



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 18, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

900B.910B / 7N0104-7020A

Customer:

TRJ

Car Model:

LEXUS-NX/RX

Document No.:

WI-ENG-PDE-410A

Purpose:

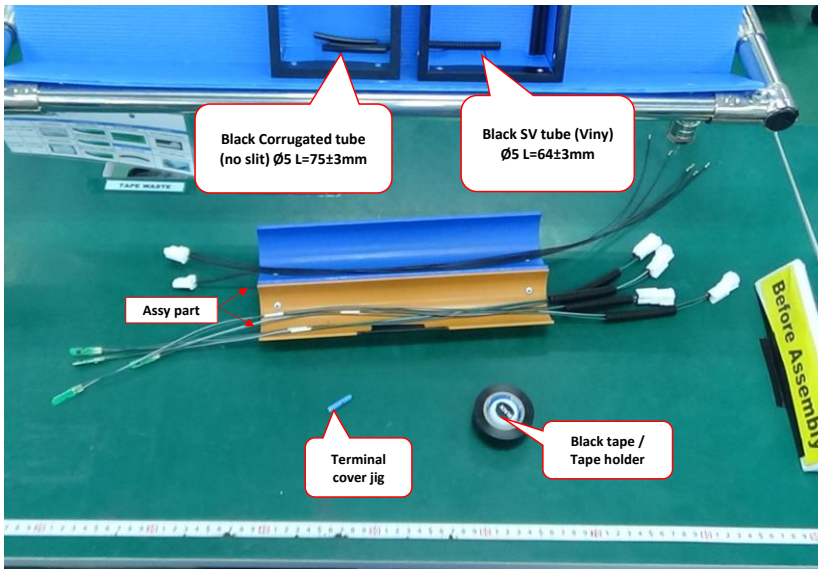
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:




4

Page No.:

1 of 6

PARTS:		1.Assy parts; Black Corrugated tube (no slit) Ø5 L=75±3mm; Black SV tube (Vinyl) Ø5 L=64±3mm		JIG:	1.Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1 4 Table Lay-out	<div>TABLE LAY-OUT</div> 		<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	<div>Document reference/s: 1. Refer to WI-ENG-PDE-808 for Offline assembly process</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>


Revision History






								Prepared by	Reviewed by	Approved by	Noted by
06/18/24	4	Separate some process to Offline assembly process. Transfer some process to WI-ENG-PDE410B due to process improvement. Update table lay-out and Quality checkpoints.	D.Castillo	C.Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a	
03/18/23	3	Work instruction improvement. Change MP from 3MP to 2MP. Transfer process from P2 (Page 2,Page 10-11). Change term Vinyl tube to SV tube (Vinyl). Update table lay-out and Quality checkpoints (Page 12).	D.Castillo	J. Loterte	C.Villanueva	A. Arañes					
12/09/22	2	Improve Quality pointers: Reminders/Notes and references on pages no.1,3,4,6,7,9,10 and 11 due to document improvements. Improve Work procedure/illustration on process 4 due to process improvement. Inclusion of Quality pointers.	M. Ariola	J. Loterte	C.Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted					Est. Date:

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		4	Page No.: 2 of 6


PARTS:		1. Black Corrugated tube (No slit) Ø5 L=75±3mm 2. Assy parts		3. Black tape 4. Black SV tube (Vinyl) Ø5 L=64±3mm		JIG:	1. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS	
2	P1	Wire insertion to Black SV tube (Vinyl) Ø5 L=64±3mm	<div><div>1. Get the Black SV tube (Vinyl) Ø5 L=64±3mm using right hand and insert B-B wires using left hand.</div></div>				n/a	1. No wrong use of part.
3		Wire insertion to Black Corrugated tube (No slit) Ø5 L=75±3mm	<div><div><div>1. Get the terminal cover jig using right hand then insert the B-B wires using left hand.</div></div><div><div>2. Get the Black COT Ø5 L=75±3mm using right hand and insert B-B wires using left hand.</div></div><div><div>3. After insertion, remove the terminal cover jig using right hand.</div></div></div> <div><div>TERMINAL COVER JIG</div></div> <td>1. No Wrong use of parts 2. No deformed terminal</td>				1. No Wrong use of parts 2. No deformed terminal	



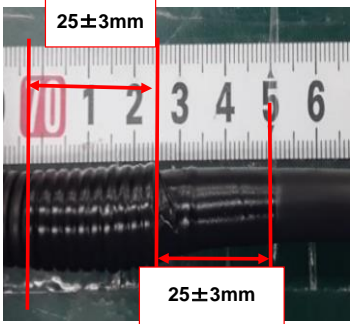

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 Taping 1 Black corrugated tube to Black SV tube (Vinyl) near connector	<div><div>1. Fix the corrugated tube and SV tube (Vinyl) using both hands. Make sure no gap between corrugated tube and SV tube (Vinyl).</div><div>2. Get the Black tape and start taping process using both hands.</div><div>3. After taping, check the measurement and taping condition.</div></div> <div><div>MEASURING TAPE</div></div>		Important reminders/Note/s: <i>1. Please use calibrated/verified measuring tape when getting the measurement.</i> <i>2. Must be no gap between COT and SV tube (vinyl).</i> 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	

