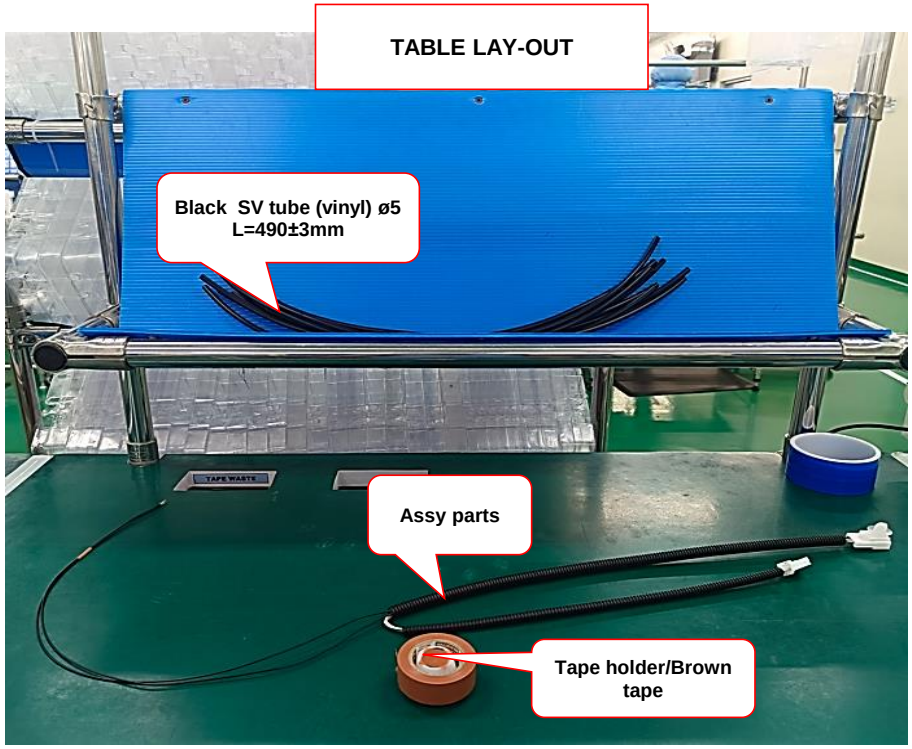
	WORK INSTRUCTION			Effectivity Date:	March 7, 2025		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 559D / 7N0237-7020B	Customer: TRJ	Car Model: TOYOTA HI-ACE	Document No.:	WI-ENG-PDE-1064B		
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	0	Page No.:	1 of 6

PARTS:	1. Assy parts, Black SV tube (vinyl) ø5 L=490±3mm; Brown tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Table lay-out		**Safety Instruction** Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) **Housekeeping** 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. **Alert level** For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	1. No wrong use of connector 2. No damaged connector 3. No wrong insert 4. One by one insertion 5. No deformed terminal 6. No wrong terminal Orientation ***Important reminders/Note/s:*** ***1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.*** ***2. Please hold the wire near terminal during insertion.*** ***Document references:*** ***1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.*** ***2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.***

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved
03/07/25	0	Initial issue. Excluded process from **WI-ENG-PDE-1064** due to new process distribution. Change from Pre-launch to Masspro. Additional table lay-out; Update the Work/Procedure Illustration	M. Ariola	J. Loterte	C. Villanueva	A. Arañes

Prepared by	Checked by	Reviewed by	Approved by
M. Ariola	J. Loterte	C. Villanueva	A. Arañes
Est. Date:	March 7, 2025		

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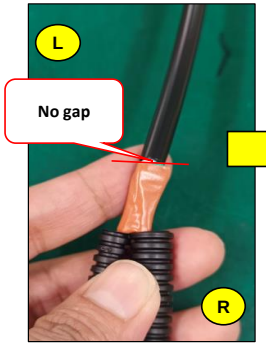
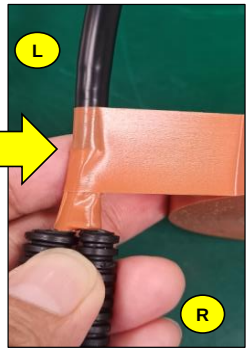
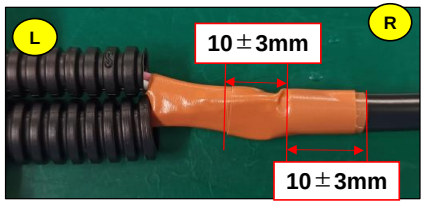
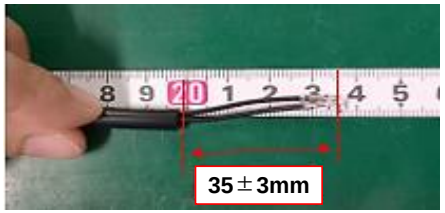
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.: 2 of 6

