

**WORK INSTRUCTION**

Effectivity Date:

**September 21, 2024**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Validity Date:

n/a

Model code/Part number:

**920B / 7R0121-7021A**

Customer:

**TRMX**Car Model: **TOYOTA-TACOMA**

Document No.:

**WI-ENG-PDE-652B**

Purpose:

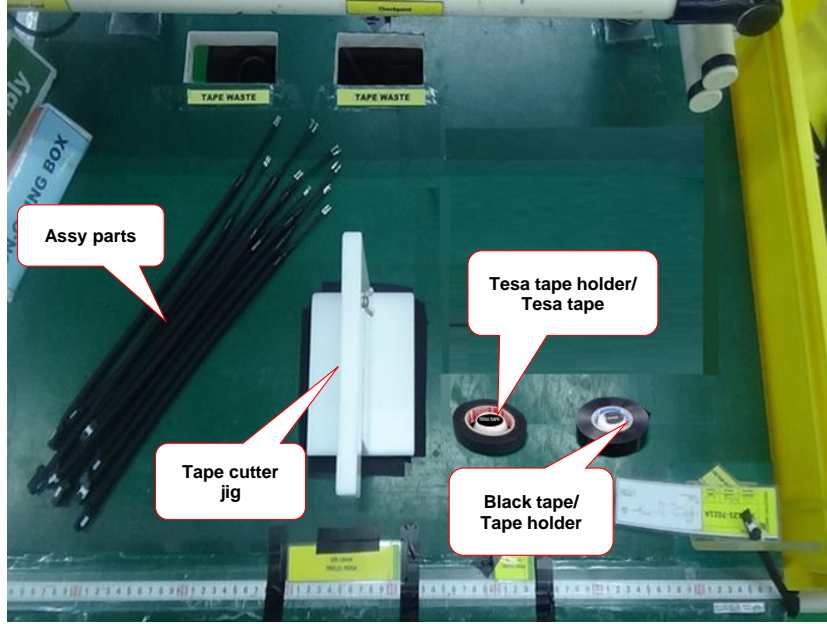


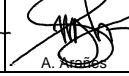
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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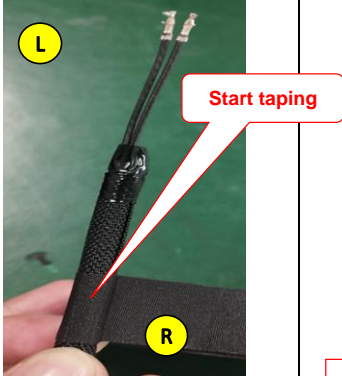
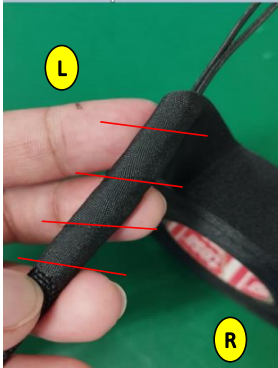
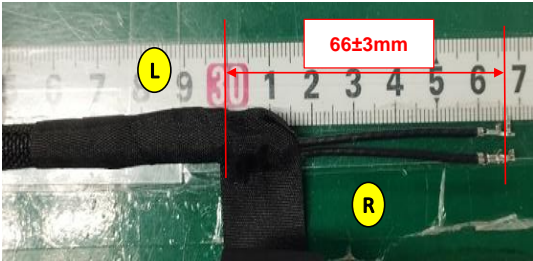

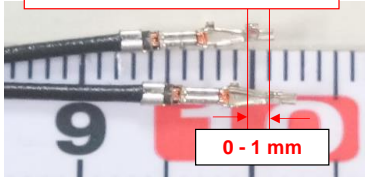
<b>PARTS:</b>	1. Assy parts; Black tape; Tesa tape			JIG:	1. Tape holder sequence jig 2. Tesa cutter jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
1	P2	Table Lay-out	<div><b>Table Lay-out</b></div>  <div><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> 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		
<b>Revision History</b>						
09/21/24	2	Transfer Twist tube to wire near terminal taping (Tesa tape) from P1 and separate clamp assembly due to process improvement. Inclusion of car model "TOYOTA-TACOMA". Improved Table lay-out, Measurement and Visual inspection/Quality checkpoints.	D.Castillo	C. Villanueva	A. Arañes	n/a
05/24/23	1	Change MO from P1 to P2 due to new process distribution. Change process purpose from Pre-launch to Masspro. Additional table lay-out. Inclusion of Quality checkpoints. Improve work procedure/illustration on process no.2 and 4.	M. Ariola	J.Loterte	C. Villanueva	A. Arañes
03/17/23	0	Initial issue. Added spot taping (Black Vinyl tape) covering the end of tesa tape.	M. Ariola	J.Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
			Prepared by	Reviewed by	Approved by	Noted by
						n/a
			Est. Date:	March 17, 2023		

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	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>September 21, 2024</b>		
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>920B / 7R0121-7021A</b>		Customer: <b>TRMX</b>	Car Model: <b>TOYOTA-TACOMA</b>	Document No.:		<b>WI-ENG-PDE-652B</b>
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:		2	Page No.: 2 of 6

<b>PARTS:</b>		1. Assy parts 2. Black tesa tape (Tesa 51036)		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
2	P2 Taping 2 Black twist tube 2420F to Wire near terminal	<div><p>1. Measure from Black twist tube 2420F <b>105±3mm</b> up to terminal tip.</p></div> <div><p>2. Hold the assy parts using left hand . Get <b>Black tesa (51036)</b> using right hand.</p></div> <div><p>3. Make <b>1 wind of tape</b> before shifting. <b>1/4 shifting</b> until it reach the wire.</p></div> <div><p>4. Measure from end of Black twist tube up to terminal tip <b>66±3mm</b> then continue the taping process using both hands.</p></div>	<div><p>Measuring tape</p></div> <div><p>Wire alignment tolerance 0 - 1 mm</p></div>	<div><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><p><b>Important reminders/note/s:</b></p><p>1.Please use calibrated/verified measuring tape when getting the measurement.</p></div>	

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Model code/Part number:

920B / 7R0121-7021A

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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### PARTS:

1. Assy parts
2. Black tesa tape (Tesa 51036)

JIG:

1. Tape cutter

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

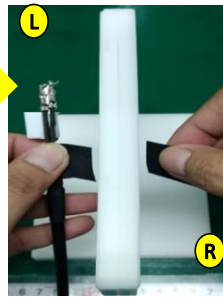
2

P2

Taping 2  
Black twist tube 2420F  
to Wire near terminal  
(Continuation)

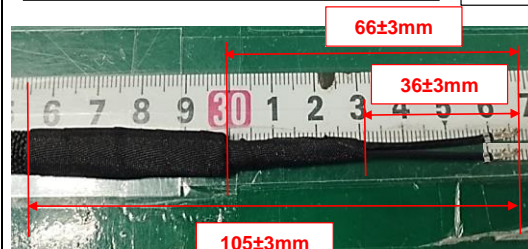


5. Measure from end of Black twisted tube up to terminal tip  $36\pm3\text{mm}$  then continue the taping process using both hands.



6. Cut the tape using provided tape cutter when reach the  $1\frac{1}{2}$  wind using both hands.

7. After cut, conduct pressing of end tape using both hands.  
**Note: End tape appearance should be slanted.**



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

TAPE CUTTER



Measuring tape

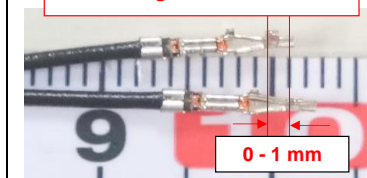


1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong use of tape
6. No wrong dimension

### Important reminders/note/s:

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


Wire alignment tolerance




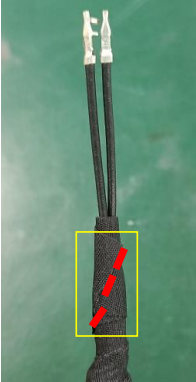
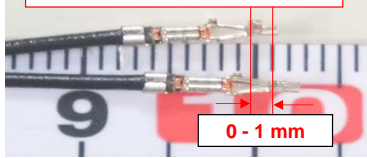
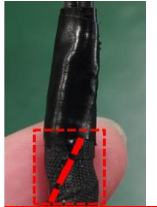



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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	2	Page No.:	4 of 6

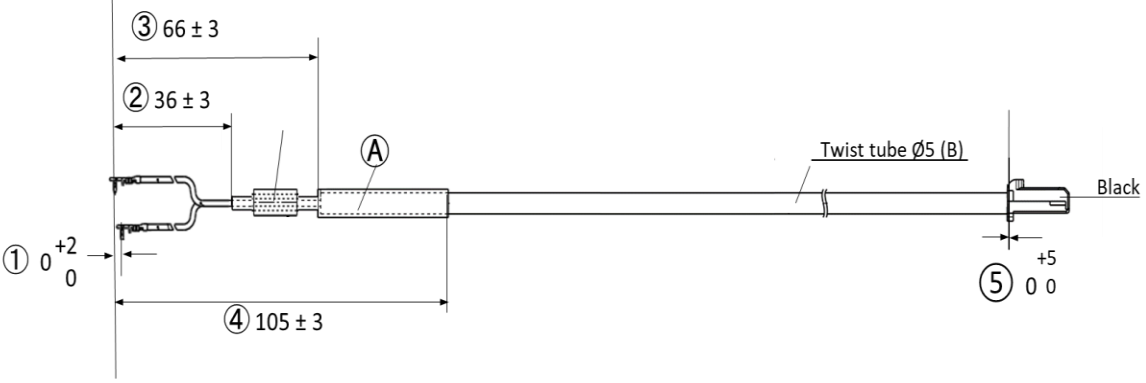

<b>PARTS:</b>		1. Assy parts 2. Black tape		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
3	P2	<div>Spot taping</div> <div></div> <div>1. Hold the assy part using left hand then get the Black tape using right hand. then start taping process using both hands.</div> <div>2. Conduct <b>windings of tape until it covers the end of tesa tape</b> then make <b>2 windings</b> of tape before end of tape using both hands.</div> <div>3. After spot taping, check the taping condition and alignment of wires. <b>Note: End of tesa tape must not visible</b></div>	n/a	<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><b>Important reminders/note/s:</b> <i>1.Please use calibrated/verified measuring tape when getting the measurement.</i></div> <div><b>Wire alignment tolerance</b> </div> <div><b>SPOT TAPING APPEARANCE</b> </div>	

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		2	Page No.: 5 of 6

<b>PARTS:</b>		1. Assy parts		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>2</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
4	P2	Measurement	<div></div>	<div><div>MEASURING TAPE</div></div>	<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension.</p>

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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P2****7R0121-7021A****1****No Missing Spot Tape**

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