
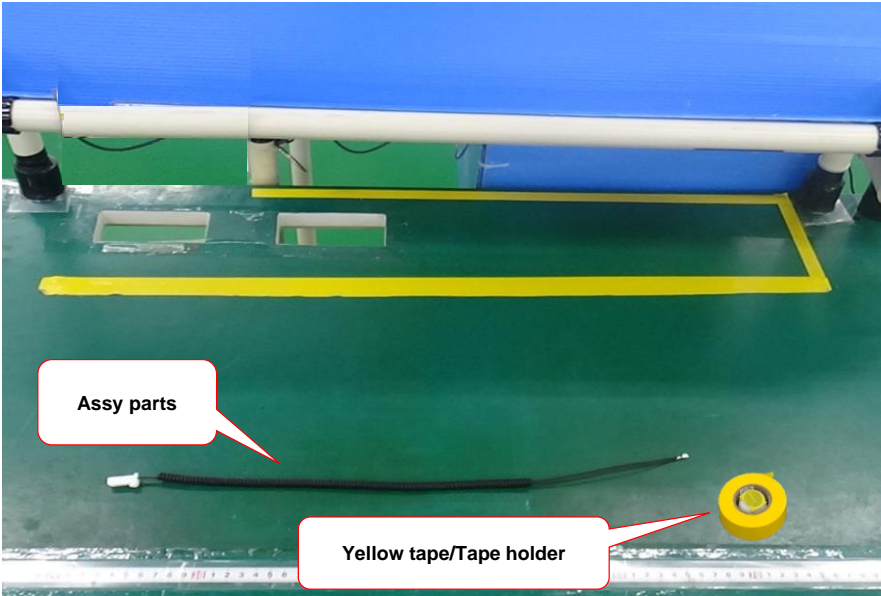


| | | | | | | | | |
|---|---|--|----------------|---------------------|-------------------|-----------|----------------|--|
|  | WORK INSTRUCTION | | | | Effectivity Date: | | June 11, 2024 | |
| | Process Name/Title: TAPING ASSEMBLY PROCESS | | | | Validity Date: | | n/a | |
| | Model code/Part number: 200D/220D / 7R0131-7021 | | Customer: TRMX | Car Model: LEXUS-LM | Document No.: | | WI-ENG-PDE-592 | |
| | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO | | Revision No.: | | 3 | Page No.: | 1 of 4 | |

| | | | | | | | | |
|--------|---|---|--|------|---|---|--|--|
| PARTS: | 1. All parts: Assy parts; Yellow tape [1pc] | | | JIG: | n/a | | | |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | | TOOLS/PPE | QUALITY POINTERS | | |
| 1 | P1 | <div>TABLE LAY-OUT</div>  <div>Assy parts</div> <div>Yellow tape/Tape holder</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> | Document references: 1. Refer to WI-ENG-PDE-591 Offline Assembly Process 1. No missing parts/tools 2. No excess parts/tools | | |

| | | | | | | | | | |
|------------------|---------|---|--|--|--|-------------|---------------|---------------|-----------|
| Revision History | | | | | | Prepared by | Reviewed by | Approved by | Noted by |
| 06/11/24 | 3 | Separate Clamp setting, Clamp assembly and Visual inspection to Clamp assembly process due to process improvement. Update table lay-out. Improved Visual inspection. Inclusion of Measurement and Car name "Lexus-LM" | | | | D.Castillo | C. Villanueva | A. Arañes | n/a |
| 04/28/23 | 2 | Inclusion of quality checkpoints. | | | | J.Loterte | C. Villanueva | A. Arañes | n/a |
| 10/21/22 | 1 | Change from Pre-Launch to Masspro. | | | | M. Ariola | J.Loterte | C. Villanueva | A. Arañes |
| Eff. Date | Rev. No | Details of Change | | | | Revised | Reviewed | Approved | Noted |

| | | | |
|------------|------------------|--|--|
| Est. Date: | October 03, 2022 | | |
|------------|------------------|--|--|

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 11, 2024

Model code/Part number:

200D/220D / 7R0131-7021

Customer:

TRMX

Car Model:

LEXUS-LM

Document No.:

WI-ENG-PDE-592

Purpose:



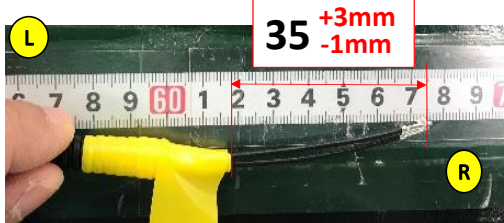
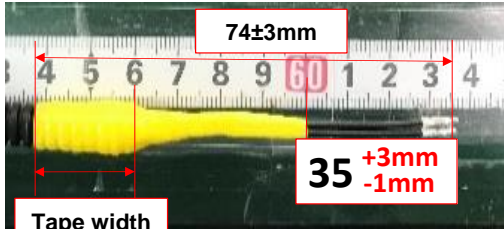

