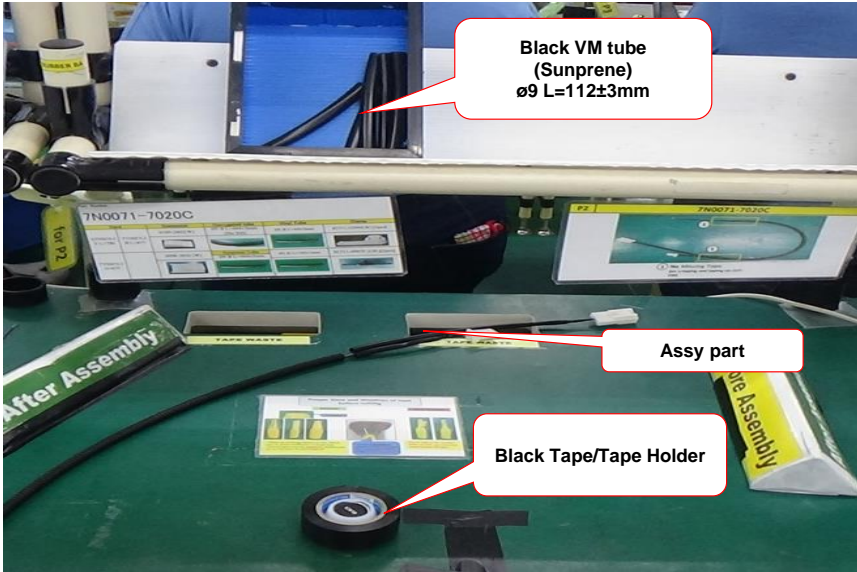


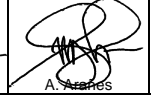
	WORK INSTRUCTION				Effectivity Date:	June 3, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 800B/900B/910B / 7N0071-7020C		Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:	WI-ENG-PDE-456C		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	4	Page No.:	1 of 5

PARTS:	1. Assy parts: Black VM tube (Sunprene) ø9 L=112±3mm; Black tape [1pc.]			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
1	P3 Table Lay-out	<div style="text-align: center;"> <div style="border: 1px solid red; padding: 2px; display: inline-block;">TABLE LAY-OUT</div>  </div>	<div style="border: 1px dashed red; padding: 5px;"> <p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>	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 Y-taping from WI-ENG-PDE-456B. Separate Clamp setting, Clamp assembly and By two's inspection due to Process improvement. Change term from Sunprene tube to VM tube (Sunprene). Update table lay-out and improved visual inspection and Measurement.	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, notes reference in process no.2,4,5,6 and 7 as document improvement. Work procedure and illustration in process no.6 - visual/by two's inspection	M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	March 28, 2024

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WORK INSTRUCTION

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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:

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PARTS:

4

1. Assy parts
2. Black VM tube (Sunprene) $\varnothing 9$ L=112 \pm 3mm

3. Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

Wire insertion to Black VM tube (Sunprene) $\varnothing 9$ L=112 \pm 3mm



1. Get the Black VM tube (Sunprene) $\varnothing 9$ L=112 \pm 3mm using right hand then insert the B-V-G wires.

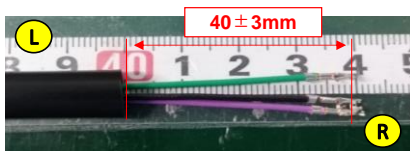
n/a

1. No wrong use of parts
2. No deformed terminal

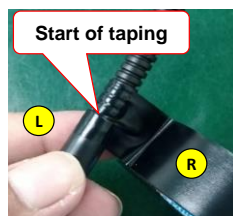
3

P3

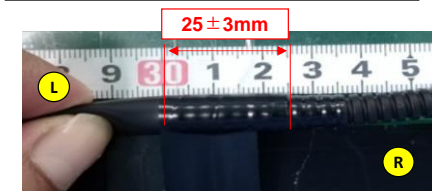
Taping 1 Black COT to VM tube (Sunprene) near terminal



1. Measure from end of tube up to terminal pointed tip 40 \pm 3mm using both hands.



2. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.



3. Confirm measurement of 25 \pm 3mm from end of tape up to end of tube then continue the taping process using both hands.

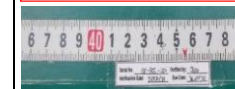


4. Confirm measurement of 25 \pm 3mm from end of tube up to end of tape then continue the taping process using both hands.



5. After taping, check the measurement, terminal appearance and taping condition.

MEASURING TAPE



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

Important reminders/Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.

