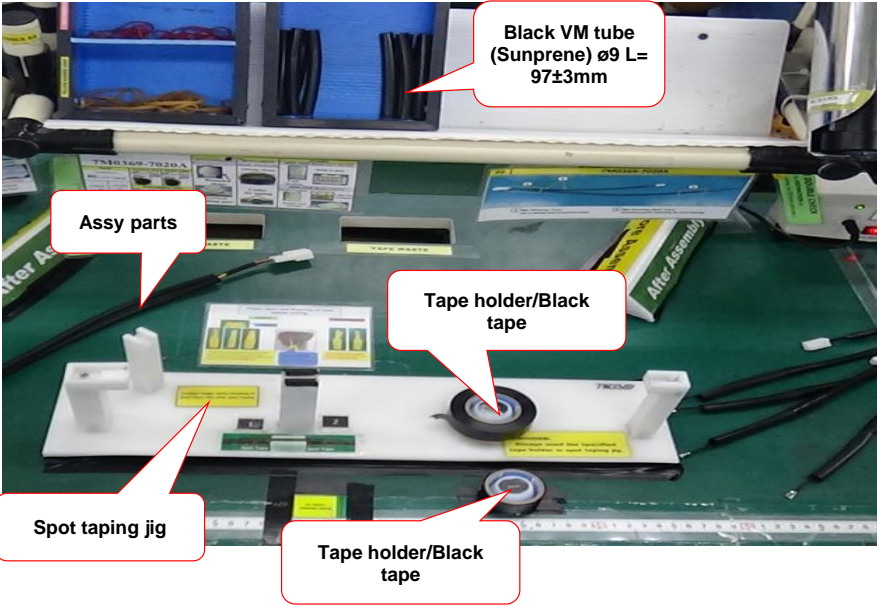
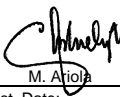
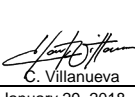
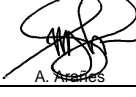
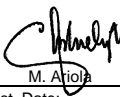
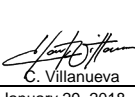
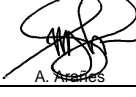
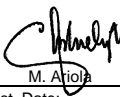
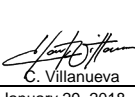
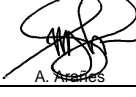
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	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 011B / 7M0369-7020A	Customer: TRJ	Car Model: TOYOTA-CAMRY	Document No.:	WI-ENG-PDE-175B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	8	Page No.:	1 of 6

PARTS:		1. Assy parts; Black tape; Black VM tube (Sunprene) ø9 L= 97±3mm				JIG:		1. Spot taping jig																																					
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS																																					
1	P2	<div style="border: 1px solid red; padding: 5px; text-align: center; margin-bottom: 10px;">TABLE LAY-OUT</div> 				<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <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																																					
<div style="display: flex; justify-content: space-between;"> <div> Revision History <table border="1" style="width: 100%;"> <thead> <tr> <th>Eff. Date</th> <th>Rev. No</th> <th>Details of Change</th> <th>Revised</th> <th>Reviewed</th> <th>Approved</th> <th>Noted</th> <th>Prepared by</th> <th>Reviewed by</th> <th>Approved by</th> <th>Noted by</th> </tr> </thead> <tbody> <tr> <td>6/03/24</td> <td>8</td> <td>Improve measurement and Visual Inspection/Quality checkpoints.</td> <td>M. Ariola</td> <td>C. Villanueva</td> <td>A. Arañes</td> <td>n/a</td> <td rowspan="3">  M. Ariola </td> <td rowspan="3">  C. Villanueva </td> <td rowspan="3">  A. Arañes </td> <td rowspan="3">n/a</td> </tr> <tr> <td>11/24/23</td> <td>7</td> <td>Update Quality checkpoints, include additional quality pointers (specify which part has a lenght of 25 +/- 3 and Tape width) due to DCS countermeasure (DC-0923-193). Update Important reminders and Note/s. Inclusion of Car model "TOYOTA-CAMRY".</td> <td>D. Castillo</td> <td>C. Villanueva</td> <td>A. Arañes</td> <td>n/a</td> </tr> <tr> <td>06/21/23</td> <td>6</td> <td>Additional table lay-out. Inclusion of Quality Checkpoints on page no.5; Improve Work Procedure/Illustration on process no.3 and 5; Standardized tube description: VM tube (Sunprene); SV tube (Vinyl)</td> <td>M. Ariola</td> <td>J. Loterte</td> <td>C. Villanueva</td> <td>A. Arañes</td> </tr> </tbody> </table> </div> <div> Est. Date: January 29, 2018 </div> </div>										Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by	6/03/24	8	Improve measurement and Visual Inspection/Quality checkpoints.	M. Ariola	C. Villanueva	A. Arañes	n/a	 M. Ariola	 C. Villanueva	 A. Arañes	n/a	11/24/23	7	Update Quality checkpoints, include additional quality pointers (specify which part has a lenght of 25 +/- 3 and Tape width) due to DCS countermeasure (DC-0923-193). Update Important reminders and Note/s. Inclusion of Car model "TOYOTA-CAMRY".	D. Castillo	C. Villanueva	A. Arañes	n/a	06/21/23	6	Additional table lay-out. Inclusion of Quality Checkpoints on page no.5; Improve Work Procedure/Illustration on process no.3 and 5; Standardized tube description: VM tube (Sunprene); SV tube (Vinyl)	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 3, 2024

