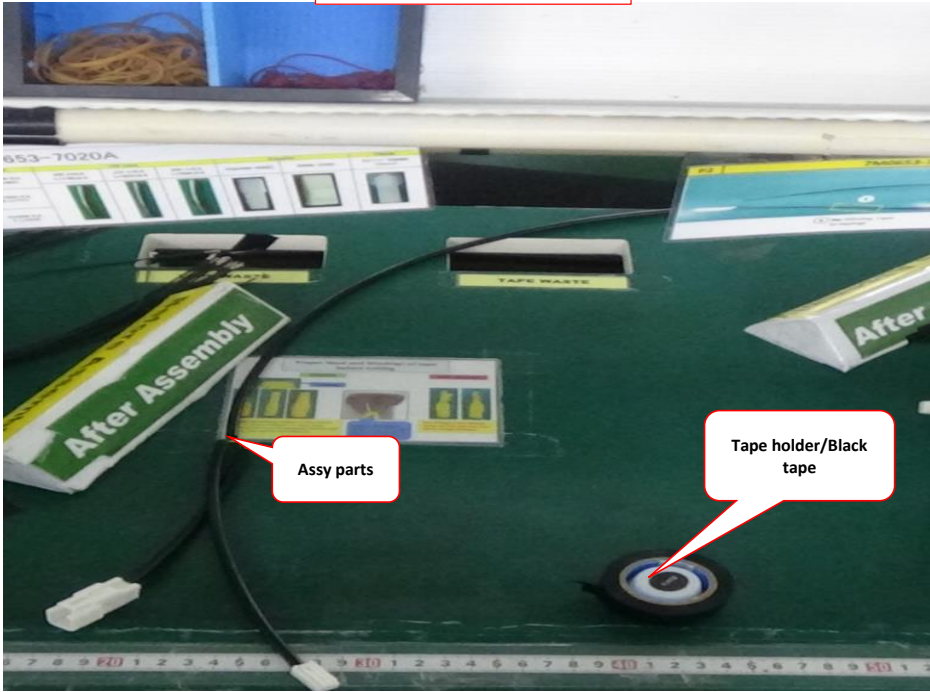
	WORK INSTRUCTION				Effectivity Date:		October 30, 2024				
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a				
	Process Name/Title:		Model code/Part number: D01L / 7M0653-7020A		Customer: TRJ		Car Model: Daihatsu/Tanto				
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.:		WI-ENG-PDE-133B				
				Revision No.:		5		Page No.:		1 of 6	

PARTS:		1. Assy parts; Black tape				JIG:		n/a			
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1		P2		<div>TABLE LAY-OUT</div>  <div>Assy parts</div> <div>Tape holder/Black tape</div>				<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.	

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
10/30/24		5		Transfer to new format and inclusion of Car model "DAIHATSU/TANTO". Additional Work procedure/Illustration and notes on page 5 for Measurement process due to process improvement.				A.Hernandez		C. Villanueva		A. Arañes		n/a	
06/08/23		4		Additional table lay-out. Inclusion of Quality checkpoints (page 5);Improve Quality checkpoints (page 2, 3 and 4); Standardized tube description: SV tube (Vinyl).				M. Ariola		J. Loterte		C. Villanueva		A. Arañes	
04/09/21		3		Apply some improvements.				M. Catapang		C. Villanueva		A. Shimamura		A. Arañes	
Eff. Date		Rev. No		Details of Change				Revised		Reviewed		Approved		Noted	
								Est. Date:		September 14, 2019					

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

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October 30, 2024

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D01L / 7M0653-7020A

Customer:

TRJ

Car Model:

Daihatsu/Tanto

Document No.:

WI-ENG-PDE-133B

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☐ PROTOTYPE

☐ PRE-LAUNCH

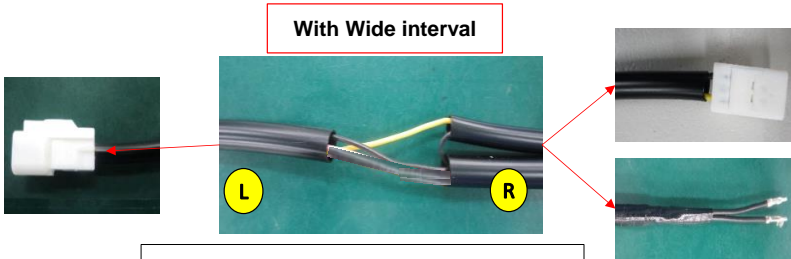
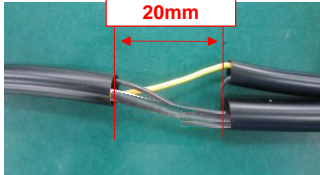
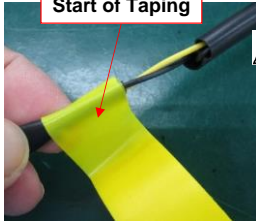
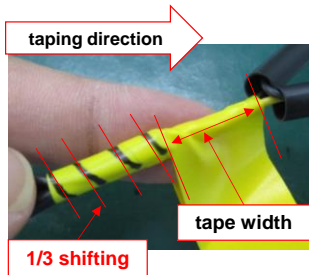
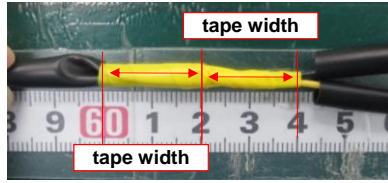