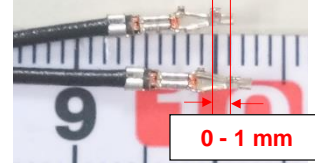
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

Page No.:


2 of 4

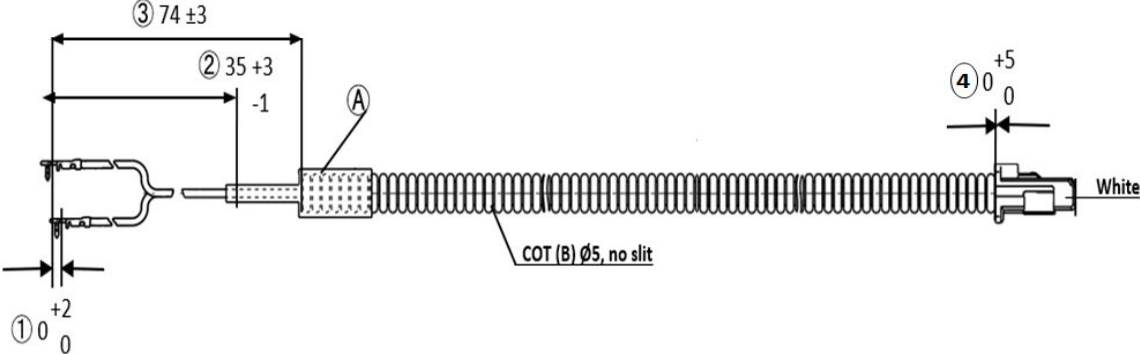

| PARTS: | | 1. Assy parts 2. Yellow tape [1pc] | | JIG: | n/a |
|--------|--|---|--|---|--|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 2 | P1 Taping 1 Corrugated tube to wire near terminal | <div><p>Start of taping</p></div> <div><p>74±3mm</p></div> <div><p>1. Get the Yellow tape, hold the Corrugated tube using left hand then start pre-taping the COT to wire near terminal.</p></div> <div><p>35 $+3mm$ $-1mm$</p></div> <div><p>2. Measure the end of the Corrugated tube up to the terminal tip 74±3mm. Then, continue the taping process.</p></div> <div><p>74±3mm</p><p>35 $+3mm$ $-1mm$</p><p>Tape width</p></div> <div><p>3. Confirm measurement of 35 (+3/-1mm) from end of tape up to terminal pointed tip then continue the taping process using both hands.</p></div> <div><p>4. After taping, check the dimension, taping condition and wire alignment.</p></div> | | <div><p>MEASURING TAPE</p></div>  | <div><p>Important reminders/Note/s:</p><p>1. Use YELLOW TAPE only.</p><p>2. Please use calibrated/verified measuring tape when getting the measurement.</p></div> <div><p>Document references:</p><p>1. Refer to WI-PRO-ASY-001 for Taping process</p></div> <div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div> |

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

| | | | | | | | |
|---|---|--|-----------------------|----------------------------|-------------------------------------|-----------|--------|
|  | WORK INSTRUCTION | | | Effectivity Date: | June 11, 2024 | | |
| | Process Name/Title: TAPING ASSEMBLY PROCESS | | | Validity Date: | n/a | | |
| | Model code/Part number: 200D/220D / 7R0131-7021 | | Customer: TRMX | Car Model: LEXUS-LM | Document No.: WI-ENG-PDE-592 | | |
| | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO | | | Revision No.: | 3 | Page No.: | 3 of 4 |

| | | | | | |
|---------------|---------------------|---|--|---|-----|
| PARTS: | 1. Assy parts | | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS | |
| 3 | P1 Measurement | <div></div> <div>NOTE: A - Taping (Y)</div> | <div>MEASURING TAPE</div>  | <p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p> | |

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 11, 2024

Model code/Part number:

200D/220D / 7R0131-7021

Customer:

TRMX

Car Model:

LEXUS-LM

Document No.:

WI-ENG-PDE-592

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

3

Page No.:

4 of 4

PARTS:

1. Assy parts

JIG:

n/a

**QUALITY CHECKPOINTS****TAPING - P1****7R0131-7021****1 No Missing/Wrong Used of Tape (Yellow tape)**

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp