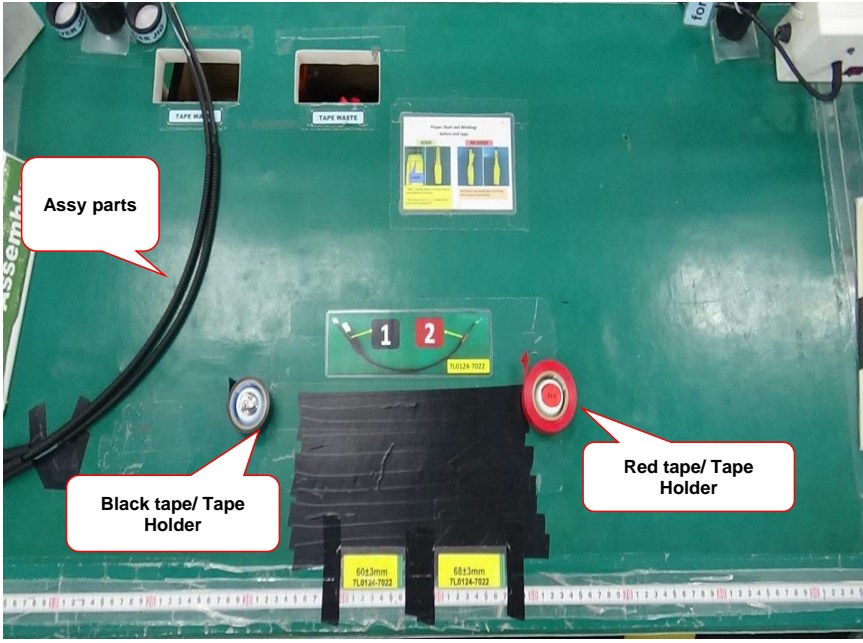
	WORK INSTRUCTION				Effectivity Date:		July 04, 2024	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 922B / 7L0124-7022		Customer: TRQSS		Car Model: LEXUS NX	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked=""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

PARTS:		1. Assy parts; Red tape; Black tape			JIG:		n/a	
NO.	PROCESS NAME	5 WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE		QUALITY POINTERS	
1	P3	<div>TABLE LAY-OUT</div> 			<div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>		<p>1. No missing parts in assy parts 2. No excess tape/tape holder 3. No wrong position of tape holder</p>	

Revision History				Prepared by		Reviewed by		Approved by		Noted by	
07/04/24	5	Transfer Taping 4 from P2 and transfer Taping 5 and Y-taping to P4 due to process improvement. Inclusion of car model "LEXUS-NX". Improved Table lay-out and Visual inspection/Quality checkpoints.				D.Castillo	C.Villanueva	A. Arañes	n/a		
12/14/23	4	Additional Important reminders/Note/s in Process 2 (Page 2) due to customer claim countermeasure.				D.Castillo	J.Loterte	C.Villanueva	A. Arañes		
02/10/23	3	Work instruction improvement. Change process sequence (Page 2-4) and remove some process due to additional MP from 3MP to 4MP. Change term Black sunprene tube to Black VM tube (Sunprene). Inclusion of Quality checkpoint (Page 5).				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

Effectivity Date:

July 04, 2024

Validity Date:

n/a

Model code/Part number:

922B / 7L0124-7022

Customer:

TRQSS

Car Model:

LEXUS NX

Document No.:

WI-ENG-PDE-266C

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

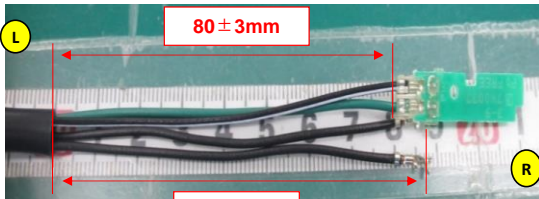
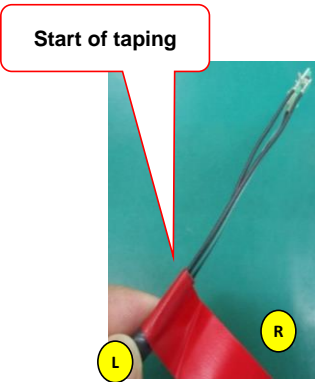
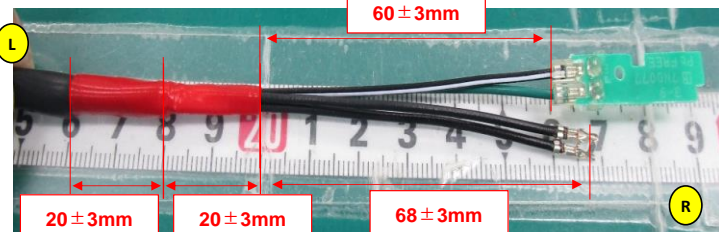

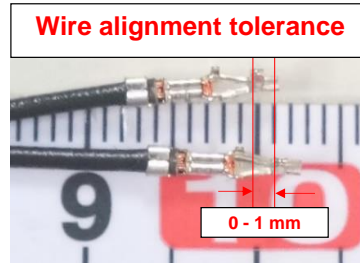
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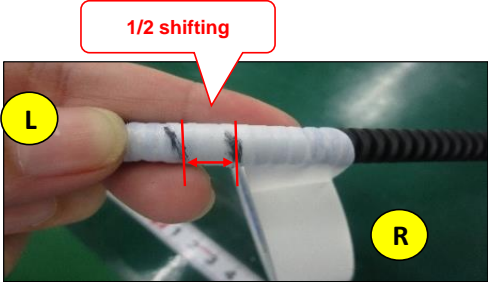
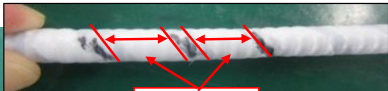
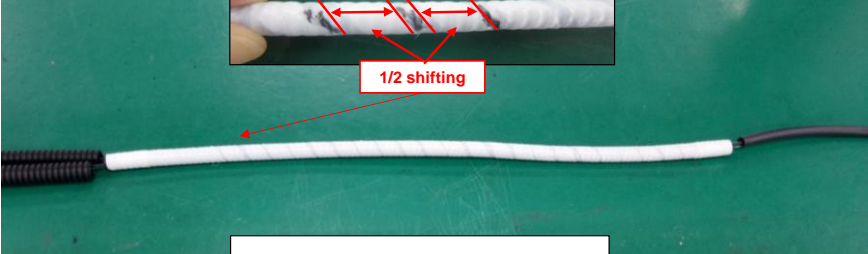

