
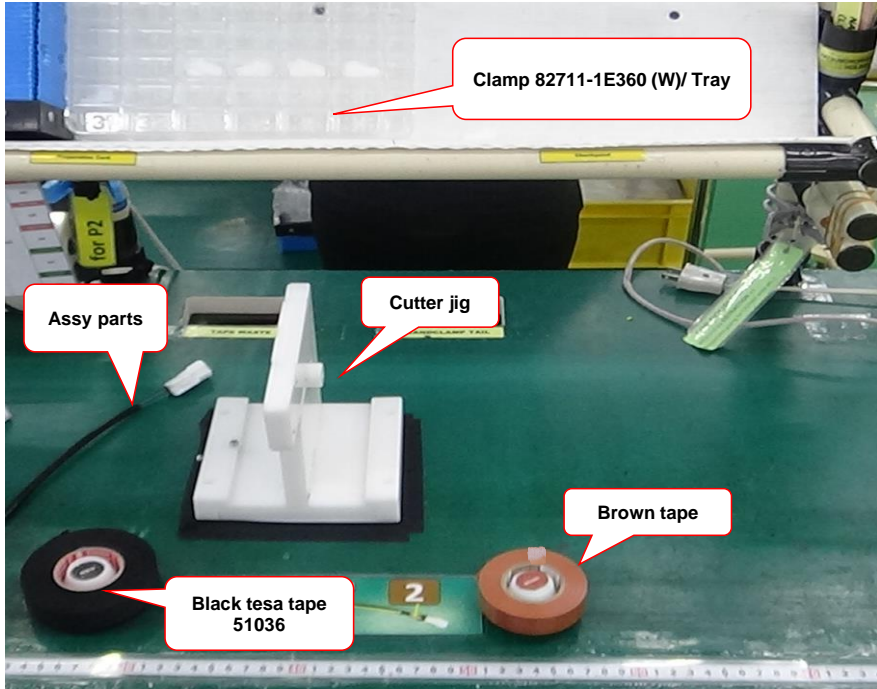

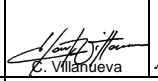
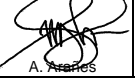


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|---|---|--|------------------------|---------------------------------|--|-------------|
|  | WORK INSTRUCTION | | | | Effectivity Date: June 24, 2024 | |
| | Process Name/Title: TAPING ASSEMBLY PROCESS | | | | Validity Date: n/a | |
| | Model code/Part number: 920B / 7R0116-7021A | | Customer: TRMX | Car Model: TOYOTA-TACOMA | Document No.: WI-ENG-PDE-650B | |
| | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO | | Revision No.: 2 | | Page No.: 1 | of 7 |

| | | | | |
|---|---------------------|--|--|---|
| PARTS: 1. Assy parts (Clamp 82711-1E360 (W)); Black tesa tape 51036; Brown tape | | JIG: 1. Cutter jig | | |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
| 1 | P2 | <div style="border: 1px solid black; padding: 5px; text-align: center;"> TABLE LAY-OUT </div>  | <div style="border: 1px solid red; padding: 5px; margin-bottom: 5px;"> 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: 5px;"> 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/tools |

| | | | | | | | | | | | | | |
|------------------|---------|--|--|--|--|-------------|---------------|---------------|-------------|--|--|--|-----|
| Revision History | | | | | | | | Prepared by | Reviewed by | Approved by | Noted by | | |
| 06/24/24 | 2 | Separate Clamp setting, Connector lock and Clamp assembly process to Clamp assembly process. Inclusion of car model "TOYOTA-TACOMA". Update Table layout, Measurement and Visual inspection/Quality checkpoints. | | | | D. Castillo | C. Villanueva | A. Arañes | n/a |  D. Castillo |  C. Villanueva |  A. Arañes | n/a |
| 04/17/23 | 1 | Document purpose from prelaunch to masspro. Improve table lay-out. Improve work procedure and illustration due to improvement. Additional quality pointers. | | | | M. Catapang | J. Loterte | C. Villanueva | A. Arañes | | | | |
| 03/16/23 | 0 | Initial issue | | | | M. Catapang | J. Loterte | C. Villanueva | A. Arañes | | | | |
| Eff. Date | Rev. No | Details of Change | | | | Revised | Reviewed | Approved | Noted | Est. Date: | March 16, 2023 | | |

