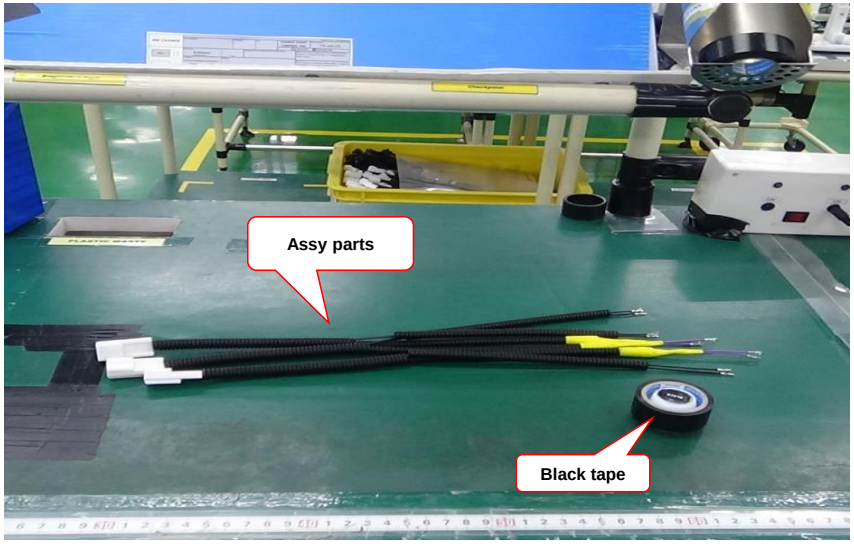
	WORK INSTRUCTION			Effectivity Date:	June 18, 2024	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 660B / 7R0111-7021	Customer: TRMX	Car Model: TOYOTA-SEQUOIA	Document No.:	WI-ENG-PDE-451B	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	3	Page No.: 1 of 6

PARTS:	1. Assy parts: Black tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	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 references:*** *1. Refer to **WI-ENG-PDE-450 7R0111-7021 - OFFLINE ASSEMBLY PROCESS*** 1. No missing parts/tools 2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
06/18/24	3	Transfer Taping 2 and Y-taping from WI-ENG-PDE451A. Separate Clamp Setting, Clamp assembly and By two's inspection to Clamp assembly process due to process improvement. Update table lay-out and inclusion of Quality checkpoints.	D.Castillo	C.Villanueva	A. Arañes	n/a
09/30/22	2	Improve: Quality pointers amd notes in Process no. 2,3,4,5 and 6 as document improvement. Wor procedure and illustration in process no.5 - visual/by two's inspection.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
03/11/22	1	Change document purpose from pre-launch to masspro.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes

Prepared by	Reviewed by	Approved by	Noted by
D. Castillo	C. Villanueva	A. Arañes	n/a
Est. Date:	March 09, 2022		

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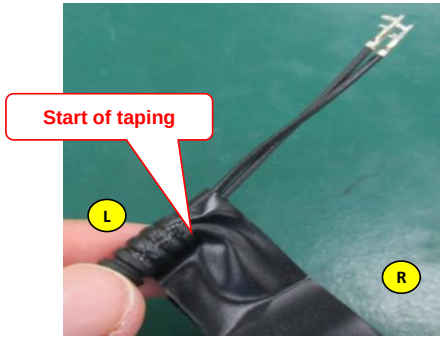
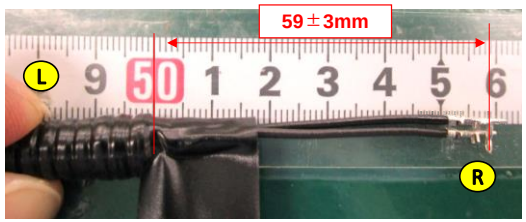
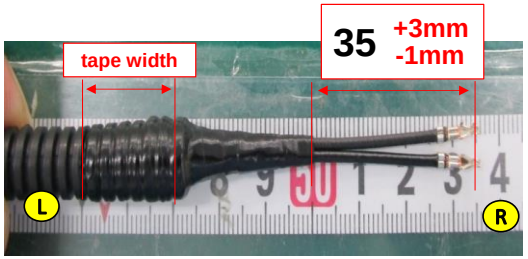
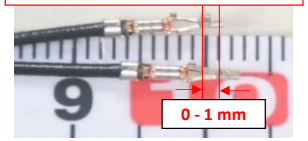
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 660B / 7R0111-7021	Customer: TRMX	Car Model: TOYOTA-SEQUOIA	Document No.:	WI-ENG-PDE-451B		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	3	Page No.:	2 of 6

PARTS:	1. Assy parts 2. Black tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	3 P2	Taping 2 Black corrugated tube to wire near terminal	 1. Hold the COT using left hand, get the **Black tape** using right hand then start pre-taping using both hands.  2. Measure from end of COT up to terminal pointed tip **59±3mm** then continue the taping process using both hands.  3. After taping, check the measurement, terminal appearance and taping condition.	MEASURING TAPE 	 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 ***Important reminders/Note/s:*** *1. Please use calibrated/verified measuring tape when getting the measurement.* ***Document references:*** *1. Refer to **WI-ENG-PDE-588** for Tape and tube end standard tolerance*

