
	WORK INSTRUCTION			Effectivity Date:	October 21, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 240B / 7M0514-7021B	Customer: TRJ	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-1125B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	1 of 3


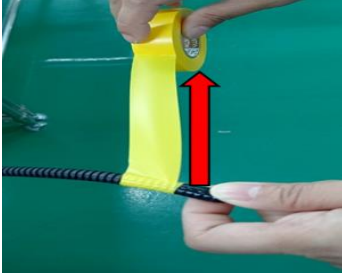




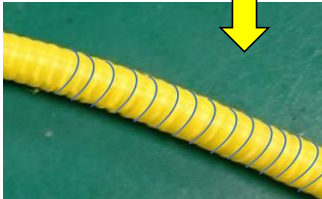
PARTS:		1. Assy parts; Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P2	Table lay-out		<div><div>Safety Instruction</div><div>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div></div> <div><div>Housekeeping</div><div>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div></div> <div><div>Alert level</div><div>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>	1. No missing parts/tools 2. No excess parts/tools

Revision History							Prepared by	Reviewed by	Approved by	Noted by
10/21/24	1	Change from Pre-launch to Masspro.			D.Castillo	C. Villanueva	A. Arañes	n/a		
10/17/24	0	Initial issue. Transfer wire insertion to VM tube and Taping 2 to P3 due to process improvement.			D.Castillo	C. Villanueva	A. Arañes	n/a		
Eff. Date	Rev. No	Details of Change			Revised	Reviewed	Approved	Noted	Est. Date:	October 17, 2024

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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	P2 Half-wrap taping	<div><p>1. Attach the tape, then make 2 windings.</p></div> <div><p>2. Pull the tape around 150mm~200mm.</p></div> <div><p>3. Hold the other side of the harness on the table and apply force to rotate the tape to make halfwrap shifting until cover the COT with slit.s</p></div> <div><p>4. Make 2 windings before cut the tape.</p></div> <div><p>5. After taping, check the condition of tape. THERE MUST BE NO EXPOSED COT BETWEEN HALF WRAP TAPING.</p></div> <div><p>6. Conduct 3x pressing at the end of Taping to prevent peel off and loose tape using left thumb.</p></div> <div><p>Appearance after Taping</p></div>				<p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>Important reminders/Note/s:</p> <p>1. Use <u>Yellow tape</u> for easy visualization of tape shifting, but actual should be <u>BLACK TAPE</u>.</p> <p>2. Internal tolerance for halfwrap taping shifting should be 0~14mm only.</p> <p>1. No loose/tight tape 2. No flip-out tape 3. No peel-off tape 4. No exposed COT between tape windings</p>

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Model code/Part number: **240B / 7M0514-7021B**Customer: **TRJ**Car Model: **LEXUS-ES**

Document No.:

WI-ENG-PDE-1125BPurpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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1

Page No.:

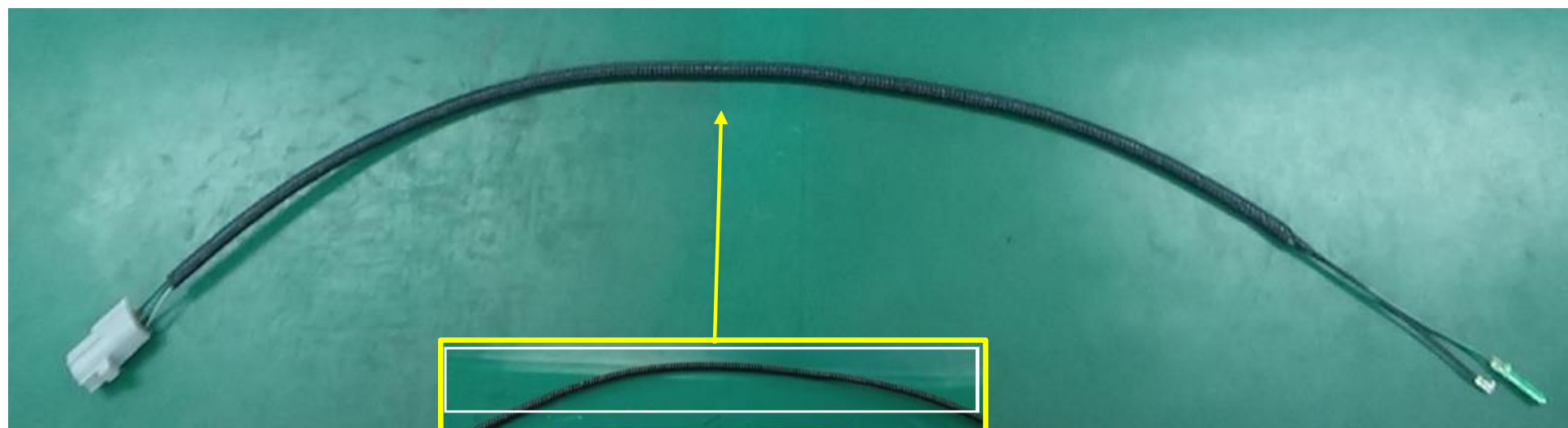
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P2****7M0514-7021B****1****FULL TAPING MUST BE
HALF WRAP (NO
EXPOSE COT)**

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