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WORK INSTRUCTION

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TAPING ASSEMBLY PROCESS

Effectivity Date:

June 24, 2024

Validity Date:

n/a

Model code/Part number:

920B / 7R0116-7021A

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Document No.:

WI-ENG-PDE-650B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

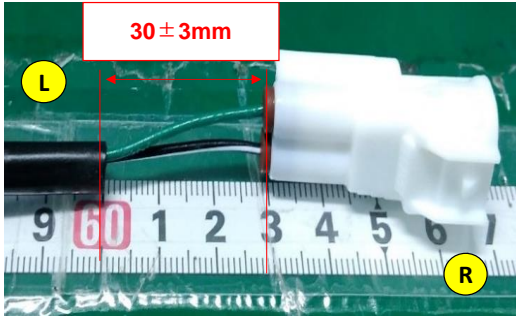
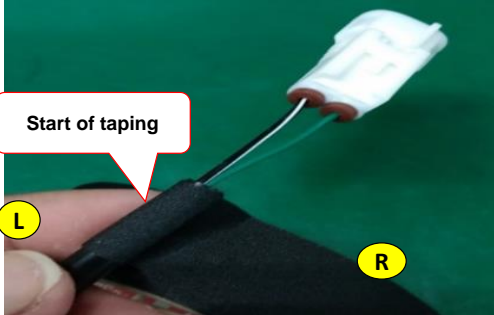

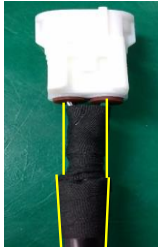

☒ MASSPRO

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| | | | | | |
|--------|---|---|--|---|--|
| PARTS: | | 1. Assy parts 2. Black tesa tape 51036 | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 2 | P2 Taping 1 SV tube to wire near connector | <div></div> <div>1. Measure from end of Black SV tube (Vinyl) up to edge of connector 30±3mm using both hands.</div> <div></div> <div>2. Hold the tube using left hand, get the Black tesa tape 51036 using right hand then start taping process using both hands.</div> | | <div>Measuring tape</div>  | <div>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</div> <div>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>TAPING CONDITION REFERENCE</div> <div><div>GOOD If the taping on wires is NOT align with tube appearance</div></div> <div><div>NG If the taping on wires is align with tube appearance and loose</div></div> |

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☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:

1. Assy parts
2. Black tesa tape 51036

JIG:

1. Cutter jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

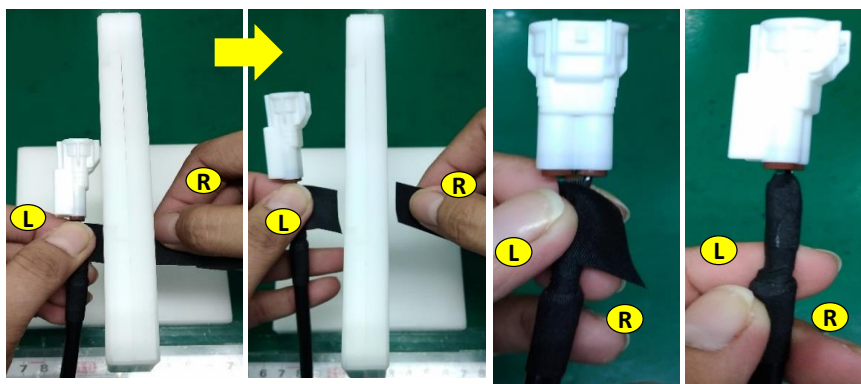
TOOLS/PPE

QUALITY POINTERS

3

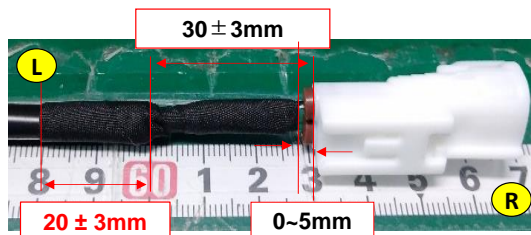
P2

Taping 1
Black tesa tape 51036 to
wire near connector
(Continuation)



