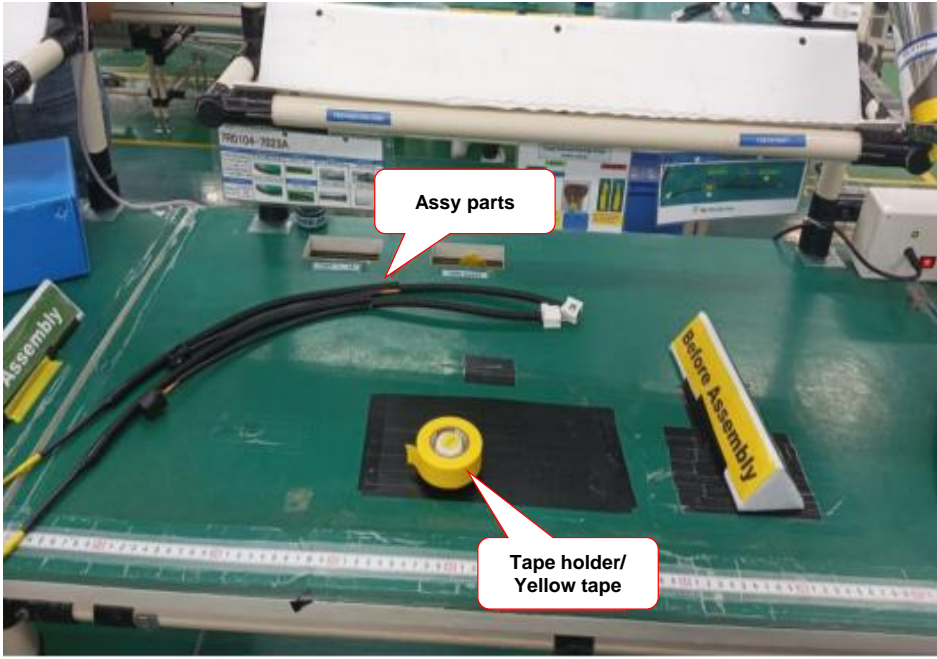
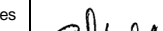


	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>October 1, 2024</b>		
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>780B / 7R0104-7023B</b>		Customer: <b>TRMX</b>	Car Model: <b>TOYOTA-TUNDRA</b>	Document No.:	<b>WI-ENG-PDE-1081C</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	1 of 6

<b>PARTS:</b>	1. Assy parts; Yellow tape			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
1	P3	Table Lay-out	<div><div>TABLE LAY-OUT</div></div>	<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></div>	1. No missing parts/tools 2. No excess parts/tools

Revision History							Prepared by	Reviewed by	Approved by	Noted by
10/01/24	1	Change from Pre-launch to Masspo.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				n/a
09/30/24	0	Initial Issue. Update Visual Inspection/Quality Checkpoints.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date	September 30, 2024		



# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

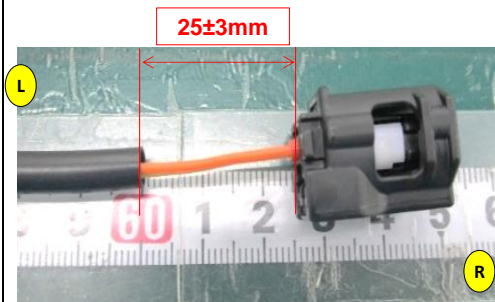
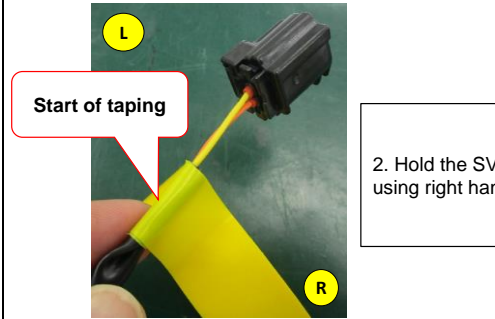
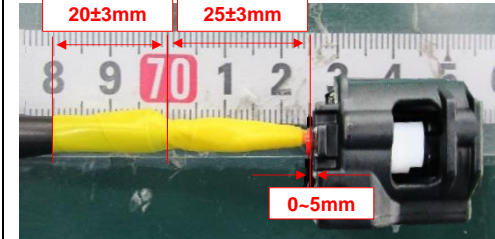

