					Effectivity Date:	November 18, 2	mber 18, 2024				
		Process Name/Title:		TAPING ASSEMBLY PR	OCESS	Validity Date:	n/a				
		Model code/Part number:	930B /	7N0205-7020C Customer: TRJ	Car Model: TOYOTA-4RUNNER	Document No.:		WI-ENG-PDE-8	70D		
		Purpose:	PROTOTYPE	☐ PRE-LAUNCH	MASSPRO	Revision No.:	1	Page No.:	1 of 5		
	1. Assy 2. Black			JIG:	IIG: n/a						
NO.	Р	ROCESS NAME		WORK PROCEDURE/ ILLUS	TRATION	TOOLS/PPE	TOOLS/PPE QUALITY POINTERS				
1	P4	TABLE-LAY-OUT			ack tape th holder		2. No exce	ing parts/tools ss parts/tools ig position of parts	h/tools		
		•		Revision History		Prepared by Re	eviewed by	Approved by	Noted by		
11/18/24 1 0	Change p	urpose from Pre-launch to Massp	ro. Update the Visual Inspect	tions/Quality checkpoints Illustration.	M. Ariola C.Villanueva A. Arañes	n/a Mhhely	1/1-11	AND TO			
04/16/24 0 li	Initial issu		•				Villanueva	A. Arañes	n/a		
Eff. Date Rev. No			Details of Cha	inge	Revised Reviewed Approved N	loted Est. Date: April 1	6, 2024				



Process Name Title: TAPING ASSEMBLY PROCESS Model code-Port number: 930B / 7N0205-7020C Cautamer: TRJ Care Models: TOYOTA-4RUNNER Revision No: 1 Page No: 2 of 5 Parts: 1. Assy parts 2. Buck tape NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS NO ap between tubes In part of the page				Effectivity Date:	November 18, 2024							
PARTS: 1. Assy parts 2. Block type 1. Assy parts 3. Block type 1. Assy parts 4. Block type 1. Assy parts 4. Block type 1. Assy parts 5. Block type 1. Assy parts 6. Block			Process Name/Title:		TAPING AS	Validity Date:	n/a					
PARTS: 1. Acry parts 2. Black tape NO. PROCESS NAME NO Gap between tubes No Gap between tubes Important reminders/Note/s: 1. Use yet_LOW TAPE for easy visualization of shifting lines, but excitual should be actual should be measuring tape when getting the measurement. 2. Start taping at the middle of combined Corrupated tubes, with must be Tape width. 3. Winding the tape 1/3 shifting until it reach the other side of corrupated tube, with must be 2 mm. Tape shifting 1/3 25 ± 3mm Tape shifting 9mm below S. Winding the tape 1/2 shifting going to other side of corrupated tube, with must be 2 mm. S. Winding the tape 1/2 shifting going to other side of corrupated tube, with must be 2 mm.			Model code/Part number:	930B /	7N0205-7020C Cu	stomer: TRJ	Car Model: TOYOTA-4RUNNER	Document No.:		WI-ENG-PDE-87	DD	
No. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS No Gap between tubes Important reminders/Note/s: 1. Use YELLOW TAPE for easy status should be IBLACK TAPE. 2. Please use calibrated/verified measurument. Document references: 1. Refer to Wi-PRO-ASY-001 for Taping process 1. Refer to Wi-PRO-ASY-001 for Taping process 1. No deformed tumes, with must be Tape width. 2. Start taping at the middle of combined corrugated tubes, when winding the tape going to 2 corrugated tubes, with must be Tape width. 3. Winding the tape 1/3 shifting until it reach the other side of corrugated tube, with must be Tape with must be Tape shifting 9mm below taping threetton Tape shifting 1/3 Laping direction S. Winding the tape 1/2 shifting 9mm below taping girection Tape shifting 1/2 S. Winding the tape 1/2 shifting 9mm below taping girection Tape shifting 1/2 S. Winding the tape 1/2 shifting 9mm below taping 9mm below taping threetton Tape shifting 1/2 S. Winding the tape 1/2 shifting 9mm below to other side of the tape 1/2 shifting 9mm below taping 9mm below taping the tape 1/2 shifting 9mm below taping 9mm below taping 9mm below taping 1/2 shifting 9mm below taping 9mm taping 9mm below taping 9mm below taping 9mm taping 9mm below taping 9mm taping			Purpose:	PROTOTYPE	☐ PR	E-LAUNCH	MASSPRO	Revision No.:	1	Page No.:	2 of 5	
No Gap between tubes Important reminders/Note/s: 1. Let YELOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE. 2. Please use calibrated/verified measurement. Corrupated tube. winding of carry pulling & vinding of tape. 2. Start taping at the middle of combined Corrupated tubes, when winding the tape going to 2 corrugated tubes, with must be Tape with. 3. Winding the tape 1/3 shifting until it reach the other side of corrugated tube, width must be 2 mm. 3. Winding the tape 1/3 shifting until it reach the other side of corrugated tube, width must be 2 mm. 4. No wong usage of parts. 2. No deformed terminal company to the tape shifting 1/3 25±3mm 25±3	PARTS:			JIG:	n/a							
Important reminders/Note/s: 1. Use YELLOW TAPE for easy visualization of shringing lines, but actual should be BLACK TAPE 1. Fix the corrugated tube. 1. Fix the corrugated tube going to combined corrugated tubes, width must be trape width. 2. Start taping at the middle of combined Corrugated tubes, with must be trape width. 2. Start taping at the middle of combined Corrugated tubes, with must be trape width. 3. Winding the tape 1/3 shrifting until it reach the other side of corrugated tube, width must be 25mm. 4. No deformed terminal 5. Winding the tape 1/2 shrifting going to other side of one side of the corrugated tube. 5. Winding the tape 1/2 shrifting going to other side of the corrugated tube. 1. Winding the tape 1/2 shrifting going to other side of the corrugated tube. 2. Vitaping 1. No wrong usage of parts. 2. No deformed terminal	NO.	l	PROCESS NAME		WORK PROCE	DURE/ ILLUSTR	ATION	TOOLS/PPE	C	QUALITY POINTERS		
4. Winding the tape backward 1/2 shirting. the condition of tape.				tape shifting below	No Gap to Note: Do not exer excessive force durity pulling to winding of tape. 25 ± 3mm 25 ± 3mm sing direction	1. Fix the cord corrugated to 25 mm. 1. Fix the cord corrugated to 2 corrugated to 25 mm.	rrugated tube . g at the middle of combined ubes, then winding the tape going to tubes, width must be Tape width. e tape 1/3 shifting until it reach the corrugated tube, width must be e shifting 9mm below ± 3mm 1/2 shifting going to other side of n cut the tape. After taping, check	MEASURING TAPE	Importa 1. Use Y visualize actual si 2. Please measure measure Docume 1. Refer process 1. No wrone	ant reminders/NELLOW TAPE for ation of shifting lin hould be BLACK to be use calibrated/ving tape when getterment. ent references: r to WI-PRO-ASY-cs	Note/s: easy nes, but TAPE. erified ting the	

