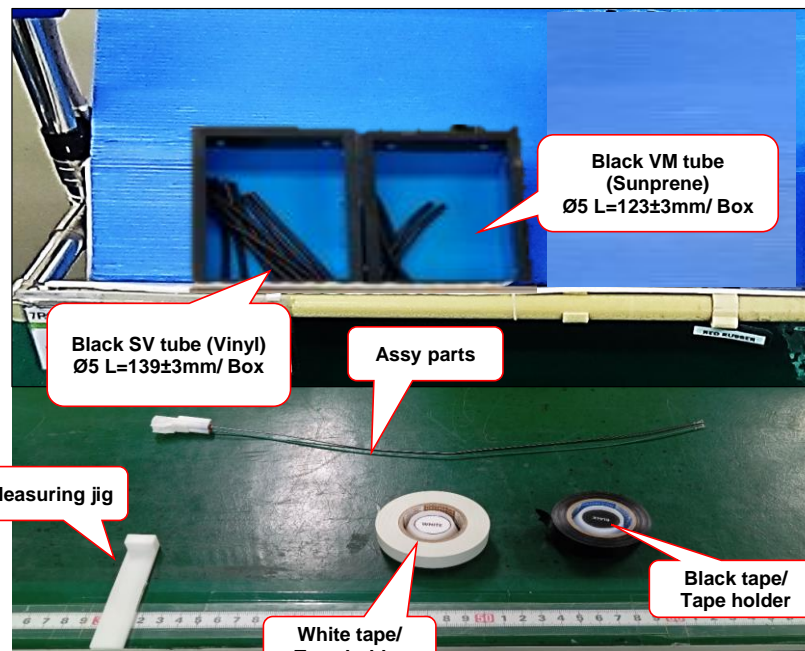
QUALITY POINTERS

1

P1

Table Lay-out

TABLE LAY-OUT



Safety Instruction

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

Document reference/s:

1. Refer to **WI-ENG-PDE-920** for Offline assembly process

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					
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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PARTS:		1. Black SV tube (Vinyl) Ø5 L=139±3mm 2. Black VM tube (Sunprene) Ø5 L=123±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	Wire Insertion to Black SV tube (Vinyl) Ø5 L=139±3mm	 <div>1. Get the Black SV tube (Vinyl) Ø5 L=139±3mm using right hand then insert the G-B/W wires using left hand.</div>	n/a	1. No wrong use of parts
3		Wire Insertion to Black VM tube (Sunprene) Ø5 L=123±3mm	 <div>1. Get the Black VM tube (Sunprene) Ø5 L=123±3mm using right hand then insert the G-B/W wires using left hand.</div>		

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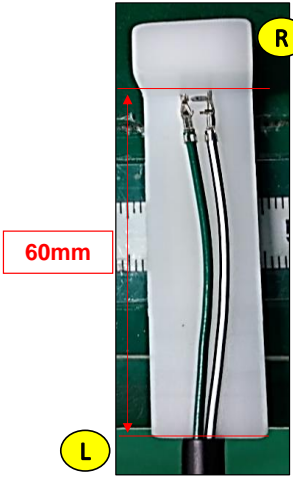
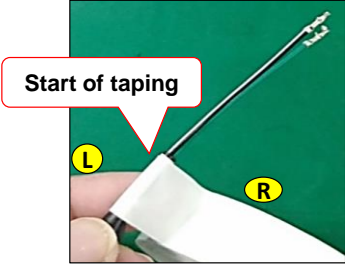
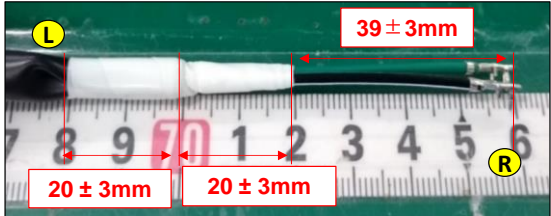


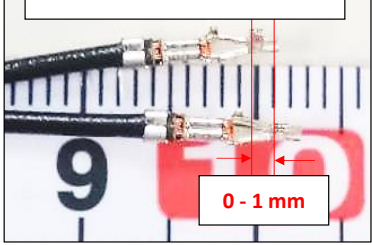
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PARTS:		1. Assy parts 2. White tape 20mm		JIG:	1. Measuring jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	<div><p>60mm</p><p>L R</p></div> <div><p>Start of taping</p><p>L R</p></div> <div><p>2. Hold the tube using left hand, get the White tape using right hand then start taping process using both hands.</p></div> <div><p>1. Conduct measurement of 60mm from end of sunprene tube up to end of the terminal pointed tip using both hands.</p></div> <div><p>39 ± 3mm</p><p>L R</p><p>20 ± 3mm 20 ± 3mm</p></div> <div><p>3. After taping, check the taping condition, measurement and wire alignment.</p></div>		<div><p>Measuring tape</p></div> <div><p>MEASURING JIG</p></div>	<p>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 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> <div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div>

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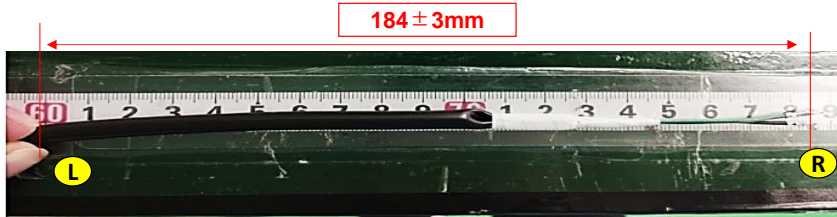
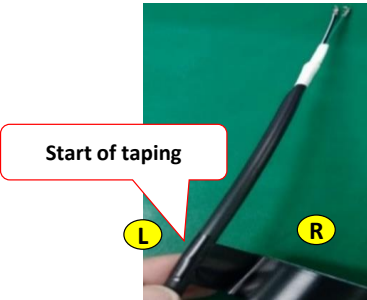
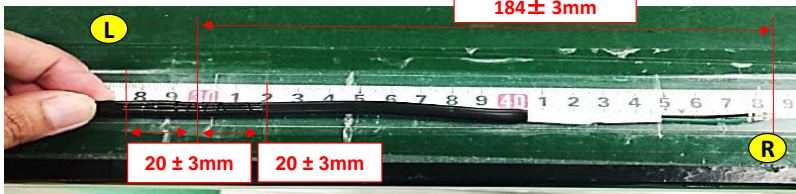

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PARTS:		1. Assy parts 2. Black tape 20mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1 Taping 2 Black SV tube (Vinyl) to Black VM tube (Sunprene) near terminal	 <p>1. Measure from end of corrugated tube up to terminal pointed tip 184±3mm using both hands.</p>  <p>2. Hold the corrugated tube and sunprene tube using left hand, get the Black tape then start taping process using both hands.</p>  <p>3. After taping, check the taping condition, measurement and wire alignment.</p>		<div>Measuring tape</div> 	<p>Important reminders and Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s:</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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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**TAPING- P1****7R0116-7022****1** No Wrong use/Missing tape**2** No Missing Black SV tube (Vinyl)**3** No Missing Black VM tube
(Sunprene)

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