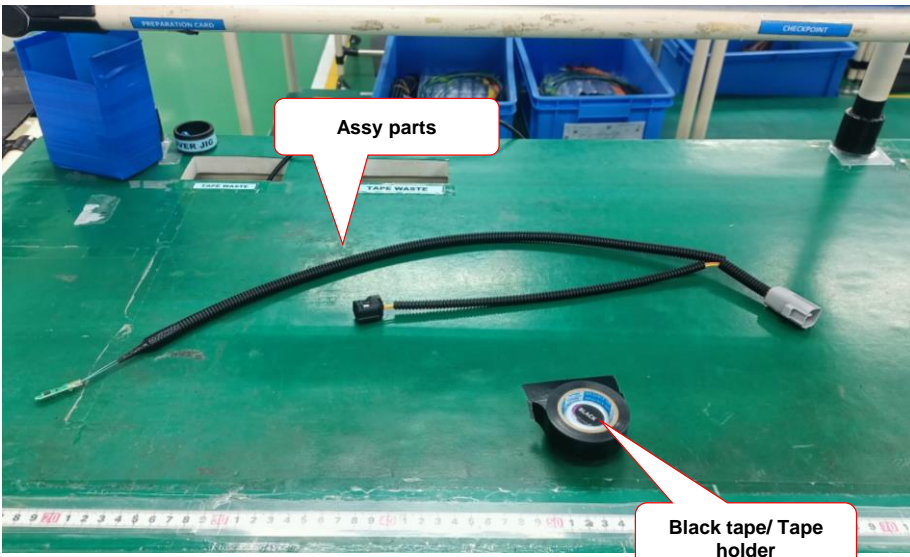

	WORK INSTRUCTION				Effectivity Date:	February 6, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 930B / 7N0204-7020A		Customer: TRJ	Car Model: TOYOTA-4 RUNNER	Document No.:	WI-ENG-PDE-792B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	1 of 4

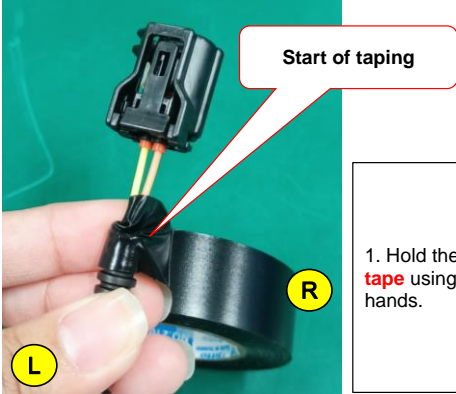
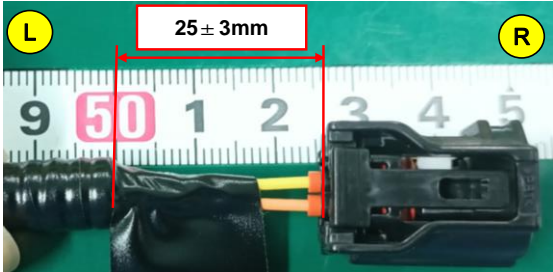
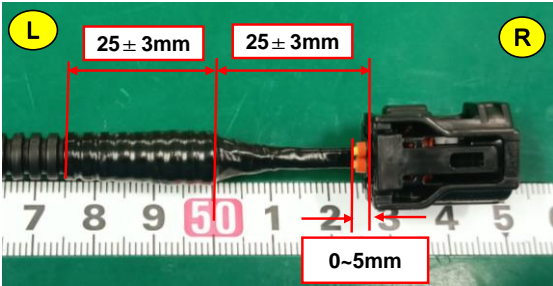

PARTS:		1. All parts: Assy parts; Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P2	<div style="border: 1px solid red; padding: 5px; text-align: center; margin-bottom: 10px;">TABLE LAY-OUT</div> 		<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> 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
02/06/24	0	Initial issue		D.Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	2 of 4

PARTS:		1. Assy parts 2. Black tape [1pc]		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
2	P2 Taping 1 COT to wire near connector	<div><p>Start of taping</p><p>1. Hold the corrugated tube using left hand, get the Black tape using right hand then start pre-taping using both hands.</p></div> <div><p>25 ± 3mm</p><p>2. Measure from end of the corrugated tube up to connector 25±3mm then continue the taping process using both hands.</p></div> <div><p>25 ± 3mm 25 ± 3mm</p><p>0~5mm</p><p>3. After taping, check the measurement and taping condition.</p></div>		<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document references:</p> <p>1. Refer to WI-PRO-ASY-001 for Taping process</p> <p>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</p>	

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WORK INSTRUCTION

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TAPING ASSEMBLY PROCESS

Model code/Part number:

930B

/

7N0204-7020A

Customer:

TRJ

Car Model:

TOYOTA-4 RUNNER

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

February 6, 2024

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n/a

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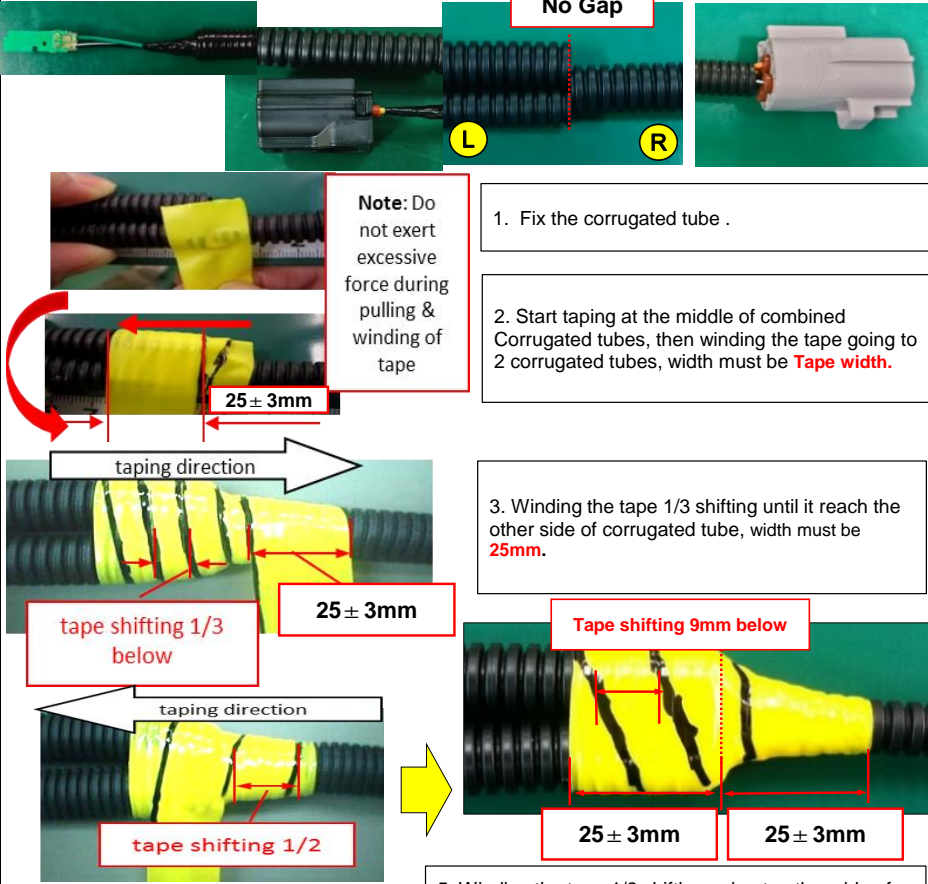

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PARTS:		1. Assy parts 2. Black tape [1pc]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	Y-taping			
		<div><div></div><div><p>Note: Do not exert excessive force during pulling & winding of tape</p><p>25 ± 3mm</p><p>taping direction</p><p>tape shifting 1/3 below</p><p>25 ± 3mm</p><p>taping direction</p><p>tape shifting 1/2</p><p>25 ± 3mm</p><p>25 ± 3mm</p></div><div><p>1. Fix the corrugated tube .</p><p>2. Start taping at the middle of combined Corrugated tubes, then winding the tape going to 2 corrugated tubes, width must be Tape width.</p><p>3. Winding the tape 1/3 shifting until it reach the other side of corrugated tube, width must be 25mm.</p><p>4. Winding the tape backward 1/2 shifting.</p><p>5. Winding the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.</p></div></div>		<div><p>MEASURING TAPE</p></div>	<p>Important reminders/Note/s:</p> <p>1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document references:</p> <p>1. Refer to WI-PRO-ASY-001 for Taping process</p> <p>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</p>

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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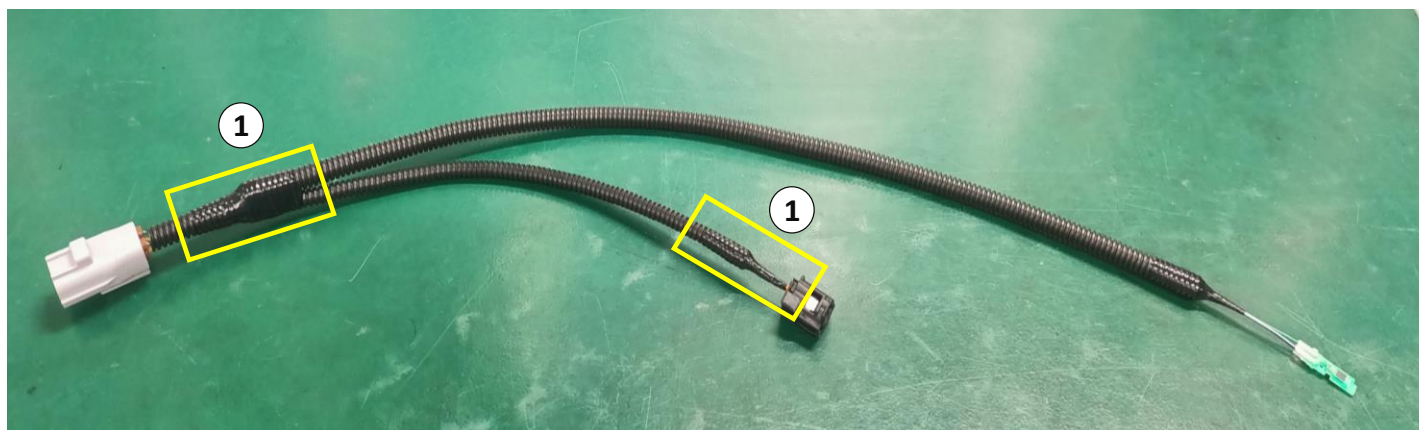
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PARTS:

1. Assy parts

JIG:

n/a

QUALITY CHECKPOINTS**P2****7N0204-7020A****1** No Missing tape

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