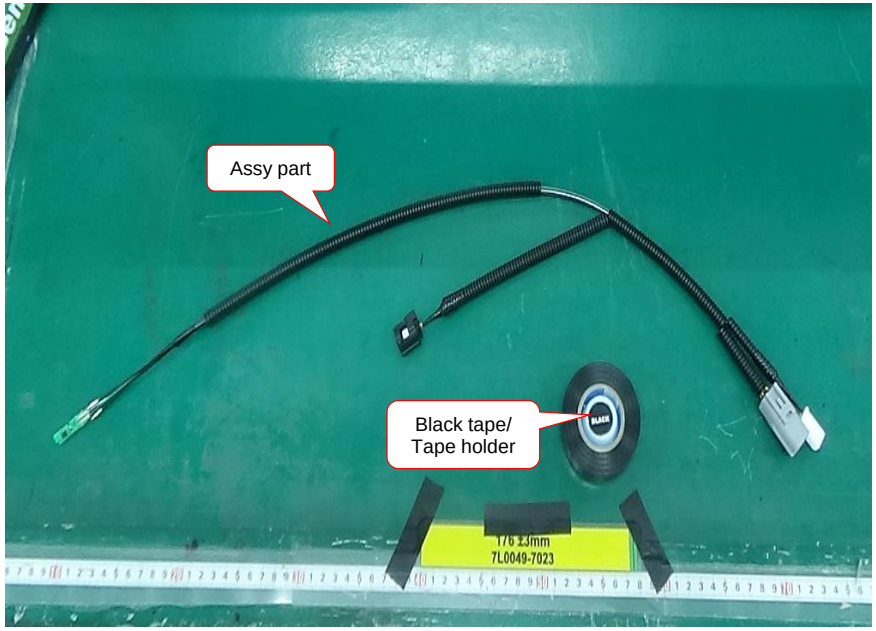
NBC	WORK INSTRUCTION			Effectivity Date:	October 01, 2024
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number:	241B / 7L0049-7023A	Customer: TRQSS / Car Model: LEXUS ES	Document No.:	WI-ENG-PDE-1067C
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1 / Page No.: 1 of 7

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							Prepared by	Reviewed by	Approved by	Noted by
10/01/24	1	Change from Pre-launch to Masspro.	A. Hernandez	C. Villanueva	A. Arañes	n/a				
09/24/24	0	Initial Issue.	A. Hernandez	C. Villanueva	A. Arañes	n/a	A.Hernandez	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 24, 2024		

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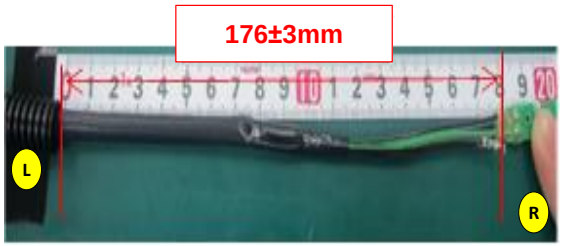
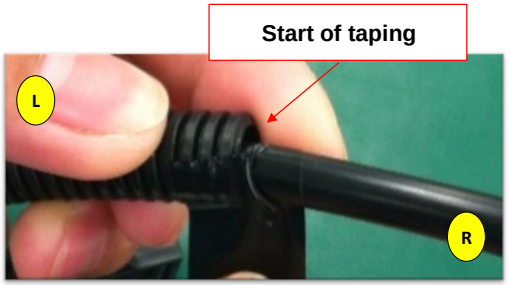
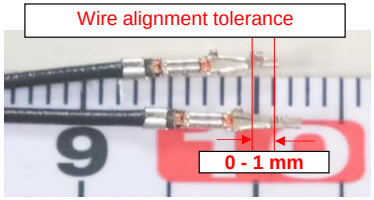
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1 / Page No.: 2 of 7