PARTS:	1. Assy parts 2. Black SV tube (vinyl) ø5 L=490±3mm 3. Brown tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2	Wire insertion to Black SV tube (vinyl) ø5 L=490±3mm	 1. Get the **B-B wires** using right left then insert the **Black SV tube (vinyl) ø5 L=490±3mm** using right hand.	n/a	1. No wrong usage of parts 2. No deformed terminal
3	P2	Spot taping 3	  1. Combine the assy parts and the Black SV tube (Vinyl. initially attach the **Brown tape** in the middle and start taping using both hands. Make **2 windings** of tape then cut the tape.   2. After taping, check the taping condition.	**MEASURING TAPE** 	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. ***Important reminders/ Note/s:*** ***1. Please use calibrated/verified measuring tape when getting the measurement.***

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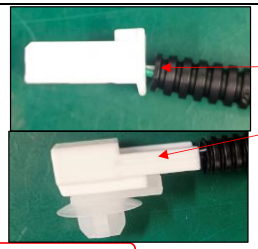
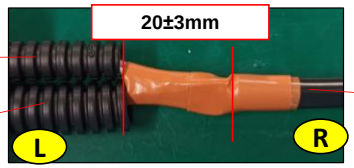
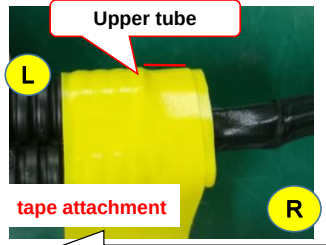
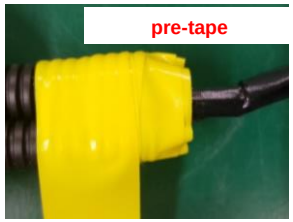
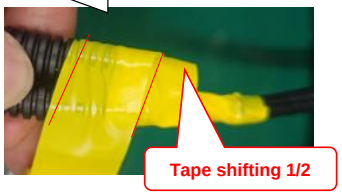
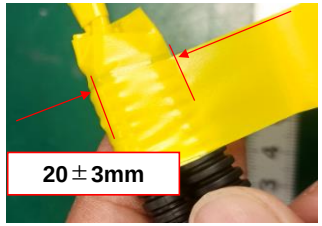
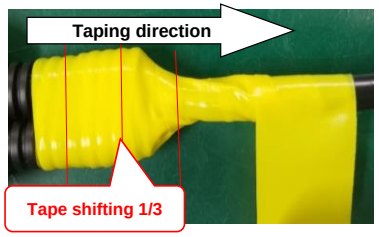
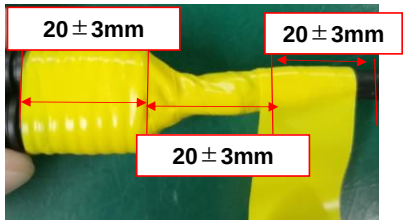
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.: 3 of 6

PARTS:	1. Assy parts 2. Black Tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2	Y-Taping	  1. Fix the 3 corrugated tube. **Note: Follow the correct facing. (If need to standard)**   2. Start taping at the middle of combined tubes, attach the tape on the upper tube. Then make pre-tape **2 windings.** ***Note**: Do not exert excessive force during pulling & winding of tape.* taping direction  3. Winding the tape **1/2 shifting** going to the left side.  4. Make **2 windings**, width must be - **20±3mm.**  5. Winding the tape **1/3 shifting** going to the right side until reach the other side of tube.  6. Make **2 windings**, width must be **20±3mm**. C		***Document reference/s:*** ***1. Refer to WI-PRO-ASY-001C for taping procedure (special).*** ***Important reminders/Note/s:*** ***1. Use yellow tape for easy visualization of tape shifting, but actual should be BROWN TAPE*** ***2. Please use calibrated/verified measuring tape when getting the measurement.*** 1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension-out tape 6. No exposed wire 7. No gap between tubes

