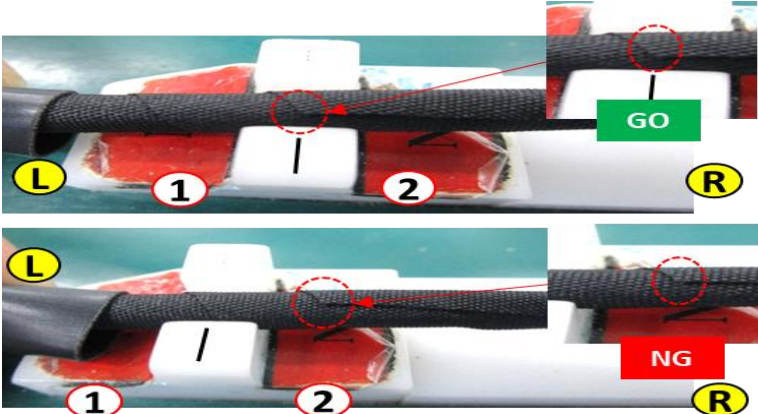


	WORK INSTRUCTION				Effectivity Date:		March 14, 2025	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 241B / 17J924-7051		Customer: TRP	Car Model: LEXUS-ES	Document No.:		WI-ENG-PDE-092F	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		17	Page No.: 1 of 7

PARTS:		1. Assy parts		JIG:	1. Measuring jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	<div style="border: 1px solid black; padding: 5px; width: fit-content; margin: 0 auto;">17</div> <div style="border: 1px solid black; padding: 5px; width: fit-content; margin: 10px auto;">HIGH</div> <div style="text-align: center;">P6 Measurement</div>	 <div style="border: 1px solid black; padding: 5px; margin-top: 10px; text-align: center;"> 1. After taping, check the END POINT TAPE using measuring jig. </div>	<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid 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 solid red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	<p>Important reminders/Note/s:</p> <p>1. END POINT TAPE should be within the limit GO. If end point tape reaches the location 1 and 2 it will be considered as NG.</p> <p>1. No wrong dimension</p>

Revision History								Prepared by	Checked by	Reviewed by	Approved by
03/14/25	17	Inclusion of Quality improvement measures (based on Mizen Boshi activity).	D.Castillo	J. Loterte	C. Villanueva	A. Arañes	 D. Castillo	 J. Loterte	 C. Villanueva	 A. Arañes	
06/24/24	16	Include Good and No good picture for reference in proper arrangement of wire to avoid bend wire and additional reminders/quality pointers. Additional Visual inspection.	D.Castillo	n/a	C. Villanueva	A. Arañes					
08/1/23	15	Update Template; Inclusion of CAR MODEL "LEXUS-ES". Transfer process of Measurement from P5 to P6 due to TPS improvement. (Refer to ENGDRR-146 for Document revision request).	M. Ariola	J. Loterte	C. Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved	Est. Date:	June 02, 2017			

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WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number: 241B / 17J924-7051

Customer: TRP

Car Model: LEXUS-ES

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

March 14, 2025

Validity Date:

n/a

Document No.:



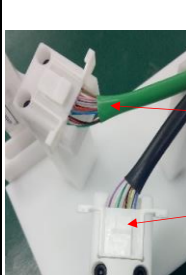
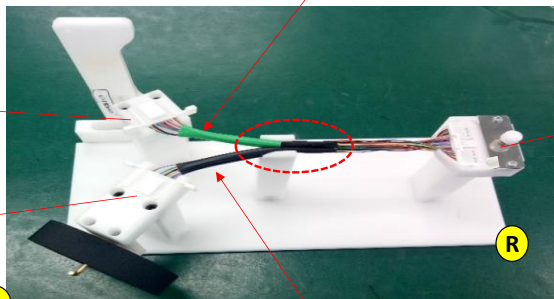
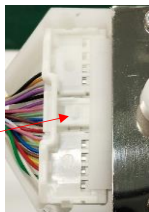

