



## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

May 17, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

800B/900B/  
910B

/ 7N0101-7020B

Customer:

TRJ

Car Model:

LEXUS NX/RX

Document No.:

WI-ENG-PDE-458C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

5

Page No.:

1 of 9

## PARTS:

1. Assy parts; Black tape; Black VM tube (Sunprene)  $\phi 9$  L=93 $\pm$ 3mm;

JIG:

N/A

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

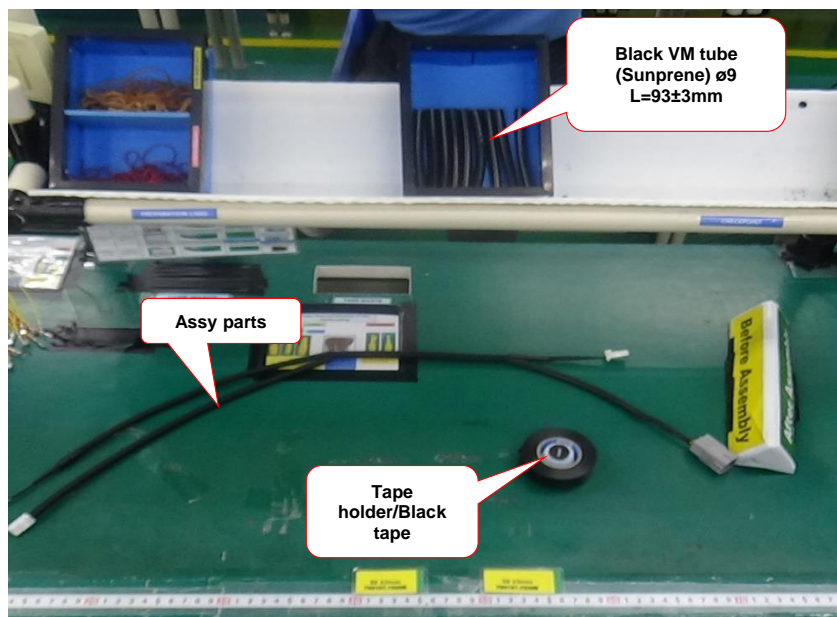
QUALITY POINTERS

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

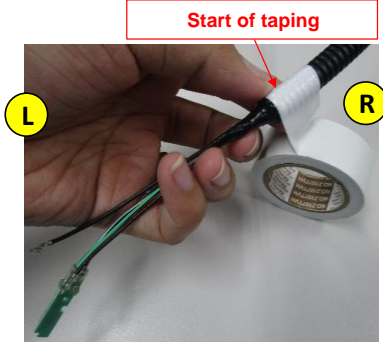
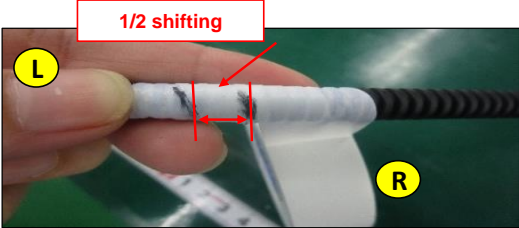
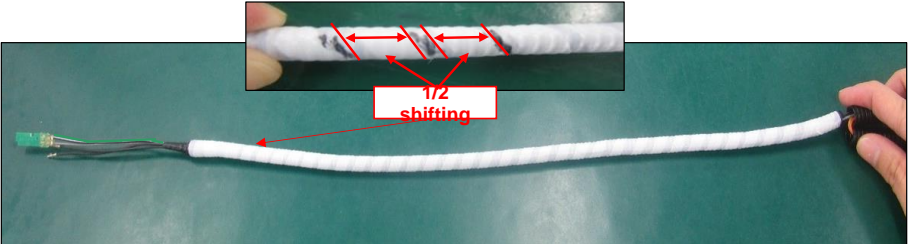

