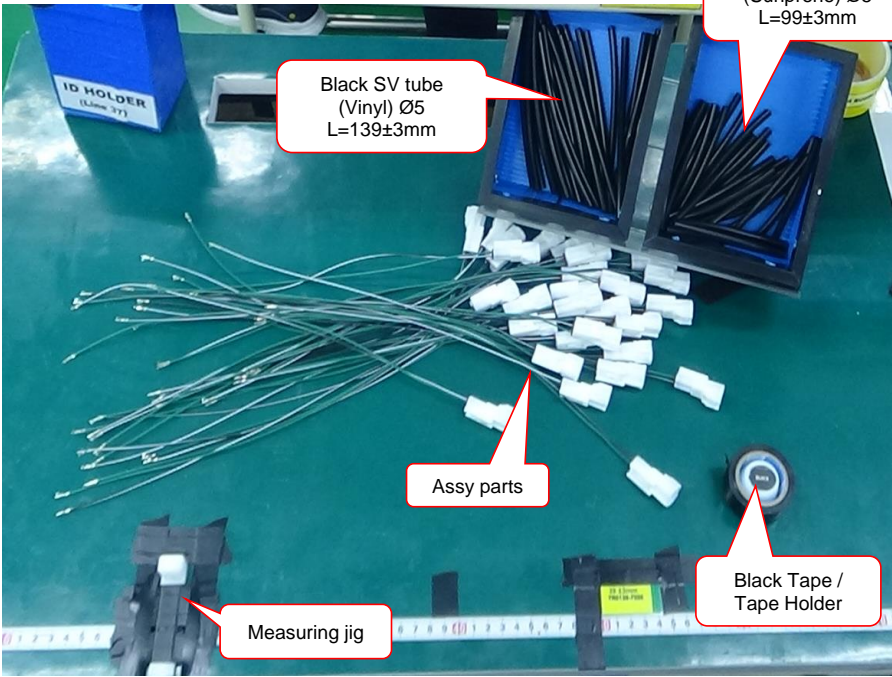


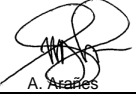
	<b>WORK INSTRUCTION</b> <b>TAPING ASSEMBLY PROCESS</b>			Effectivity Date:	August 15, 2024		
	Process Name/Title:			Validity Date:	n/a		
	Model code/Part number:	920B / 7R0120-7022	Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:	WI-ENG-PDE-978A	
	Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.: 1 of 4

PARTS:		1.Assy parts; Black SV tube (Vinyl) Ø5 L=139±3mm; Black VM tube (Sunprene) Ø5 L=99±3mm; Black Tape		JIG:	1. Insertion jig with switch cover 2. Measuring jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
1	P1	<div>Table Lay-out</div> 		<div>Safety Instruction</div> <p>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<div>Document reference/s:</div> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>	

Revision History							Prepared by	Reviewed by	Approved by	Noted by
							 A. Hernandez	 C. Villanueva	 A. Arañes	n/a
08/15/24	1	Change Pre Launch to Mass Pro.	A. Hernandez	C. Villanueva	A. Arañes	n/a				
08/08/23	0	Initial issue	A. Hernandez	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted	Est. Date:	August 08, 2024	

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

Effectivity Date:

**August 15, 2024**

Process Name/Title:

Validity Date:

**n/a**

Model code/Part number:

**920B / 7R0120-7022**

Customer:

**TRMX**

Car Model:

**TOYOTA-TACOMA**

Document No.:

**WI-ENG-PDE-978A**

Purpose:



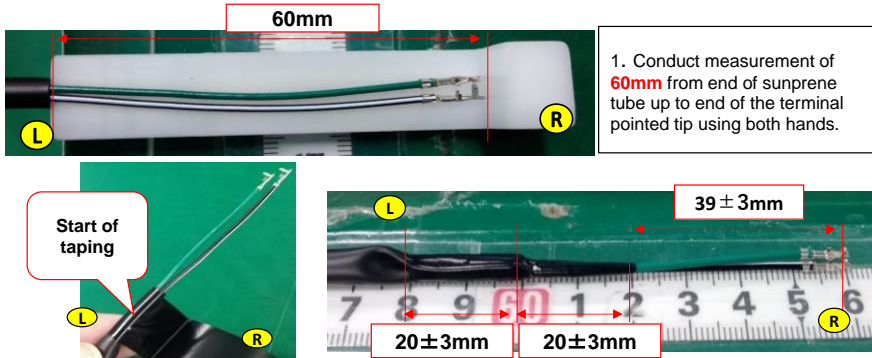
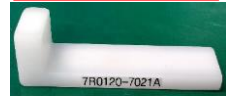