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		Process Name/Title:		TAPING AS	Validity Date:	n/a										
		Model code/Part number:	930B /	7N0205-7020C Cu	ıstomer: TRJ	Car Model: TOYOTA-4RUNNER	Document No.:		WI-ENG-PDE-870	D						
		Purpose:	PROTOTYPE	☐ PR	E-LAUNCH	MASSPRO	Revision No.:	1	Page No.:	3 of 5						
PARTS:	2. Black tape									n/a						
NO.	F	PROCESS NAME		WORK PROCE	:DURE/ ILLUSTR	RATION	TOOLS/PPE	C	QUALITY POINTERS							
				Note: Do not exer excessive force durit pulling 8	1. Fix the co	orrugated tube .		Important reminders/Note/s: 1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement. Document references: 1. Refer to WI-PRO-ASY-001 for Taping								
3	P4	Y-taping 2	tape	05 t 3 mm	3. Winding the other side of 25mm. Tap 25 5. Winding the tape	tubes, then winding the tape going to tubes, width must be Tape width. The tape 1/3 shifting until it reach the corrugated tube, width must be The shifting 9mm below The shifting 9mm below The shifting going to other side of the cut the tape. After taping, check e.	6 7 8 9 10 1 2 3 4 5 6 7 8 9 9	process 1. No wrong								



				WORK INSTE					Effectivity Date:	November 18, 2024				
		Process Name/Title:		TAPING	ASSEMBLY	Validity Date:	n/a							
		Model code/Part number:	930B /	7N0205-7020C	Customer: TF	₹J (Car Model: TOYOT	A-4RUNNER	Document No.:		WI-ENG-PDE-87	0D		
		Purpose:	PROTOTYPE		PRE-LAUNCH		MASSPRO		Revision No.:	1	Page No.:	4 of 5		
PARTS:	1. Assy	parts							JIG:	n/a				
NO.	F	ROCESS NAME		WORK PR	OCEDURE/ ILL	USTRA	TION		TOOLS/PPE	C	QUALITY POINT	TERS		
4	P4	Measurement	①105-13 (205-1	(Vinyt tube (8) C4		COT(8) ©Z	© 2513 ⊕2513 / © 2513 ⊕2513 / © 2513 ⊕2513 /	© 25:33 © 25:33 © 35:30 © 3	MEASURING TAPE	1. Pleas measur measur 2. For h OWARI Documer 1. Refer t Assy Hat Owarinor	ant reminders/Note use calibrated/ ing tape when ge ement. IATSUMONO, NA MONO only. at references: o WI-PRO-ASY-0s sumono , Nakam no inspection.	verified tting the KAMONO AND 56 for Sub-		



			WORK INSTRU	Effectivity Date:	November 18, 2024								
		Process Name/Title:			TAPING A	SSEMB		Validity Date:	n/a				
		Model code/Part number:	930B	1	7N0205-7020C	Customer:	TRJ	Car Model:	TOYOTA 4RUNNER	Document No.:		WI-ENG-PDE-87	0D
		Purpose:	□PR	OTOTYPE		PRE-LAUNCH	l	MASSPE	RO	Revision No.:	1	Page No.:	5 of 5
											ı		1
PARTS:	n/a									JIG:	n/a		

VISUAL INSPECTIONS/QUALITY CHECKPOINTS

TAPING 4

7N0205-7020C



No Wrong Facing of Y-taping

2 No Missing tape (Y-taping)

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