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/17/24	5	Additional Important reminders/Note/s in Process 5 (Page 4) due to customer claim countermeasure.	D. Castillo	C. Villanueva	A. Arañes	na				
08/15/23	4	Change table lay-out; Change Quality Checkpoints; Transferred process of Half wrap taping; Wire insertion to Black VM tube (Sunprene); Taping 2: Black sunprene tube to Black COT near PCB and terminal and Y-taping from P2 to P3. Removed and Transferred process of Clamp setting; Clamp Assembly; Visual/By two's inspection and measurement to CLAMP ASSEMBLY PROCESS due to new process distribution.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
04/06/23	3	Work instruction improvement. Change MP from 4MP to 3MP. Transfer process from P4 to P3 (Page 2, 5-10). Inclusion of Quality checkpoints (Page 11).	D. Castillo	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	April 12, 2022		

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)  
MASTER COPY

DCC Stamp


	<b>WORK INSTRUCTION</b>				Effectivity Date:		May 17, 2024		
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a		
	Model code/Part number: 800B/900B/910B / 7N0101-7020B		Customer: TRJ	Car Model: LEXUS NX/RX		Document No.:		WI-ENG-PDE-458C	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		5	Page No.:	2 of 9

<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>	
2	P3 Taping 1 Half-wrap taping	<div><div><p>1. Hold the corrugated tube using left hand and begin taping using right hand.</p></div><div><p>2. Make <b>1/2 shifting</b>. Repeat the process until the end of corrugated tube. Make <b>3 windings</b> and then cut the tape.</p></div><div><p>3. Check the taping condition.</p></div></div>		<div><b>MEASURING TAPE</b> </div>	<p><b>Important reminders/Note/s</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. Used <b>WHITE TAPE</b> to easily visualize the tape shifting, but actual should be <b>BLACK TAPE</b>.</p> <p>3. Internal tolerance for halfwrap taping shifting should be 0~14mm only.</p> <p>5</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>	

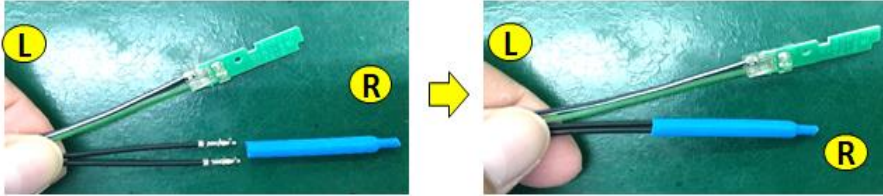
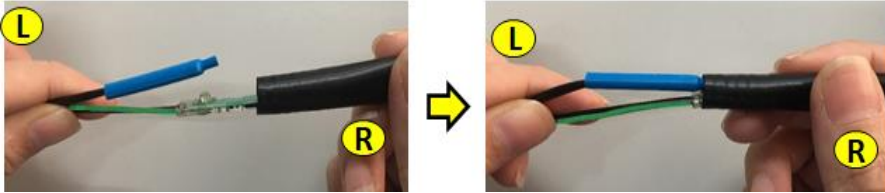
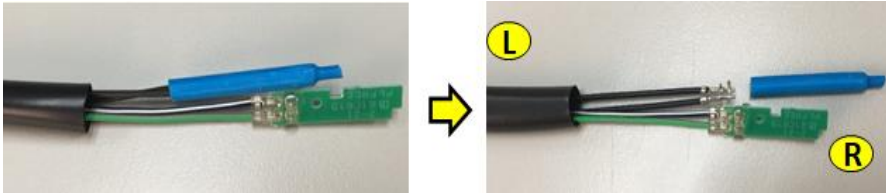

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**

DCC Stamp

	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>May 17, 2024</b>		
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>800B/900B/910B / 7N0101-7020B</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS NX/RX</b>	Document No.:	<b>WI-ENG-PDE-458C</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	5	Page No.:	3 of 9

<b>PARTS:</b>		1. Assy parts 2. Black VM tube (Sunprene) $\varnothing 9$ L=93 $\pm$ 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>	
3	P3  Wire insertion to Black VM tube (Sunprene) $\varnothing 9$ L=93 $\pm$ 3mm	 <p>1. Get the terminal cover jig using right hand then insert the terminal <b>B-B wires</b> using left hand.</p>  <p>2. Hold the Black VM tube (Sunprene) <math>\varnothing 9</math> L=93<math>\pm</math>3mm 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.</p>  <p>3. After insertion, remove the terminal cover jig using right hand.</p>	<div style="border: 1px solid red; padding: 5px; text-align: center;"> <b>TERMINAL COVER JIG</b> </div> 	1. No wrong usage of parts 2. No deformed terminal	

<b>CONFIDENTIAL:</b> Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.	<b>NBC (Philippines)</b> <b>MASTER COPY</b>	DCC Stamp
--	--	-----------



# WORK INSTRUCTION

Effectivity Date:

May 17, 2024

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

800B/900B/  
910B

/ 7N0101-7020B

Customer: TRJ

Car Model:

LEXUS NX/RX

Document No.:

WI-ENG-PDE-458C

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

5

Page No.:

4 of 9

### PARTS:

1. Assy parts
2. Black tape

JIG:

N/A

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

P3

Taping 2  
Black sunprene tube to  
Black COT near PCB  
and terminal

**50 ± 3mm**

**58 ± 3mm**

**25 ± 3mm**

**Start of taping**

2. Hold the tubes using left hand, get the **Black tape** using right hand then start pre-taping using both hands.

**25 ± 3mm**

3. Confirm measurement of **25 ± 3mm** from end of tape up to end of tube then continue the taping process using both hands.

**25 ± 3mm**

4. Confirm measurement of **25 ± 3mm** from end of tube up to end of tape then continue the taping process using both hands.

**25 ± 3mm**

**50 ± 3mm**

**58 ± 3mm**

5. After taping, check the measurement, terminal appearance and taping condition.

1. Measure from end of VM tube (Sunprene) up to terminal pointed tip **58 ± 3mm**; and tube up to PCB **50 ± 3mm** using both hands.

### MEASURING TAPE

**Important reminders/Note/s:**  
1. Please use calibrated/verified measuring tape when getting the measurement.


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

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

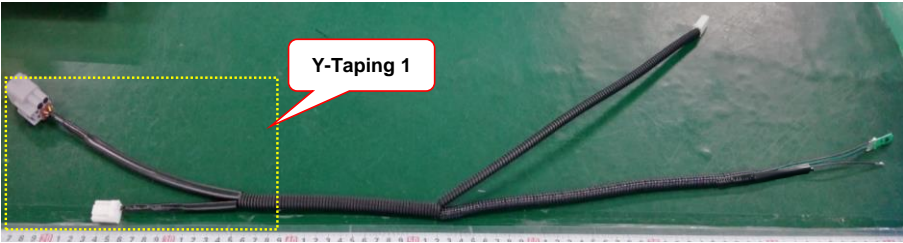
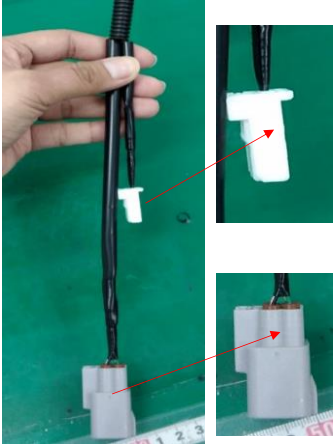


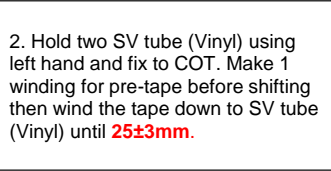


NBC (Philippines)  
MASTER COPY

DCC Stamp






	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>May 17, 2024</b>		
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:	<b>n/a</b>		
	Model code/Part number: <b>800B/900B/910B / 7N0101-7020B</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS NX/RX</b>	Document No.:	<b>WI-ENG-PDE-458C</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	<b>5</b>	Page No.:	<b>5 of 9</b>



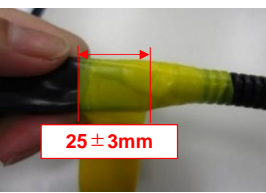
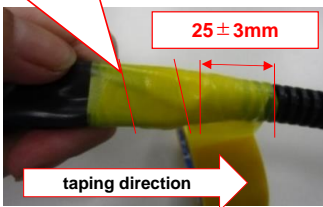
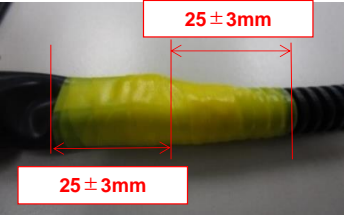
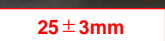
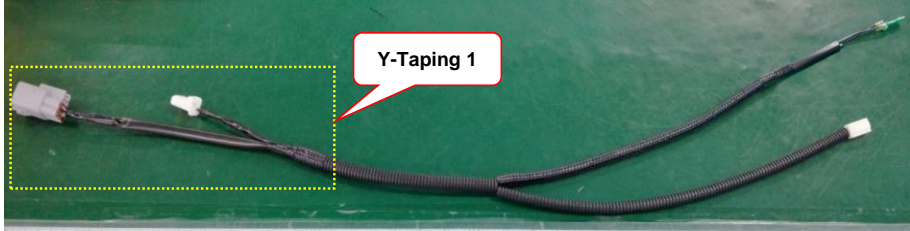


  

<b>PARTS:</b>			1. Assy parts 2. Black tape		JIG:	N/A
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
5	P3	<div>  <p><b>Y-Taping 1</b></p> </div> <div>  <p>1. Fix the two SV tubes (Vinyl) and COT using both hands. <i>See illustration for correct facing of connector.</i></p> </div> <div>  <p><b>25 ± 3mm</b></p> </div> <div>  <p>tape shifting 1/2 below taping direction</p> </div> <div>  <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 SV tube (Vinyl) until <b>25±3mm</b>.</p> </div>			<div>  <p><b>MEASURING TAPE</b></p> </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>  1. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines, but actual should be <b>BLACK TAPE</b>.  2. Please use calibrated/verified measuring tape when getting the measurement.</p> <div>  <p><b>Y-TAPING ORIENTATION</b></p> </div>

<b>CONFIDENTIAL:</b> Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.	<div>  </div>	<div>  </div>
--	--	--


	<b>WORK INSTRUCTION</b>				Effectivity Date:		May 17, 2024	
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Model code/Part number: <b>800B/900B/910B / 7N0101-7020B</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS NX/RX</b>	Document No.:		<b>WI-ENG-PDE-458C</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		5	Page No.: 6 of 9

<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>	
5	P3 Y-Taping 1 (Continuation)	<div><p>tape shifting 1/3 below</p><p>taping direction</p></div> <div><p>tape shifting 1/2 below</p><p>taping direction</p></div> <div><p>25 ± 3mm</p></div> <div><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></div> <div><p>tape shifting 1/2 below</p><p>25 ± 3mm</p><p>taping direction</p></div> <div><p>25 ± 3mm</p><p>25 ± 3mm</p></div> <div><p>4. From COT, wind the tape down to SV tube (Vinyl) (1/2 shifting) until <b>25±3mm</b>.</p></div> <div><p>25 ± 3mm</p></div> <div><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.</p></div> <div><p>Y-Taping 1</p></div>	<div><p>MEASURING TAPE</p></div>	<div><p>Y-TAPING ORIENTATION</p></div> <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></div>	

