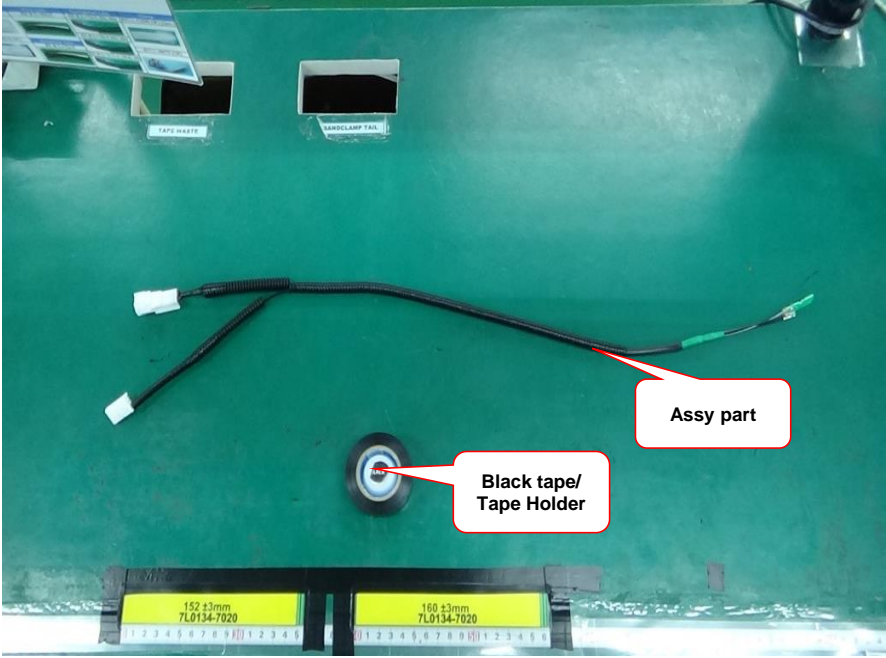
	WORK INSTRUCTION			Effectivity Date:	October 14, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 220D / 7L0134-7020B	Customer: TRQSS	Car Model: LEXUS-LM	Document No.:	WI-ENG-PDE-1099C		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> 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	<div style="border: 1px solid red; padding: 5px; text-align: center; margin-bottom: 10px;">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
10/14/24	1	Change from Pre-launch to Masspro.				D.Castillo	C.Villanueva	A. Arañes	n/a	
10/09/24	0	Initial issue. Seprate clamp assembly. Transfer process from P1 and P2.				D.Castillo	C.Villanueva	A. Arañes	n/a	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:
										October 08, 2024

**WORK INSTRUCTION**

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TAPING ASSEMBLY PROCESS

Effectivity Date:

October 14, 2024

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220D / 7L0134-7020B

Customer:

TRQSS

Car Model:

LEXUS-LM

Document No.:

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Purpose:

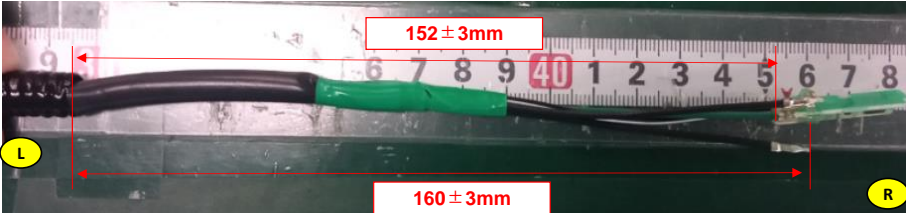
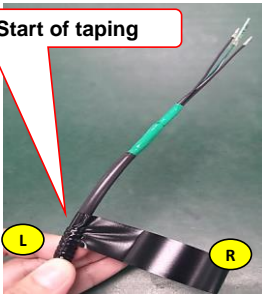
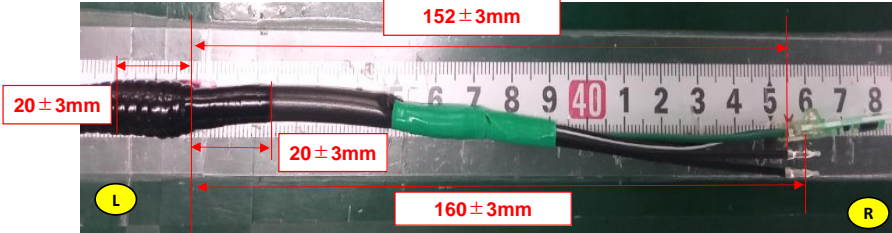

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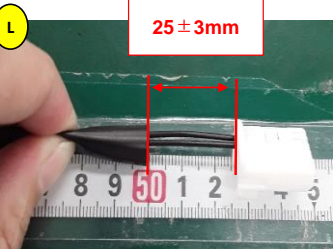

