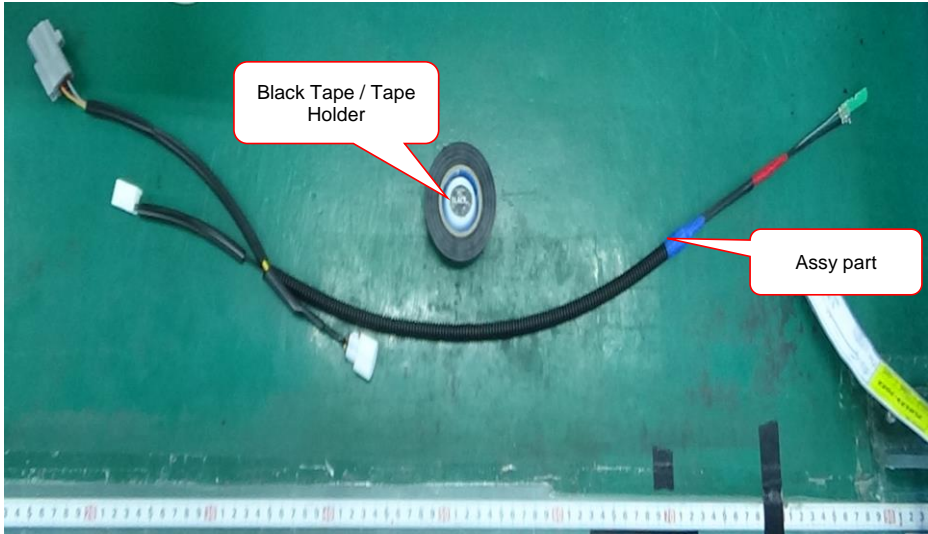
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	TAPING ASSEMBLY PROCESS				Validity Date:	n/a	
	Process Name/Title:		Model code/Part number: 922B / 7L0123-7022A	Customer: TRQSS	Car Model: LEXUS-NX	Document No.: WI-ENG-PDE-1042C	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.: 1	Page No.: 1 of 7

PARTS:		1. Assy parts; Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P3	<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>	1. No missing parts/tools 2. No excess parts/tools 3. No wrong position of parts/tools

Revision History								Prepared by	Reviewed by	Approved by	Noted by
09/13/24	1	Change pre-launch to mass pro.				A.Hernandez	C. Villanueva	A. Arañes	n/a		
09/09/24	0	Initial issue, Separate clamp assy to Clamp assembly process. Transfer Taping 5 from P1; Taping 4 and Y-taping from P2 due to process				A.Hernandez	C. Villanueva	A. Arañes	n/a		
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	September 09, 2024

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

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922B / 7L0123-7022A

Customer:

TRQSS

Car Model:

LEXUS-NX

Purpose:

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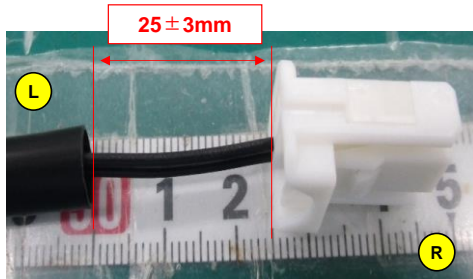
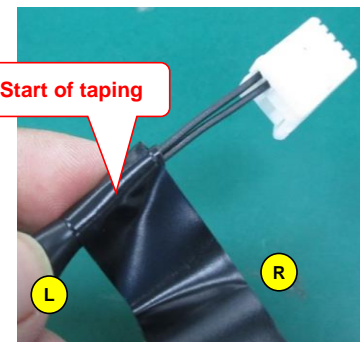
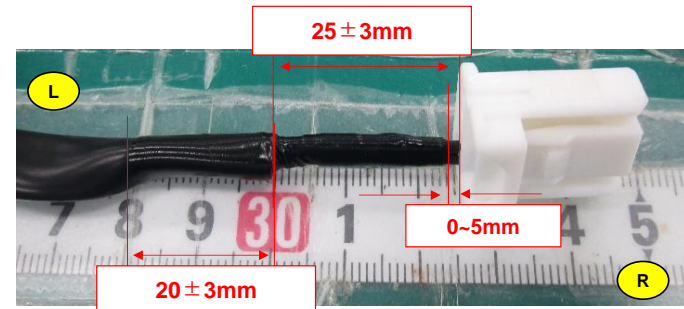

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PARTS:		1. Assy parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P3 Taping 4 SV tube (Vinyl) to wire near Connector	<div><div><p>1. Measure from end of SV tube (Vinyl) up to edge of connector 25±3mm using both hands.</p></div><div><p>2. Get the Black tape using right hand then start taping process using both hands.</p></div><div><p>3. After taping, check the measurement and taping condition.</p></div></div> <div><div>MEASURING TAPE</div></div> <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</div>			

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WORK INSTRUCTION

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Customer:

TRQSS

Car Model:

LEXUS-NX

Document No.:

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Purpose:

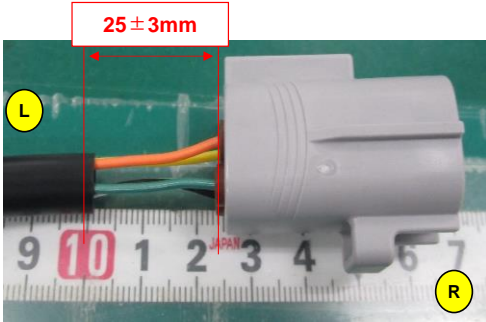
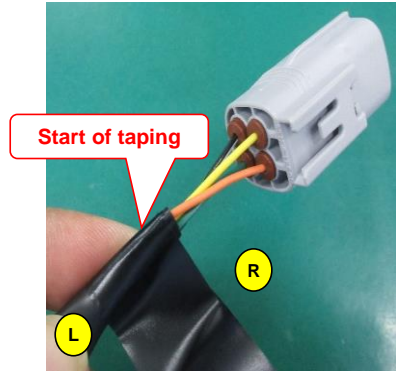
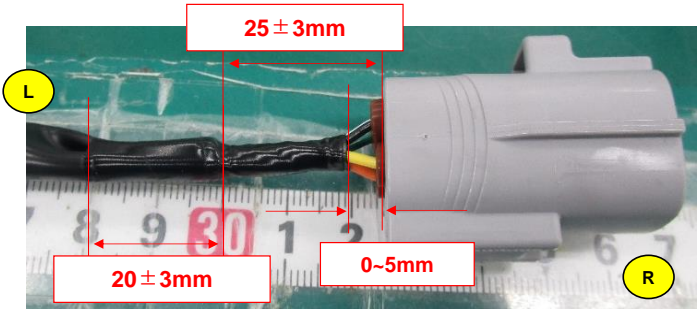

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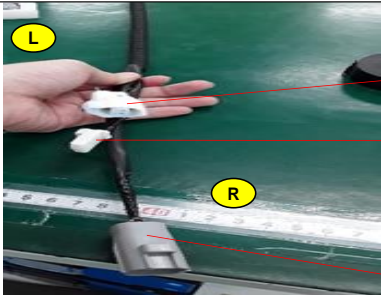

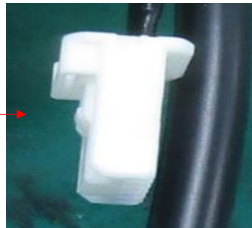
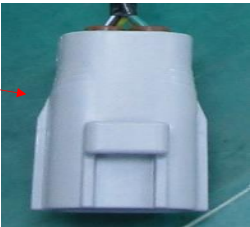
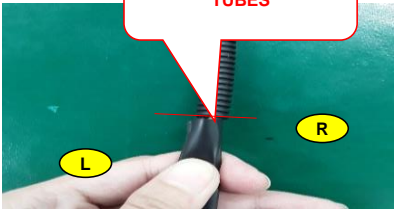
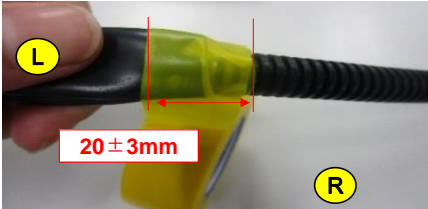
PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P3 Taping 5 SV tube (Vinyl) to wire near Connector	<div></div> <div>1. Measure from end of vinyl tube up to edge of connector 25±3mm using both hands.</div> <div></div> <div>2. Get the Black tape using right hand then start taping process using both hands.</div> <div></div> <div>3. After taping, check the measurement and taping condition.</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> <ol 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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	WORK INSTRUCTION TAPING ASSEMBLY PROCESS			Effectivity Date:	September 13, 2024		
	Process Name/Title:			Validity Date:	n/a		
	Model code/Part number:	922B / 7L0123-7022A	Customer: TRQSS	Car Model: LEXUS-NX	Document No.:	WI-ENG-PDE-1042C	
	Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO	Revision No.:	1	Page No.:	4 of 7	

PARTS: 1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
4	P3 Y-taping	<div> <p>Y-taping and Connector Facing</p>       </div> <div> <p>NO GAP IN BETWEEN TUBES</p> </div> <div> <p>1. Conduct harness facing using both hands. <i>Note: Follow the correct facing.</i></p> </div> <div> <p>2. Fix the SV tube (Vinyl) and corrugated tube. Make sure that there is no gap in between.</p> </div> <div> <p>3. Start taping at the middle of combined tubes, attach the tape on the upper tube. Then make pre-tape 2 windings. <i>Note: Do not exert excessive force during pulling & winding of tape.</i></p> </div>	<p>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>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.</p> <p>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 7. Must follow the correct facing</p>

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TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

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Customer:

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Car Model:

LEXUS-NX

Purpose:

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☐ PRE-LAUNCH

☒ MASSPRO

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PARTS:

1. Assy parts
2. Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

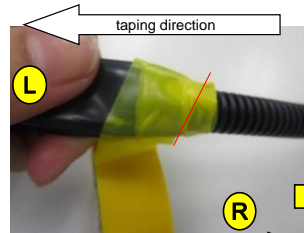
TOOLS/PPE

QUALITY POINTERS

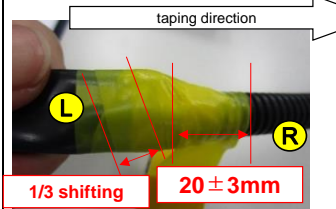
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P3

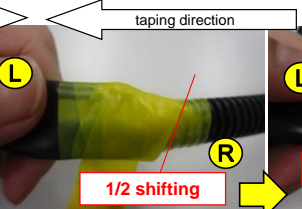
Y-taping
(Continuation)



4. Winding the tape **1/2 shifting** going to the left side. Make **2 windings**, width must be **20±3mm**.



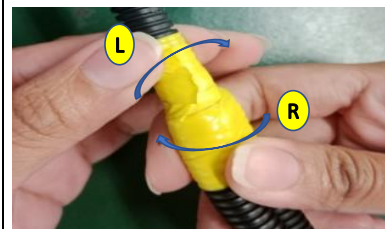
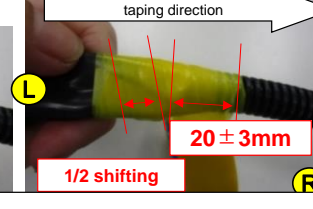
5. Winding the tape **1/3 shifting** going to the right side until reach the other side of tube. Make **2 windings**, width must be **20±3mm**.



6. Winding the tape **1/2 shifting** going to the left side. Make **2 windings**, width must be **20±3mm**.



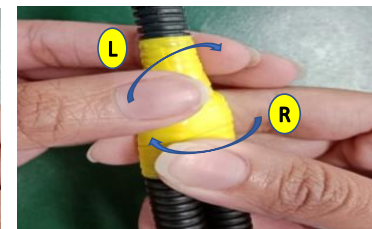
7. Winding the tape **1/2 shifting** going to the right side until it reach the other side of tube. Make **3 winds**, width must be **20±3mm**. Then cut the tape.



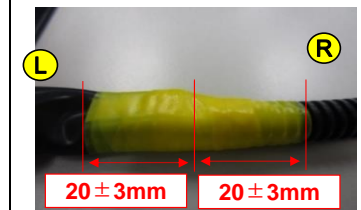
11. conduct proper pressing of end tape using left hand (**top part**)



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



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



14. Check the Measurement and condition of tape.

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.

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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Process Name/Title:

TAPING ASSEMBLY PROCESS

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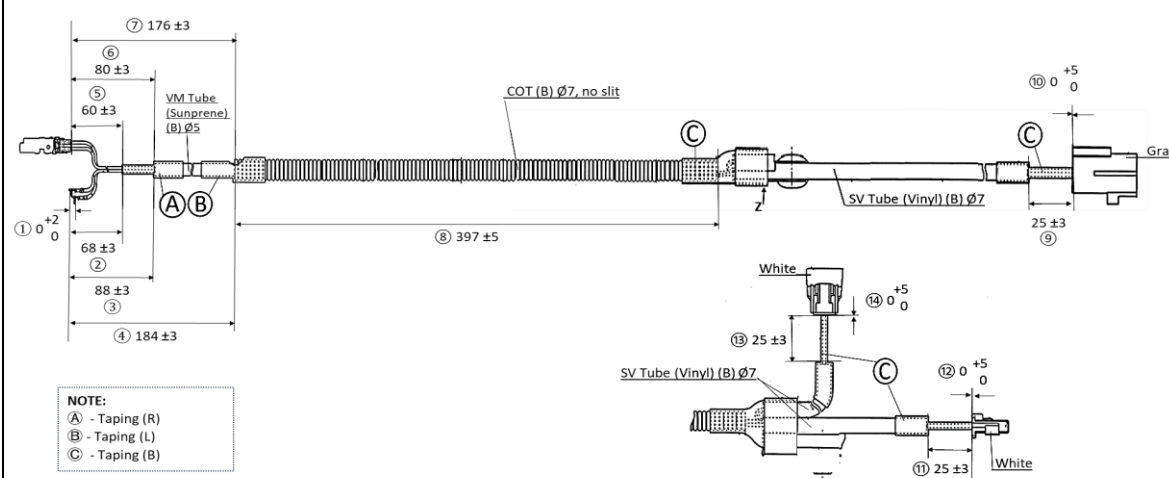

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P3	Measurement	 <p>NOTE: (A) - Taping (R) (B) - Taping (L) (C) - Taping (B)</p>	MEASURING TAPE 	Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono. Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection
					1. No wrong dimension

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PARTS:

1. Assy part

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P3****7L0123-7022A****1****2****3****No Missing tape****4****No Wrong Facing of
Connector (Y-taping)**

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