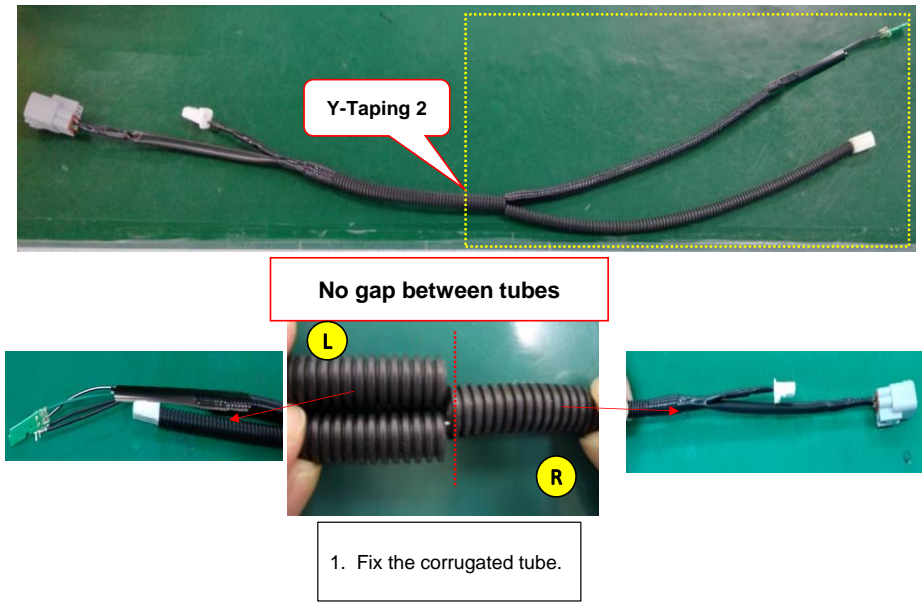
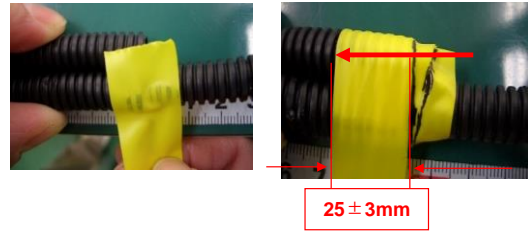

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**


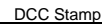
DCC Stamp


	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>May 17, 2024</b>		
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>800B/900B/910B / 7N0101-7020B</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS NX/RX</b>	Document No.:	<b>WI-ENG-PDE-458C</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	5	Page No.:	7 of 9

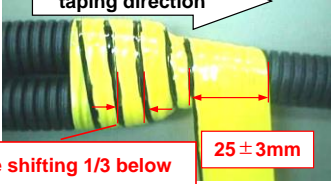

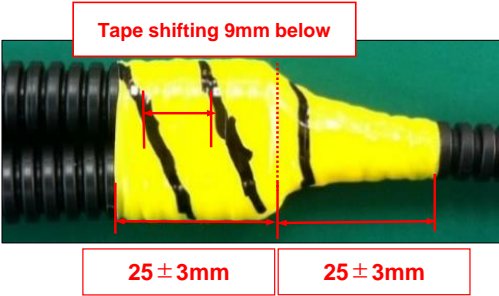
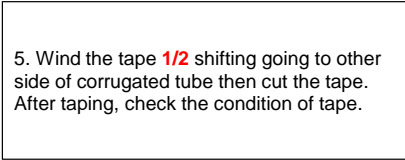
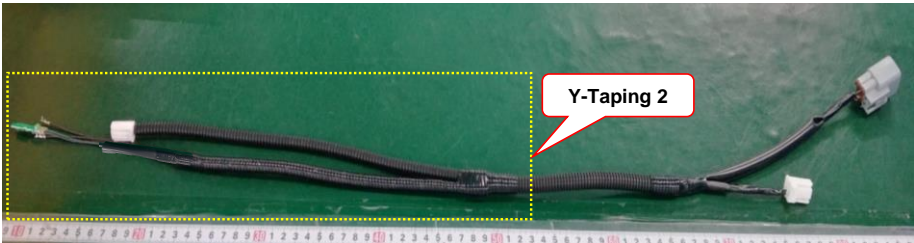

  

<b>PARTS:</b>	1. Assy parts 2. Black tape			JIG:	N/A
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
6	P3	<div>  </div> <div> <p><b>Note:</b> Do not exert excessive force during pulling &amp; winding of tape</p>  <p><b>25 ± 3mm</b></p> </div> <div> <p>2. Hold the 2 COT using left hand and fix to other COT. Make 1 winding for pre-tape before shifting then wind the tape down to COT until <b>25±3mm</b>.</p> </div>		<div>  </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>  1. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines, but actual should be <b>BLACK TAPE</b>.  2. Please use calibrated/verified measuring tape when getting the measurement.</p>

<b>CONFIDENTIAL:</b> Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.	<div>  </div>	<div>  </div>
--	--	--