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PARTS:		1. Assy part 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2	Y - Taping	<div><p>With Wide interval</p><p>1. Arrange the assy parts. (See above picture.)</p><p>20mm</p><p>Start of Taping</p><p>taping direction</p><p>tape width</p><p>1/3 shifting</p><p>4. Make 1/3 shifting going to the right side and then wind the tape 3x before cutting of tape.</p><p>tape width</p><p>tape width</p><p>5. After taping, check the measurement and taping condition.</p></div>	<p>Measuring tape</p> 	<p>Important reminders/note/s:</p> <p>1. Used YELLOW TAPE for easy visualization of tape shifting. But actual should be BLACK.</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 exposed wire 5. No wrong dimension</p>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

D01L / 7M0653-7020A

Customer: TRJ

Car Model: Daihatsu/Tanto

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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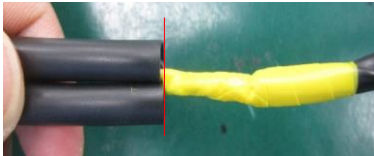
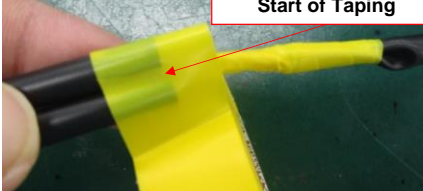
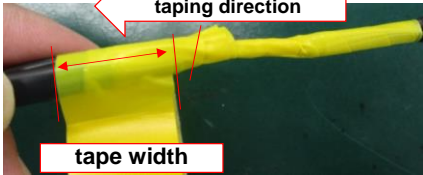
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PARTS:	1. Assy part 2. Black tape			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Y - Taping (Continuation)	<div><div><div><div><div></div><div><div>With Wide interval</div></div></div><div><div>1. Check the facing of harness.</div></div></div><div><div></div><div><div>2. Fix the two SV tubes (Vinyl).</div></div></div><div><div><div><div></div><div><div>Start of Taping</div></div></div><div><div><div><div></div><div><div>taping direction</div></div><div><div>tape width</div></div></div><div><div><div>Note: Do not exert excessive force during pulling & winding of tape.</div></div><div><div>3. Start taping at the middle of combined SV tubes (Vinyl), then wind the tape to left side, width must be same with tape width (19mm).</div></div></div></div></div></div></div></div></div>		n/a	<div>Important reminders/note/s: 1. Used YELLOW TAPE for easy visualization of tape shifting. But actual should be BLACK.</div> <div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No exposed wire 5. No wrong dimension</div>

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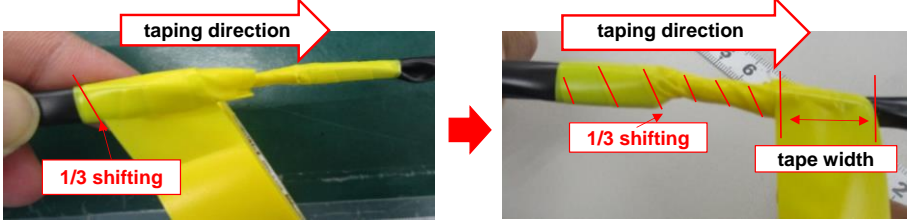
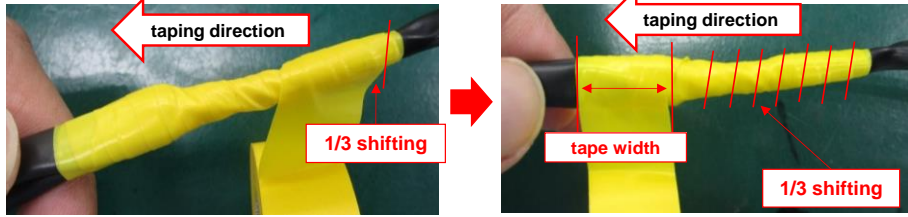
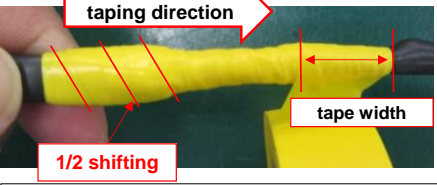
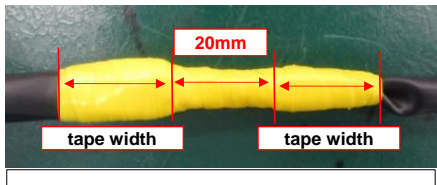