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Customer:

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Car Model:

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH



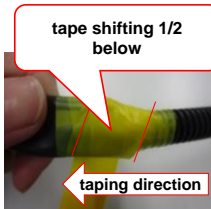


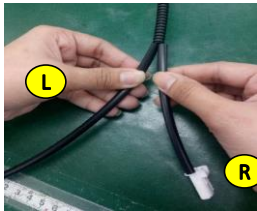

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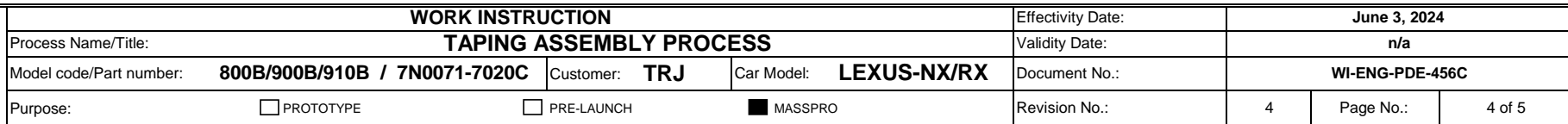
3 of 5

PARTS:		1. Assy parts 2. Black tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P3 Y-Taping	<div><p>1. Fix the two Vinyl tubes and COT using both hands. <i>See illustration for correct facing of connector.</i></p><p>2. Hold two vinyl tube using left hand and fix to COT. Make 1 winding for pre-tape before shifting then wind the tape down to vinyl tube until 25±3mm.</p><p>3. From vinyl tube, make 1/3 shifting to COT until 25±3mm. Wind the tape 1 time before shifting.</p><p>4. From COT, wind the tape down to vinyl tube (1/2 shifting) until 25±3mm.</p><p>5. From vinyl tube, wind the tape (1/2 shifting) going to side of corrugated tube then cut the tape after 2 windings. After taping, check the condition of tape.</p></div>	n/a	<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>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>Y-TAPING ORIENTATION</p> 

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**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**

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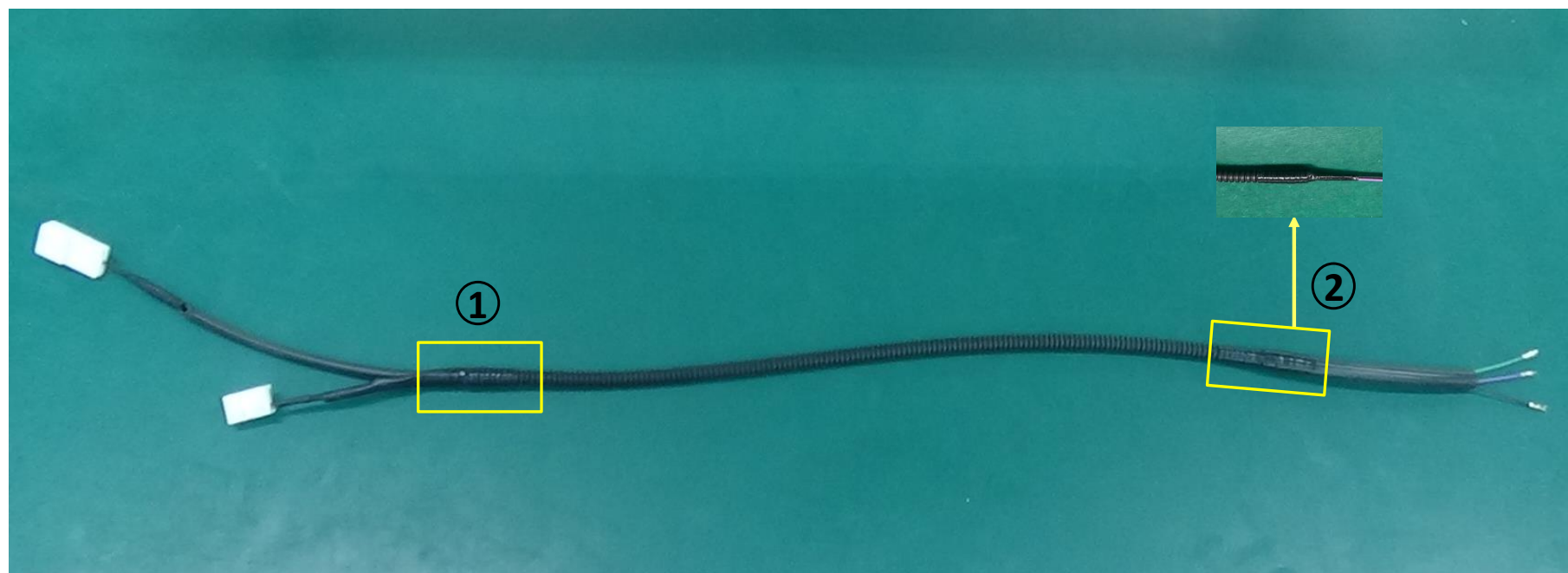
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION****P3****7N0071-7020C****①② No Missing Tape**

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