3. Cut the tape using tape cutter using both hands.

4. After cut, conduct pressing of end tape using both hands.



5. Check the taping condition, measurement and wire alignment.

MEASURING TAPE



TAPE CUTTER

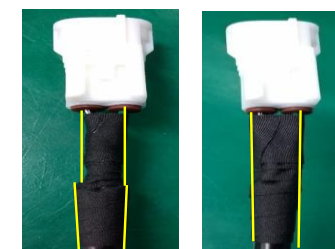


1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong use of tape
6. No wrong dimension

Important reminders/Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.

TAPING CONDITION REFERENCE



GOOD

If the taping on wires is NOT align with tube appearance


NG

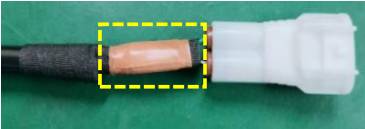
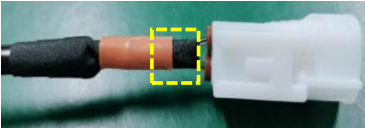
If the taping on wires is align with tube appearance and loose

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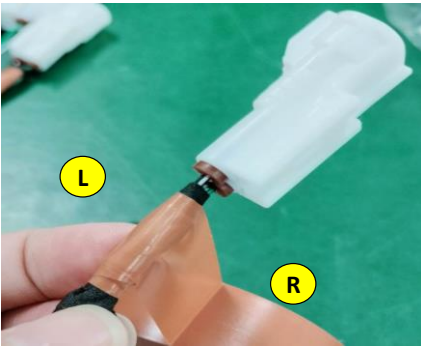
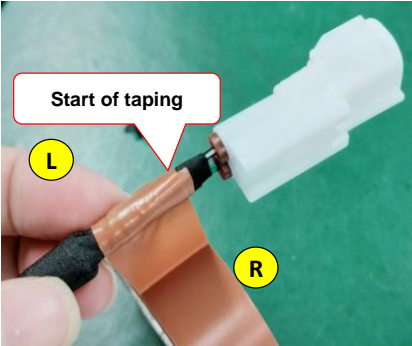
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| | TAPING ASSEMBLY PROCESS | | | | Validity Date: | | n/a | | | |
| | Process Name/Title: | | Model code/Part number: 920B / 7R0116-7021A | | Customer: TRMX | | Car Model: TOYOTA-TACOMA | | | |
| | Purpose: | | <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO | | Document No.: | | WI-ENG-PDE-650B | | | |
| | | | | Revision No.: | | 2 | | Page No.: | 4 of 7 | |

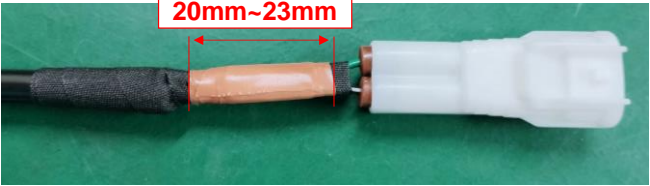
| | | | | | | | |
|---------------|---------------------|-------------------------------------|--|------------------|--|---|--|
| PARTS: | | 1. Assy parts 2. Brown tape | | JIG: | | n/a | |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | | QUALITY POINTERS | |
| 4 | P2 | Spot taping | | n/a | | <div><p>GOOD NO EXPOSED END OF TESA TAPE</p><p>NG WITH EXPOSED END OF TESA TAPE</p><div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape</div></div> | |

Start of taping



1. Hold the assy parts using left hand, get the **Brown tape** using right hand then start taping process using both hands.

2. Conduct **windings of tape until it covers the end of tesa tape** then conduct **2 windings** of tape before cut using both hands.



3. After taping, check the taping condition. **Spot taping** must be from **20mm~23mm** only.

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TAPING ASSEMBLY PROCESS

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Car Model:

TOYOTA-TACOMA

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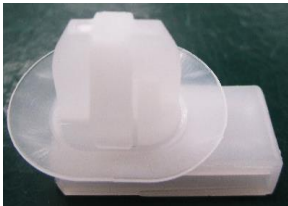
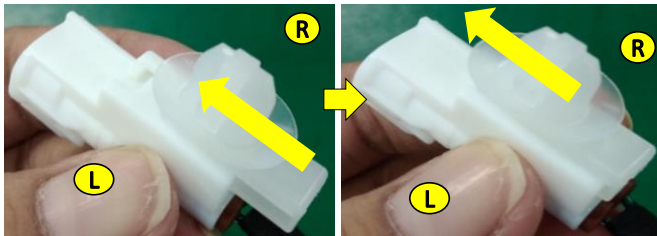
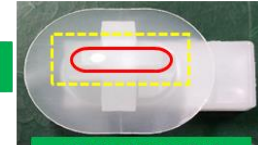
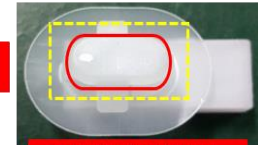
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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| | | | | | |
|---------------|---------------------|--|--|------------------|---|
| PARTS: | | 1. Clamp 82711-1E360 (W) | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 5 | P2 | <div><p>CLAMP ORIENTATION</p><p>1. Hold the connector using left hand, get the Clamp 82711-1E360 (W) then insert using right hand.</p></div> | | | <div><p>CLIP CLAMP ILLUSTRATION</p><div><p>GOOD</p><p>82711-1E360 (W)</p></div><div><p>NG</p><p>82711-12B10 (W)</p></div></div> <p>1. No wrong use of clamp 2. No damaged clamp 3. No missing clamp</p> |

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Car Model:

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PARTS:

1. Assy parts

JIG:

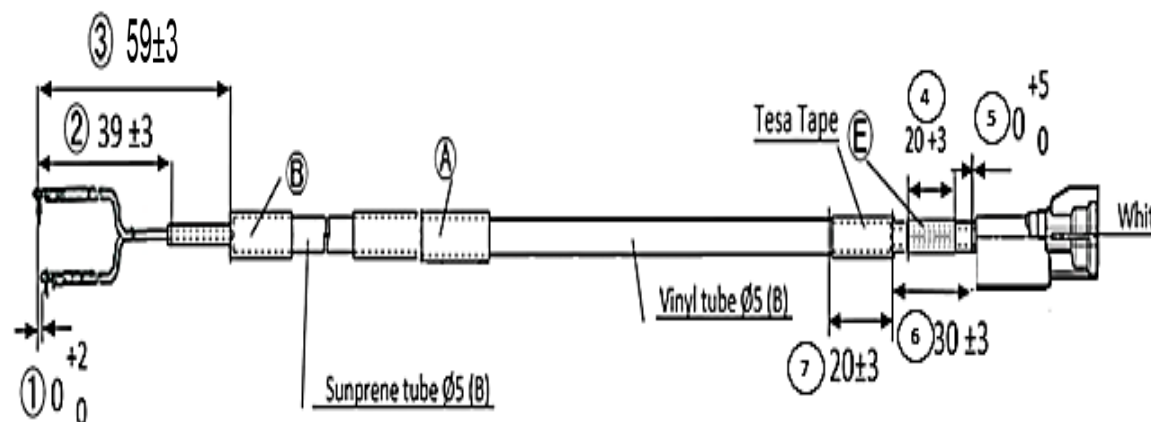
n/a

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

6

P2

Measurement

**NOTE:**

Ⓐ - Taping (B)

Ⓑ - Taping (W)

Ⓔ - Taping (BR) ***Check the presence of spot tape

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

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7 of 7**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING- P2****7R0116-7021A****1****No Missing Clip clamp****2****No Missing Spot tape (Brown tape)****3****No Deformed Terminal**

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