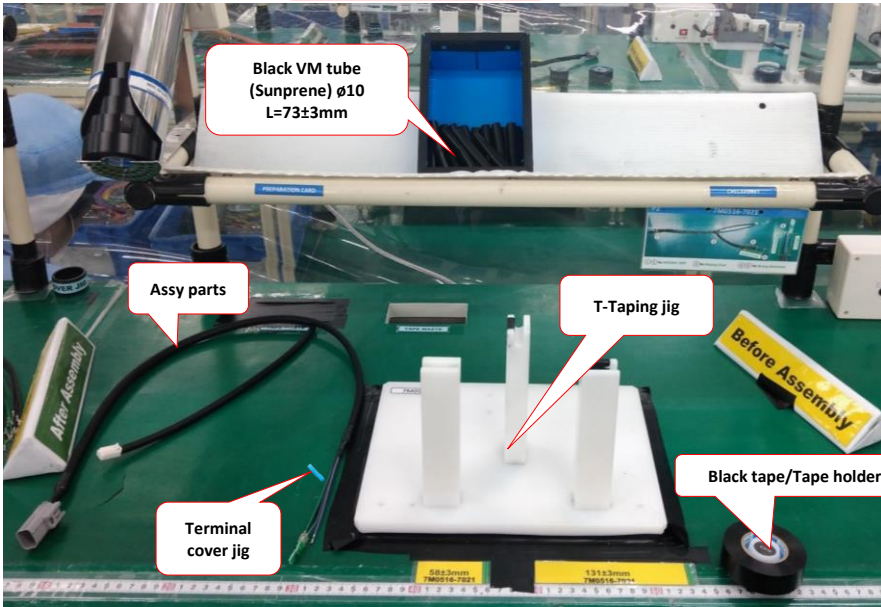
	WORK INSTRUCTION				Effectivity Date:	October 22, 2024			
	TAPING ASSEMBLY PROCESS				Validity Date:	n/a			
	Process Name/Title:		Model code/Part number: 240B / 7M0516-7021B	Customer: TRJ	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-1091C		
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	1	Page No.:	1 of 10

PARTS:		1. Assy part; Black VM tube (Sunprene) ø10 L=73±3mm; Black tape [2pcs.]		JIG:	1. Terminal cover jig 2. T-Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P3	Table Lay-out	<div><div>TABLE LAY-OUT</div></div>	<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></div>	1. No missing parts/tools 2. No excess parts/tools

Revision History								Prepared by	Reviewed by	Approved by	Noted by
10/22/24	1	Change from Pre-launch to Masspro. Update the Illustration of Visual Inspections/Quality checkpoints				M. Ariola	C. Villanueva	A. Arañes	n/a		
10/17/24	0	Initial issue.				M. Ariola	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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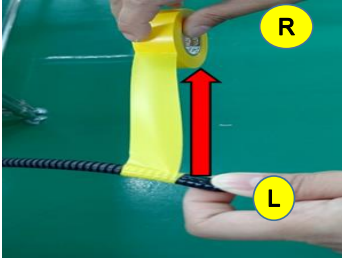
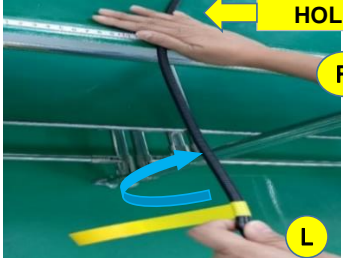


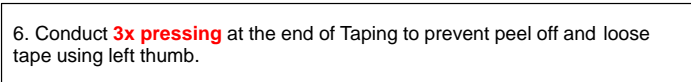

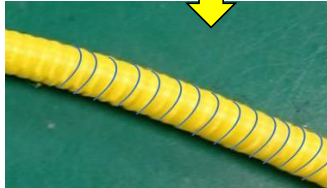
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PARTS:	1. Black tape 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3 Taping 1 Half wrap taping	<div><p>1. Attach the tape, then make 2 windings.</p></div> <div><p>2. Pull the tape around 150mm~200mm.</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>internal tolerance 0~14mm</p></div> <div><p>Appearance after Taping</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. Internal tolerance for halfwrap taping shifting should be 0~14mm only.</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

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Purpose:



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PRE-LAUNCH







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PARTS:		1. Black tape 2. Black VM tube (Sunprene) $\varnothing 10$ L=73 \pm 3mm		3. Assy parts	JIG:	1. Terminal cover jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P3	Wire insertion to VM tube (Sunprene) $\varnothing 10$ L=73 \pm 3mm	<div><p>1. Hold the wires using left hand and insert the terminal cover jig using right hand.</p></div>		<div><div>TERMINAL COVER JIG</div></div>	1. No wrong use of parts 2. No wrong insertion to assy 3. No deformed terminal
			<div><p>2. Hold the wires using left hand and insert the sunprene tube $\varnothing 10$ L=73\pm3mm using right hand.</p></div>			
			<div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div>			

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PARTS:		1. Black tape 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P3 Taping 2 Corrugated tube to VM tube (Sunprene)	<div><div><div>L</div><div>58±3mm</div><div>62±3mm</div></div><div>1. Hold the assy parts using left hand and measure from end of VM tube (Sunprene) up to hotmelt 58±3mm, VM tube (Sunprene) up to terminal tip 62±3mm using both hands.</div></div> <div><div><div>L</div><div>R</div></div><div>2. Hold the assy parts using left hand and begin taping using both hands.</div></div> <div><div><div>131±3mm, end of VM tube (Sunprene) to PCB</div><div>58±3mm</div><div>tape width</div><div>62±3mm</div></div><div>3. After taping, check the dimension, terminal appearance and taping condition.</div></div>		<div>MEASURING TAPE</div> <div></div>	<div>Important reminders/Note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>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</div>

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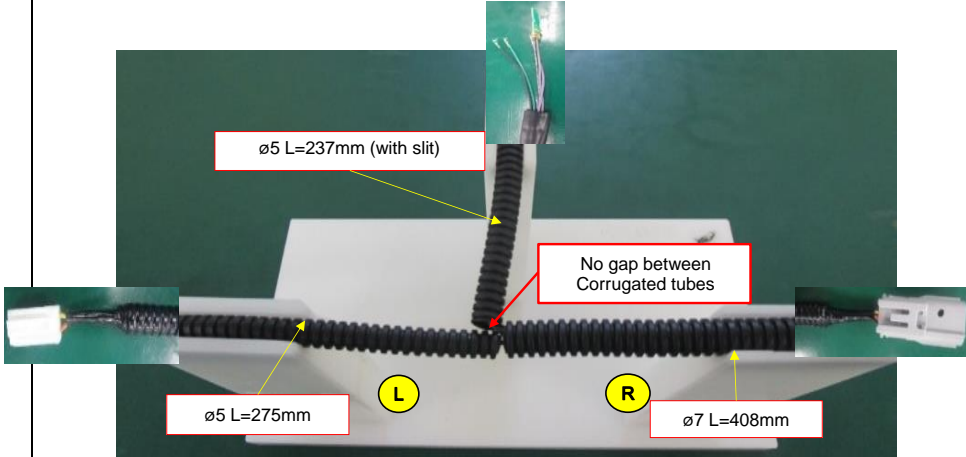
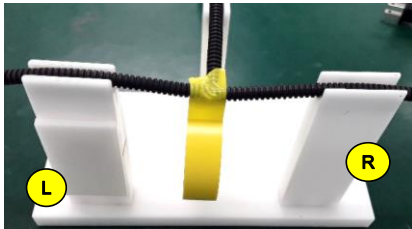

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PARTS:	1. Black tape 2 Assy parts			JIG:	1. T-Taping jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
5	P3	T-Taping	<div></div> <div>1. Arrange the 3 corrugated tube to form inverted T using left and right hand.</div> <div></div> <div>2. Start taping at the middle to fix the 3 corrugated tubes using both hands.</div> <div></div> <div>3. Wind the tape from front to back at the right side.</div>			n/a	<p>Important reminders/Note/s:</p> <p>1. Use <u>YELLOW TAPE</u> for easy visualization of shifting lines, but actual should be <u>BLACK TAPE</u>.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No gap between the COT 5. No exposed wire</p>

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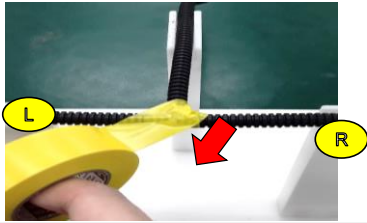

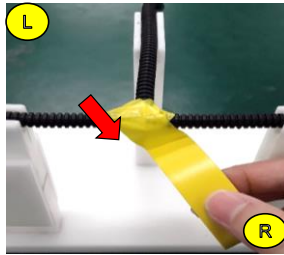
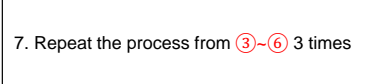
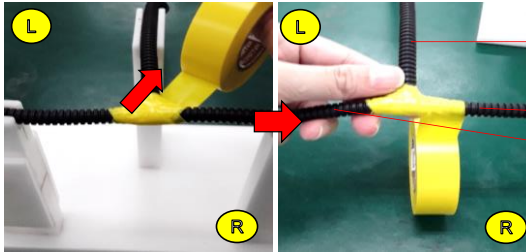

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PARTS:		1. Black tape 2. Assy parts		JIG:	1. T-Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P3 T-Taping (continuation)	<div><div></div><div>4. Wind the tape from back to front (cross pattern)</div><div></div><div>5. Wind the tape from front to back at the left side</div><div></div><div>6. Wind the tape from back to front (cross pattern)</div><div></div><div>7. Repeat the process from ③~⑥ 3 times</div><div><div></div><div>8. Remove the harness for T-taping jig then tape the right side corrugated tube (3 winds), width must be same as tape (19mm)</div></div></div>		<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s:</p> <p>1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No gap between the COT 5. No exposed wire</p>

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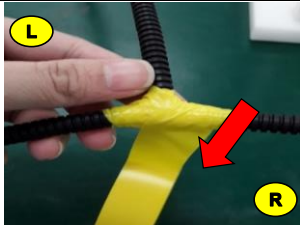
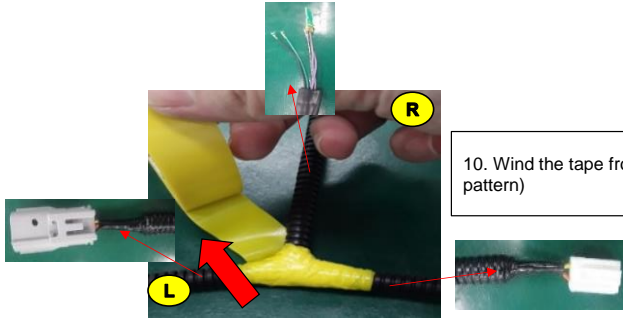
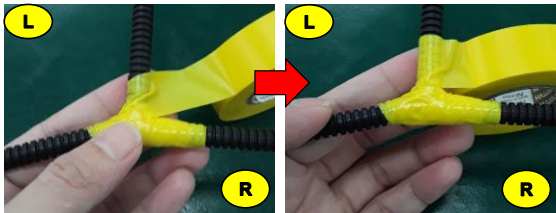
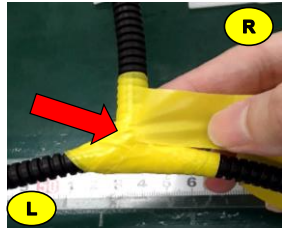

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PARTS:		1. Black tape 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P3 T-Taping (continuation)	<div></div> <div></div> <div></div> <div></div> <div>9. From the right side, wind the tape 2/3 shifting going to center</div> <div>10. Wind the tape from front to back side (cross pattern)</div> <div>11. Tape the top side corrugated tube (3 winds), width must be same as tape (19mm)</div> <div>12. From the top side, wind the tape 2/3 shifting going to center</div>		<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s:</p> <ol style="list-style-type: none">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. <ol style="list-style-type: none">1. No peel-off tape2. No flip out tape3. No loose tape4. No gap between the COT5. No exposed wire

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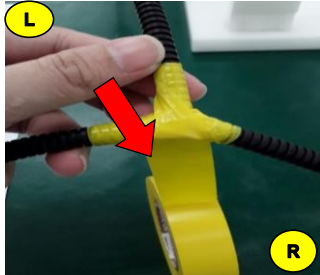
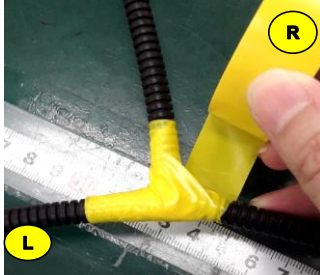
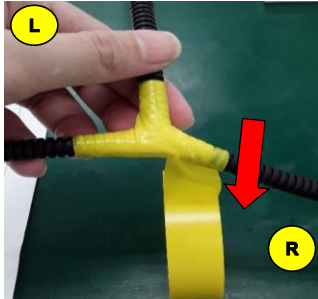
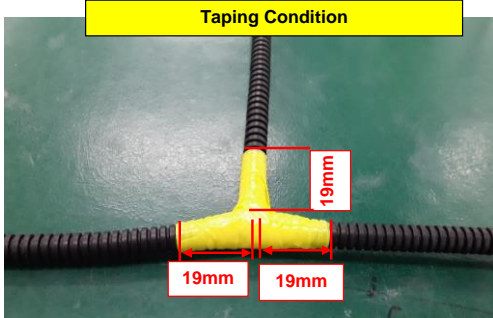

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PARTS:		1. Black tape 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P3 T-Taping (continuation)	<div><div><p>13. Wind the tape going to front side(cross pattern)</p></div><div><p>14. Wind the tape from front to back side (cross pattern)</p></div><div><p>15. Tape the right side corrugated tube (3 winds), width must be same as tape (19mm)</p></div><div><div><p>16. After taping, check the measurement and condition of tape.</p></div></div></div>		<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s:</p> <p>1. Use <u>YELLOW TAPE</u> for easy visualization of shifting lines, but actual should be <u>BLACK TAPE</u>.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No gap between the COT 5. No exposed wire</p>

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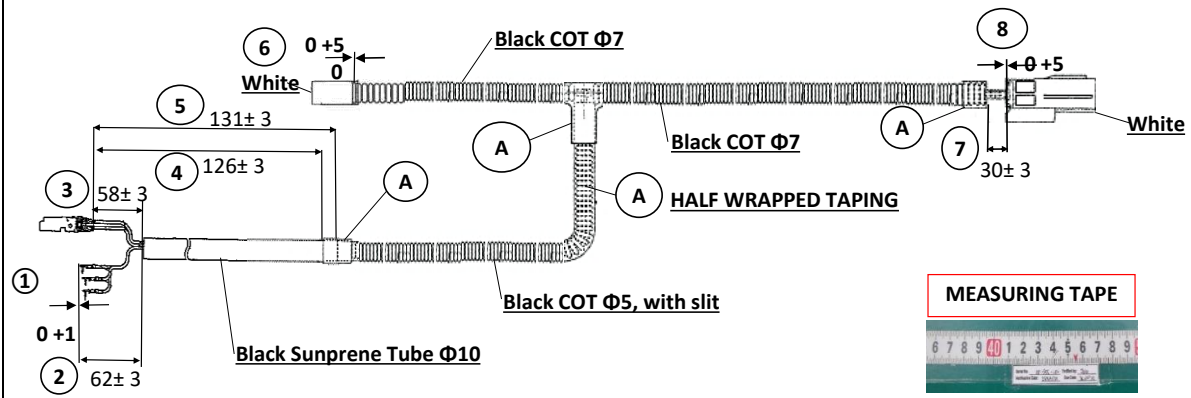

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PARTS:		n/a		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P3	Measurement	 <p>① 0+1 ② 62±3 ③ 58±3 ④ 126±3 ⑤ 131±3 ⑥ 0+5 ⑦ 30±3 ⑧ 0+5</p> <p>White</p> <p>Black COT Φ7</p> <p>Black COT Φ7</p> <p>HALF WRAPPED TAPING</p> <p>Black COT Φ5, with slit</p> <p>Black Sunprene Tube Φ10</p> <p>MEASURING TAPE</p>		<ol style="list-style-type: none">1. No peel-off tape2. No flip out tape3. No loose tape4. No gap between the COT5. No exposed wire

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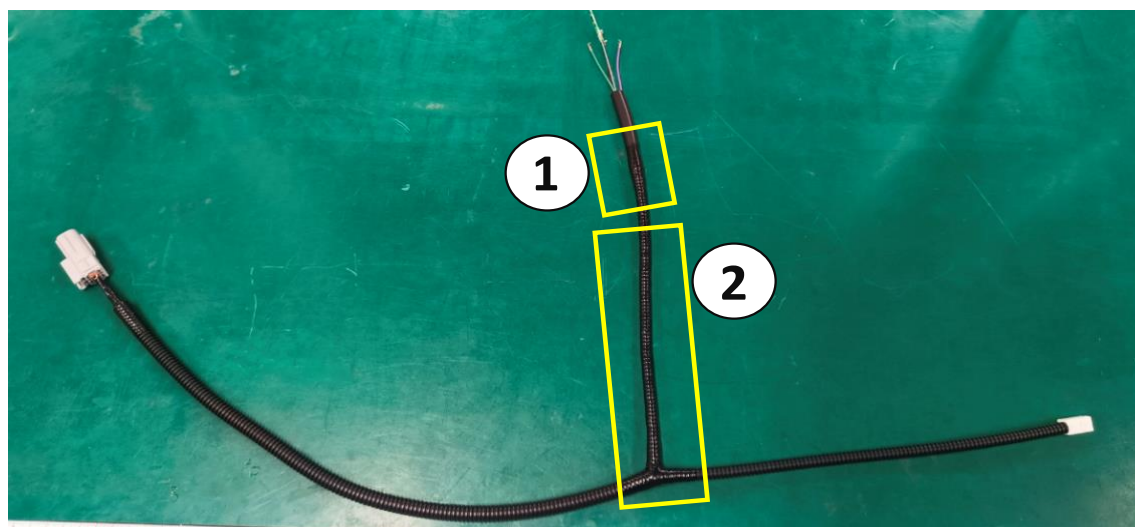
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PARTS:

JIG:

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P3****7M0516-7021B**

- ① **No Missing Tape (COT to VM tube (Sunprene))**
- ② **No Missing Tape (Half-wrap taping)**
- ③ **No Wrong facing of T-taping**

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