



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

September 13, 2024

Model code/Part number:

922B / 7L0124-7022A

Customer:

TRQSS

Car Model:

LEXUS NX

Document No.:

WI-ENG-PDE-1044B

Purpose:

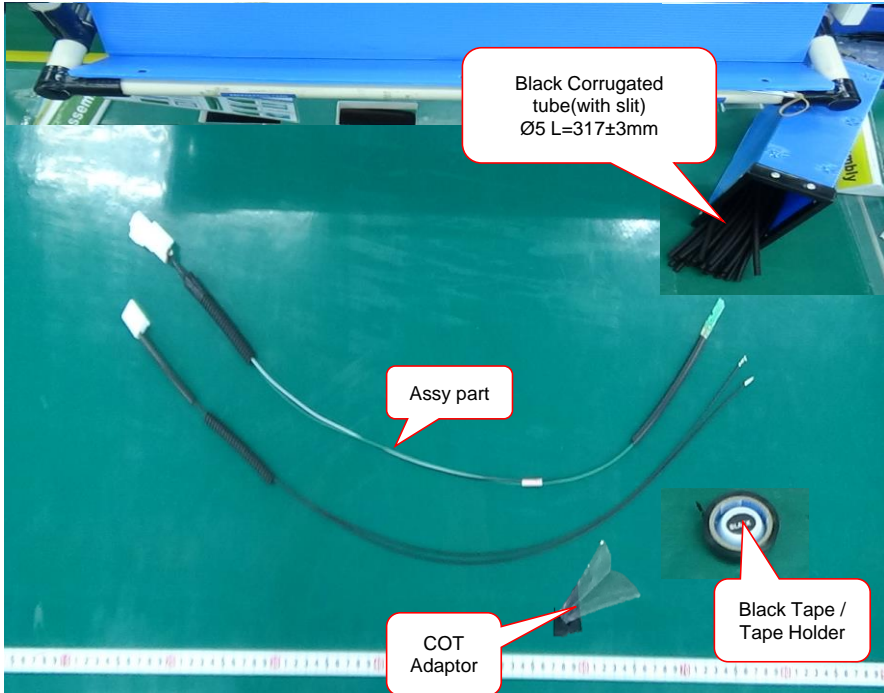
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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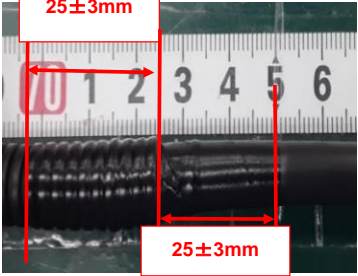

PARTS:		1. Assy parts; Black tape; Black Corrugated tube(with slit) Ø5 L=317±3mm				JIG:		1. COT Adaptor					
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS				
1	P2	Table Lay-out	<div>TABLE LAY-OUT</div>  <div>Black Corrugated tube(with slit) Ø5 L=317±3mm</div> <div>Assy part</div> <div>COT Adaptor</div> <div>Black Tape / Tape Holder</div>				<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		1. No missing parts in assy parts 2. No excess tape/tape holder				
Revision History						Prepared by		Reviewed by		Approved by		Noted by	
09/13/24	1	Change from Pre-launch to Masspro.				D.Castillo	C.Villanueva	A. Arañes	n/a				
09/10/24	0	Initial issue.				D.Castillo	C.Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	Septmeber 10, 2024		

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	Model code/Part number: 922B / 7L0124-7022A		Customer: TRQSS	Car Model: LEXUS NX	Document No.:	WI-ENG-PDE-1044B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	2 of 6


PARTS:		1. Assy parts 2. Black tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
2	P2 Taping 2 Black corrugated tube to Black SV tube (Vinyl)	<div><div></div><div></div><div></div><div><p>1. Fix the corrugated tube and SV tube (Vinyl) using both hands. Make sure no gap between corrugated tube and vinyl tube.</p><p>2. Get the Black tape and start taping process using both hands.</p><p>3. After taping, check the measurement and taping condition.</p></div></div>		<div><div>Measuring tape</div></div>	<p>Important reminders/note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. Must be no gap between COT and Vinyl tube.</p> <p>Document references:</p> <p>1. Please refer to WI-PRO-ASY-001 for taping procedure.</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</p>	

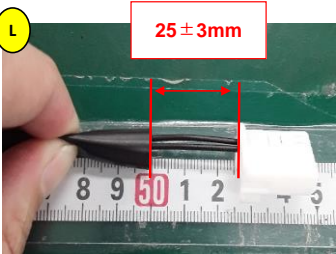

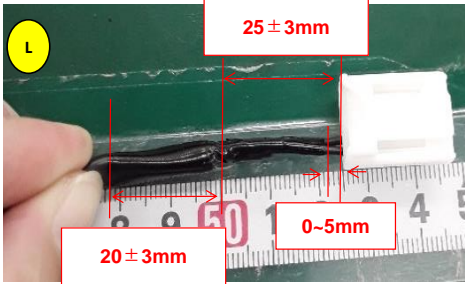

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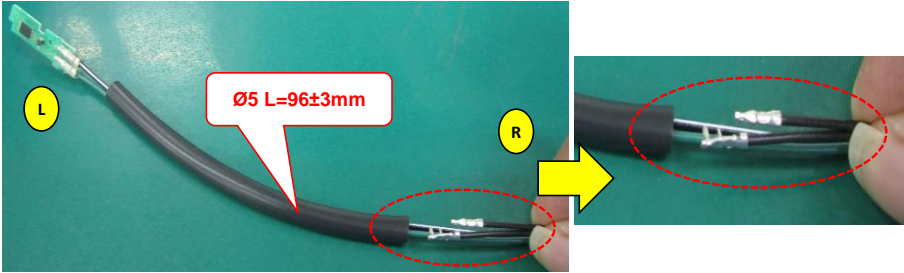
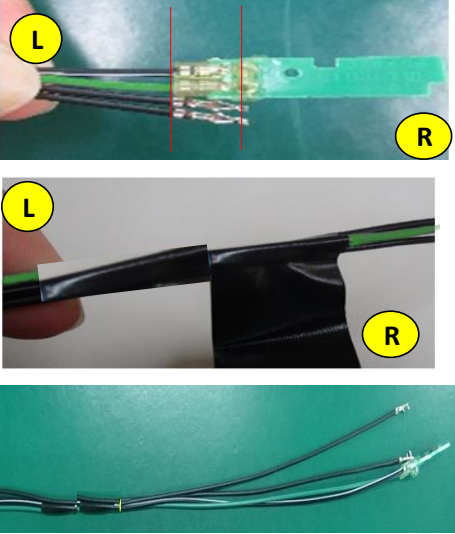
PARTS:		1. Assy parts 2. Black tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
3	P2 Taping 3 Black SV tube (Vinyl) to wire near connector	<div><div><p>1. Hold vinyl tube using left hand, measure from SV tube (Vinyl) up to end of connector 25±3mm.</p></div><div><p>2. Get Black tape using right hand, hold the SV tube (Vinyl) (ø5 L=64±3mm) using left hand then fold the SV tube (Vinyl) and start taping using right hand.</p></div><div><p>3. After taping check the measurement, wire alignment and taping condition.</p></div></div> <div><div>Measuring tape</div></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. Please refer to WI-PRO-ASY-001 for taping procedure.</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</p>		

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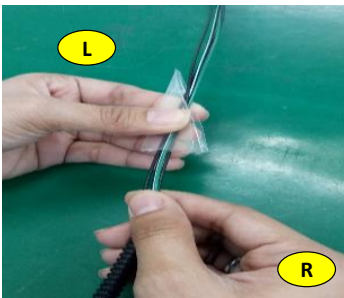
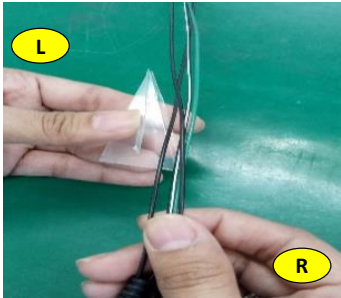
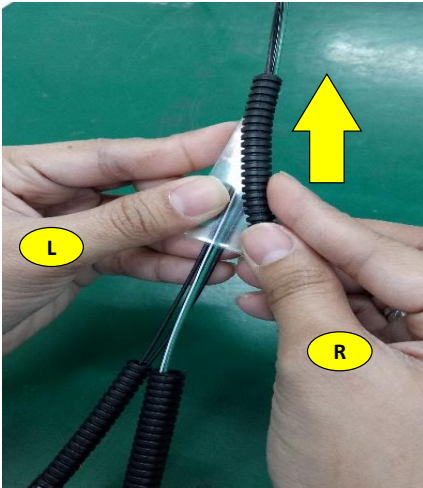

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Wire Insertion to assy parts	 <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> 1. Hold the Black VM tube (Sunprene) Ø5 L=96±3mm using left hand then continue to insert the assy parts using right hand. </div>		n/a	1. No wrong usage of parts 2. No wrong insertion
5	P2 Spot taping	 <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> 1. Fix the hotmelted wire and terminal pointed tip using both hands. </div> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> 2. Hold the wires using left hand, get the Black tape using right hand then make 2 windings of tape using both hands. <i>Note: Position of spot taping must be right beside Black tape.</i> </div> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> 3. Check the wire alignment and taping condition. </div>		n/a	1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No wrong use of tape

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PARTS:		1. Black Corrugated tube(with slit) Ø5 L=317±3mm		JIG:	1. COT Adaptor	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
6	P2 Wire insertion to Black Corrugated tube (w/slit) ø5 L=317±3mm	<div><p>1. Hold the COT adaptor using left hand. Combined the 2 assy parts and put inside the COT adaptor using right hand</p><p>2. Hold the COT adaptor with wires using left hand, get the Black Corrugated tube (w/slit) ø5 L=317±3mm using right hand and insert to COT adaptor. Pull the adaptor and push the COT (same timing) using both hands. Make sure all wires are inserted.</p></div>		<div><div>COT Adaptor</div></div>	1. No wrong use of parts 2. No wires left in between the COT with slit	

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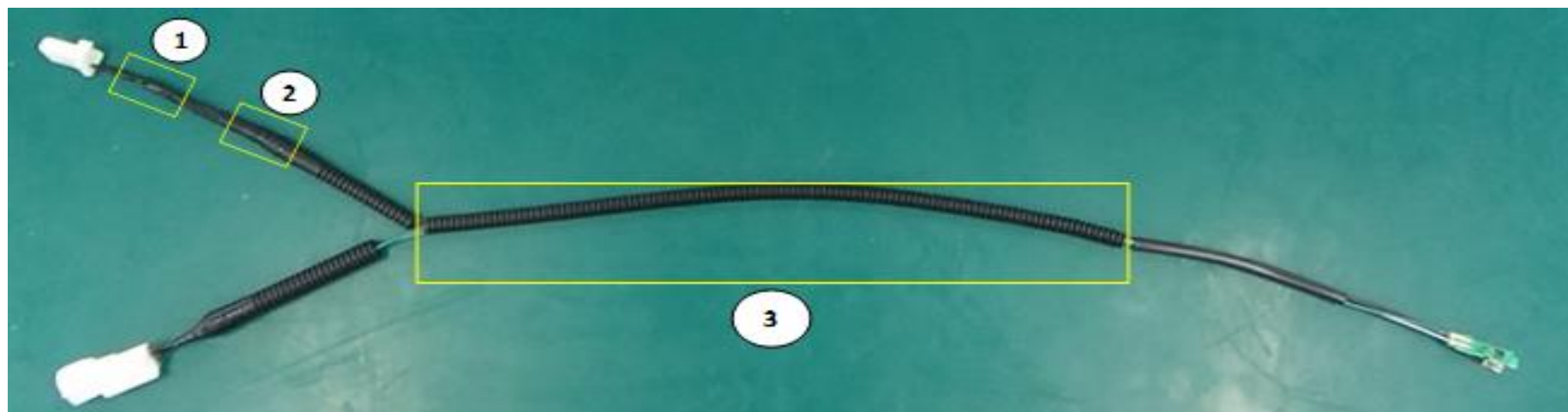
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1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P2****7L0124-7022A****1****2****No Missing Tape****3****No Missing COT (w/ slit)**

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