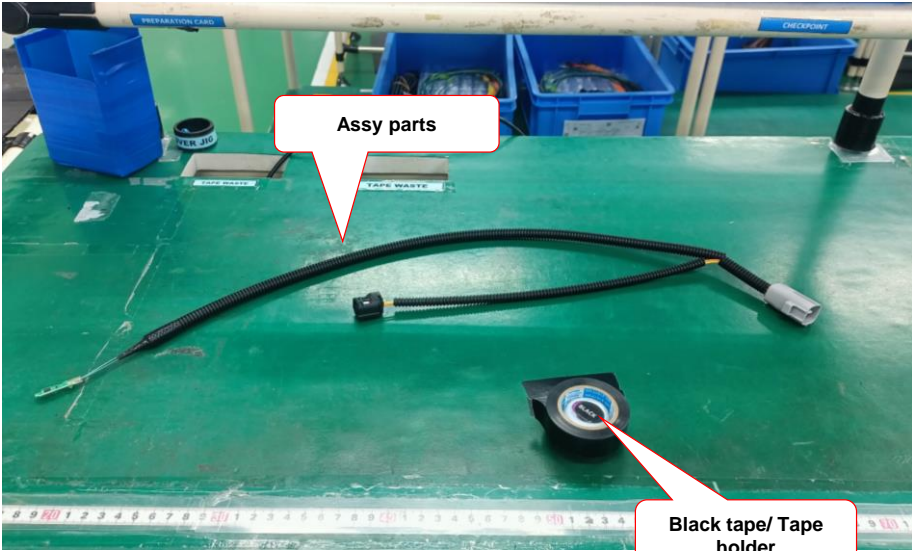
	WORK INSTRUCTION				Effectivity Date:	April 30, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 930B / 7N0204-7020Ca		Customer: TRJ	Car Model: TOYOTA-4 RUNNER	Document No.:	WI-ENG-PDE-880B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	1 of 5




PARTS:		1. All parts: Assy parts; Black tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
1	P2	Table Lay-out		<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>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	

TABLE LAY-OUT



Assy parts


Black tape/ Tape holder

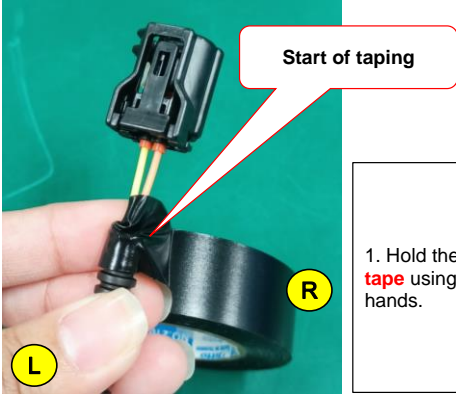
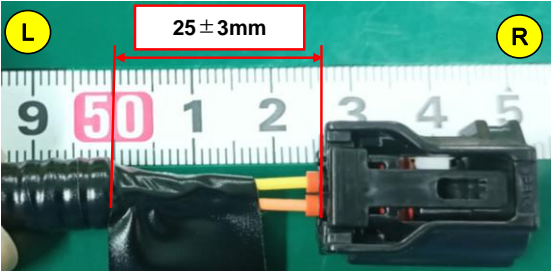
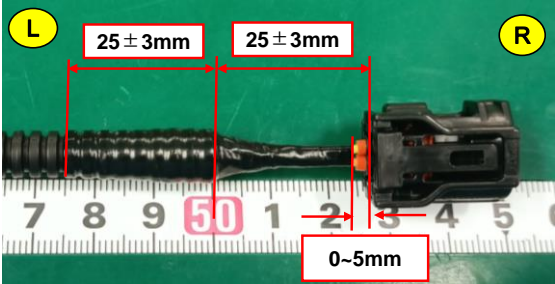

Revision History								Prepared by	Reviewed by	Approved by	Noted by		
04/30/24	1	Change from Pre-launch to Masspro				D.Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
04/24/24	0	Initial issue				D.Castillo	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted				

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	WORK INSTRUCTION				Effectivity Date:	April 30, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 930B / 7N0204-7020Ca		Customer: TRJ	Car Model: TOYOTA-4 RUNNER	Document No.:	WI-ENG-PDE-880B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	2 of 5

PARTS:		1. Assy parts 2. Black tape [1pc]		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
2	P2 Taping 1 COT to wire near connector	<div><p>Start of taping</p><p>1. Hold the corrugated tube using left hand, get the Black tape using right hand then start pre-taping using both hands.</p></div> <div><p>25 ± 3mm</p><p>2. Measure from end of the corrugated tube up to connector 25±3mm then continue the taping process using both hands.</p></div> <div><p>25 ± 3mm 25 ± 3mm</p><p>0~5mm</p><p>3. After taping, check the measurement and taping condition.</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>Document references:</p> <p>1. Refer to WI-PRO-ASY-001 for Taping process</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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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model code/Part number:

930B

/

7N0204-7020Ca

Customer:

TRJ

Car Model:

TOYOTA-4 RUNNER

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

April 30, 2024

Validity Date:

n/a

Document No.:

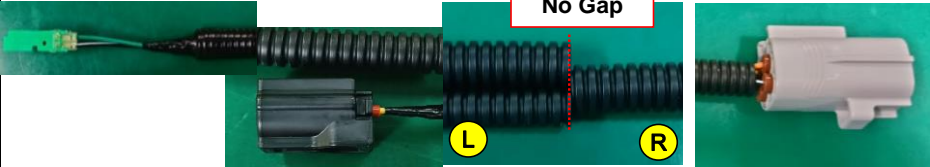
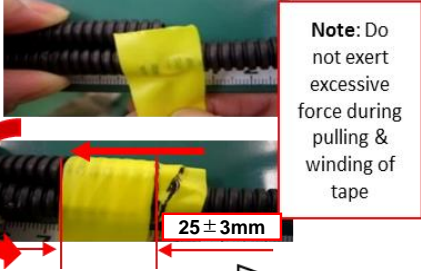
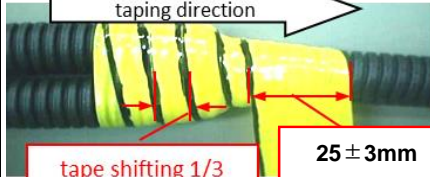

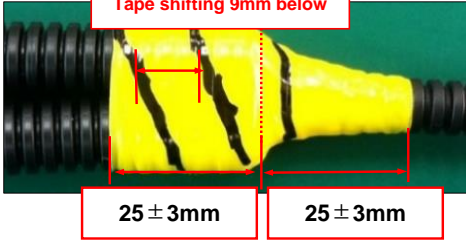

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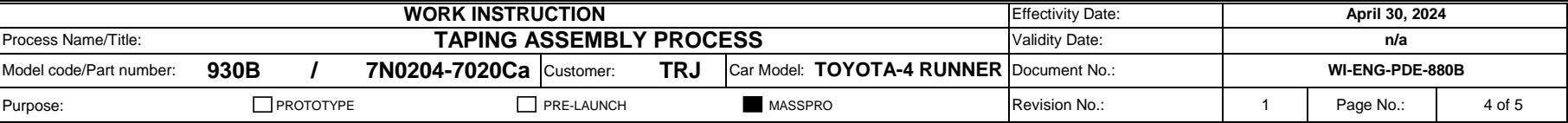
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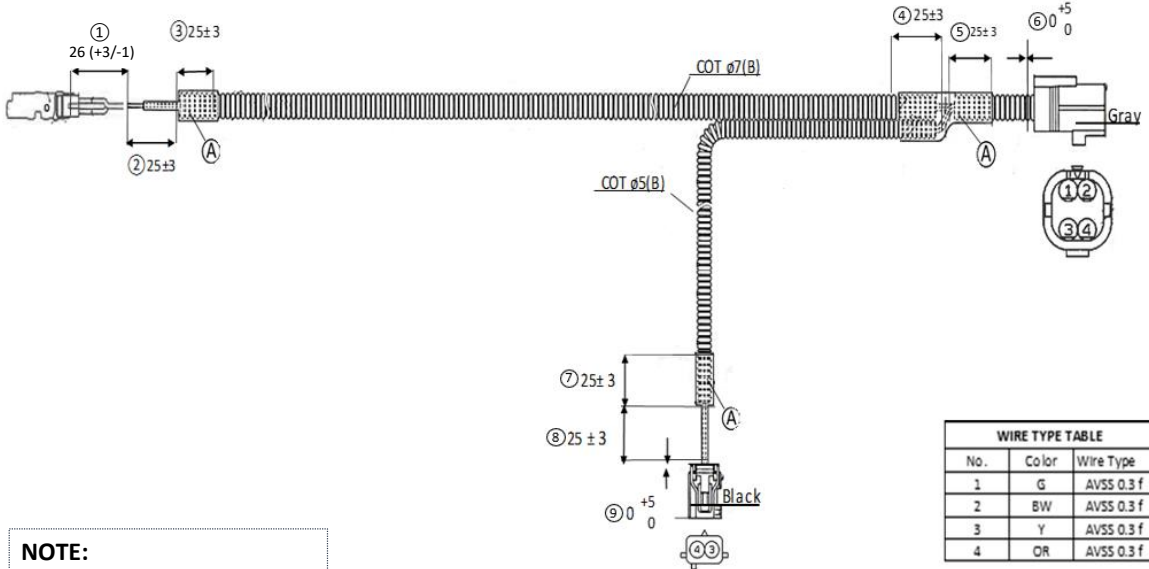
PARTS:		1. Assy parts 2. Black tape [1pc]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	Y-taping			
		<div><div><div></div><div><div></div><div><div></div><div><div></div><div><div></div></div><div><div><div>1. Fix the corrugated tube .</div><div>2. Start taping at the middle of combined Corrugated tubes, then winding the tape going to 2 corrugated tubes, width must be Tape width.</div><div>3. Winding the tape 1/3 shifting until it reach the other side of corrugated tube, width must be 25mm.</div><div>4. Winding the tape backward 1/2 shifting.</div><div>5. Winding the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.</div></div></div></div></div></div></div></div>		<div><div>MEASURING TAPE</div><div></div></div>	<div><div>Important reminders/Note/s:</div><div>1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.</div><div>2. Please use calibrated/verified measuring tape when getting the measurement.</div><div>Document references:</div><div>1. Refer to WI-PRO-ASY-001 for Taping process</div><div>1. No flip-out tape</div><div>2. No peel-off tape</div><div>3. No loose tape</div><div>4. No missing tape</div><div>5. No wrong dimension</div><div>6. No wrong use of tape</div></div>

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PARTS:		1. Assy parts		JIG:	n/a																		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS																		
4	P2	Measurement		<div>MEASURING TAPE</div>   <table><tr><th colspan="3">WIRE TYPE TABLE</th></tr><tr><th>No.</th><th>Color</th><th>Wire Type</th></tr><tr><td>1</td><td>G</td><td>AVSS 0.3 f</td></tr><tr><td>2</td><td>BW</td><td>AVSS 0.3 f</td></tr><tr><td>3</td><td>Y</td><td>AVSS 0.3 f</td></tr><tr><td>4</td><td>OR</td><td>AVSS 0.3 f</td></tr></table> <div>NOTE: Ⓐ - Taping (B)</div>	WIRE TYPE TABLE			No.	Color	Wire Type	1	G	AVSS 0.3 f	2	BW	AVSS 0.3 f	3	Y	AVSS 0.3 f	4	OR	AVSS 0.3 f	<div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension</div>
WIRE TYPE TABLE																							
No.	Color	Wire Type																					
1	G	AVSS 0.3 f																					
2	BW	AVSS 0.3 f																					
3	Y	AVSS 0.3 f																					
4	OR	AVSS 0.3 f																					

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**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**

Effectivity Date:

April 30, 2024

Validity Date:

n/aModel code/Part number: **930B / 7N0204-7020Ca** Customer: **TRJ** Car Model: **TOYOTA-4 RUNNER**

Document No.:

WI-ENG-PDE-880BPurpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

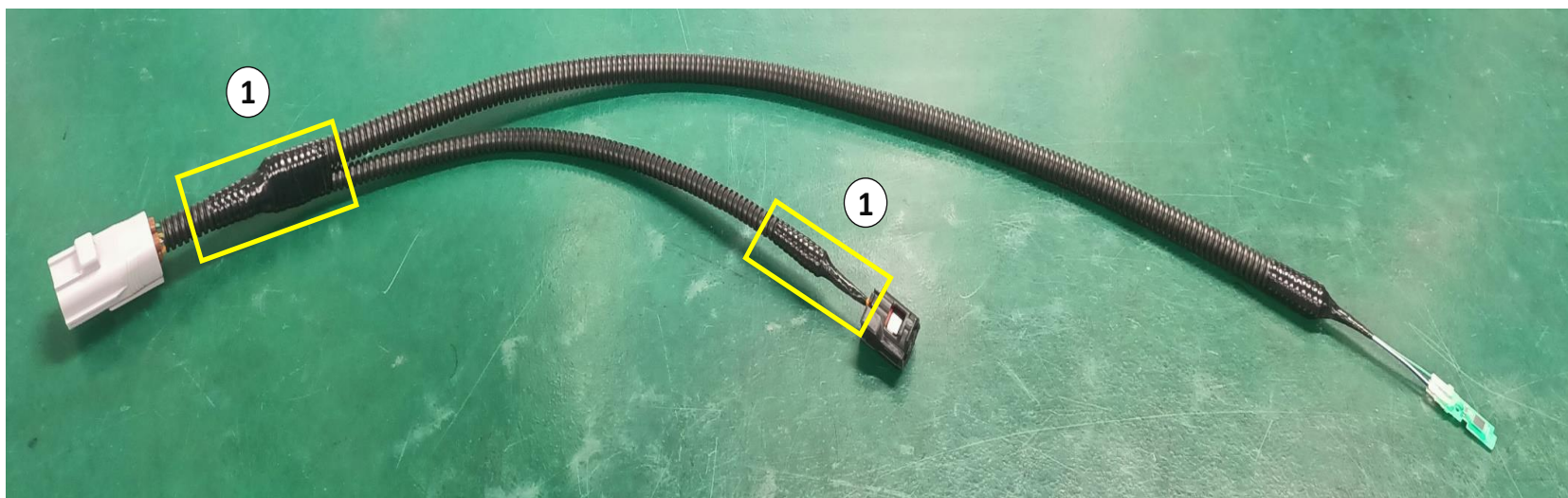
Page No.:

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1. Assy parts

JIG:

n/a

VISUAL INSPECTION**TAPING - P2****7N0204-7020C****① No Missing tape**

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