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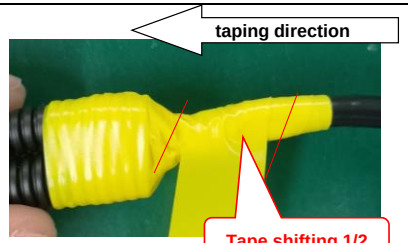
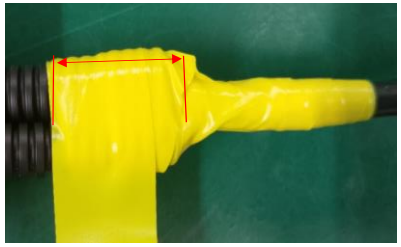
	Model code/Part number: 559D / 7N0237-7020B	Customer: TRJ	Car Model: TOYOTA HI-ACE	Document No.:	WI-ENG-PDE-1064B	
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	0	Page No.: 4 of 6

PARTS:	1. Assy parts 2. Black Tape	JIG:	n/a

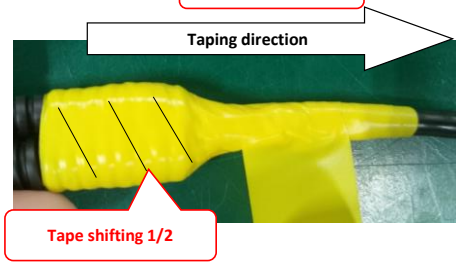
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2	Y-Taping (continuation)			



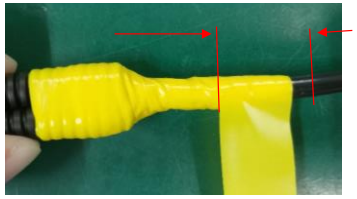
7. Winding the tape **1/2 shifting** going to the left side.



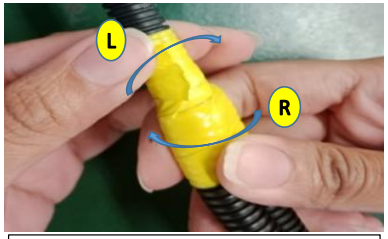
8. Make **2 windings**, width must be **20±3mm.**



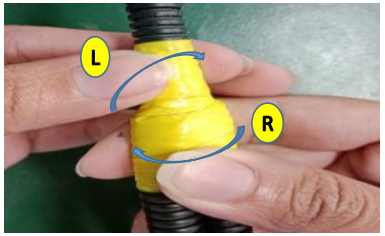
9. Winding the tape **1/2 shifting** going to the right side until it reach the other side of tube



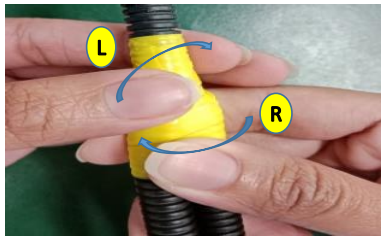
10. Make **3 winds,** width must be **20±3mm.** Then cut the tape.



11. conduct proper pressing of end tape using left hand **(top part).**
Note: Reference only.



12. conduct proper pressing of end tape using left hand **(Middle part).**



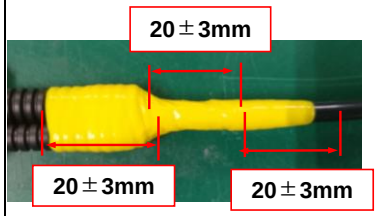
13. conduct proper pressing of end tape using left hand **(bottom part).**

Document reference/s:
1. Refer to WI-PRO-ASY-001C for taping procedure (special).

Important reminders/Note/s:

1. Use <u>yellow tape</u> for easy visualization of tape shifting, but actual should be <u>BLACK TAPE.</u>
2. Please use calibrated/verified measuring tape when getting the measurement.

1. No loose tape
2. No flip-out tape
3. No peel-off tape
4. No wrong use of tape
5. No wrong dimension-out tape
6. No exposed wire
7. No gap between tubes