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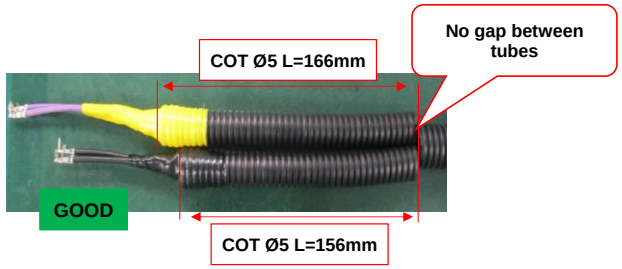
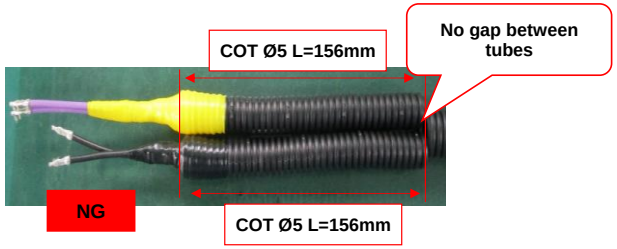
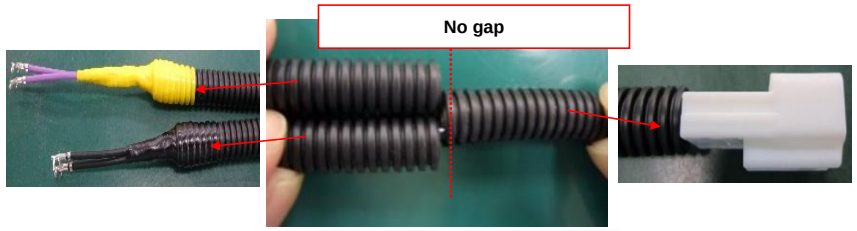
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 660B / 7R0111-7021	Customer: TRMX	Car Model: TOYOTA-SEQUOIA	Document No.:	WI-ENG-PDE-451B		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	3	Page No.:	3 of 6

PARTS:	1. Assy parts 2. Black tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2	Y-Taping	  **Note: 2 COT must not aligned for both terminal sides before Y-taping procedure. Refer above illustration as reference.**  1. Fix the corrugated tube.	**MEASURING TAPE** 	***Important reminders/Note/s:*** *1. Please use calibrated/verified measuring tape when getting the measurement.* 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 7. No gap in between COT 8. No wrong orientation

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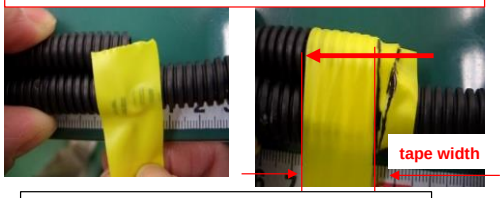
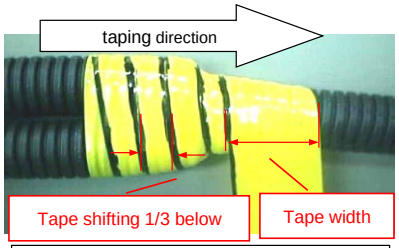
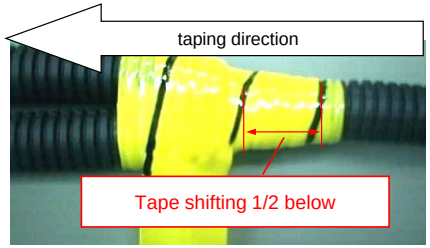
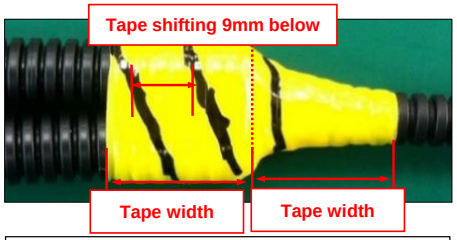
PARTS:	1. Assy parts 2. Black tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1	Y-Taping (Continuation)	3 **Note: Do not exert excessive force during pulling & winding of tape**  2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side (must be tape width)  3. Wind the tape **1/3 shifting** until it reach the other side of corrugated tube **(must be tape width)**  4. Wind the tape backward **1/2 shifting.**  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.	n/a	***Important reminders/Note/s:*** *1. Use **YELLOW TAPE** for easy visualization of shifting lines, but actual should be **BLACK TAPE.*** 1. No gap in between COT 2. No wrong orientation 3. No wrong dimension

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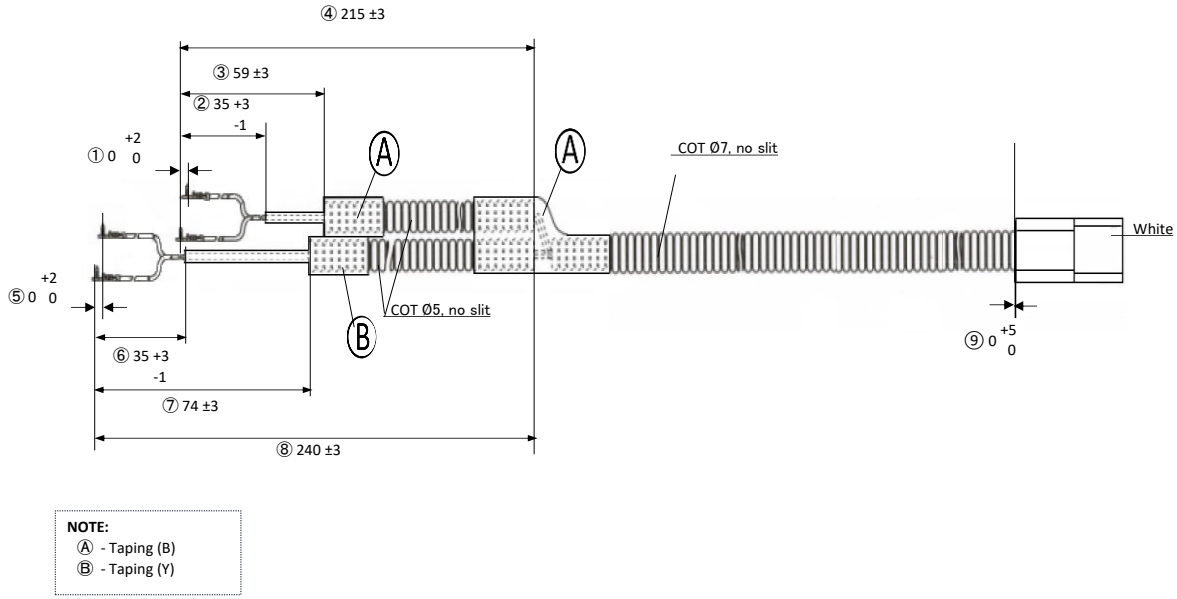
PARTS:	1. Assy parts	JIG:	n/a

NO.	PROCESS NAME		3 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1	Measurement		**MEASURING TAPE**	***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* 1. No wrong dimension

NOTE:
Ⓐ - Taping (B)
Ⓑ - Taping (Y)

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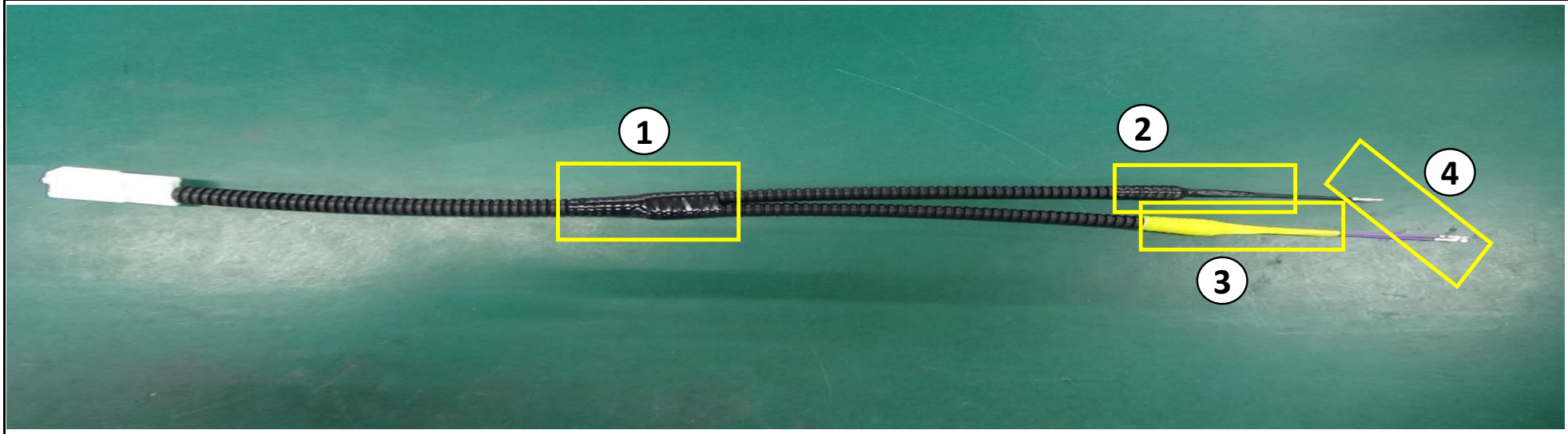
PARTS:	n/a	JIG:	n/a

3

VISUAL INSPECTION/ QUALITY CHECKPOINTS

P2 7R0111-7021



1 2 3 **No Missing Tape/No Wrong use of tape**

4 **No Deform Terminal**

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