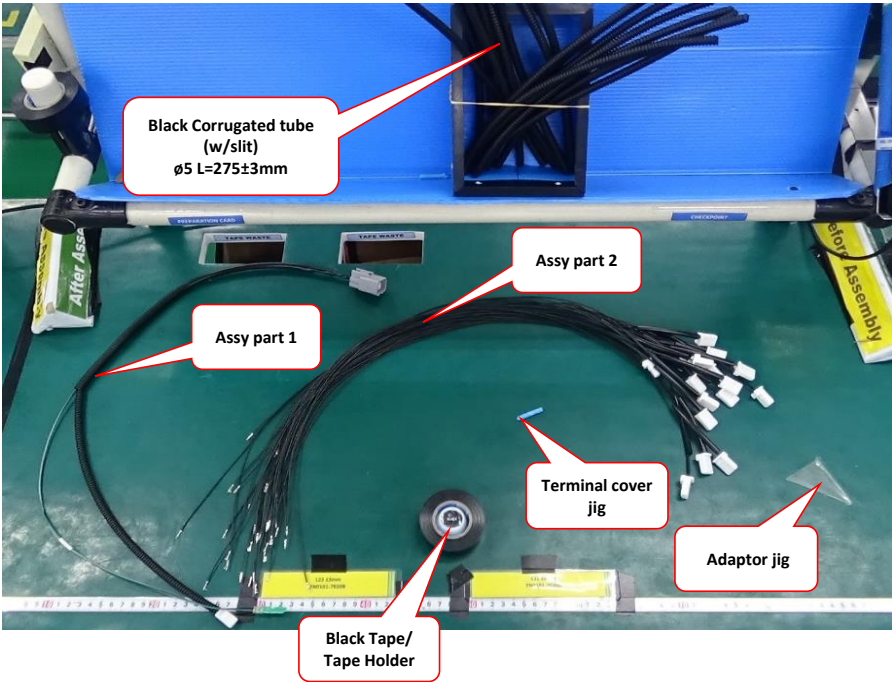



	WORK INSTRUCTION			Effectivity Date:	October 22, 2024		
	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Process Name/Title:	Model code/Part number: 800B/900B/910B / 7N0101-7020D	Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:	WI-ENG-PDE-1134B	
	Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	1	Page No.: 1 of 8

PARTS:		1. Assy parts; Black Corrugated tube (w/slit) ø5 L=275±3mm; Black Tape		JIG:	1. Terminal cover jig 2. Adaptor jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
1	P2	Table lay-out	<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>	1. No missing parts/tools 2. No excess parts/tools	

Revision History							Prepared by	Reviewed by	Approved by	Noted by
							 A. Hernandez	 C. Villanueva	 A. Arañes	n/a
10/22/24	1	Change from Pre-launch to Masspro.		A. Hernandez	C. Villanueva	A. Arañes				
10/17/24	0	Initial Issue.		A. Hernandez	C. Villanueva	A. Arañes	n/a			
Eff. Date	Rev. No	Details of Change			Revised	Reviewed	Approved	Noted	Est. Date:	October 17, 2024



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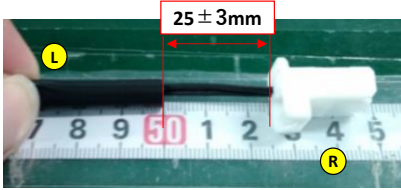
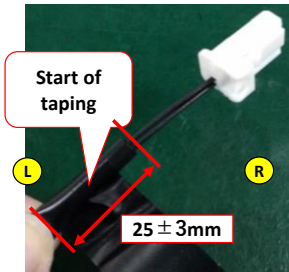
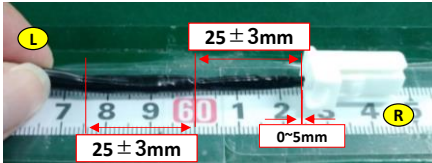

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PARTS:		1. Assy parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 2 Black SV tube (Vinyl) to wire near connector	 <p>1. Measure from end of tube up to edge of connector 25±3mm using both hands.</p>  <p>2. Hold the SV tube (Vinyl) using left hand, get the Black tape using right hand then start taping process using both hands.</p>  <p>3. After taping, check the measurement and taping condition.</p>		MEASURING TAPE 	<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>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 1. Please refer to WI-PRO-ASY-001 for taping procedure.</p>