☒ MASSPRO

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PARTS:		1. Assy parts 2. Yellow tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P3 Taping 4 Black SV tube (Vinyl) to wire near connector	<div><p>25±3mm</p><p>1. Hold the SV tube (Vinyl) using left hand. Measure from end of SV tube (Vinyl) up to connector 25±3mm using both hands.</p></div> <div><p>Start of taping</p><p>2. Hold the SV tube (Vinyl) using left hand. Get the Black tape using right hand and start taping process using both hands.</p></div> <div><p>20±3mm 25±3mm 0~5mm</p><p>3. After taping, check the measurement and taping condition.</p></div>		<div><p>MEASURING TAPE</p></div>	<p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. 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> <p>2. Set aside the assy part after assembly.</p> <p>3. Use <b>YELLOW TAPE</b> only.</p> <p><b>Document references:</b></p> <p>1. Please refer to <b>WI-PRO-ASY-001</b> for taping procedure.</p>

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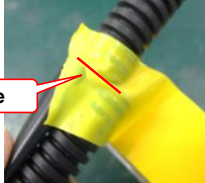

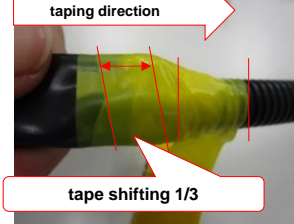

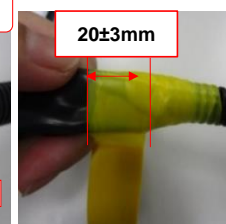
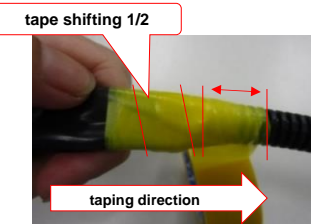
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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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	P3	Y-Taping			
		<div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div></div> <div><div>No gap between tubes</div><div>Connector and Y-taping facing</div><div>Top of tube</div><div>taping direction</div><div>tape shifting 1/2</div><div>taping direction</div><div>tape shifting 1/3</div><div>tape shifting 1/2</div><div>20±3mm</div><div>taping direction</div></div> <div><div>1. Fix the One (1) SV tubes (Vinyl) and (2) COT using both hands.</div><div>2. Start taping at the middle of combined tubes, attach the tape on the top of tube. Then make pre-tape <b>2 windings</b>. Winding the tape <b>1/2 shifting</b> going to the left side. Make <b>2 windings</b>, width must be <b>20±3mm</b>. <b>Note: Do not exert excessive force during pulling &amp; winding of tape.</b></div><div>3. Winding the tape <b>1/3 shifting</b> going to the right side until reach the other side of tube. Make <b>2 windings</b>, width must be <b>20±3mm</b>.</div><div>4. Winding the tape <b>1/2 shifting</b> going to the left side. Make <b>2 windings</b>, width must be <b>20±3mm</b>.</div><div>5. Winding the tape <b>1/2 shifting</b> going to the right side until it reach the other side of tube. Make <b>3 winds</b>, width must be <b>20±3mm</b>. Then cut the tape.</div></div>		<div>Document reference/s: <b>1. Refer to WI-PRO-ASY-001 for taping procedure.</b></div> <div>Important reminders/Note/s: <b>1. Use <u>YELLOW TAPE</u> for easy visualization of shifting lines, but actual should be <u>BLACK TAPE</u>.</b> <b>2. Please use calibrated/verified measuring tape when getting the measurement.</b></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>	

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WI-ENG-PDE-1081C

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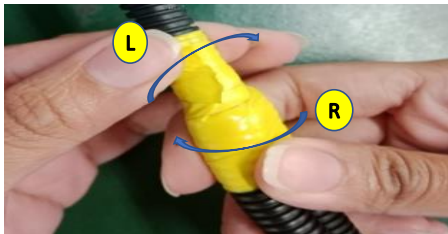
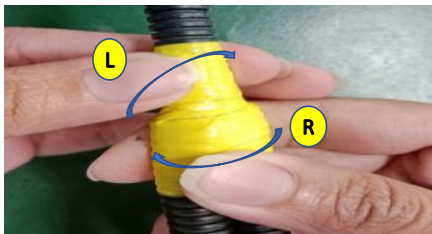
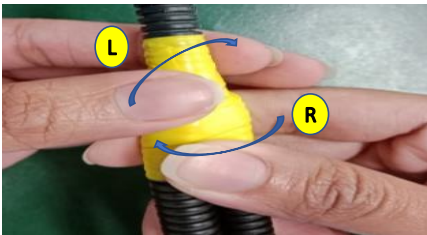
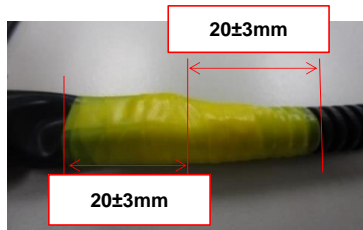
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## PARTS:

1. Assy parts
2. Black tape

JIG:

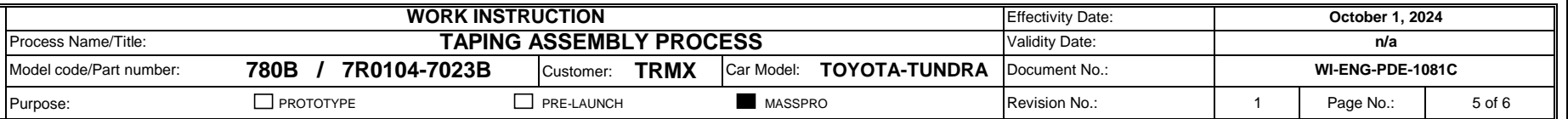
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3 Y-taping (Continuation)	<div></div> <div>6. conduct proper pressing of end tape using left hand (<b>top part</b>)</div> <div></div> <div>7. conduct proper pressing of end tape using left hand (<b>Middle part</b>)</div> <div></div> <div>8. conduct proper pressing of end tape using left hand (<b>bottom part</b>)</div> <div></div> <div>9. Check the Measurement and condition of tape.</div>	n/a	<p><b>Document reference/s:</b></p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <p><b>Important reminders/Note/s:</b></p> <p>1. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines, but actual should be <b>BLACK TAPE</b>.</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</p>

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**TAPING ASSEMBLY PROCESS**

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**October 1, 2024**

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n/a

Model code/Part number:

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Customer:

**TRMX**

Car Model:

**TOYOTA-TUNDRA**

Document No.:

**WI-ENG-PDE-1081C**

Purpose:

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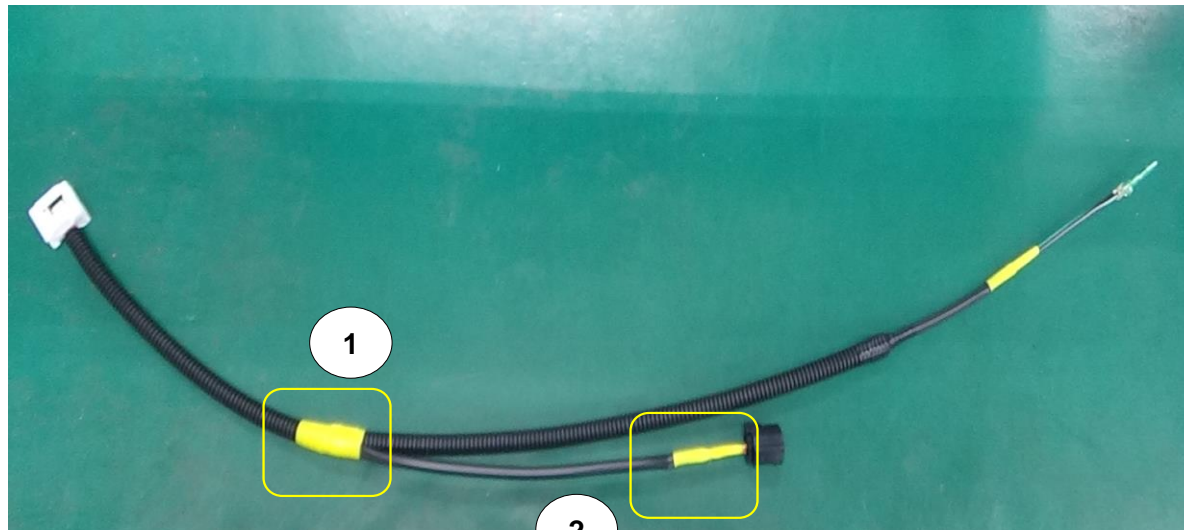
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**PARTS:**

n/a

JIG:

n/a

**QUALITY CHECKPOINTS****TAPING - P3****7R0104-7023B**

① ② **No MISSING TAPE  
(YELLOW TAPE)**

③ **No WRONG FACING OF  
CONNECTOR**

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