PARTS:		1. Assy parts 2. Red tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3 Taping 4 VM tube (Sunprene) to wire near terminal and hotmelted wire	<div><p>1. Hold VM tube (Sunprene) using left hand. Measure from VM tube (Sunprene) to end of hotmelted wire <b>80±3mm</b> and Sunprene tube to terminal tip <b>88±3mm</b>.</p></div> <div><p>2. Get <b>Red tape</b> using right hand, hold the VM tube (Sunprene) (ø5 L=96±3mm) using left hand. Fold the VM tube (Sunprene) and start taping using right hand.</p></div> <div><p>3. After taping check the measurement, wire alignment and taping condition.</p></div>	<div><p>Measuring tape</p></div>	<div><p>1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape</p></div> <div><p>Wire alignment tolerance</p></div> <div><p><b>Important reminders/Note/s:</b></p><p>1. Please use calibrated/verified measuring tape when getting the measurement.</p><p><b>Document references:</b></p><p>1. Please refer to <b>WI-PRO-ASY-001</b> for taping procedure.</p></div>

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	<b>WORK INSTRUCTION</b>				Effectivity Date:		July 04, 2024	
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: <b>922B / 7L0124-7022</b>		Customer: <b>TRQSS</b>		Car Model: <b>LEXUS NX</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.:		Revision No.:		5	Page No.: 3 of 4

<b>PARTS:</b>		1. Assy parts 2. Black tape [1pc]		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 Half-wrap taping	<div><div></div><div></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></div><div></div><div><p>3. Check the taping condition.</p></div></div> <div><div><b>Measuring tape</b></div></div> <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>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No exposed COT 6. No wrong windings</p></div>			

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

July 04, 2024

Validity Date:

n/a

Model code/Part number:

**922B / 7L0124-7022**

Customer:

**TRQSS**

Car Model:

**LEXUS NX**

Document No.:

**WI-ENG-PDE-266C**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

5

Page No.:

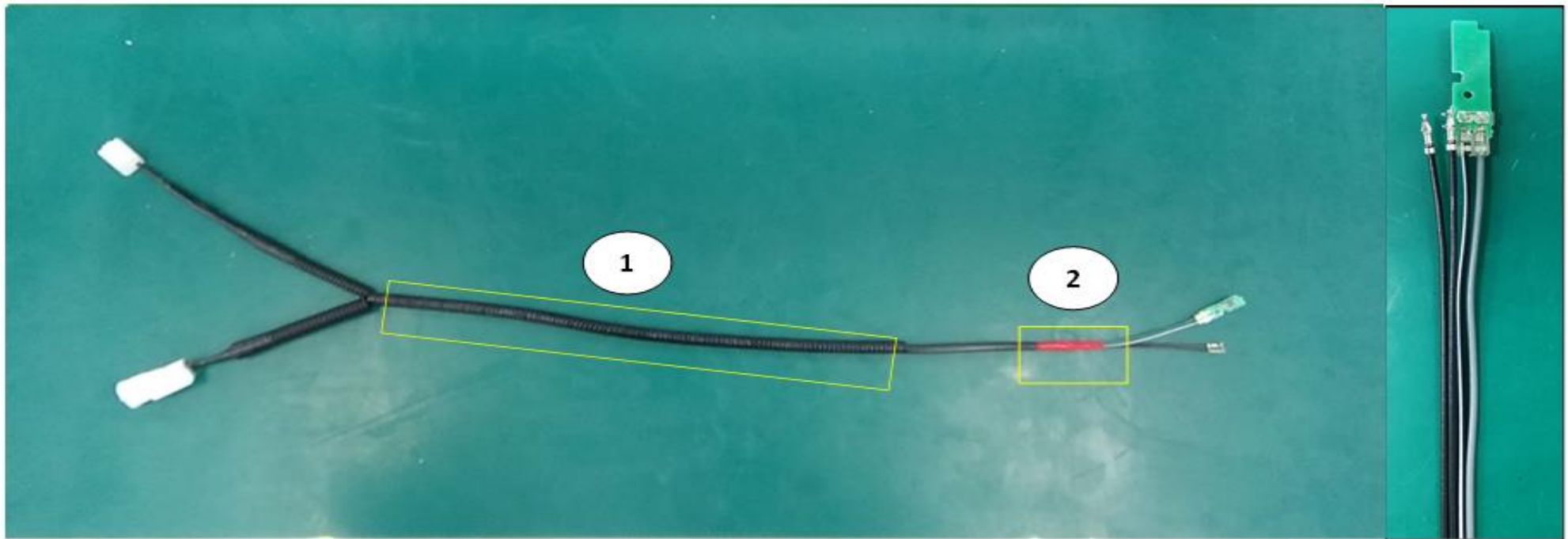
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P3****7L0124-7022****1****No MISSING TAPE****2****No Wrong use of tape****Proper alignment of  
B-B wires and hotmelt**

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