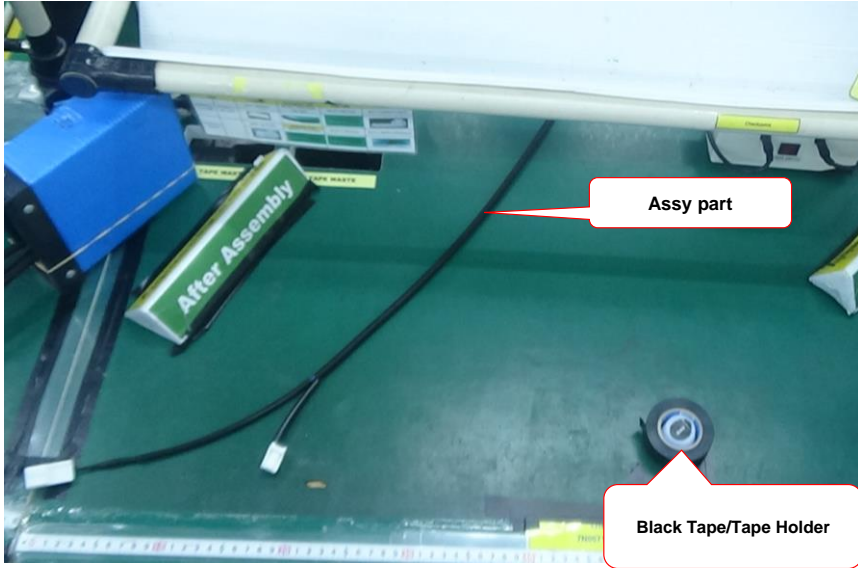


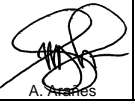
	<b>WORK INSTRUCTION</b>				Effectivity Date:	June 3, 2024		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>800B/900B/910B / 7N0071-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS-NX/RX</b>	Document No.:	<b>WI-ENG-PDE-456B</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	4	Page No.:	1 of 4

<b>PARTS:</b>	1. Assy parts; Black Tape			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
1	P2 Table Lay-out		<p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> 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		
06/03/24	4	Transfer Black vinyl tube to wire near connector taping (G-B wire) from WI-ENG-PDE-456A. Transfer Wire insertion to Black corrugated tube ø5 L=444±4mm (no slit) to WI-ENG-PDE-456A and Y-taping to WI-ENG-PDE-456C due to Process improvement. Change term from Vinyl tube to SV tube (Vinyl). Update table lay-out and improved Visual inspection.				D. Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
04/24/23	3	Inclusion of quality checkpoints				J. Loterte	C. Villanueva	A. Arañes	n/a				
10/28/22	2	Improve quality pointers: Reminders/notes and references in process no.3 and 4 due to document improvement.				M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	March 28, 2022		

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## WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Model code/Part number: 800B/900B/910B / 7N0071-7020C

Customer: TRJ

Car Model: LEXUS-NX/RX

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

June 3, 2024

Validity Date:

n/a

Document No.:

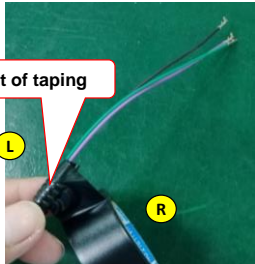
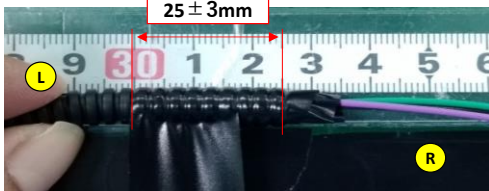
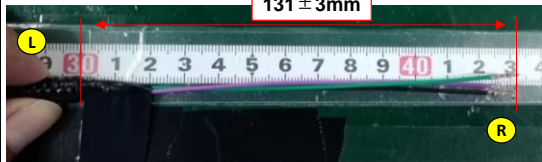
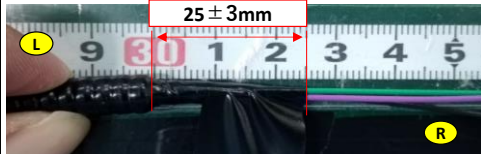


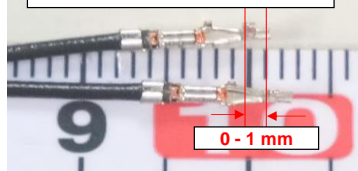
WI-ENG-PDE-456B

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4

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 2 Black COT to wire near terminal	<div><div><p>Start of taping</p></div><div><p>25 ± 3mm</p></div><div><p>2. Confirm measurement of 25±3mm from end of tape up to COT then continue the taping process using both hands.</p></div><div><p>131 ± 3mm</p></div><div><p>3. Measure from end of COT up to terminal pointed tip 131±3mm then continue the taping process using both hands.</p></div><div><p>25 ± 3mm</p></div><div><p>4. Confirm measurement of 25±3mm from COT up to end of tape then continue the taping process using both hands.</p></div><div><p>131 ± 3mm</p></div><div><p>25 ± 3mm 25 ± 3mm</p></div><div><p>5. After taping, check the measurement, terminal appearance and taping condition.</p></div></div> <div><div>MEASURING TAPE</div></div> <div><div>Wire alignment tolerance</div><p>0 - 1 mm</p><p><b>Important reminders/Note/s:</b></p><p>1. Please use calibrated/verified measuring tape when getting the measurement.</p><ul style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong dimension</li><li>6. No wrong use of tape</li></ul></div>		