14. Check the Measurment and condition of tape.

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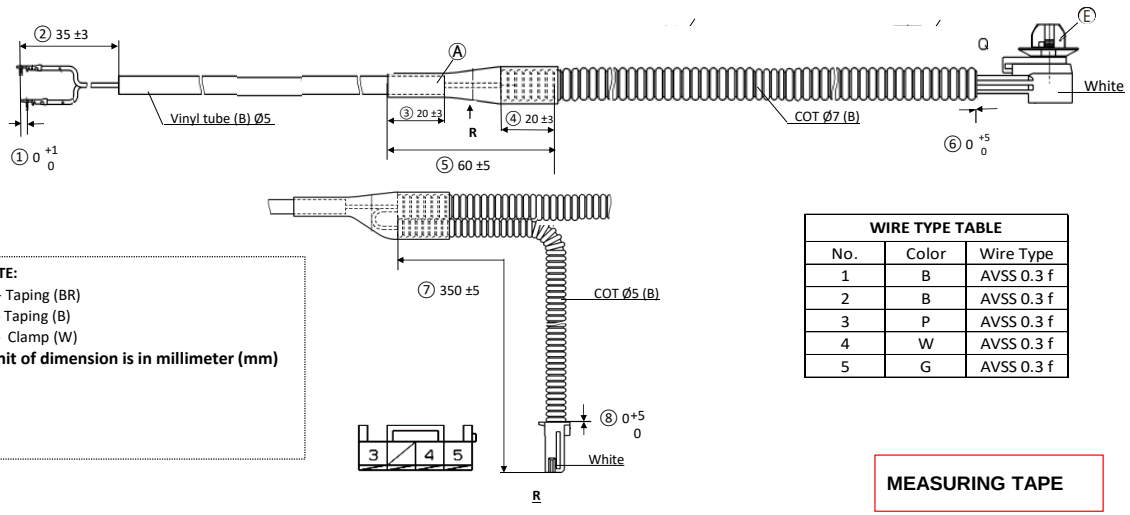
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	0 — Page No.: 5 of 6

PARTS:	1. Assy parts	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2	Measurement			1.No wrong dimension ***Important reminders/ Note/s:*** ***1. Please use calibrated/verified measuring tape when getting the measurement.*** ***2. For Hatsumono and Owarimono*** ***Document reference/s:*** ***1. Refer to WI-PRO-ASY-056 For sub-Assembly Hatsumono, Nakamono and Owarimono Inspection.***

WIRE TYPE TABLE

No.	Color	Wire Type
1	B	AVSS 0.3 f
2	B	AVSS 0.3 f
3	P	AVSS 0.3 f
4	W	AVSS 0.3 f
5	G	AVSS 0.3 f

MEASURING TAPE

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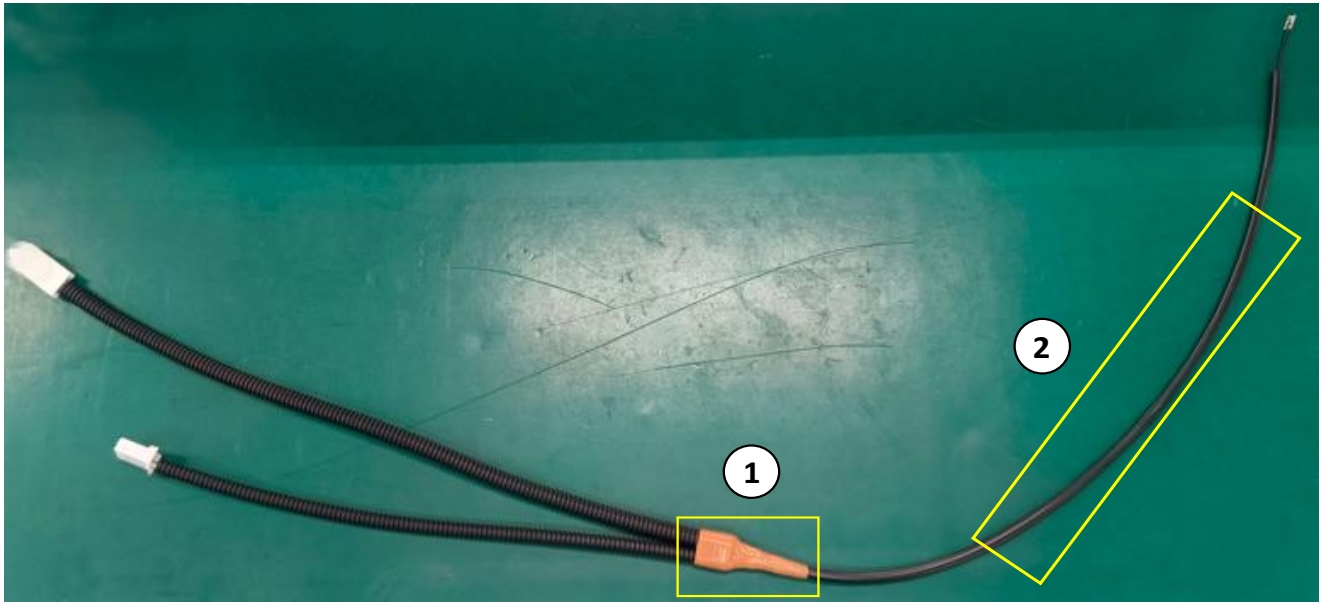
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.: 0	Page No.: 6 of 6

PARTS:		JIG:	

VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING -P2 7N0237-7020B



① No Wrong used of tape Y-taping

② No Missing SV tube (Vinyl)

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