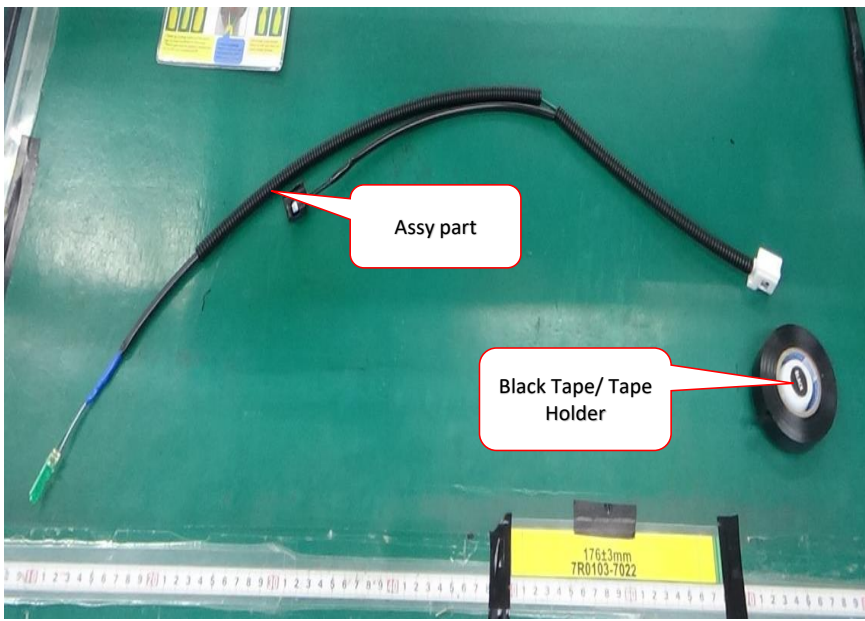


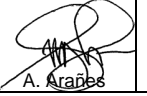
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	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 780B / 7R0103-7023B		Customer: TRMX	Car Model: TOYOTA-TUNDRA	Document No.:		WI-ENG-PDE-1078C	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		1	Page No.:	1 of 6	


PARTS:	1. Assy part; VM tube (Sunprene) ø5 L=135±3mm ; Black Corrugated tube ø7 L=355±3mm (no slit); MR SW CP (TVSSF 0.3 wires G-B/W L=737±3mm); Blue Tape			JIG:	1. Insertion jig 2. locking jig 3. Measuring jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
1	P3	<p style="text-align: center;">Table Lay-out</p> 	<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	1. No missing parts/tools 2. No excess parts/tools	


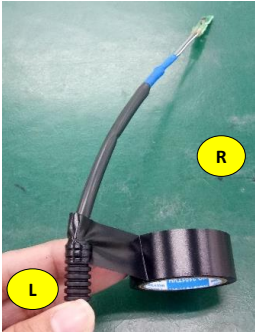
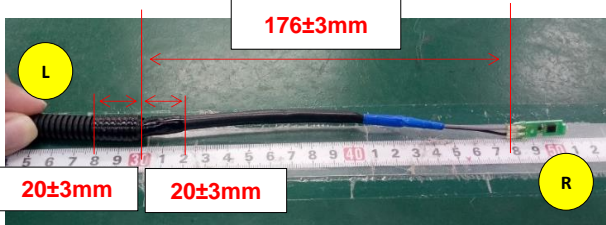

Revision History						Prepared by	Reviewed by	Approved by	Noted by	
						 D. Castillo	 C. Villanueva	 A. Arañes	n/a	
10/01/24	1	Change from Pre-launch to Masspro.	D.Castillo	C. Villanueva	A. Arañes					n/a
09/24/24	0	Initial issue. Separate Clamp assembly and transfer Taping 3 and Y-taping process from P2 due to process improvement.	D.Castillo	C. Villanueva	A. Arañes					n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	

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PARTS:		1. Black tape 2. Assy parts		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
2	P3 Taping 3 COT to VM tube (Sunprene) near to PCB	<div><p>1. Hold the COT using left hand. Measure the end of COT up to the edge of hotmelted wire 176±3mm using right hand.</p></div> <div><p>2. Hold the COT using left hand. Get the Black tape using right hand and start taping using both hands.</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>		<div>MEASURING TAPE</div> 	<p>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <ul style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension	