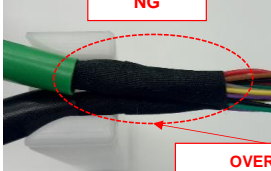
WI-ENG-PDE-092F

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PARTS:		1. Assy parts 2. Tesa tape 51036		JIG:	1. Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	<div>17</div> <div>P6</div> <div>HIGH</div> <div>Taping 3 Wire taping (Tesa)</div>	<div><div><div></div><div>BEFORE PRESSING</div></div><div><div></div><div>AFTER PRESSING</div></div></div> <div><div><div></div><div>Green VM tube (Sunprene)</div></div><div><div></div><div>Black VM tube (Sunprene)</div></div></div> <div><div><div></div><div>CONNECTOR SETTING</div></div><div><div></div><div>GOOD</div></div><div><div></div><div>NG</div><div>OVERLAP</div></div></div> <div>1. Set the connector 1827842-1 (W) then push the guide lock using right index finger.</div> <div>2. Continue to set the harness on Jig 2. (See picture for the correct setting).</div>		n/a	1. No wrong setting of harness 2. No wrong orientation of connector 3.Wires must allign properly to avoid bend wire .

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Effectivity Date:

March 14, 2025

Process Name/Title:

Model code/Part number:

241B / 17J924-7051

Customer:

TRP

Car Model:

LEXUS-ES

Document No.:

WI-ENG-PDE-092F

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

17

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PARTS:

1. Assy parts
2. Tesa tape 51036

JIG:

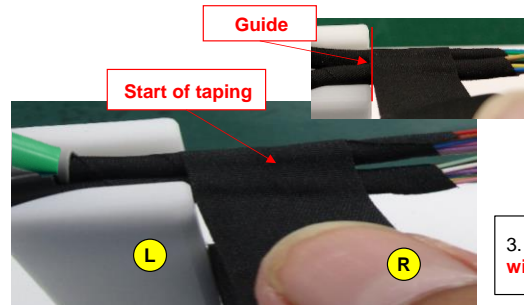
1. Taping jig

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

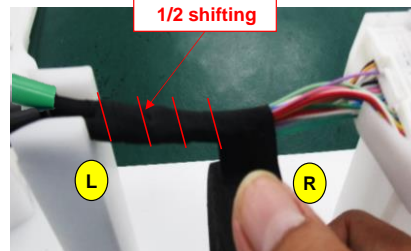
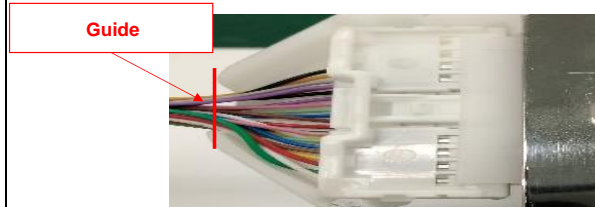
17

HIGH

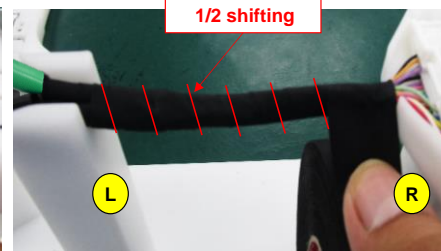
Taping 3
Wire taping (Tesa)
(Continuation)



3. Start taping using guide **1 1/2 winding.**



4. Make **1/2 shifting** or **6-7 windings** going to the right side until it reach the guide near connector.



5. Make **2 windings** of tape before cut.

1. No loose tape
2. No excessive tape winding
3. No damage on parts
4. No peel off tape
5. No bend wire
6. No NG of end tape

Important reminders/Note/s:

1. **No holding/fixing of wire during taping.**



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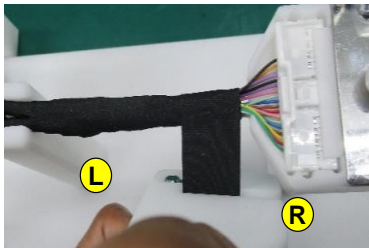
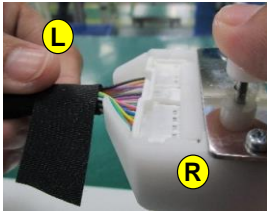
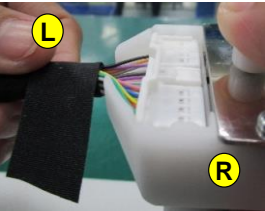


WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

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Process Name/Title: **TAPING ASSEMBLY PROCESS**

Model code/Part number: **241B / 17J924-7051** Customer: **TRP** Car Model: **LEXUS-ES**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Assy parts 2. Tesa tape 51036		JIG:	1. Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	<div>17</div> <div>P6</div> <div>HIGH</div> <div>Taping 3 Wire taping (Tesa) (Continuation)</div>	<div><div>L</div><div>R</div></div> <div>6. Cut the tape using provided cutter only using both hands.</div> <div><div>L</div><div>R</div><div>BEFORE PRESSING</div><div>L</div><div>R</div><div>AFTER PRESSING</div><div>7. Hold the assy parts then press the lock button using right thumb. Remove the harness from jig.</div></div>		<div><div>Handy cutter</div></div>	<div>1. No wrong setting of harness 2. No wrong orientation of connector</div>
		<div><div>L</div><div>R</div></div> <div>8. Press the end tape using left hand. Do not touch the adhesive</div>			

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

March 14, 2025

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

241B / 17J924-7051

Customer: TRP

Car Model:

LEXUS-ES

Document No.:

WI-ENG-PDE-092F

Purpose:

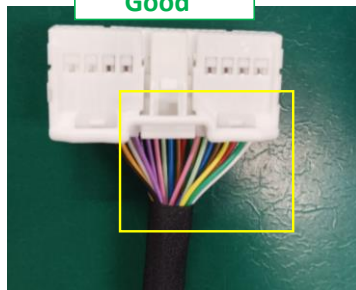
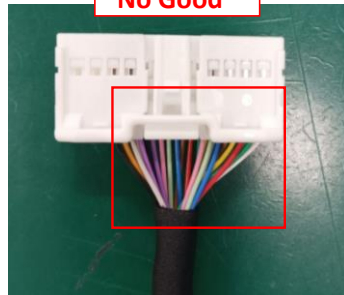

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	<div>17</div> <div>Medium</div> <div>Taping 3 Wire taping (Tesa) (Continuation)</div> <div>P6</div>	<div><div>Good</div></div> <div><div>No Good</div></div> <div></div> <div>8. After taping, check the alignment and condition of tape.</div> <div>9. Proceed to Continuity checking of a product and follow the instructions.</div> <div>10. After checking of continuity of a product, proceed to End tape pressing process and follow the instruction</div>	n/a	<div>1. No loose tape 2. No excessive tape winding 3. No damage on parts 4. No peel off tape 5. No bend Wire</div> <div>Important reminders/Note/s: 1. All wires must be properly align and not tangled to avoid bend wire . (see picture for reference) 2. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</div> <div>Document references: 1. Refer to WI-ENG-PDE-010 Continuity Testing 2. Refer to WI-ENG-PDE-001 Sub Assembly Treatment on Lever Con Continuity Checker NG if encountered any defect/NG product 3. Refer to WI-ENG-PDE-096 End tape pressing process 4. Refer to IS-QAD-QAC-005 Inspection Standard 17J796-7051</div>