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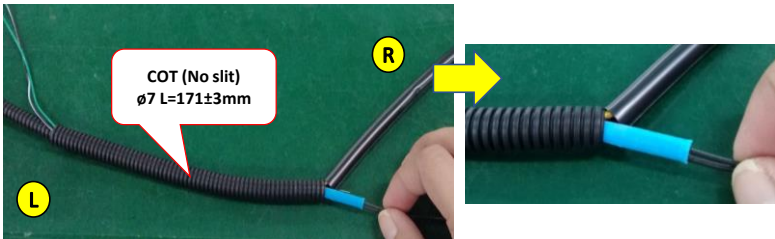


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PARTS:		1. Assy parts		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	<div><div>1. Get the cover jig then insert to B-B wires using right hand.</div></div> <div><div>2. Hold the corrugated tube (no slit) Ø7 L=171±3mm using left hand then insert B-B wires using right hand.</div></div> <div><div>3. After insertion, remove the cover jig using right hand.</div></div>		<div>TERMINAL COVER JIG</div> 	1. No wrong insertion 2. No deformed terminal

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**WORK INSTRUCTION****TAPING PROCESS ASSEMBLY**

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Validity Date:

n/aModel code/Part number: **800B/900B/910B / 7N0101-7020D**Customer: **TRJ**Car Model: **LEXUS-NX/RX**

Document No.:

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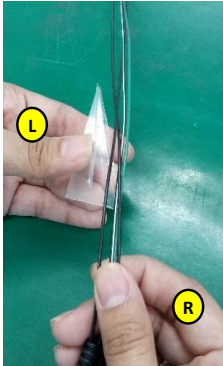
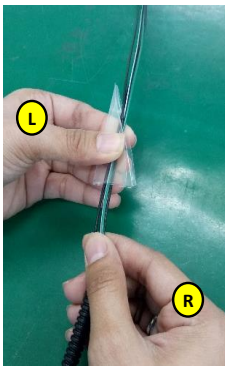
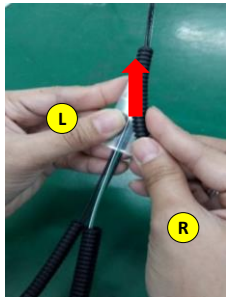
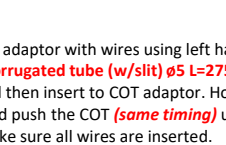

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PARTS:		1. Assy parts 2. Black Tape 3. Black corrugated tube (w/slit) $\phi 5$ L=275 \pm 3mm		JIG:	1. Adaptor jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Taping 3 Spot taping	  		n/a	1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape
5	P2 Wire insertion to Black Corrugated tube (w/slit) $\phi 5$ L=275 \pm 3mm	   		COT Adaptor 	1. No wrong use of parts 2. No wires left inside COT with slit

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Customer: TRJ

Car Model: LEXUS-NX/RX

Document No.:

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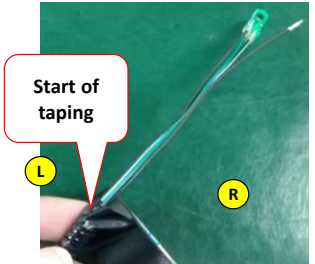
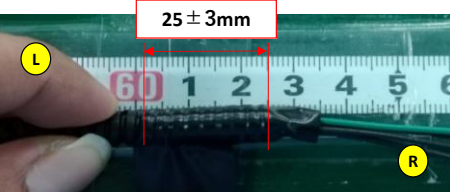
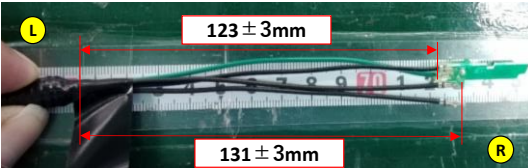
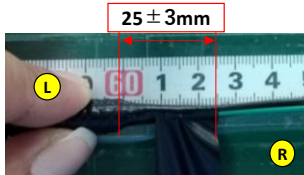
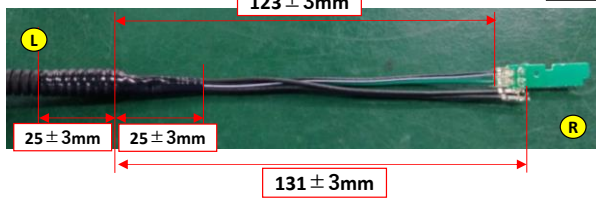

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P2	<p>Taping 4 Black Corrugated tube (w/slit) to wire near PCB and terminal tip</p>  <p>1. Hold the corrugated tube using left hand then start taping using right hand.</p>  <p>2. Confirm measurement of 25±3mm from end of tape up to COT then continue the taping process using both hands.</p>  <p>3. Measure from end of COT up to terminal pointed tip L=131±3mm; and COT to PCB L=123±3mm then continue the taping process using both hands.</p>  <p>4. Confirm measurement of 25±3mm from COT up to end of tape then continue the taping process using both hands.</p>  <p>5. After taping, check the measurement, terminal and PCB appearance and taping condition.</p>		<p>MEASURING TAPE</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> <p>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p>