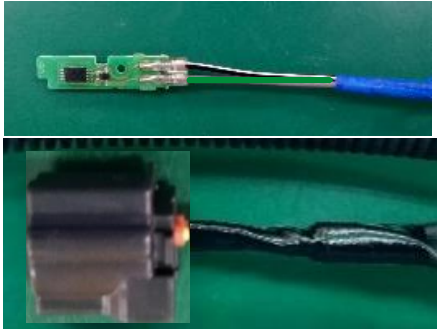
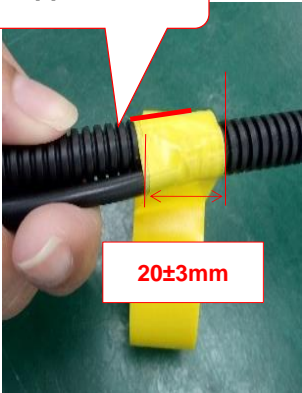
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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	P3 Y-Taping	<div><div>NO GAP</div><div>CONNECTOR CORRECT FACING</div><div>Upper COT</div><div>20±3mm</div><div>20±3mm</div><div>taping direction</div><div>2. Start taping at the middle of combined tubes, attach the tape on the upper tube. Then make pre-tape 2 windings. Winding the tape 1/2 shifting going to the left side. Make 2 windings, width must be 20±3mm. Note: Do not exert excessive force during pulling & winding of tape.</div></div> <div><div>1. Fix the corrugated and SV tube (Vinyl) using both hands. Note: Follow the correct facing of Black Connector</div></div>		<p>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>Important reminders/Note/s: 1. Use yellow tape for easy visualization of tape shifting, but actual should be BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement.</p> <div>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</div>	

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WI-ENG-PDE-1078C

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PROTOTYPE



PRE-LAUNCH



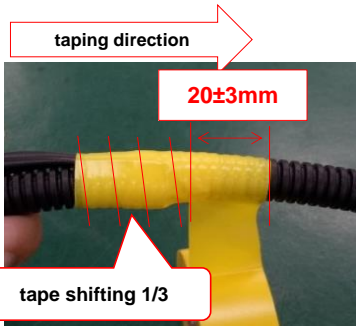
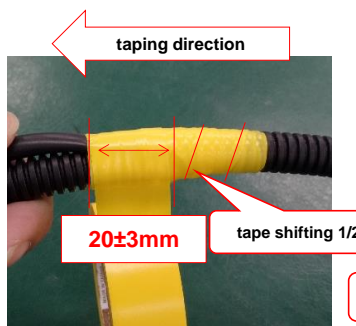
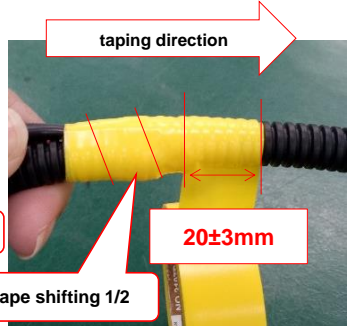
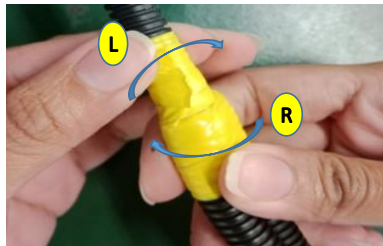
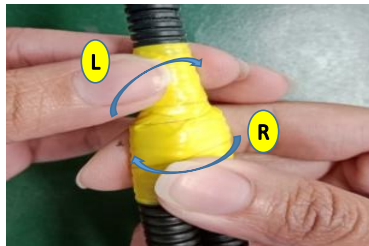
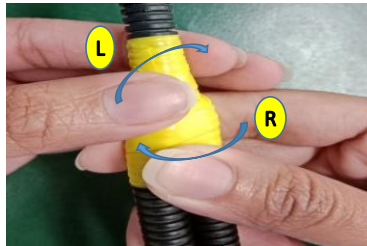
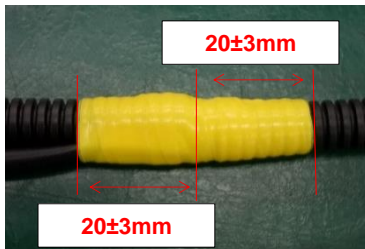
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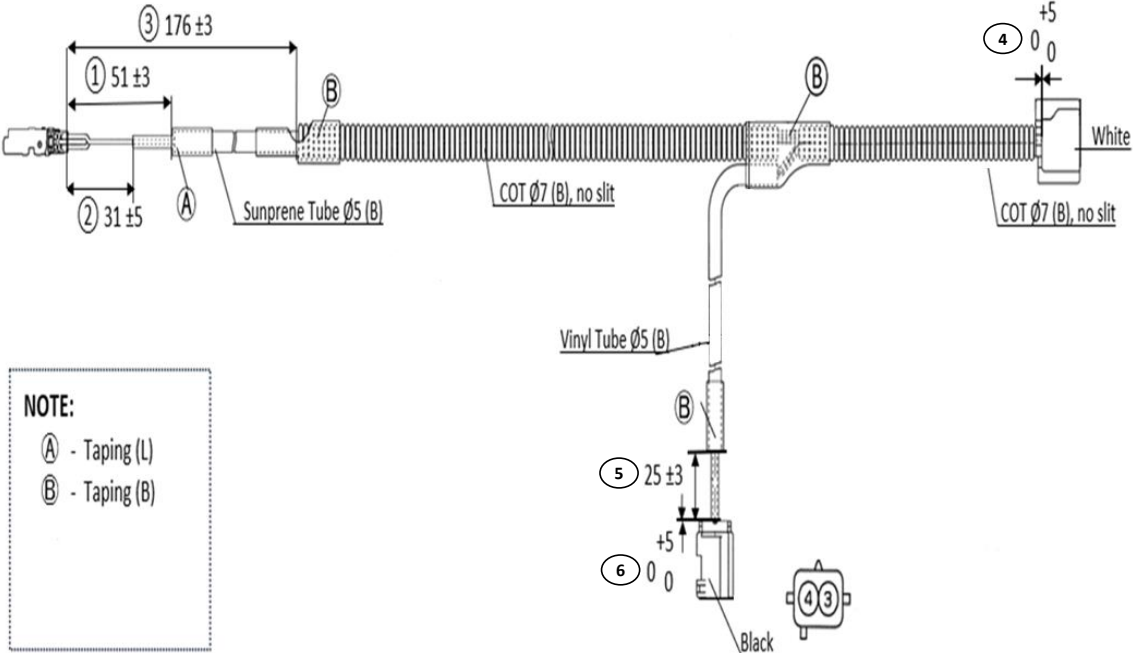
PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P3 Y-Taping (Continuation)	<div><div><p>3. Winding the tape 1/3 shifting going to the right side until reach the other side of tube. Make 2 windings, width must be 20±3mm.</p></div><div><p>4. Winding the tape 1/2 shifting going to the left side. Make 2 windings, width must be 20±2mm.</p></div><div><p>5. Winding the tape 1/2 shifting going to the right side until it reach the other side of tube. Make 3 winds, width must be 20±3mm. Then cut the tape.</p></div><div><p>6. conduct proper pressing of end tape using left hand (top part). Note: Reference only.</p></div><div><p>7. conduct proper pressing of end tape using left hand (Middle part). Note: Reference only.</p></div><div><p>8. conduct proper pressing of end tape using left hand (bottom part). Note: Reference only.</p></div><div><p>9. Check the Measurement and condition of tape.</p></div></div> <div><p>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p><p>Important reminders/Note/s: 1. Use yellow tape for easy visualization of tape shifting, but actual should be BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement.</p><ul style="list-style-type: none">1. No loose tape2. No flip-out tape3. No peel-off tape4. No wrong use of tape5. No wrong dimension-out tape6. No exposed wire7. No gap between tubes</div>			