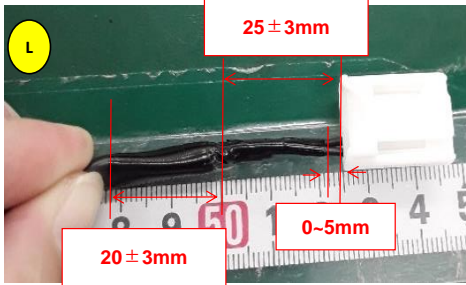

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P3 Taping 4 Black corrugated tube to Black VM tube (Sunprene)	<div></div> <div><p>1. Measure from end of VM tube (Sunprene) up to edge of hotmelted wire 152±3mm and up to terminal pointed tip 160±3mm using both hands.</p></div> <div><div><p>Start of taping</p></div><div><p>2. Get the Black tape using right hand then start taping process using both hands.</p></div><div></div><div><p>3. After taping, check the measurement and taping condition.</p></div></div>		<div><p>Measuring tape</p></div>	<p>Important reminders/Note/s:</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 use of tape 6. No wrong dimension</p> <p>Document references:</p> <p>1. Please refer to WI-PRO-ASY-001 for taping procedure.</p>

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	WORK INSTRUCTION			Effectivity Date:	October 14, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 220D / 7L0134-7020B		Customer: TRQSS	Car Model: LEXUS-LM	Document No.: WI-ENG-PDE-1099C		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> 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 Taping 5 Black SV tube (Vinyl) to wire near connector	<div><p>1. Hold vinyl tube using left hand, measure from SV tube (Vinyl) up to end of connector 25±3mm.</p></div> <div><p>2. Get Black tape using right hand, hold the SV tube (Vinyl) using left hand then fold the SV tube (Vinyl) and start taping using right hand.</p></div> <div><p>3. After taping check the measurement, wire alignment and taping condition.</p></div>	<div>Measuring tape</div> 	<p>Important reminders/Note/s:</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 use of tape 6. No wrong dimension</p> <p>Document references:</p> <p>1. Please refer to WI-PRO-ASY-001 for taping procedure.</p>	

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WORK INSTRUCTION

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TAPING ASSEMBLY PROCESS

Effectivity Date:

October 14, 2024

Model code/Part number:

220D / 7L0134-7020B

Customer:

TRQSS

Car Model:

LEXUS-LM

Document No.:

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Purpose:


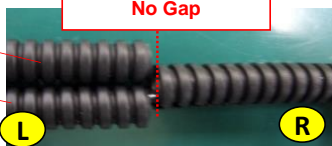
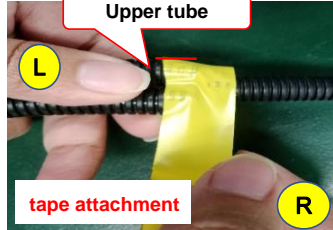

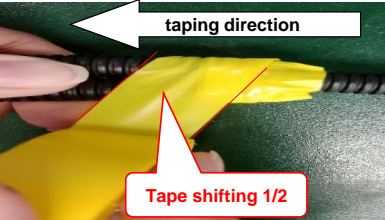
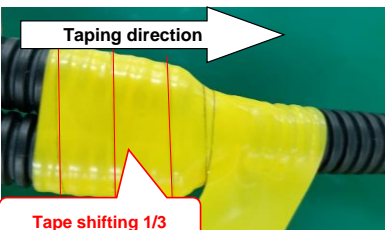
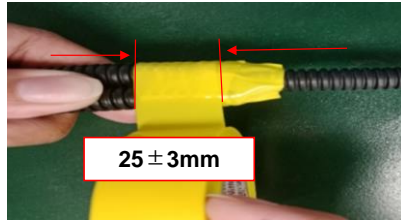
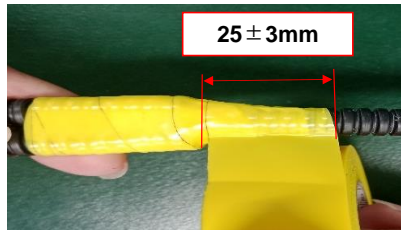
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PARTS:		1. Assy parts 2. Black tape [1pc]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P3	Y-Taping			
		<div><div><p>CONNECTOR FACING</p></div><div><p>No Gap</p><p>1. Fix the 3 corrugated tube. <i>Note: Follow the Connector facing</i></p></div><div><p>Upper tube</p><p>tape attachment</p></div><div><p>pre-tape</p></div><div><p>taping direction</p><p>Tape shifting 1/2</p><p>3. Winding the tape 1/2 shifting going to the left side.</p></div><div><p>Taping direction</p><p>Tape shifting 1/3</p><p>5. Winding the tape 1/3 shifting going to the right side until reach the other side of tube.</p></div><div><p>25 ± 3mm</p><p>4. Make 2 windings, width must be 25±3mm.</p></div><div><p>25 ± 3mm</p><p>6. Make 2 windings, width must be 25±3mm.</p></div></div> <div><p>2. Start taping at the middle of combined tubes, attach the tape on the upper tube. Then make pre-tape 2 windings. <i>Note: Do not exert excessive force during pulling & winding of tape.</i></p></div>		<div><div>1. No loose tape</div><div>2. No flip-out tape</div><div>3. No peel-off tape</div><div>4. No wrong use of tape</div><div>5. No wrong dimension-out tape</div><div>6. No exposed wire</div><div>7. No gap between tubes</div><div>8. Follow the connector facing</div></div> <div><p>Document reference/s:</p><p>1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p></div> <div><p>Important reminders/Note/s:</p><p>1. Use yellow tape for easy visualization of tape shifting, but actual should be BLACK TAPE.</p><p>2. Please use calibrated/verified measuring tape when getting the measurement.</p></div>	

