



## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

June 11, 2024

Process Name/Title:

Validity Date:

-

Model code/Part number: 900B/910B / 7N0070-7020C

Customer: TRJ

Car Model: LEXUS-NX/RX

Document No.:

WI-ENG-PDE-460C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

1 of 4

## PARTS:

1. Assy parts; Black tape

JIG:

n/a

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

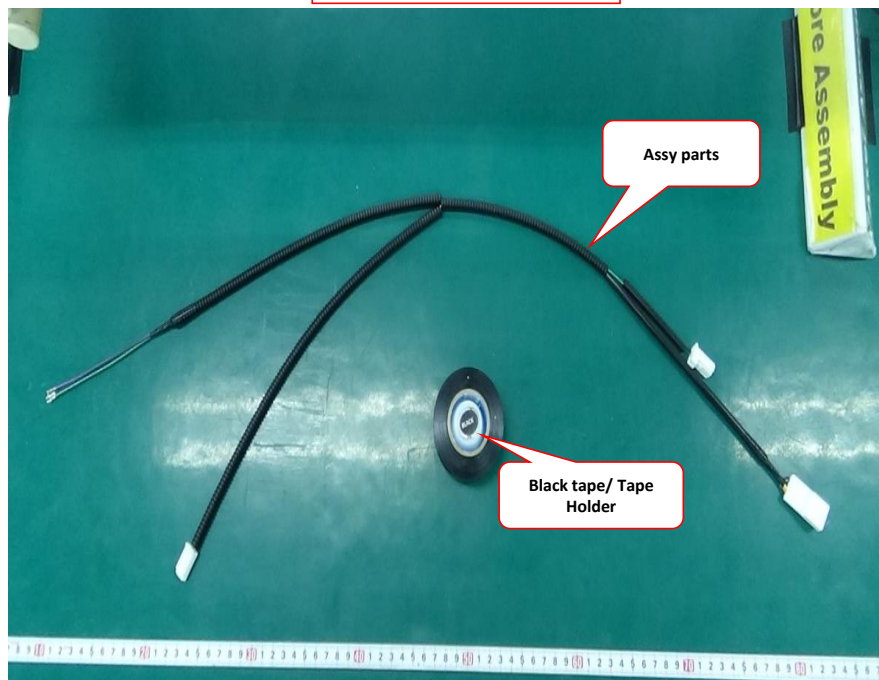
QUALITY POINTERS

1

P3

Table Lay-out

## TABLE LAY-OUT



## Safety Instruction

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

## Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

## Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. No missing parts/tools.
2. No excess parts/tools.

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	Prepared by	Reviewed by	Approved by	Noted by
06/11/24	1	Change MP from 4 To 5 MP (With Offline); Transferred process of Taping 1 Black SV tube (Vinyl) to wire near connector from P2 to P3; Remove process of Y-taping 2 then transferred to P4 due to new process distribution. Change table lay-out Illustration.	M. Ariola	C. Villanueva	A. Arañes	n/a					
08/15/23	0	Initial Issue. Change MP from 2MP to 3MP. Transfer process of Taping SV tube (Vinyl) to wire near connector from P1 to P3; Transferred process of Y-taping 1&2 from P2 to P3 due to change process distribution. Inclusion of Quality checkpoints on page no.5; Change table lay-out; Standardized tube description: SV tube (Viny).	M. Ariola	J. Loterte	C. Villanueva	A. Arañes					n/a

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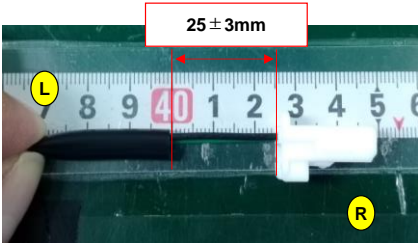
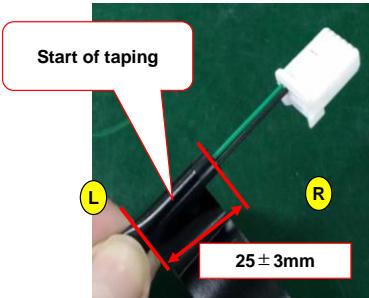
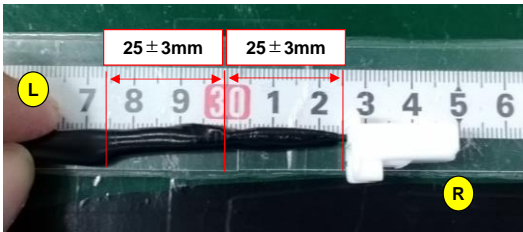

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
2	P3 Taping 1 Black SV tube (Vinyl) to wire near connector	<div><p>25 ± 3mm</p></div> <div><p>Start of taping</p><p>25 ± 3mm</p></div> <div><p>25 ± 3mm 25 ± 3mm</p></div> <div><p>1. Measure from end of SV tube (Vinyl) up to edge of connector <b>25±3mm</b> using both hands.</p><p>2. Hold the SV tube (Vinyl) using left hand, get the <b>Black tape</b> using right hand then start taping process using both hands. <b>(With folding)</b></p><p>3. After taping, check the measurement and taping condition.</p></div>	<div>MEASURING TAPE</div> 	<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> <p><b>Important reminders/Note/s:</b></p> <p><b>1. Please use calibrated/ verified measuring tape when getting the measurement.</b></p>	

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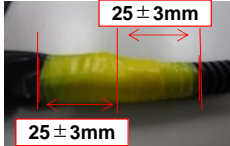
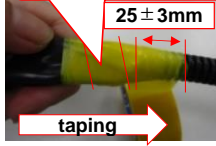
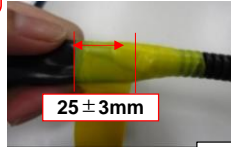






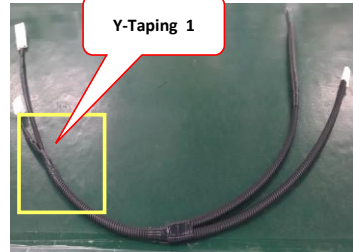
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PARTS:		1. Assy parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P3	Y-Taping 1	<div></div> <p>1. Fix the two SV tube (Vinyl) and COT using both hands. <i>See illustration for correct facing of connector.</i></p> <p>2. Hold two SV tube (Vinyl) using left hand and fix to COT. Make 1 winding for pre-tape before shifting then wind the tape down to vinyl tube until <b>25±3mm</b>.</p> <p>3. From SV tube (Vinyl) , make 1/3 shifting to COT until <b>25±3mm</b>. Wind the tape 1 time before shifting.</p> <p>4. From COT, wind the tape down to SV tube (Vinyl) (1/2 shifting) until <b>25±3mm</b>.</p> <p>5. From SV tube (Vinyl) , wind the tape (1/2 shifting) going to side of corrugated tube then cut the tape after 2 windings. After taping, check the condition of tape. <b>Note : Taping must be tape width 25±3mm.</b></p>	<p>MEASURING TAPE</p>  <p>Y-TAPING ORIENTATION</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> <p><b>Important reminders/Note/s:</b></p> <p>1. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines, But actual should <b>BLACK TAPE</b>. 2. Please use calibrated/verified measuring tape when getting the measurement.</p> 

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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION / QUALITY CHECKPOINTS****P3****7N0070-7020C****① ② No Missing Tape**

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