



WORK INSTRUCTION

Effectivity Date:

September 19, 2024

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

920B / 7R0122-7022

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Document No.:

WI-ENG-PDE-721C

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

2

Page No.:

1 of 6

PARTS:

1. Assy parts: White tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

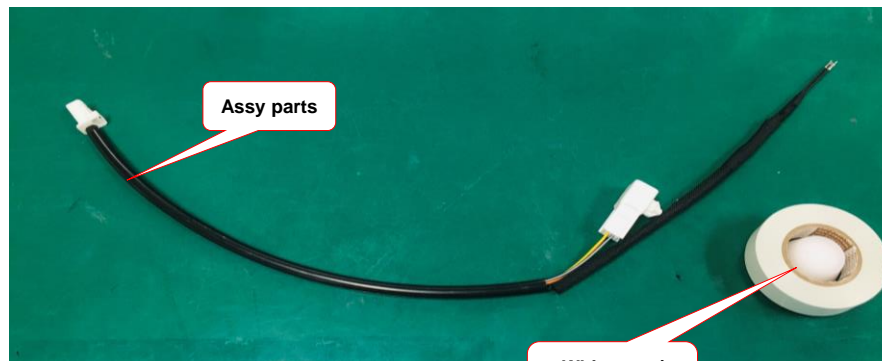
QUALITY POINTERS

1

P3

Table lay-out

Table Lay-out



Assy parts

White tape/
Tape holder

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.

1. No missing parts/tools
2. No excess parts/tools

Revision History

Prepared by

Reviewed by

Approved by

Noted by

09/19/24 2 Inclusion of Measurement and improved Visual inspection/Quality checkpoint.

D.Castillo

C. Villanueva

A. Arañes

n/a

09/06/23 1 Change purpose from pre-launch to mass pro.

M. Manalac

J. Lotere

C. Villanueva

A. Arañes

09/01/23 0 Initial issue.

M. Manalac

J. Lotere

C. Villanueva

A. Arañes

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted


Est. Date:

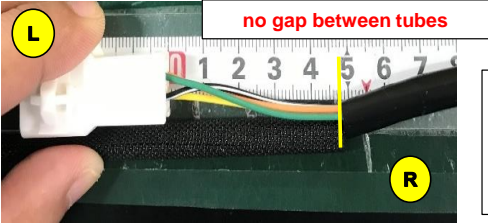
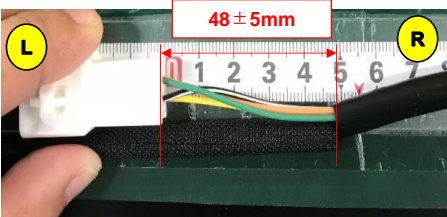
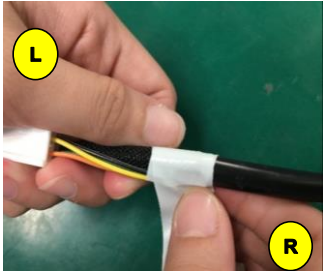
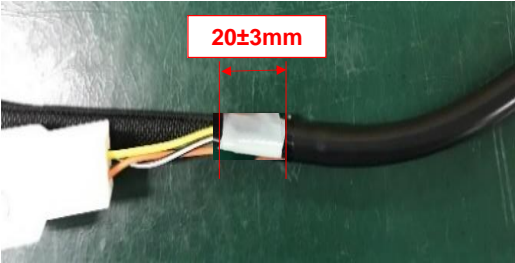

September 01, 2023

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	Model code/Part number: 920B / 7R0122-7022		Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:	WI-ENG-PDE-721C	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	2	Page No.:	2 of 6

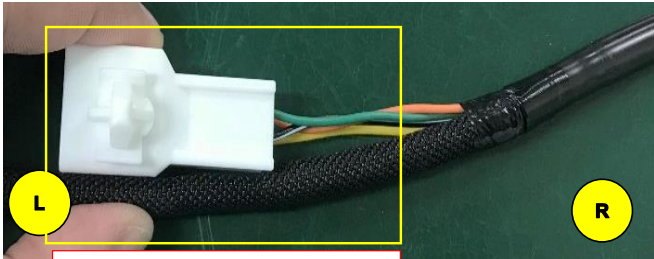
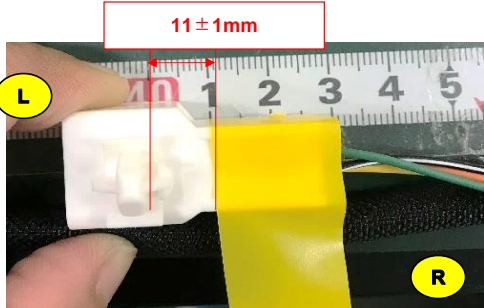
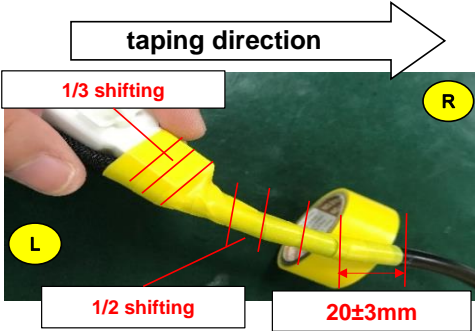

PARTS:		1. Assy parts 2. White tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
2	P3 Spot taping 4	<div></div> <div></div> <div></div> <div></div> <div><p>1. Fix the Connector and the twisted tube.</p><p><i>Note: Alignment of twisted tube must be beside the Connector. Follow the illustration.</i></p><p>2. Measure from end of connector up to end of twisted tube 48±5mm using both hands.</p><p>3. Get the White tape using right hand then conduct 2 windings of tape using both hands.</p></div>		<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</p>	

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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
3	P3	Y-taping				
		<div><p>1. Fix the Twisted tube to the side of the Connector.</p><p><i>Note: Follow the correct facing.</i></p></div> <div><p>CORRECT FACING</p><p>2. Measure from Connector to tape 11±1mm. Then, start taping the connector and twisted tube, make 2 windings before 1/3 shifting upward.</p></div> <div><p>taping direction</p><p>3. Winding the tape upward 1/3 shifting, then conduct 1/2 shifting upward until it reach the SV tube (Vinyl). Make 2 windings, width must be 20±3mm.</p></div>		<div><p>MEASURING TAPE</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 dimension 6. No wrong use of tape 7. Follow the correct facing</p></div>		

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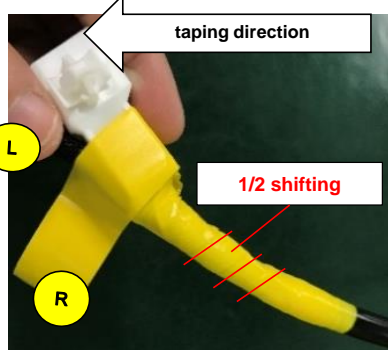
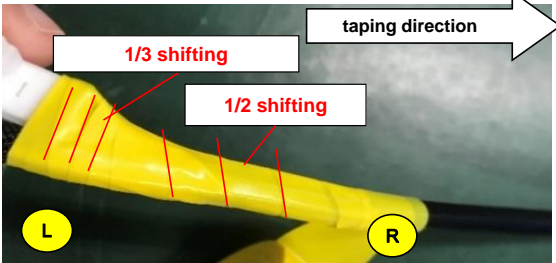
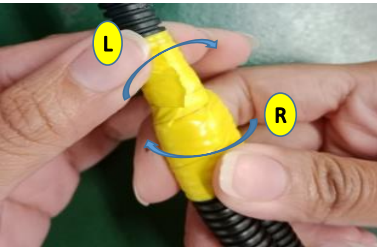

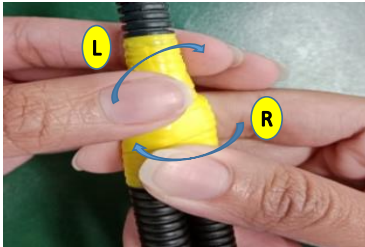
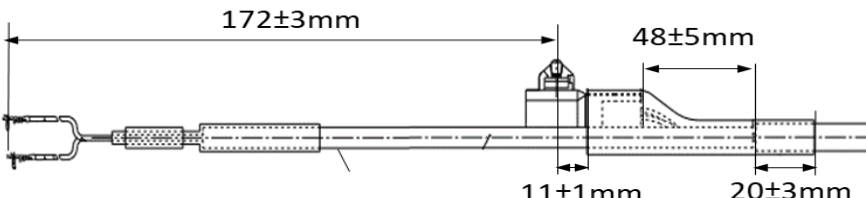
MASSPRO

Revision No.:

2

Page No.:

4 of 6

PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3 Y-taping (Continutaion)	<div><div></div><div></div><div></div><div></div><div></div><div></div></div> <div><p>4. Winding the tape backward until reach the connector 1/2 shifting. Make 2 windings.</p><p>5. Winding the tape going to Sv tube (Vinyl) 1/3 shifting then 1/2 shifting. Make 2 windings, then cut the tape.</p><p>6. conduct proper pressing of end tape using left hand (top part). <i>Note: Reference only.</i></p><p>7. conduct proper pressing of end tape using left hand (Middle part). <i>Note: Reference only.</i></p><p>8. conduct proper pressing of end tape using left hand (bottom part) . <i>Note: Reference only.</i></p><p>9. Check the Measurment and condition of tape.</p></div> <div><p>Important reminders/Note/s:</p><p>1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be WHITE TAPE.</p><p>2. Please use calibrated/verified measuring tape when getting the measurement.</p><p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape 7. Follow the correct facing</p></div>		

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5 of 6

PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P3 Clamp Assembly	<div><div>⑤ 172 ±3</div><div>③ 66 ±3</div><div>② 36 ±3</div><div>① 0 +2 0</div><div>④ 105 ±3</div><div>⑥ 11 ±1</div><div>⑦ 48 ±5</div><div>⑧ 0 +5 0</div></div> <div><div>Tesa Tape</div><div>White</div><div>Twist tube Ø5 (B)</div><div>SV tube (Vinyl) Ø7 (B)</div><div>White</div><div>W</div></div> <div><div>NOTE:</div><div>Ⓐ - Taping (B)</div><div>Ⓑ - Taping (W)</div><div>* Check the presence of spot tape</div></div>		<div>MEASURING TAPE</div> <div></div>	<div>Important reminders and note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div>

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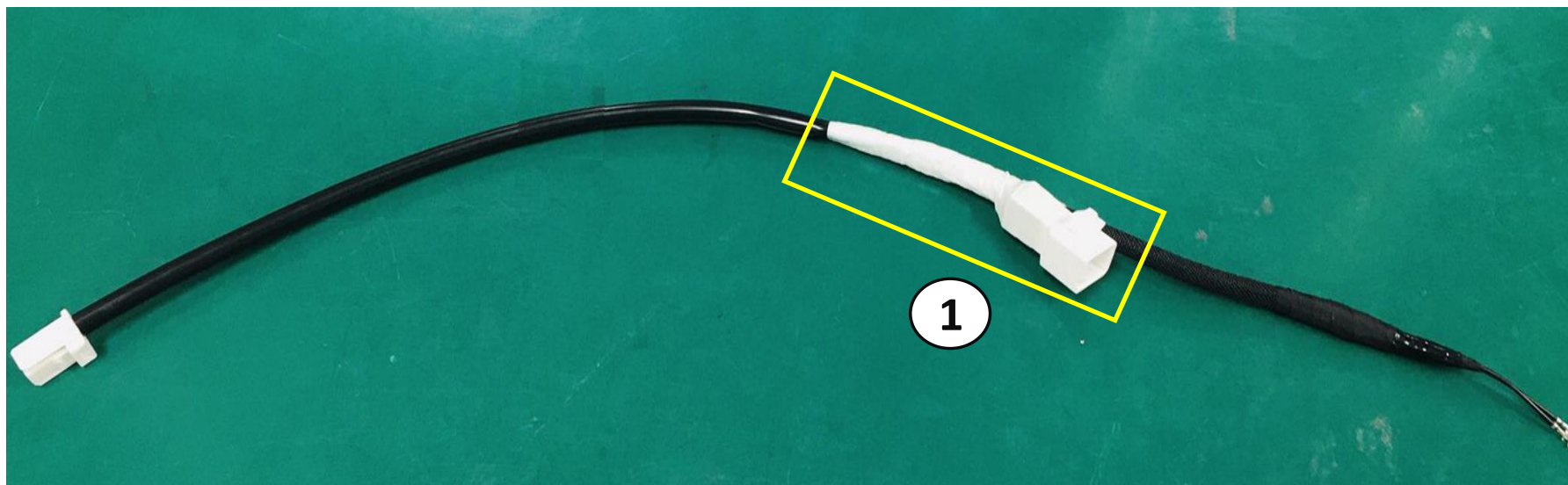
6 of 6

PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P3****7R0122-7022****1****No Missing tape (Y-taping)**

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