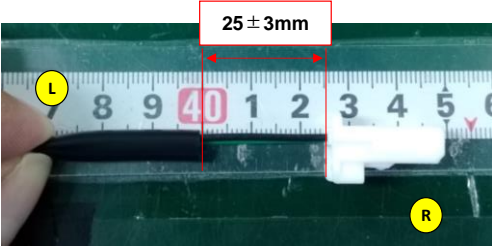
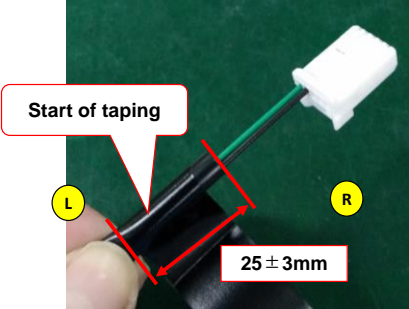
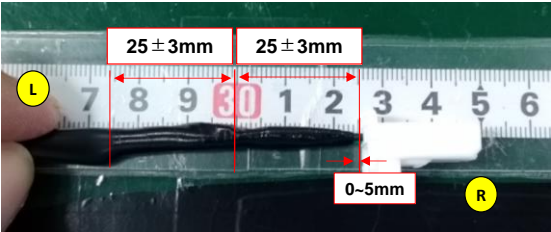

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	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>June 3, 2024</b>		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>800B/900B/910B / 7N0071-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS-NX/RX</b>	Document No.:	<b>WI-ENG-PDE-456B</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	4	Page No.:	3 of 4

<b>PARTS:</b> 1. Assy parts 2. Black tape		JIG: n/a	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>
3	P2  Taping 3 SV tube (Vinyl) to wire near to connector (G,B wire)	<div>  <p>1. Measure from end of tube up to edge of connector <b>25±3mm</b> using both hands.</p> </div> <div>  <p>2. Hold the tube using left hand, get the <b>Black tape</b> using right hand then start taping process using both hands.</p> </div> <div>  <p>3. After taping, check the measurement and taping condition.</p> </div>	<div> <b>MEASURING TAPE</b> </div>  <div> <b>Important reminders/Note/s:</b>            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 dimension            6. No wrong use of tape         </div>

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**June 3, 2024**

Validity Date:

**n/a**Model code/Part number: **800B/900B/910B / 7N0071-7020C**Customer: **TRJ**Car Model: **LEXUS-NX/RX**

Document No.:

**WI-ENG-PDE-456B**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

**4**

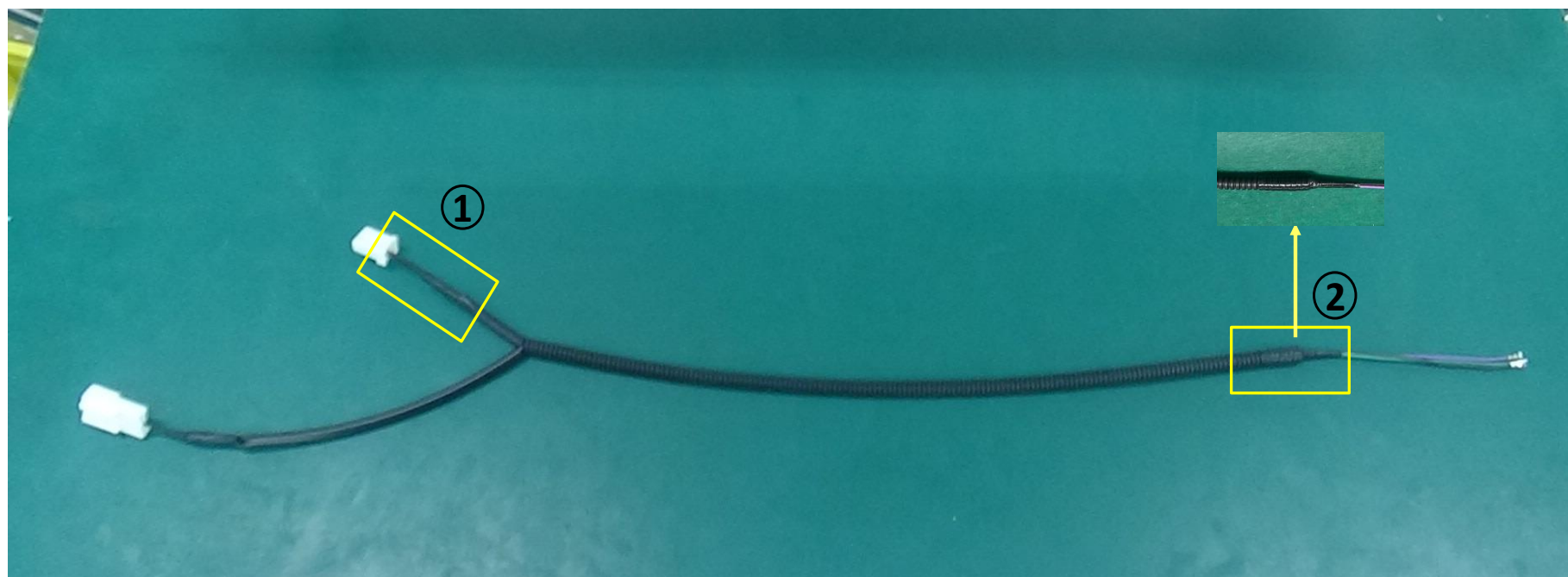
Page No.:

**4 of 4****PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION****P2****7N0071-7020C****①② No Missing Tape**

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