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Model code/Part number:

011B / 7M0369-7020A

Customer: TRJ

Car Model: TOYOTA-CAMRY

Validity Date:

n/a

Document No.:

WI-ENG-PDE-175B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


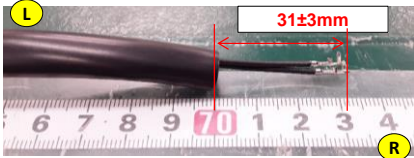
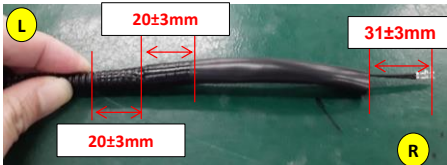



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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) Ø9 L= 97±3mm 3. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2	Wire insertion to VM tube (Sunprene) Ø9 L= 97±3mm	<div></div> <div>1. Get the Black VM tube (Sunprene) Ø9 L= 97±3mm using right hand and insert the wires using left hand.</div>	n/a	1. No wrong use of parts
3		Taping COT to Black VM tube (Sunprene)	<div><div></div><div>1. Hold the assy parts using left hand. Measure from VM tube (Sunprene) tube to terminal pointed tip 31±3mm.</div><div></div><div>20±3mm</div><div>31±3mm</div><div>20±3mm</div></div> <div></div> <div>2. Hold the assy parts using left hand. Get the Black tape and start taping using right hand.</div> <div>3. After taping, check the measurement and taping condition.</div>	<div>MEASURING TAPE</div> 	<div>1. Check the tape from COT to SV tube (Vinyl) (Conduct bending for verification) 2.No flip out tape. 3.No tape peeling. 4.No loose tape</div> <div></div> <div>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process. Do not attempt to repair.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-001 for Taping procedure.</div>

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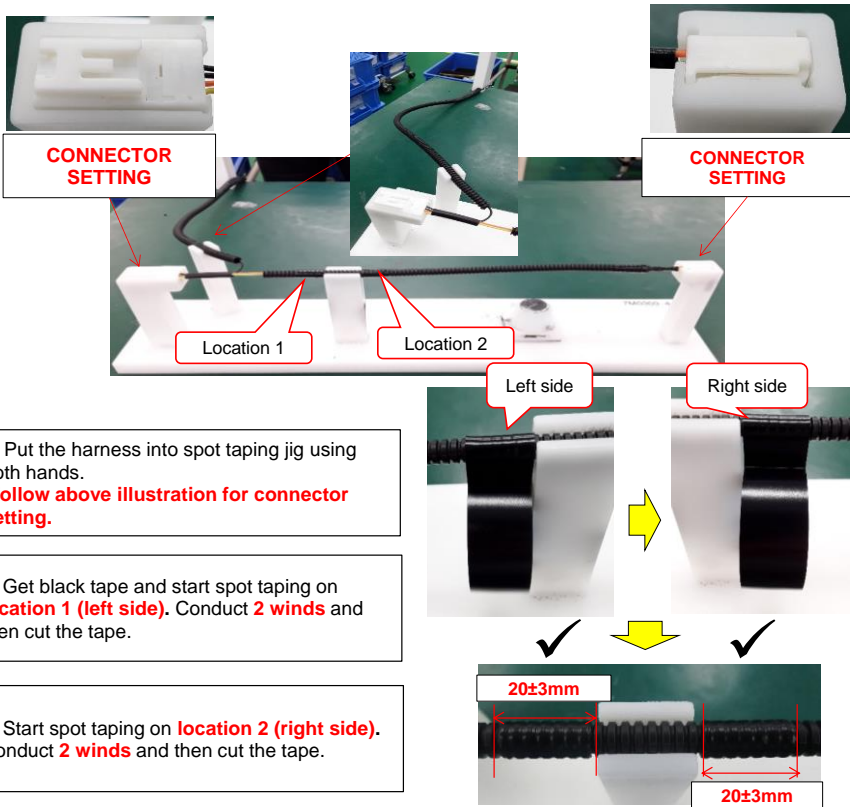
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts 2. Black tape [1pc]			JIG:	1. Spot taping jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
4	P2	Spot Taping	<div><div></div><div><div>1. Put the harness into spot taping jig using both hands. Follow above illustration for connector setting.</div><div>2. Get black tape and start spot taping on location 1 (left side). Conduct 2 winds and then cut the tape.</div><div>3. Start spot taping on location 2 (right side). Conduct 2 winds and then cut the tape.</div></div></div>			n/a	<div>1. No peel-off 2. No wrong location 3. No missing tape 4. Check the offset spot tape</div> <div>Important reminders and Note/s: 1. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process. Do not attempt to repair.</div>

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☐ PROTOTYPE

☐ PRE-LAUNCH


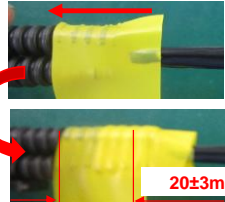

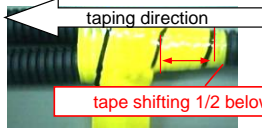
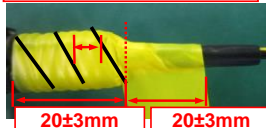

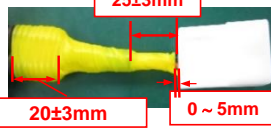

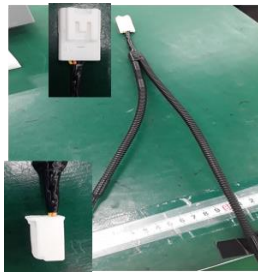
☒ MASSPRO

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2	Y-Taping		
		<div><div><div>No gap between tubes</div><div></div><div>1. Fix the corrugated tube and SV tube (Vinyl). Follow the correct connector orientation.</div></div><div><div>20±3mm</div><div></div><div>Note: Do not exert excessive force during pulling & winding of tape</div></div><div>2. Start taping at the middle of combined COT & SV tube (Vinyl), then wind the tape going to 2 corrugated tubes (2 windings) , width must be same with tape (20mm).</div><div><div>taping direction</div><div></div><div>tape shifting 1/3 below</div><div>20±3mm</div></div><div><div>taping direction</div><div></div><div>tape shifting 1/2 below</div></div><div>4. Wind the tape backward 1/2 shifting</div><div><div>Tape shifting 9mm below</div><div></div><div>20±3mm</div><div>20±3mm</div></div><div><div>tape shifting 1/3 below</div><div></div><div>25±3mm</div></div><div><div>25±3mm</div><div></div><div>20±3mm</div><div>0 ~ 5mm</div></div><div>5. Wind the tape 1/2 shifting going to SV tube (Vinyl). Cover the SV tube (Vinyl) & wire 1/3 shifting. Measure vinyl tube up to connector 25±3mm then make 3 winds on wire before cutting of tape.</div><div>6. Check the tape condition.</div></div> <div><div>MEASURING TAPE</div><div></div></div> <div><div>1. No peel-off 2. No wrong location 3. No missing tape</div><div>CONNECTOR ORIENTATION</div><div></div><div>Important reminders and Note/s: 1. USED YELLOW TAPE TO EASY VISUALIZE THE TAPE SHIFTING BUT ACTUAL SHOULD BE BLACK. 2. Please use calibrated/verified measuring tape when getting the measurement. 3. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process. Do not attempt to repair.</div></div>		