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.: 5 of 6

PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
4	P3	Measurement	<div style="border: 1px solid red; padding: 5px; color: red; text-align: center; margin-bottom: 10px;"> MEASURING TAPE </div>  <div style="border: 1px dashed black; padding: 5px; margin-top: 10px;"> NOTE: (A) - Taping (L) (B) - Taping (B) </div>	<div> Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono. </div> <div> Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection </div> <div> 1. No wrong dimension </div>	

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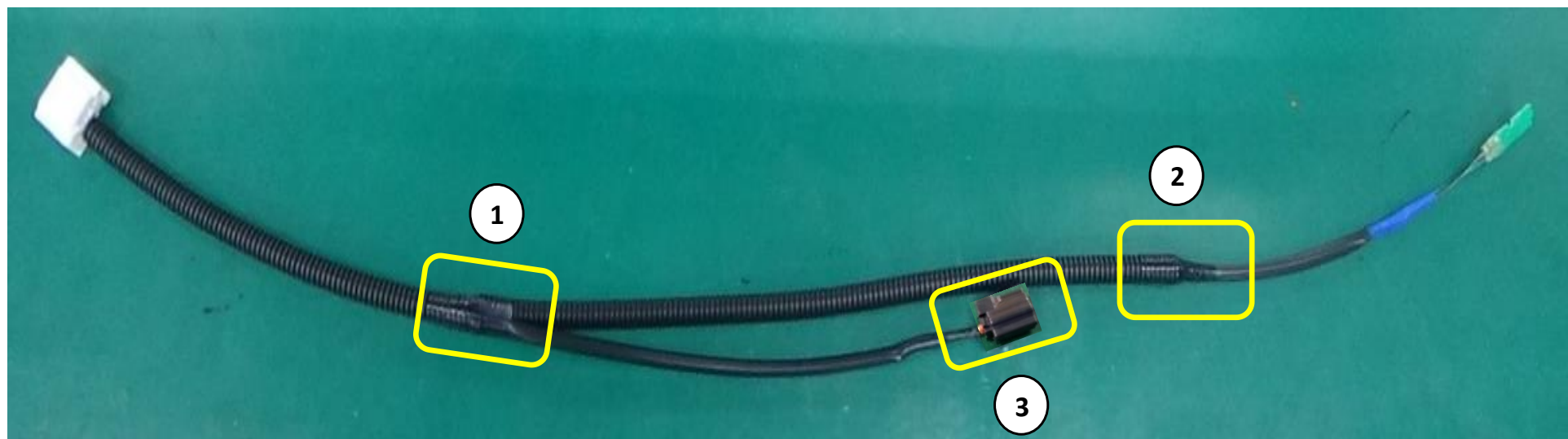
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P3****7R0103-7023B**

1

2

No MISSING TAPE (BLACK TAPE)

3

No WRONG FACING OF CONNECTOR

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