

	WORK INSTRUCTION						Effectivity Date:		July 04, 2024		
	TAPING ASSEMBLY PROCESS						Validity Date:		n/a		
	Process Name/Title:		Model code/Part number:		Customer:		Car Model:		Document No.:		
			922B / 7L0124-7022		TRQSS		LEXUS NX		WI-ENG-PDE-266D		
Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:		4 Page No.: 1 of 5	

PARTS:		1. Assy parts; Blue tape; Black tape				JIG:		n/a	
NO.	PROCESS NAME	<div style="border: 1px solid black; padding: 2px; display: inline-block;">4</div> WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	P4 Table Lay-out	<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px; text-align: center;">TABLE LAY-OUT</div>				<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px solid red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>		1. No missing parts in assy parts 2. No excess tape/tape holder 3. No wrong position of tape holder	

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
								 D. Castillo	 C. Villanueva	 A. Arañes	 A. Arañes		n/a		
07/04/24	4	Transfer Taping 5 and Y-taping from P3 and Separate clamp assembly due to process improvement. Inclusion of car model "LEXUS-NX". Improved Table lay-out, Measurement and Visual inspection/Quality checkpoints.	D. Castillo	C. Villanueva	A. Arañes	n/a									
02/10/23	3	Work instruction improvement. Remove Taping 5 Black corrugated tube to Black VM tube (Sunprene) process due to additional MP from 3MP to 4MP. Update By two's inspection. Inclusion of Quality checkpoint (Page 8).	D. Castillo	J. Loterte	C. Villanueva	A. Arañes									
10/22/21	2	Change part number due to additional clamp quantity 82711-52090 (W). Change sequence number of clamp assembly jig.	D. Castillo	J. Loterte	C. Villanueva	A. Arañes									
Eff. Date	Rev. No	Details of Change					Revised	Reviewed	Approved	Noted	Est. Date:	June 5, 2021			

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model code/Part number:

922B / 7L0124-7022

Customer:

TRQSS

Car Model:

LEXUS NX

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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PARTS:

1. Assy parts
2. Blue tape [1pc]

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

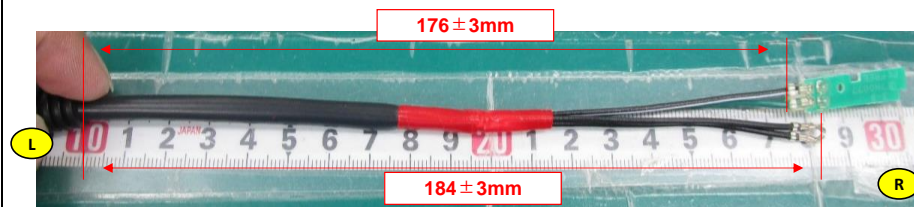
TOOLS/PPE

QUALITY POINTERS

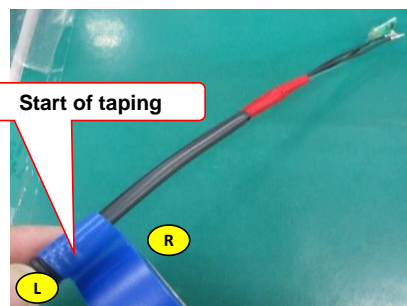
2

P4

Taping 5
Black corrugated tube to
Black VM tube
(Sunprene)

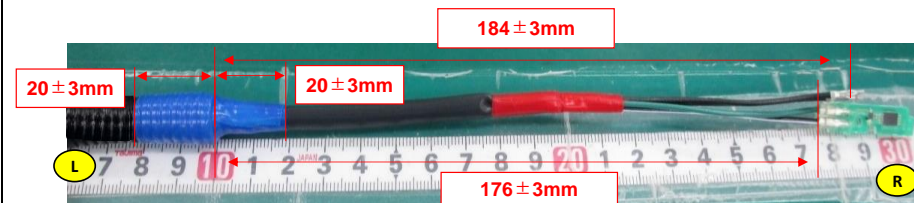


1. Measure from end of VM tube (Sunprene) up to edge of hotmelted wire **176±3mm** and up to terminal pointed tip **184±3mm** using both hands.



Start of taping

2. Get the **Blue tape** using right hand then start taping process using both hands.



3. After taping, check the measurement and taping condition.

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 use of tape
6. No wrong dimension

Document references:

1. Please refer to **WI-PRO-ASY-001** for taping procedure.

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TAPING ASSEMBLY PROCESS

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922B / 7L0124-7022

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☐ PROTOTYPE

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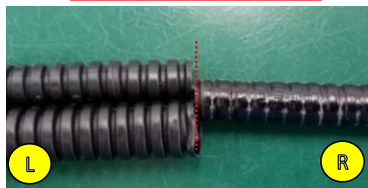
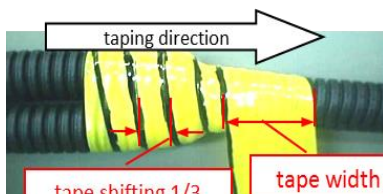
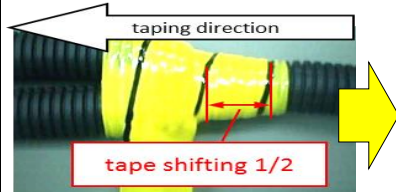
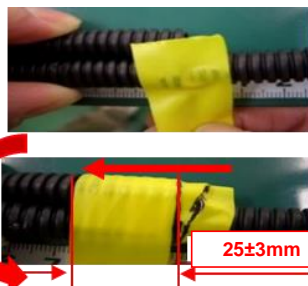
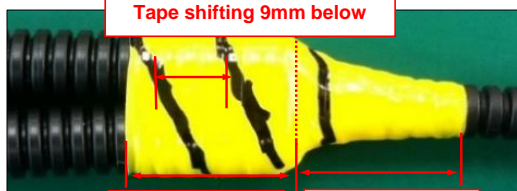


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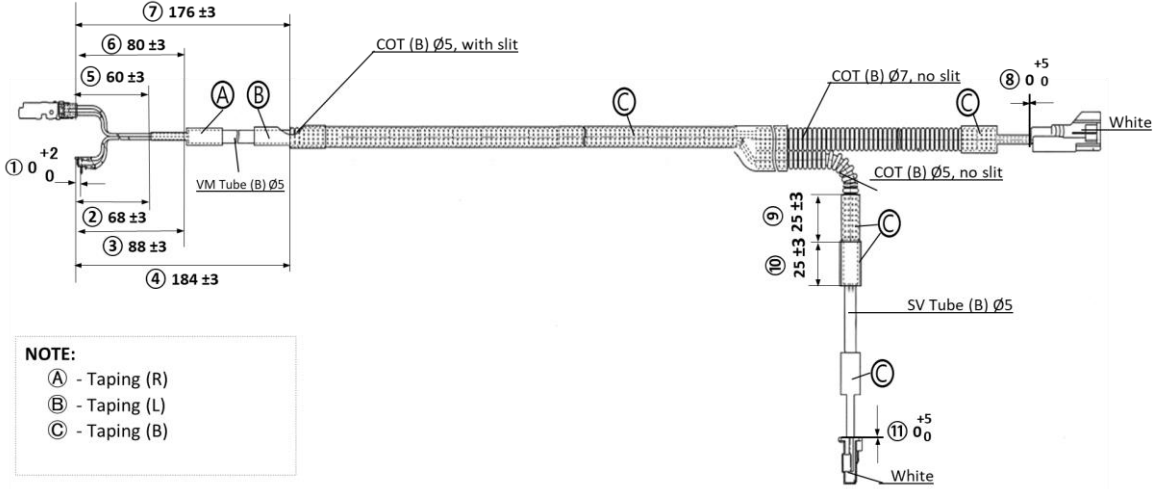
PARTS:		1. Assy parts 2. Black tape [1pc]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P4	Y-Taping			
		<div><div><div>No wide interval</div><div></div><div>1. Fix the corrugated tube .</div></div><div><div><div>taping direction</div><div></div><div>tape shifting 1/3 below</div><div>tape width</div></div><div><div><div>taping direction</div><div></div><div>tape shifting 1/2</div></div><div>4.Winding the tape backward 1/2 shifting.</div></div></div><div><div><div><div>Note: Do not exert excessive force during pulling & winding of tape</div><div></div><div>25±3mm</div></div><div>2. Start taping at the middle of combined Corrugated tubes, then winding the tape going to 2 corrugated tubes, width must be 25±3mm.</div><div>3. Winding the tape 1/3 shifting until it reach the other side of corrugated tube, width must be 25±3mm.</div><div><div><div>Tape shifting 9mm below</div><div></div><div>25±3mm</div><div>25±3mm</div></div><div>5. Winding the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.</div></div></div></div></div>		<div>Measuring tape</div> <div></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> <div>Important reminders/Note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>2. Used YELLOW TAPE to easily visualize the tape shifting, but actual should be BLACK TAPE.</div> <div>3. Do not exert excessive force during pulling and winding of tape.</div> <div></div> <div>Connector Orientation</div>