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WORK INSTRUCTION

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TAPING ASSEMBLY PROCESS

Effectivity Date:

October 14, 2024

Model code/Part number:

220D / 7L0134-7020B

Customer:

TRQSS

Car Model:

LEXUS-LM

Document No.:

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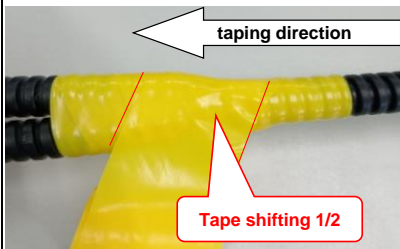
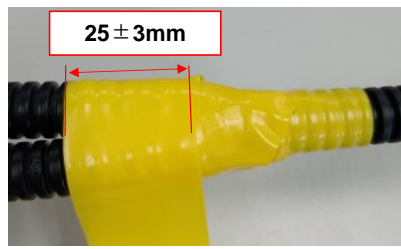
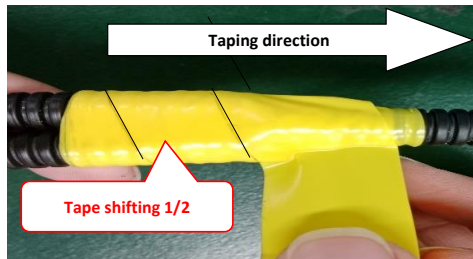
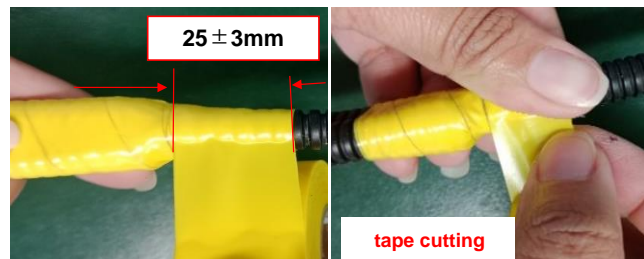
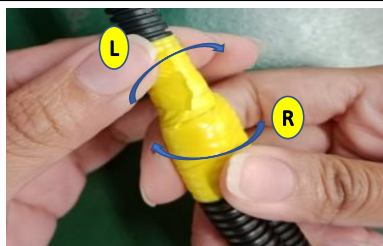

