

	WORK INSTRUCTION				Effectivity Date:		July 12, 2024	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: D10L / 7M0654-7020A		Customer: TRJ	Car Model: DAIHATSU-TANTO	Document No.: WI-ENG-PDE-156C	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO		Revision No.:	4 Page No.: 1 of 4

PARTS:	1. Assy parts ;Black tape			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
1	P3 Table Lay-out	<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px; display: inline-block;">TABLE LAY-OUT</div>	<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px solid red; padding: 5px;"> 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/tols	

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
07/12/24	4	Transfer Y-taping 2 from P2 (WI-ENG-PDE-156B) due to process improvement. Inclusion of car model "DAIHATSU-TANTO" and Table lay-out. Improved Measurement and Visual inspection/Quality checkpoints.	D.Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	 A. Arañes		n/a			
04/27/21	3	Change clamp color in accordance with color standardization for plastic parts GL-COM-003; put assy parts on pg.3	J.Loterter	C. Villanueva	A. Shimamura	A. Arañes									
10/09/20	2	Remove cycle time.	D.Castillo	C. Villanueva	A. Arañes	n/a									
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:		March 1, 2019			

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☐ PROTOTYPE

☐ PRE-LAUNCH


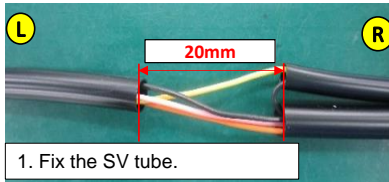
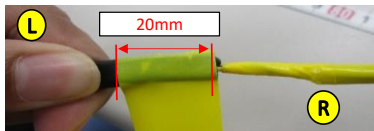
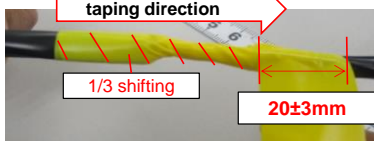
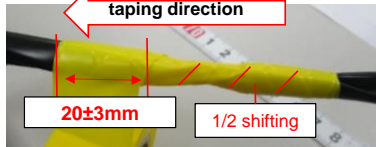
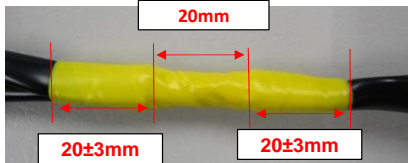

☒ MASSPRO

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PARTS:		1. Black tape 2. Assy parts	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3 Y-taping 2	<p>With Wide interval</p>  <p>1. Fix the SV tube.</p>  <p>2. Measure from SV tube (Vinyl) up to SV tube (Vinyl) 20mm. Tape the SV tube (Vinyl) 1/3 shifting going to wire then cut the tape.</p>  <p>3. Combine the two SV tube (Vinyl) , make 2 winds. <i>Note: Do not exert excessive force during pulling & winding of tape.</i></p>  <p>4. Wind the tape 1/3 shifting until it reach the other side of SV tube (Vinyl) (must be tape width).</p>  <p>5. Wind the tape backward 1/2 shifting.</p>  <p>6. Wind the tape 1/2 shifting going to other side of SV tube (Vinyl) then cut the tape. After taping, check the condition of tape.</p>	<p>MEASURING TAPE</p> 	<p>Important reminders/Note/s:</p> <p>1. Use YELLOW TAPE for eady visualization of tape shifting nut actual should be BLACK TAPE</p> <p>2. Please use calibrated/verified measuring tape when getting the measument.</p> <p>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No gap between vinyl tube and COT</p>

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	<div>4</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3	Measurement	<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>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p>
1. No wrong dimension				

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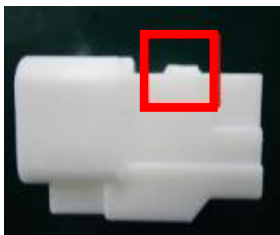
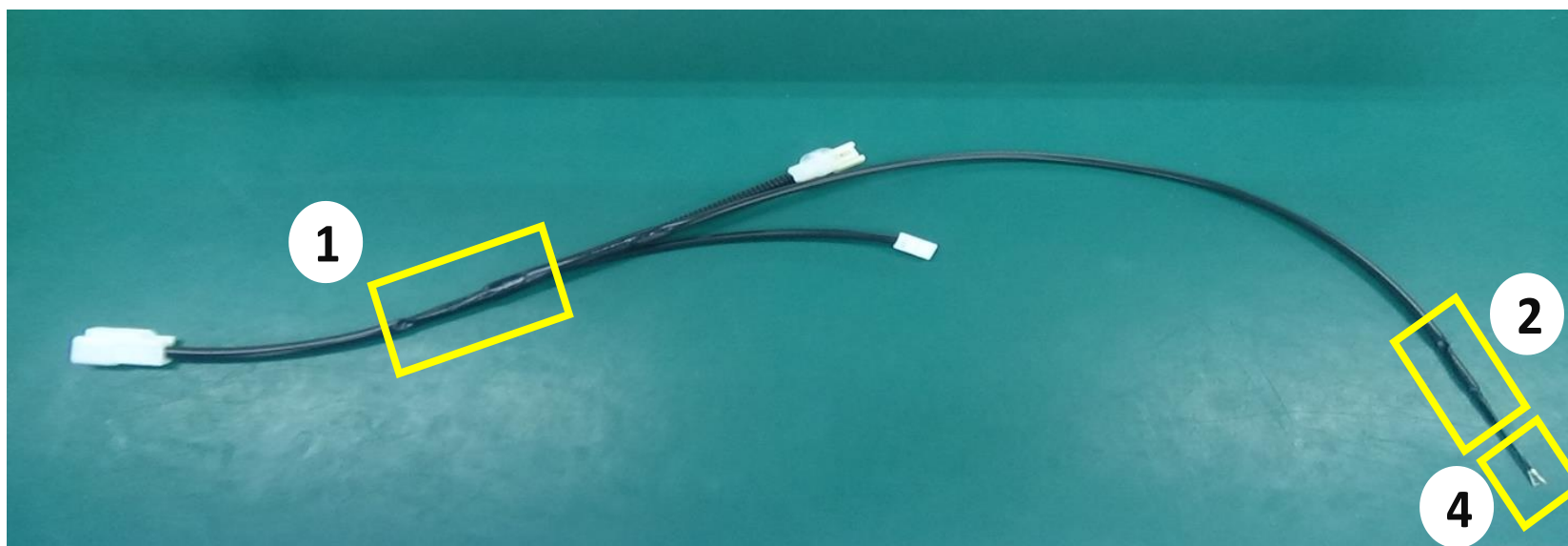
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P3****7M0654-7020A****GOOD****NO GOOD****① ② No Missing Tape****③ Check facing of Y-taping****④ No Deformed Terminal**

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