	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>May 17, 2024</b>		
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>800B/900B/910B / 7N0101-7020B</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS NX/RX</b>	Document No.:	<b>WI-ENG-PDE-458C</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	5	Page No.:	8 of 9

<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>	
6	P3  Y-Taping 2 (Continuation)	<div><p>Tape shifting 1/3 below 25 ± 3mm</p></div> <div><p>Tape shifting 1/2 below</p></div> <div><p>3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube until <b>25±3mm</b>.</p></div> <div><p>Tape shifting 9mm below 25 ± 3mm 25 ± 3mm</p></div> <div><p>4. Wind the tape backward 1/2 shifting.</p></div> <div><p>5. Wind the tape <b>1/2</b> shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.</p></div> <div><p>Y-Taping 2</p></div>		<div><b>MEASURING TAPE</b></div> 	<div>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</div> <div><b>Important reminders/Note/s:</b> 1. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines, but actual should be <b>BLACK TAPE</b>. 2. Please use calibrated/verified measuring tape when getting the measurement.</div>	

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**

DCC Stamp



**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

May 17, 2024

Validity Date:

n/a

Model code/Part number:

800B/900B/  
910B

/ 7N0101-7020B

Customer: TRJ

Car Model:

LEXUS NX/RX

Document No.:

WI-ENG-PDE-458C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

5

Page No.:

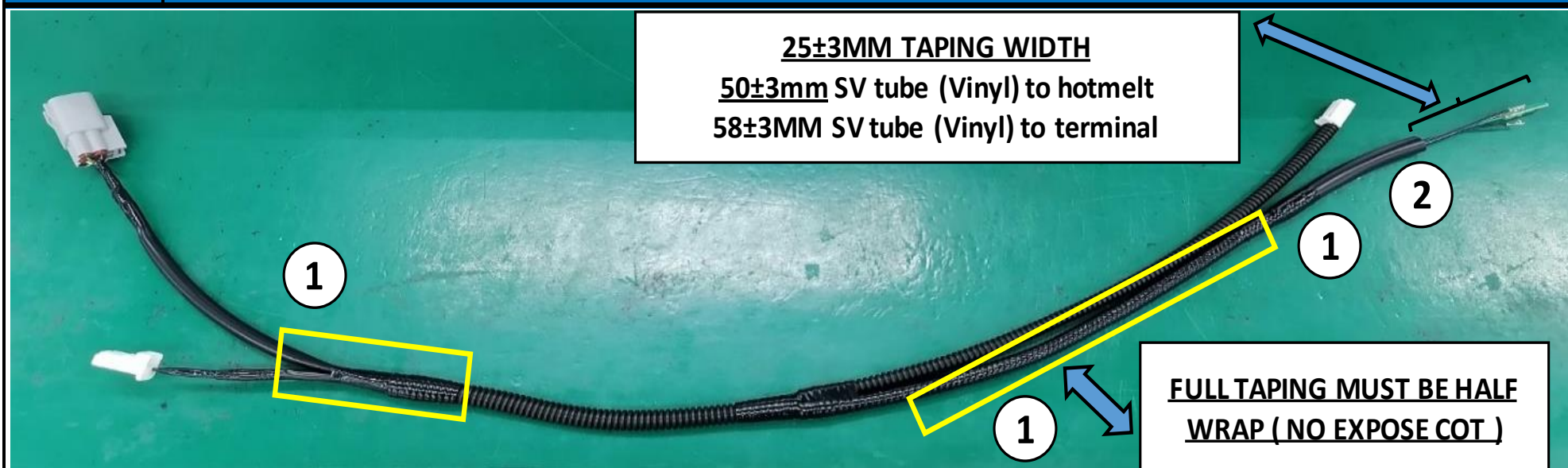
9 of 9

**PARTS:**

1. Assy parts

JIG:

N/A

**QUALITY CHECKPOINTS****P3****7N0101-7020B****1****NO Missing Tape**  
**CORRECT FACING OF Y-TAPING****2****No Missing SV tube**  
**(Vinyl)**

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**

DCC Stamp