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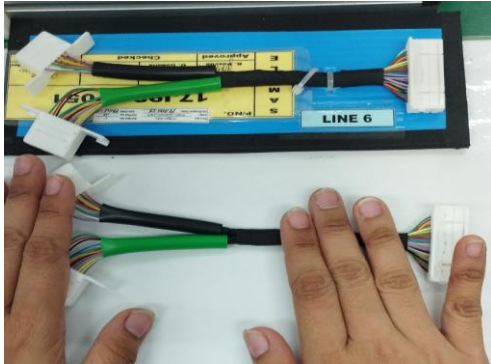
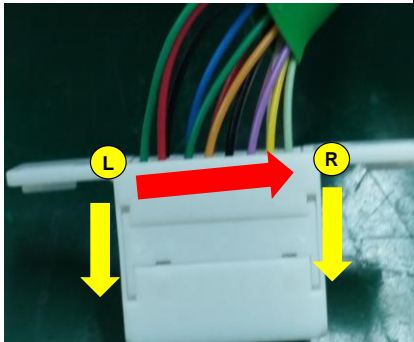
WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	March 14, 2025		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-092F		
Revision No.:	17	Page No.:	6 of 7

Process Name/Title: **TAPING ASSEMBLY PROCESS**

Model code/Part number: **241B / 17J924-7051** Customer: **TRP** Car Model: **LEXUS-ES**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	<div><div>17</div><div>Medium</div><div>P6</div><div>Visual inspection</div></div>	<div><div>1. After test of a product, compare to Master sample by tapping.</div></div> <div><div>LEGEND:</div><div><div>→ First way checking of connector lock</div><div>→ Second way checking of connector lock</div></div><div><div>GREEN VM TUBE (SUNPRENE)</div></div><div><div>2. Ensure that connector is in locked condition by slide touching the connector lock from LEFT to RIGHT using right thumb.</div><div><div>3. Ensure that connector is in locked condition by touching the LEFT SIDE of connector lock from TOP to BOTTOM using right thumb.</div><div>4. Ensure that connector is in locked condition by touching the RIGHT SIDE of connector lock from TOP to BOTTOM using right thumb.</div></div></div></div>	n/a	<div>1. No loose tape</div> <div>2. No excessive tape winding</div> <div>3. No damage on parts</div> <div>4. No peel off tape</div> <div>5. No bend wire</div> <div>6. No NG of end tape</div> <div>7. No damaged double lock</div> <div>8. No half-locked connector</div>

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**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

March 14, 2025

Validity Date:

n/a

Model code/Part number:

241B / 17J924-7051Customer: **TRP**

Car Model:

LEXUS-ES

Document No.:

WI-ENG-PDE-092F

Purpose:

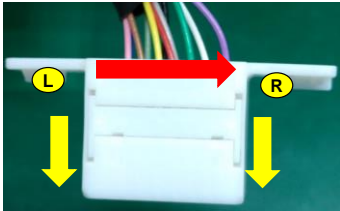




☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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Page No.:

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PARTS:	1. Assy parts				JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	P6 17 Medium Visual inspection (Continuation)	<div>LEGEND: → First way checking of connector lock → Second way checking of connector lock</div> <div>BLACK VM TUBE (SUNPRENE)</div> <div></div> <div>WAY OF CHECKING CONNECTOR LOCK</div> <div></div> <div></div> <div></div> <div>5. Ensure that connector is in locked condition by slide touching the connector lock from LEFT to RIGHT using right thumb.</div> <div>6. Ensure that connector is in locked condition by touching the LEFT SIDE of connector lock from TOP to BOTTOM using right thumb.</div> <div>7. Ensure that connector is in locked condition by touching the RIGHT SIDE of connector lock from TOP to BOTTOM using right thumb.</div> <div>8. Ensure that connector is in locked condition by slide touching the connector lock from left to right sing right thumb based on the sequence illustrated.</div> <div></div> <div>9. Check the taping condition, must be no exposed end tape inside.</div>			n/a	1. No loose tape 2. No excessive tape winding 3. No damage on parts 4. No peel off tape 5. No bend wire 6. No NG of end tape 7. No damaged double lock 8. No half-locked connector

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