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PARTS:		1. Assy part 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Y - Taping (Continuation)	<div><p>4. Make 1/3 shifting going to the right side until it reach the other side of SV tube (Vinyl) (must be tape width) then winds 2x.</p></div> <div><p>5. Make 1/3 shifting going to the left side and winds 2x.</p></div> <div><p>6. Make 1/2 shifting going to the right side and wind the tape 3x windings before cutting of tape.</p></div> <div><p>7. After taping, check the measurement and taping condition.</p></div>		<div>Measuring tape</div> 	<p>Important reminders/note/s:</p> <ol style="list-style-type: none">1. Used YELLOW TAPE for easy visualization of tape shifting. But actual should be BLACK.2. Please use calibrated/verified measuring tape when getting the measurement <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No exposed wire5. No wrong dimension

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Process Name/Title:

Model code/Part number:

D01L / 7M0653-7020ACustomer: **TRJ**Car Model: **Daihatsu/Tanto**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy part			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION 5	TOOLS/PPE	QUALITY POINTERS 5	
3	P2 Measurement	<div data-bbox="495 539 1713 890"></div> <div data-bbox="577 810 808 965">NOTE: (A) Taping (B) (B) Taping (GR)</div>	<div data-bbox="1368 911 1682 1093">MEASURING TAPE </div>	<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>	

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Model code/Part number:

D01L / 7M0653-7020ACustomer: **TRJ**Car Model: **Daihatsu/Tanto**

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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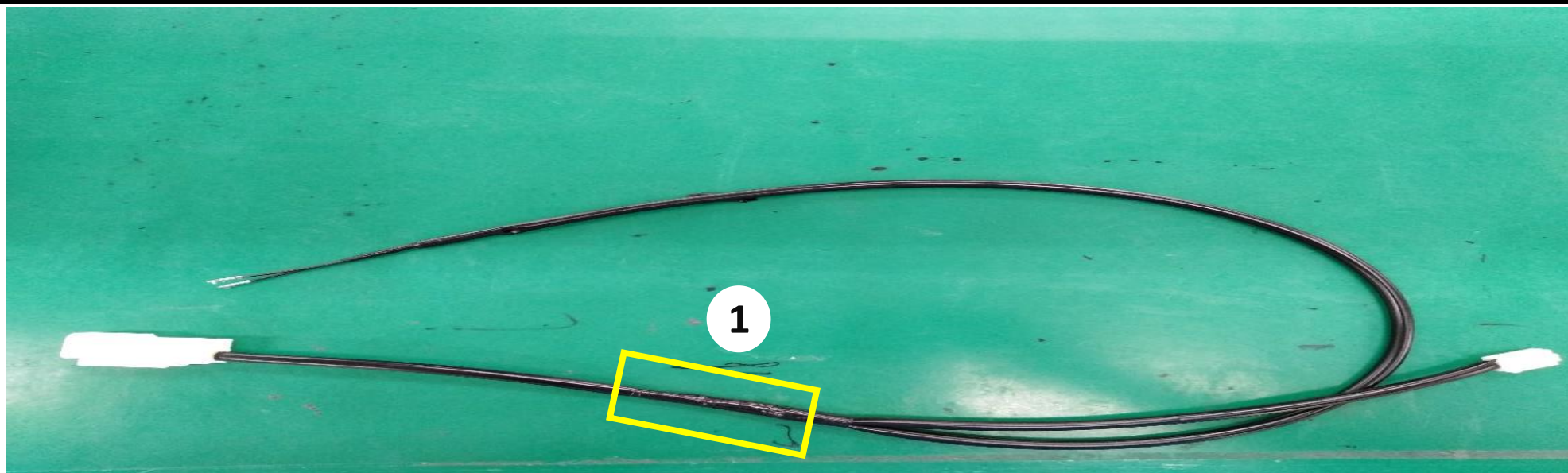
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**P2****7M0653-7020A**

**1 No Missing Tape
(y-taping)**

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