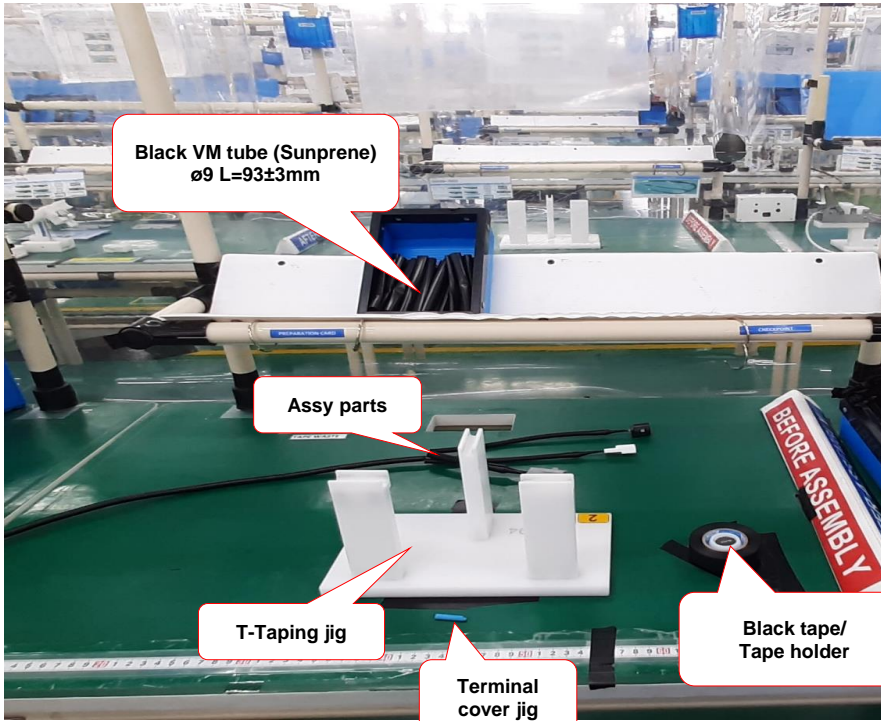



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	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 100B / 7M0594-7021		Customer: TRJ	Car Model: LEXUS US	Document No.:		WI-ENG-PDE-425C	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		3	Page No.: 1 of 10


PARTS:	1. Assy parts; Black VM tube (Sunprene) ø9 L=93±3mm			JIG:	1. T-Taping jig 2. Terminal cover jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
1	P3	Table Lay-out	<div>TABLE LAYOUT</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/tools 2. No excess parts/tools		

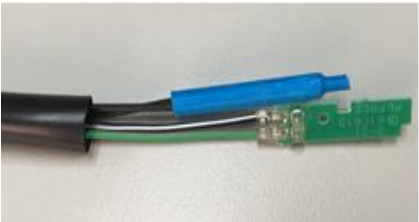
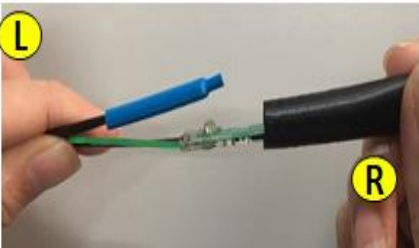


Revision History								Prepared by	Reviewed by	Approved by	Noted by		
07/10/24	3	Inclusion of Measurement. Change tape width to value (20±3mm).				D.Castillo	C.Villanueva	A. Arañes	N/A	 D. Castillo	 C.Villanueva	 A. Arañes	N/A
09/07/23	2	Update template and inclusion of Car model.				A.Hernandez	J. Loterte	C. Villanueva	A. Arañes				
12/17/22	1	Improve quality pointers: Reminders/notes and references. Inclusion of Quality checkpoints				M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted				
								Est. Date:	February 24, 2022				

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	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>100B / 7M0594-7021</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS US</b>	Document No.: <b>WI-ENG-PDE-425C</b>		
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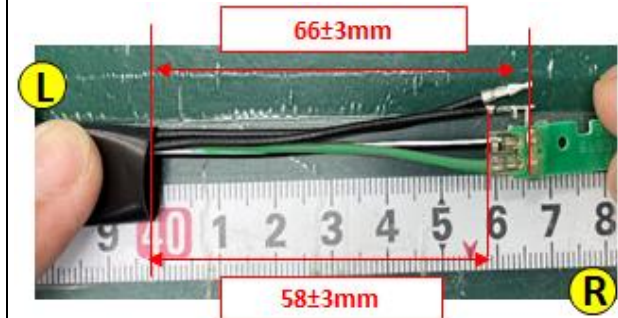

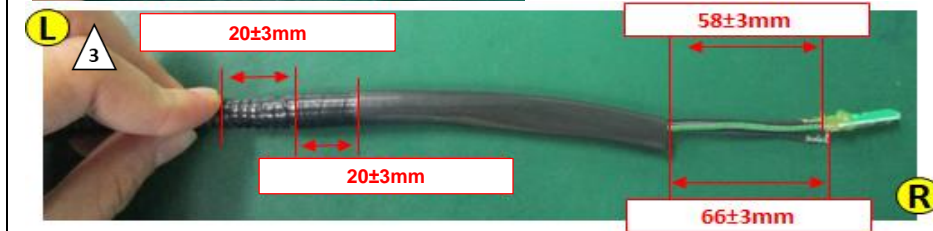

<b>PARTS:</b>		1. Assy parts 2. Black VM tube (Sunprene) ø9 L=93±3mm		JIG:	1. Terminal cover jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
2	P3  Wire insertion to Black VM tube (Sunprene) ø9 L=93±3mm	<div></div> <div>1. Get the terminal cover jig using right hand then insert the terminal <b>B-B wires</b> using left hand.</div> <div>2. Hold the Black Sunprene tube <b>ø9 L=93±3mm</b> using right hand then Insert first the <b>hotmelted wires</b> and then next the <b>B-B wires</b> with cover jig using left hand.</div> <div>3. After insertion, remove the terminal cover jig using right hand.</div>	<div><b>TERMINAL COVER JIG</b></div> 	1. No wrong use of parts 2. No deformed terminal	

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	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Process Name/Title:			Document No.:	WI-ENG-PDE-425C		
	Model code/Part number: 100B / 7M0594-7021		Customer: TRJ	Car Model: LEXUS US	Revision No.: 3		
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Page No.:	3 of 10		


PARTS:		1. Assy parts 2. Black tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
3	P3  Taping 5 BlackVM tube (Sunprene) to Black COT tube	<div><div>1. Measure from end of the sunprene tube up to the edge of hotmelt 58±3mm and sunprene tube up to terminal tip 66±3mm.</div></div> <div><div>2. Hold the sunprene tube using left hand then start taping using right hand. <i>Note: Refer to WI-PRO-ASY-001 for taping procedure</i></div></div> <div><div>3. After taping, check the dimension, terminal appearance and taping condition.</div></div>		<div>MEASURING TAPE</div> 	<p><b>Important reminders/Note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</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>	



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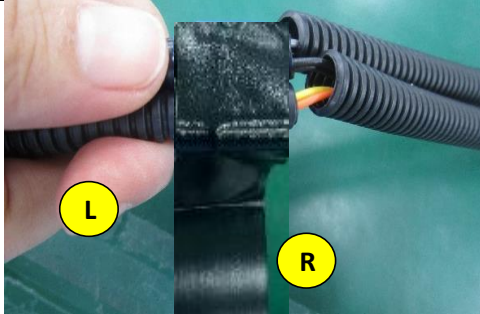
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	Process Name/Title:		Model code/Part number: <b>100B / 7M0594-7021</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS US</b>		Document No.: <b>WI-ENG-PDE-425C</b>
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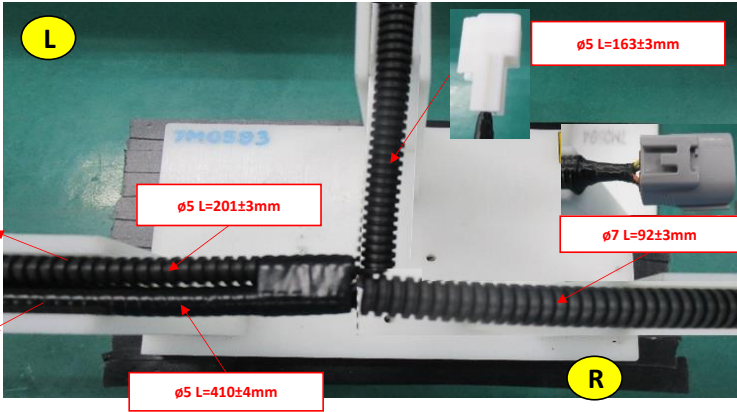

<b>PARTS:</b>		1. Assy parts 2. Black tape		<b>JIG:</b>		1. T-Taping jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>		<b>QUALITY POINTERS</b>	
4	P3	T- Taping		<div>T-TAPING JIG</div> 		<div>1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. No wrong facing of assy parts</div>	







1. Align both COT ø5. (*Follow the correct orientation of connector*). Tape 2 winds using black tape then cut the tape.




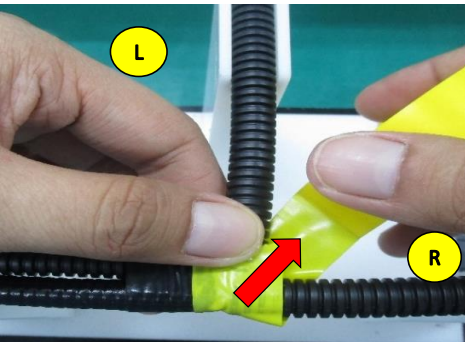
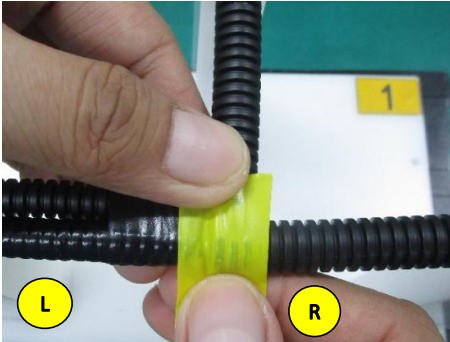
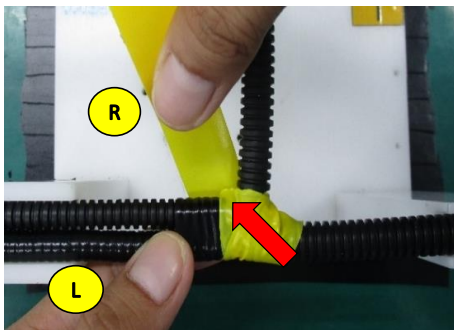
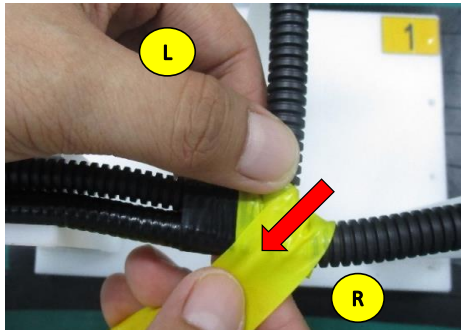

2. Arrange the 4 corrugated tube to form **inverted T** into jig using left and right hand.

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	Model code/Part number: <b>100B / 7M0594-7021</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS US</b>	Document No.:		<b>WI-ENG-PDE-425C</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		3	Page No.: 5 of 10

<b>PARTS:</b>		1. Assy parts 2. Black tape		<b>JIG:</b>		1. T-Taping jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>		<b>QUALITY POINTERS</b>	
4	P3  T-taping (Continuation)	<div> <div>3. Start taping at the middle to fix the 4 corrugated tubes using right hand.</div><div>4. Wind the tape from front to back at the right side</div></div> <div> <div>5. Wind the tape from back to front (<b>cross pattern</b>)</div><div>6. Wind the tape from front to back at the left side</div></div>		<div><b>T-TAPING JIG</b></div> 		<p><b>Important reminders/Note/s:</b></p> <p>1. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines, but actual should be <b>BLACK TAPE</b>.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. No wrong dimension</p>	

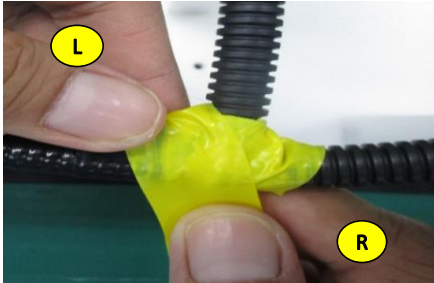
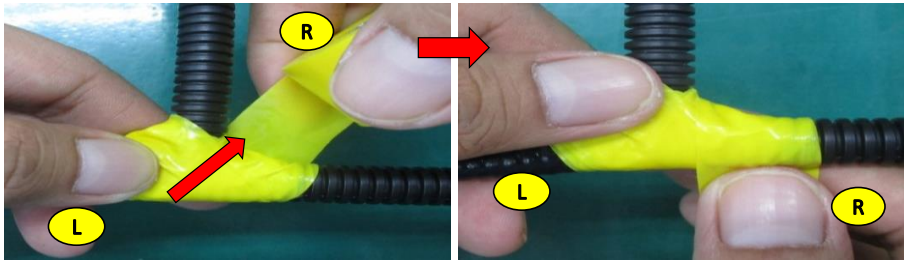
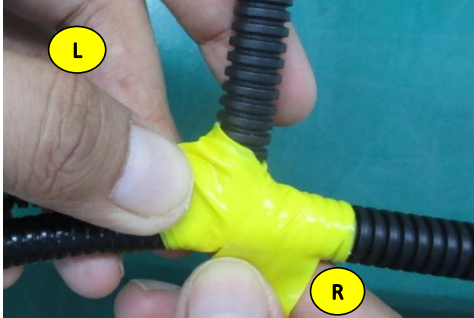
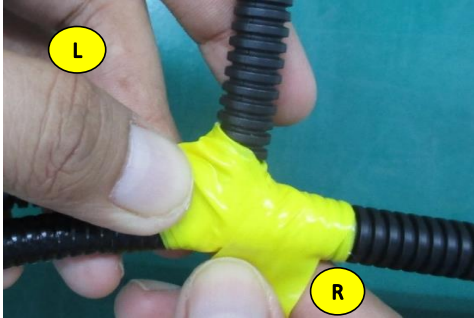
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	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	<b>n/a</b>					
	Process Name/Title:		<b>100B / 7M0594-7021</b>		Customer:	<b>TRJ</b>	Car Model:	<b>LEXUS US</b>			
	Model code/Part number:		<b>100B / 7M0594-7021</b>		Document No.:	<b>WI-ENG-PDE-425C</b>					
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<b>PARTS:</b>		1. Assy parts 2. Black tape		JIG:	1. T-Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P3 T-taping (Continuation)	<div>  <p>7. Wind the tape from back to front (<b>cross pattern</b>)</p> </div> <div>  <p>8. Repeat the process from <b>4-6</b>, 3 times then remove from jig.</p> </div> <div>  <p>9. Tape the right side corrugated tube (<b>3 winds</b>), width must be same as tape (<b>20±3mm</b>)</p> </div> <div>  <p>10. From the right side, wind the tape <b>2/3 shifting</b> going to center</p> </div>		N/A	<b>Important reminders/Note/s:</b> <b>1. Use <u>YELLOW TAPE</u> for easy visualization of shifting lines, but actual should be <u>BLACK TAPE</u>.</b> <b>2. Please use calibrated/verified measuring tape when getting the measurement.</b>  1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. No wrong dimension

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Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

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Validity Date:

n/a

Model code/Part number:

**100B / 7M0594-7021**

Customer:

**TRJ**

Car Model:

**LEXUS US**

Document No.:

**WI-ENG-PDE-425C**

Purpose:

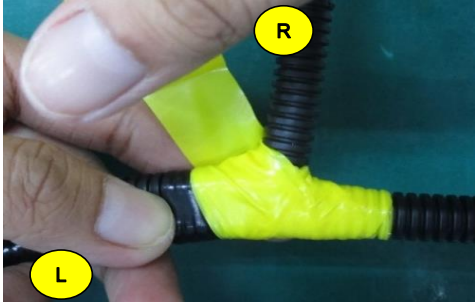
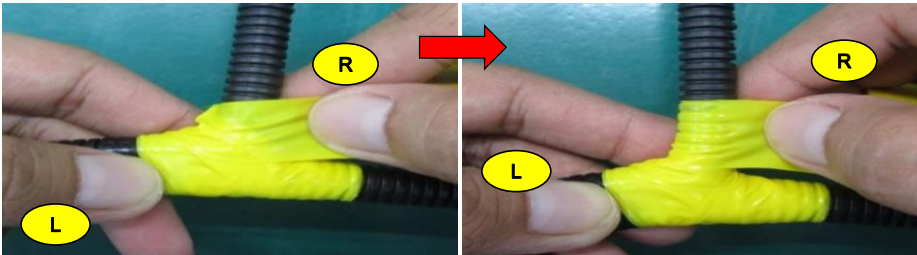
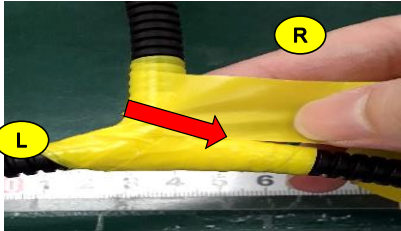
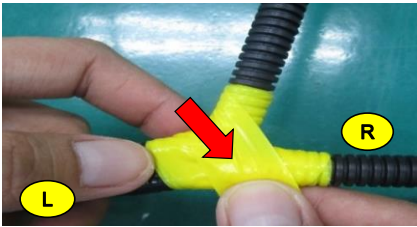
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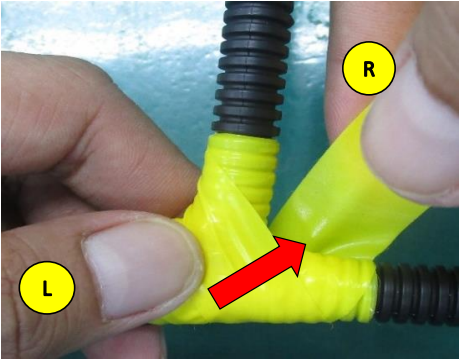
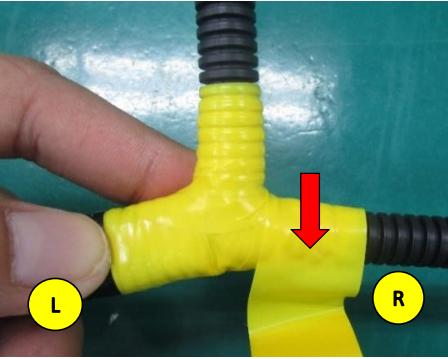
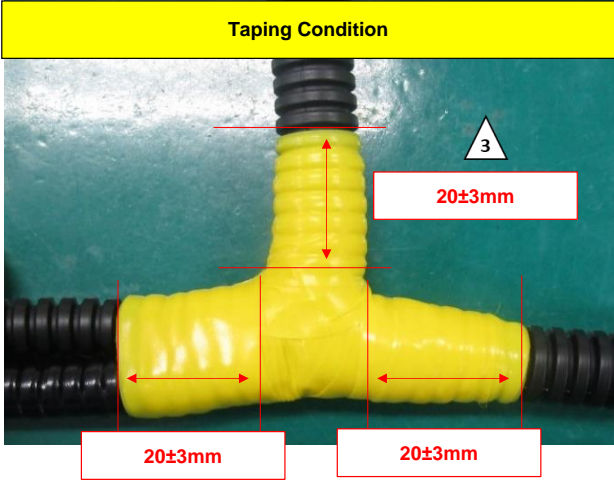

<b>PARTS:</b>	1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P3  T-taping (Continuation)	 <div data-bbox="1034 472 1469 563">11. Wind the tape from front to back side (cross pattern)</div>  <div data-bbox="577 948 1435 1000">12. Tape the top side corrugated tube (3 winds), width must be same as tape (20±3mm)</div>  <div data-bbox="548 1246 994 1337">13. From the top side, wind the tape 2/3 shifting going to center</div>  <div data-bbox="1014 1246 1469 1337">14. Wind the tape going to front side (cross pattern)</div>	N/A	<b>Important reminders/Note/s:</b> <b>1. Use <u>YELLOW TAPE</u> for easy visualization of shifting lines, but actual should be <u>BLACK TAPE</u>.</b> <b>2. Please use calibrated/verified measuring tape when getting the measurement.</b>  1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. No wrong dimension

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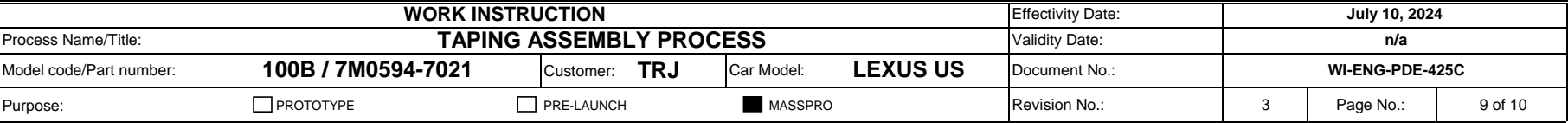
<b>PARTS:</b>		1. Assy parts 2. Black tape		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
4	P3  T-taping (Continuation)	<div></div> <div>15. Wind the tape from front to back side (<b>cross pattern</b>)</div> <div></div> <div>16. Tape the right side corrugated tube (<b>3 winds</b>), width must be same as tape (<b>20±3mm</b>)</div> <div></div> <div>17. After taping, check the measurement and condition of tape.</div>	<div><b>MEASURING TAPE</b></div> 	<p><b>Important reminders/Note/s:</b></p> <p>1. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines, but actual should be <b>BLACK TAPE</b>.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. No wrong dimension</p>	

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Model code/Part number: **100B / 7M0594-7021**Customer: **TRJ**Car Model: **LEXUS US**

Document No.:

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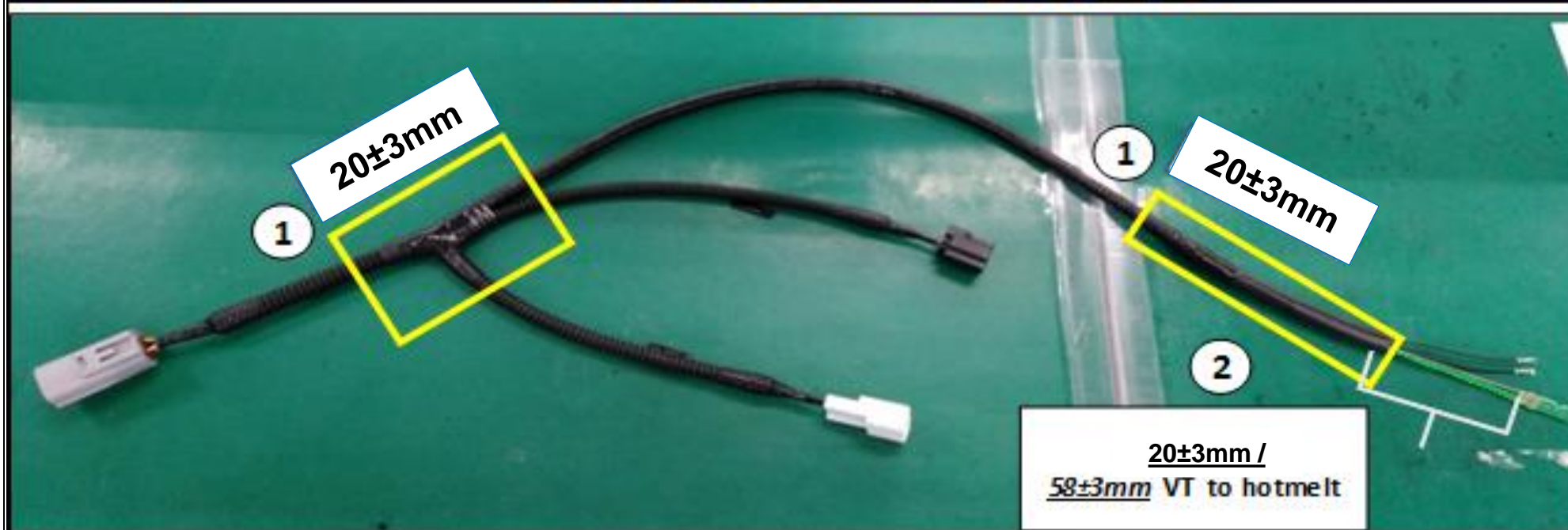
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P3****7M0594-7021**

① **No MISSING TAPE**  
**CORRECT FACING OF T-TAPING**

② **No MISSING VT**

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