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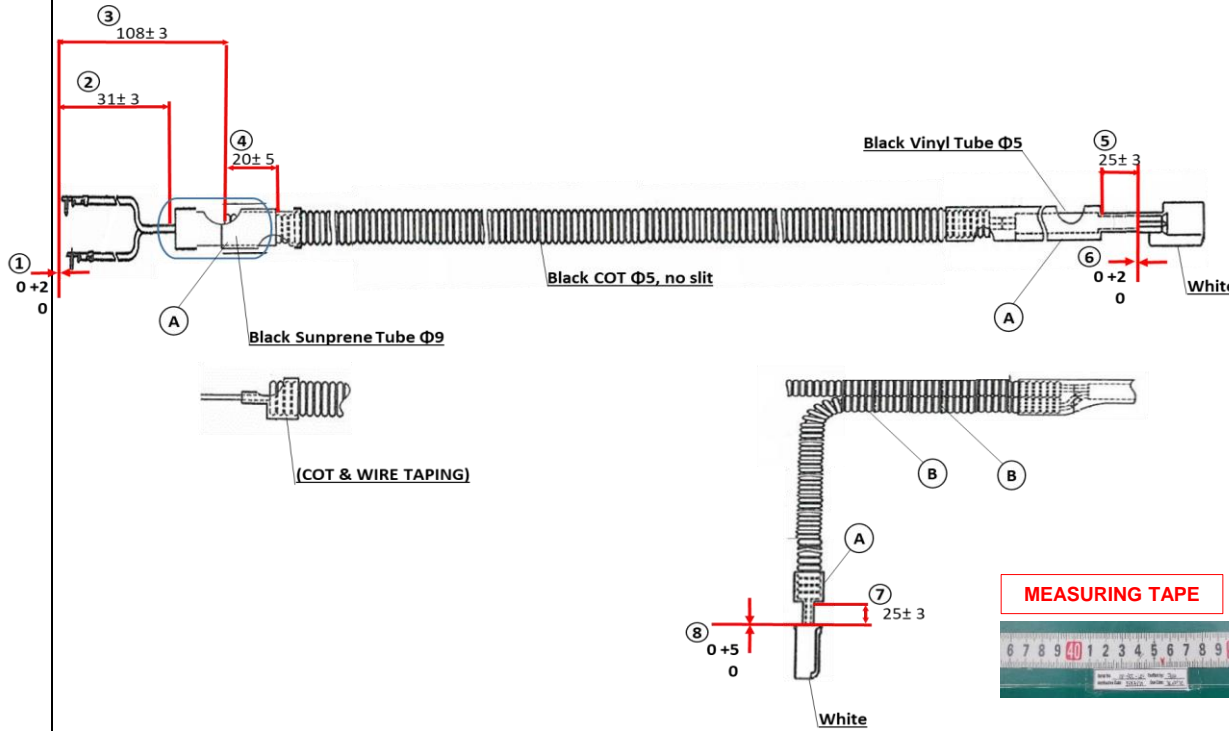
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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PARTS:		n/a		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
6	P2	Measurement		<p>1. No wrong dimension</p> <p>Important reminders/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>	

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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION / QUALITY CHECKPOINTS**P2****7M0369-7020A**

1 No Missing Tape
(on y-taping and sunprene tube)

2 No Missing Spot Tape
(Conduct point checking for spot)

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