PARTS:	1. Assy parts 2. Black tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3	Taping 4 Corrugated tube to Sunprene tube	 1.Measure the end of the corrugated tube up to the edge of hotmelt and terminal pointed tip 176mm using both hands.  2. Hold corrugated tube using left hand then start taping using right hand. 3. After taping, check the measurement and tape condition	**MEASURING TAPE** 	1. No flip-out tape 2.No peel-off tape 3. No loose tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape ***Important reminders and Note/s:*** ***1. Please use calibrated/verified measuring tape when getting the measurement.*** ***Document reference/s:*** ***1. Refer to WI-PRO-ASY-001 for taping procedure.*** 

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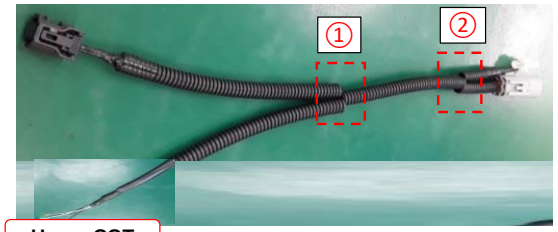
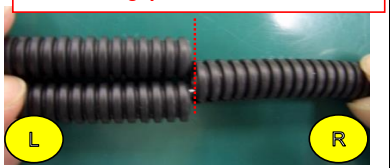
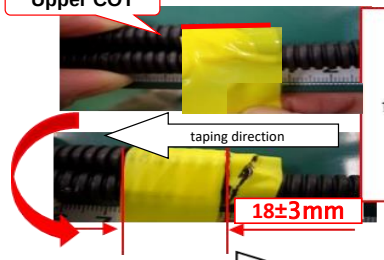
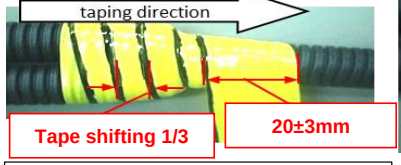
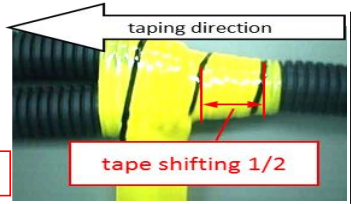
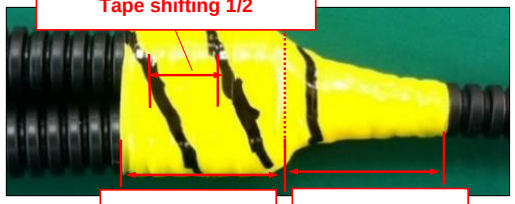
	Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	1	Page No.: 3 of 7

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	 No gap between tubes  1. Fix the 3 corrugated tube. Upper COT  taping direction 18±3mm Note: Do not exert excessive force during pulling & winding of tape 2. Start taping at the middle of combined tubes, position the tape into upper COT (2 winds). Then wind the tape to left side, width must be 18±3mm (2 winds).  taping direction Tape shifting 1/3 20±3mm 3. Wind the tape 1/3 shifting until it reach the other side of COT then wind the tape, width must be 20±3mm (2 winds).  taping direction tape shifting 1/2 4. Wind the tape backward 1/2 shifting until it reach the COT. Then wind the tape, width must be 20±3mm (2 winds). 5. Wind the tape 1/2 shifting going to other side of COT. Then wind the tape, width must be 20±3mm (2 winds) and cut the tape. After taping, check the condition of tape and measurement. Tape shifting 1/2  18±3mm 20±3mm	MEASURING TAPE 	***Important reminders/Note/s:*** ***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.*** ***Document reference/s:*** ***1. Refer to WI-PRO-ASY-001C for taping procedure (Special)*** 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 7. Do not exert excessive force during pulling & winding of tape **Proper facing of Y taping**

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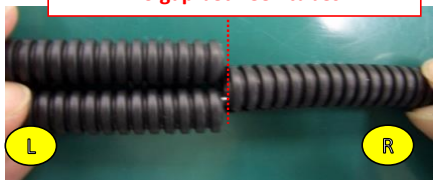
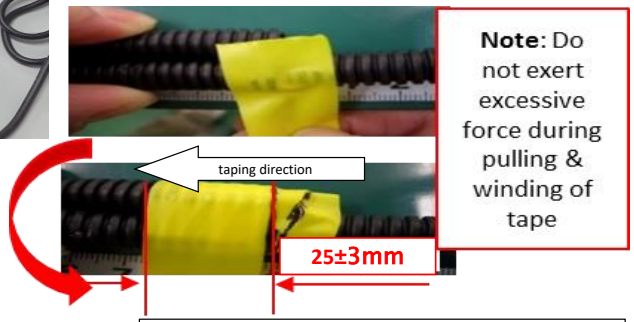
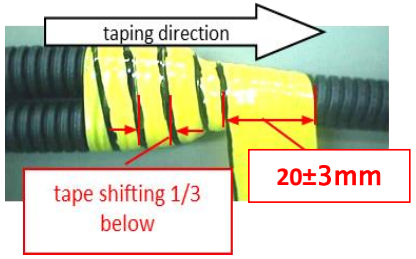
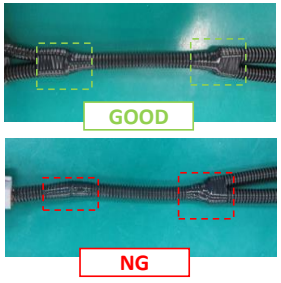
	Model code/Part number: 241B / 7L0049-7023A	Customer: TRQSS	Car Model: LEXUS ES	Document No.:	WI-ENG-PDE-1067C	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 1	Page No.:	4 of 7

PARTS:	1. Assy parts 2. Black tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P3	Y-taping 2	 No gap between tubes  1. Fix the 3 corrugated tube .  **Note**: Do not exert excessive force during pulling & winding of tape  2. Start taping at the middle of combined tubes, position the tape into upper COT **(2 winds).** Then wind the tape to left side, width must be **25±3mm (2 winds).** 3. Wind the tape **1/3 shifting** until it reach the other side of COT then wind the tape, width must be **20±3mm (2 winds).**	MEASURING TAPE 	***Important reminders/Note/s:*** ***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.*** ***Document reference/s:*** ***1. Refer to WI-PRO-ASY-001C for taping procedure (Special)*** 1. No tape peeling 2. No flip out of tape 3. No wide interval between the COT 4. No exposed wire 5.Y taping should be same facing **Proper facing of Y taping** 

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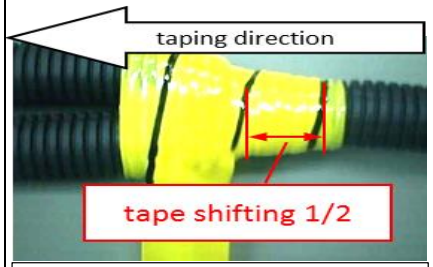
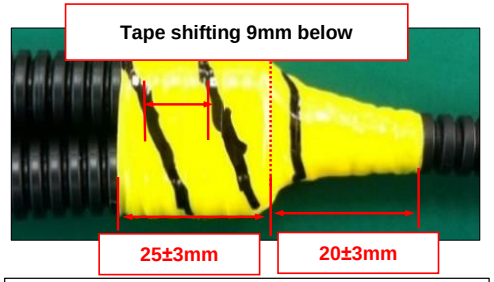
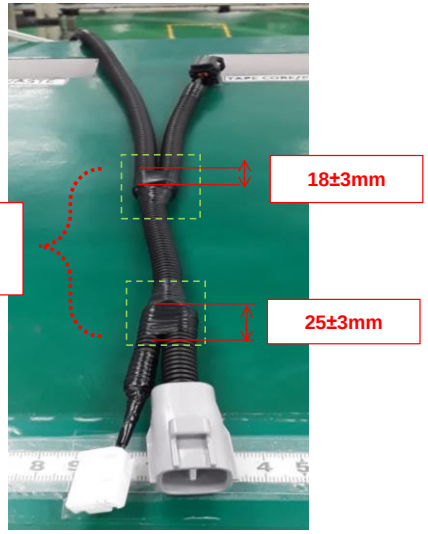
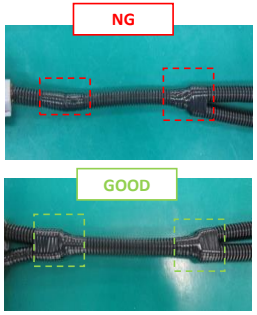
	Model code/Part number: 241B / 7L0049-7023A	Customer: TRQSS	Car Model: LEXUS ES	Document No.:	WI-ENG-PDE-1067C	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 5 of 7

PARTS:	1. Assy parts 2. Black tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P3	Y-taping 2 (continuation)	 4. Wind the tape backward **1/2 shifting** until it reach the COT. Then wind the tape, width must be **20±3mm (2 winds).**  5. Wind the tape **1/2 shifting** going to other side of COT. Then wind the tape, width must be **20±3mm (2 winds)** and cut the tape. After taping, check the condition of tape and measurement. **Check the proper Y taping orientation** 	**MEASURING TAPE** 	***Important reminders/Note/s:*** ***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.*** ***Document reference/s:*** ***1. Refer to WI-PRO-ASY-001C for taping procedure (Special)*** 1. No tape peeling 2. No flip out of tape 3. No wide interval between the COT 4. No exposed wire 5. Y-taping should be same facing **Proper facing of Y taping** 

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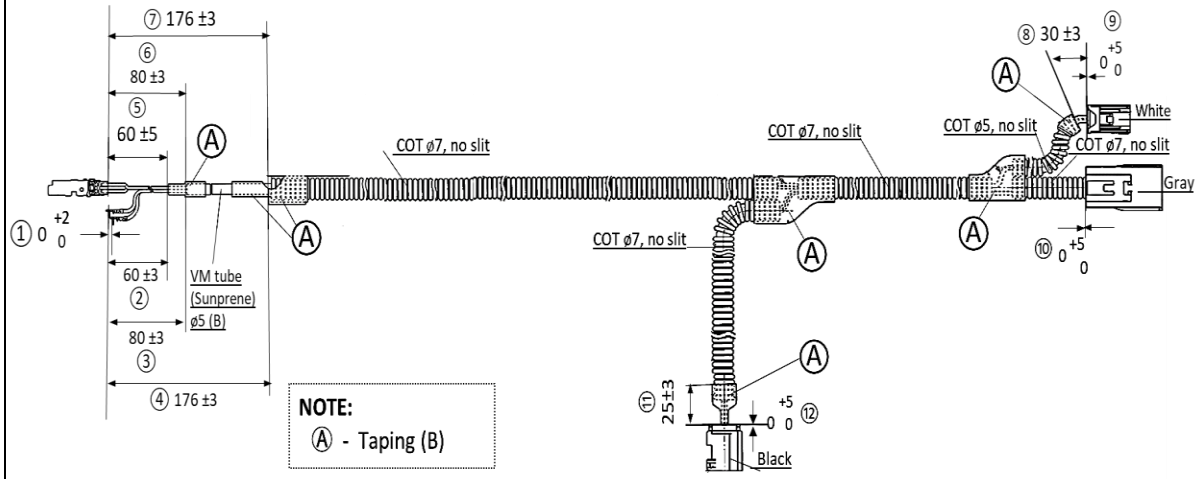
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 6 of 7

PARTS:	1. Assy parts	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P3	Measurement		MEASURING TAPE	***Important reminders and note/s:*** ***1. Please use calibrated/verified measuring tape when getting the measurement.*** ***2. For Hatsumono, Nakamono and Owarimono.*** ***Document reference/s:*** *1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection* 1. No wrong dimension

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PARTS:	1. Assy parts	JIG:	n/a

VISUAL INSPETCION/ QUALITY CHECKPOINTS

TAPING - P3	7L0049-7023A

1. No Missing Tape (BLACK)
2. No Wrong Orientation of Y-Taping

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