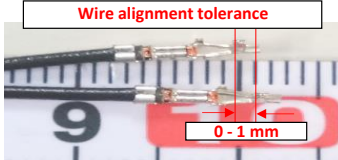
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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**1**

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<b>PARTS:</b>		1. Assy parts 2. Black SV tube (Vinyl) Ø5 L=139±3mm	3. Black VM tube (Sunprene) Ø5 L=99±3mm 4. Black tape	JIG:	1. Measuring jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	Wire Insertion to Black SV tube (Vinyl) Ø5 L=139±3mm	 <div>1. Get the Black SV tube (Vinyl) <b>Ø5 L=139±3mm</b> using right hand then insert the <b>G-B/W wires</b> using left hand.</div>		n/a	1. No wrong use of parts
3	Wire Insertion to Black VM tube (Sunprene) Ø5 L=99±3mm	 <div>1. Get the Black VM tube (Sunprene) <b>Ø5 L=99±3mm</b> using right hand then insert the <b>G-B/W wires</b> using left hand.</div>		n/a	1. No wrong use of parts
4	P1 Taping 1 Black VM tube (Sunprene) to wire near terminal	 <div>1. Conduct measurement of <b>60mm</b> from end of sunprene tube up to end of the terminal pointed tip using both hands.</div> <div>2. Hold the tube using left hand, get the <b>Black tape</b> using right hand then start taping process using both hands.</div> <div>3. After taping, check the taping condition, measurement and wire alignment.</div>		<div><b>MEASURING JIG</b></div>  <div><b>MEASURING TAPE</b></div> 	<div><b>Wire alignment tolerance</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> <div><b>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></div>

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# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

920B / 7R0120-7022

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

August 15, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-978A

Revision No.:

1

Page No.:

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### PARTS:

1. Assy parts
2. Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

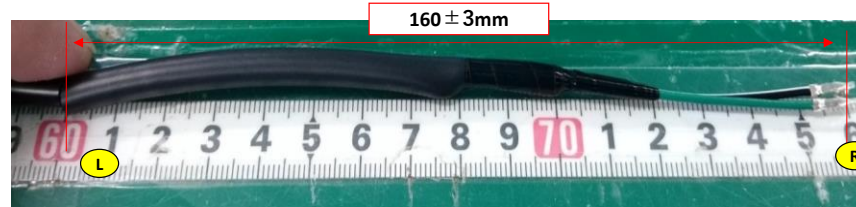
TOOLS/PPE

QUALITY POINTERS

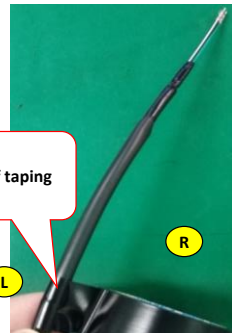
5

P1

Taping 2  
Black SV tube (Vinyl) to  
Black VM tube (Sunprene)  
near terminal



1. Measure from end of corrugated tube up to terminal pointed tip  $184 \pm 3\text{mm}$  using both hands.



2. Hold the corrugated tube and sunprene tube using left hand, get the **Black tape** then start taping process using both hands.



3. After taping, check the taping condition, measurement and wire alignment.

### MEASURING TAPE



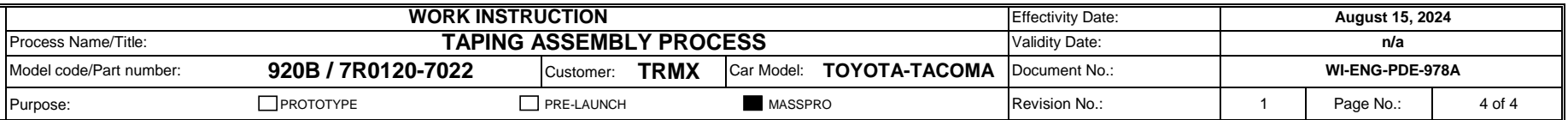
**Important reminders/Note/s:**  
**1. Please use calibrated/verified measuring tape when getting the measurement.**

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

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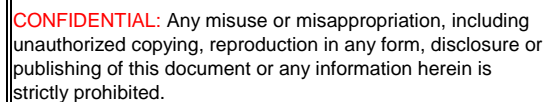
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JIG:	n/a
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**P1**

**7R0120-7022**



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