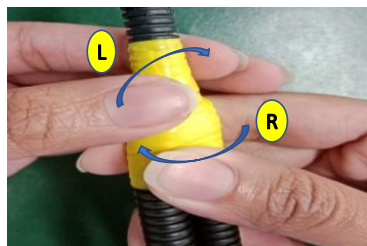
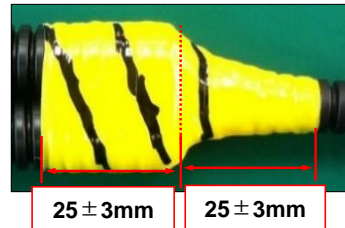
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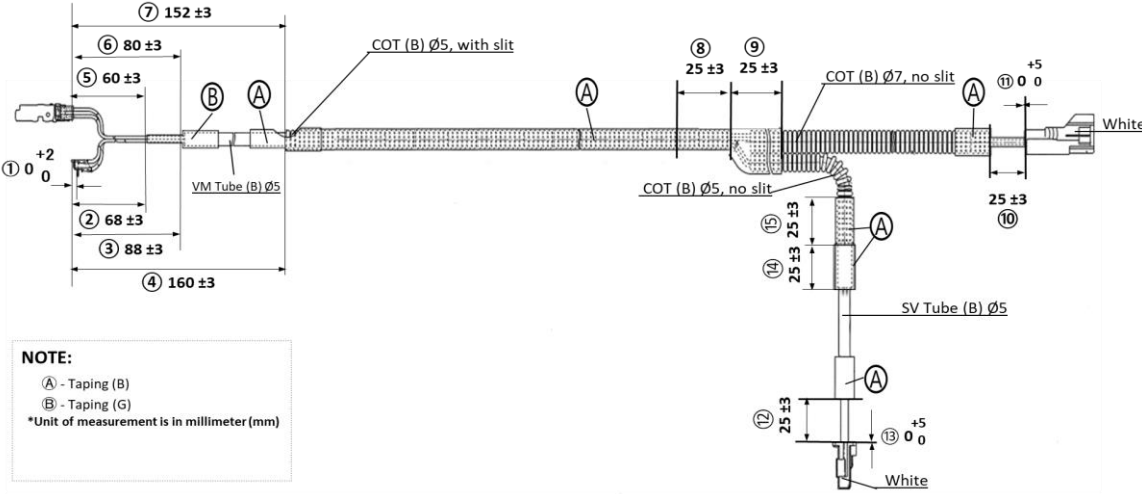
PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P3	Y-Taping (Continuation)	<div></div> <div>7. Winding the tape 1/2 shifting going to the left side.</div> <div></div> <div>8. Make 2 windings, width must be 23±2mm.</div>		<div>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension-out tape 6. No exposed wire 7. No gap between tubes</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</div> <div>Important reminders/Note/s: 1. Use <u>yellow tape</u> for easy visualization of tape shifting, but actual should be <u>BLACK TAPE</u>. 2. Please use calibrated/verified measuring tape when getting the measurement.</div>
			<div></div> <div>9. Winding the tape 1/2 shifting going to the right side until it reach the other side of tube</div> <div></div> <div>10. Make 3 winds, width must be 25±3mm. Then cut the tape.</div>		
			<div></div> <div>11. conduct proper pressing of end tape using left hand (top part)</div> <div></div> <div>12. conduct proper pressing of end tape using left hand (Middle part)</div> <div></div> <div>13. conduct proper pressing of end tape using left hand (bottom part)</div>		
			<div></div> <div>14. Check the Measurement and condition of tape.</div>		

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	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 220D / 7L0134-7020B		Customer: TRQSS	Car Model: LEXUS-LM	Document No.:	WI-ENG-PDE-1099C		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> 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		
5	P3	Measurement	<div><div>MEASURING TAPE</div></div>  <div>NOTE: A - Taping (B) B - Taping (G) *Unit of measurement is in millimeter (mm)</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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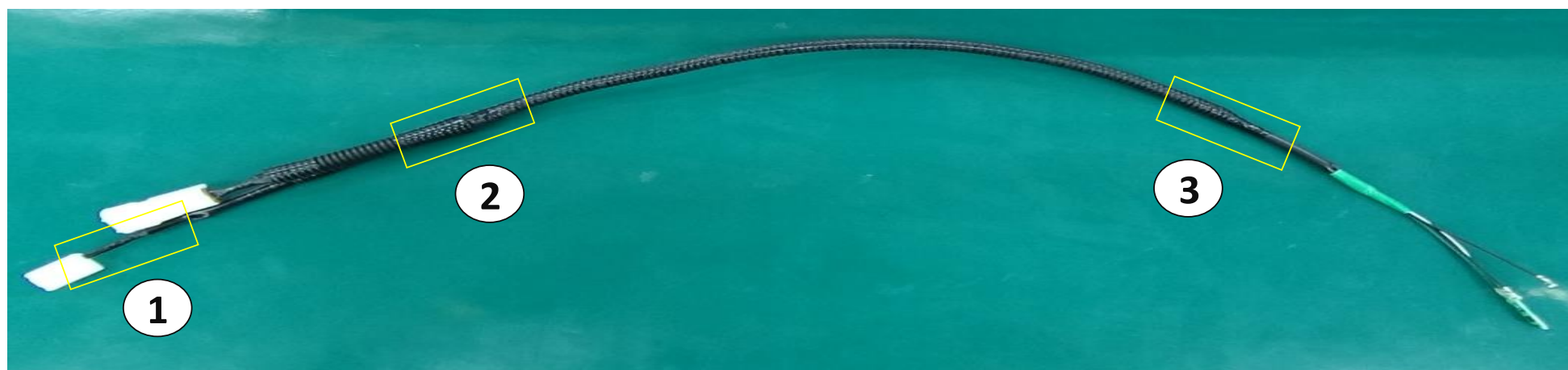
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7 of 7**PARTS:**

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P3****7L0134-7020B****1 2 3****No Missing Tape****No wrong use of tape (Black)**

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