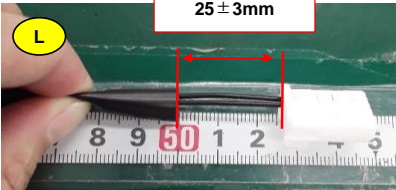
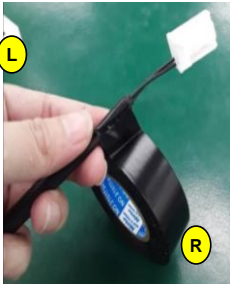
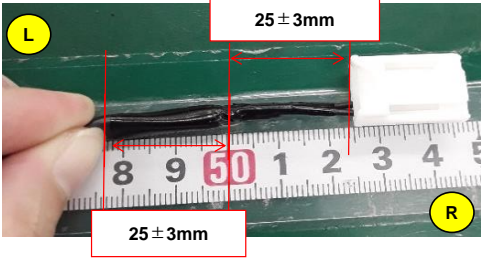

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
5	P1 Taping 2 Black SV tube (Vinyl) to wire near connector	<div><p>1. Hold SV tube (Vinyl) using left hand, measure from SV tube (Vinyl) up to end of connector 25±3mm.</p></div> <div><p>2. Get Black tape using right hand, hold the SV tube (Vinyl) (ø5 L=64±3mm) using left hand then fold the vinyl tube and start taping using right hand.</p></div> <div><p>3. After taping, check the measurement 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 dimension 6. No wrong use of tape</p>	

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Revision No.:

4

Page No.:

5 of 6

PARTS:

1. Assy parts
2. Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

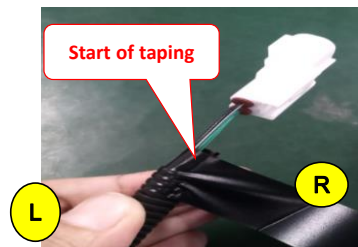
TOOLS/PPE

QUALITY POINTERS

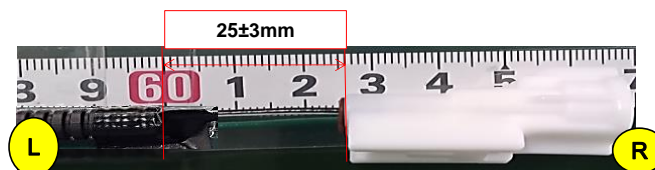
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P1

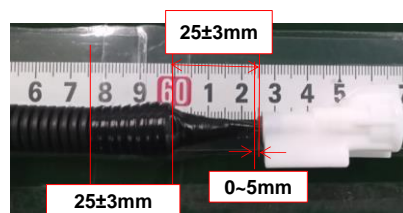
Taping 3
COT to Wire near
Connector



1. Hold the Corrugated tube using left hand then start taping using right hand.



2. Measure from end of the COT up to connector **25±3mm** then continue the 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.

Document reference/s:

1. WI-PRO-ASY-001 for taping proced.

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

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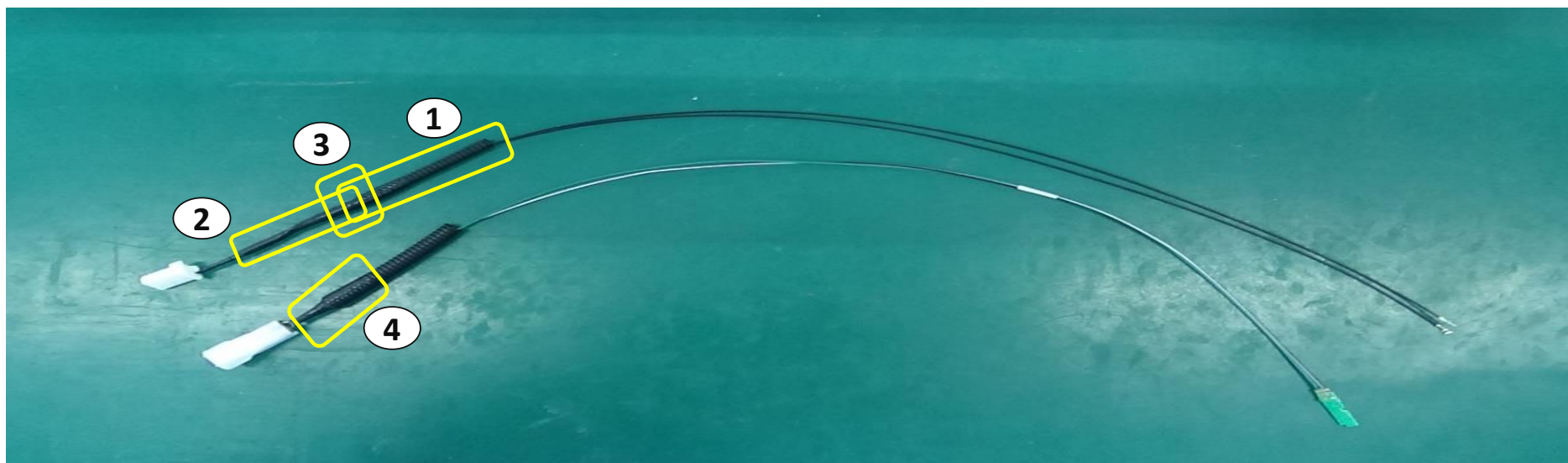
6 of 6

PARTS:

n/a

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P1****7N0104-7020A****1 No Missing COT****3 No Missing tape to COT and SV tube (Vinyl)****2 No Missing SV tube (Vinyl)****4 No Missing tape to COT to wire near connector**

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