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Customer:

TRJ

Car Model:

LEXUS-NX/RX

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Purpose:





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PARTS:		1. Assy part 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P2	Y-Taping	<div><p>Y-Taping 1</p><p>1. Fix the two SV tubes (Vinyl) and COT using both hands. <i>See illustration for correct facing of connector.</i></p><p>Connector facing and Y-taping facing</p><p>Top of tube</p><p>taping direction</p><p>tape shifting 1/2</p><p>2. Start taping at the middle of combined tubes, attach the tape on the top of tube. Then make pre-tape 2 windings. Winding the tape 1/2 shifting going to the left side. Make 2 windings, width must be 20±3mm. Note: Do not exert excessive force during pulling & winding of tape.</p><p>taping direction</p><p>tape shifting 1/3</p><p>3. Winding the tape 1/3 shifting going to the right side until reach the other side of tube. Make 2 windings, width must be 20±3mm.</p><p>tape shifting 1/2</p><p>taping direction</p><p>4. Winding the tape 1/2 shifting going to the left side. Make 2 windings, width must be 20±3mm.</p><p>taping direction</p><p>5. Winding the tape 1/2 shifting going to the right side until it reach the other side of tube. Make 3 winds, width must be 20±3mm. Then cut the tape.</p></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>Important reminders/Note/s:</p><p>1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.</p><p>2. Please use calibrated/verified measuring tape when getting the measurement.</p><p>Y-TAPING ORIENTATION</p></div>

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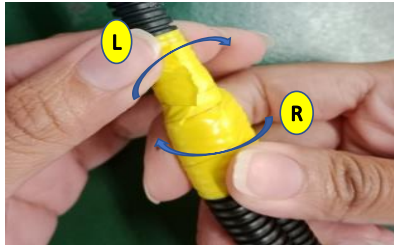
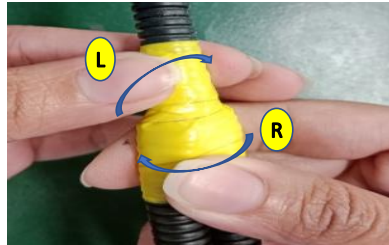
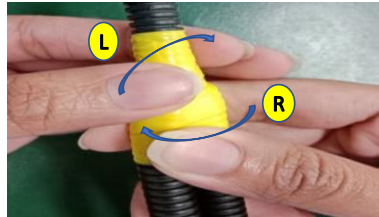
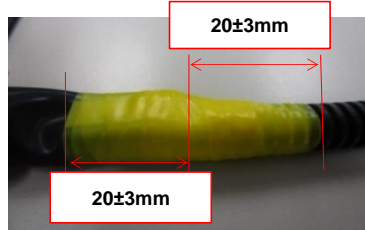
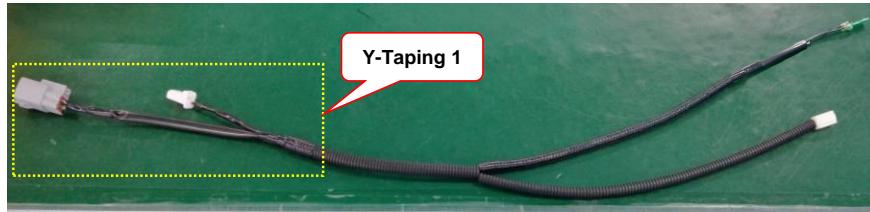


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PARTS:		1. Assy parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P2 Y-Taping (Continuation)	<div><p>6. conduct proper pressing of end tape using left hand (top part)</p></div> <div><p>7. conduct proper pressing of end tape using left hand (Middle part)</p></div> <div><p>8. conduct proper pressing of end tape using left hand (bottom part)</p></div> <div><p>9. Check the Measurement and condition of tape.</p></div> <div><p>Y-Taping 1</p></div>		<div>MEASURING TAPE</div> 	<div>Important reminders/Note/s:</div> <div>1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.</div> <div>2. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Y-TAPING ORIENTATION</div> 

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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION / QUALITY CHECKPOINTS

P2

7N0101-7020D

25±3mm SV tube(Vinyl) o
Connector
25±3mm TAPING LEGTH



25±3mm Tape Width

131±3mm COT to TERMINAL
123±3mm COT TO PCB

Proper alignment
of B-B wires and
hotmelt

1 No Missing Spot Tape(Black Tape)

2 3 4 No Missing Tape(Black Tape)

5 No Wrong facing
of wire

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