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	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 922B / 7L0124-7022		Customer: TRQSS	Car Model: LEXUS NX	Document No.: WI-ENG-PDE-266D		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	4	Page No.:	4 of 5

PARTS:	1. Assy parts			JIG:	n/a		
NO.	PROCESS NAME	4 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
4	P4	Measurement	<div><div>MEASURING TAPE</div></div>  <div>NOTE: A - Taping (R) B - Taping (L) C - Taping (B)</div>	<div>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</div> <div>1. No wrong dimension</div>			

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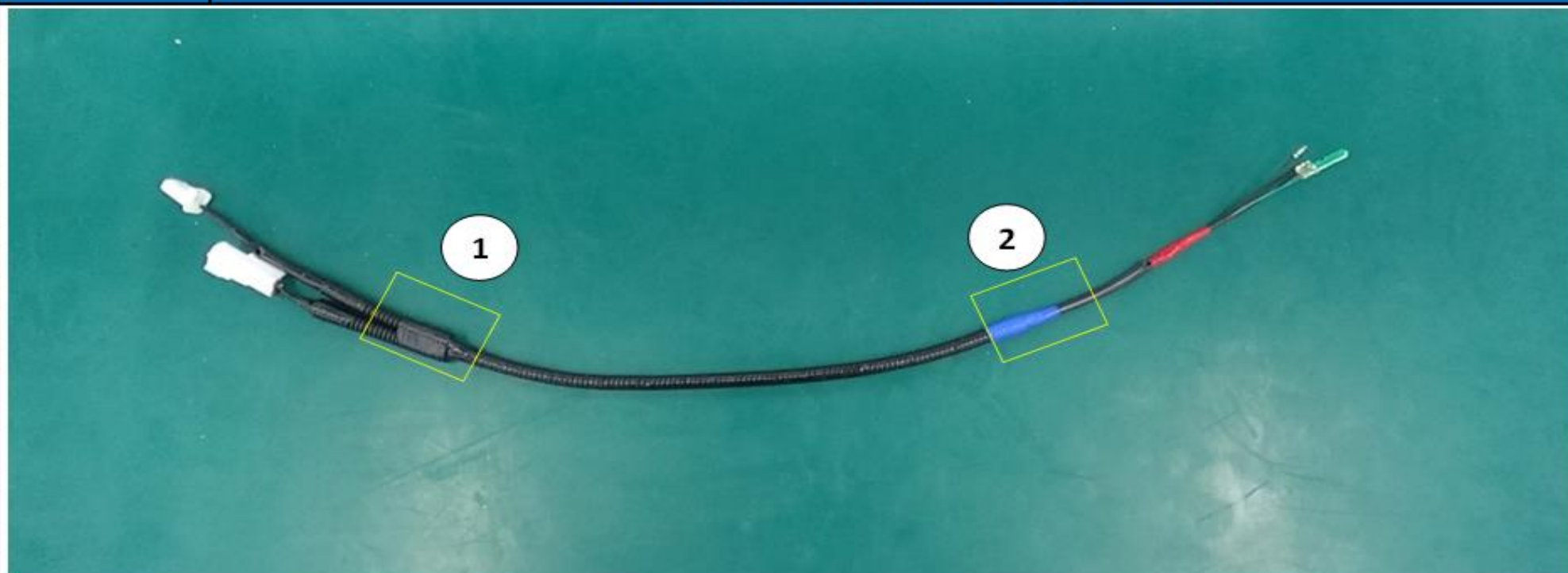
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P4****7L0124-7022****1****No WRONG Y-FACING****2****No Wrong used of tape**

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