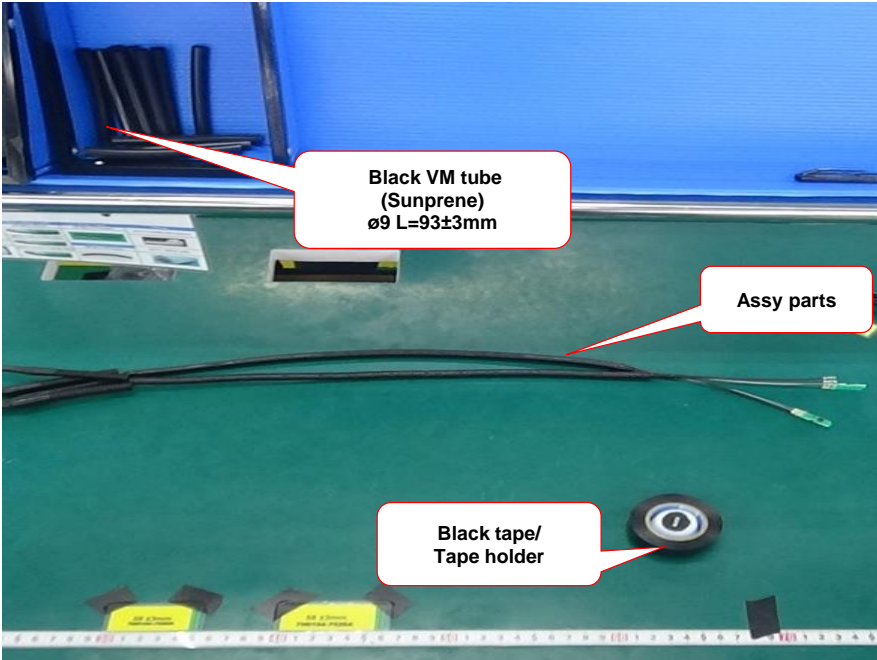
	WORK INSTRUCTION				Effectivity Date:	June 18, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 900B.910B / 7N0104-7020A		Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:	WI-ENG-PDE-410C		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	1 of 6

PARTS:	1.Assy parts; Black VM tube (Sunprene) ø9 L=93±3mm; Black tape			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P3	<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>	1. No missing parts/tools 2. No excess parts/tools

Revision History				Prepared by	Reviewed by	Approved by	Noted by
06/18/24	0	Initial issue.		D.Castillo	C.Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: June 18, 2024

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900B.910B / 7N0104-7020ACustomer: **TRJ**

Car Model:

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Document No.:

WI-ENG-PDE-410C

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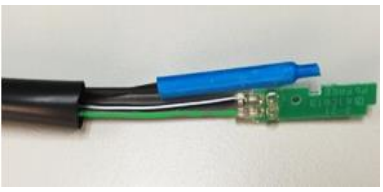
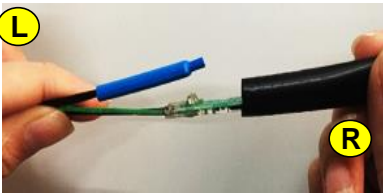


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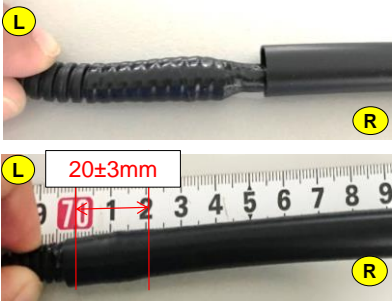
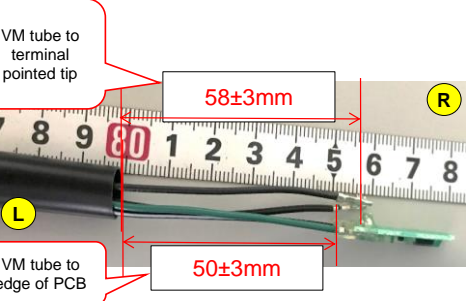



PARTS:		1. Assy part 2. Black VM tube (Sunprene) $\varnothing 9$ L=93 \pm 3mm		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P3 Wire insertion to Black VM tube (Sunprene) $\varnothing 9$ L=93 \pm 3mm	<div></div> <div>1. Get the terminal cover jig using right hand then insert the terminal B-B wires using left hand.</div> <div>2. Hold the Black VM tube (Sunprene) $\varnothing 9$ L=93\pm3mm using right hand then Insert first the hotmelted wires and then next the B-B wires with cover jig using left hand.</div> <div>3. After insertion, remove the terminal cover jig using right hand.</div>		<div>TERMINAL COVER JIG</div> 	1. No wrong use of parts 2. No deformed terminal

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	3 of 6

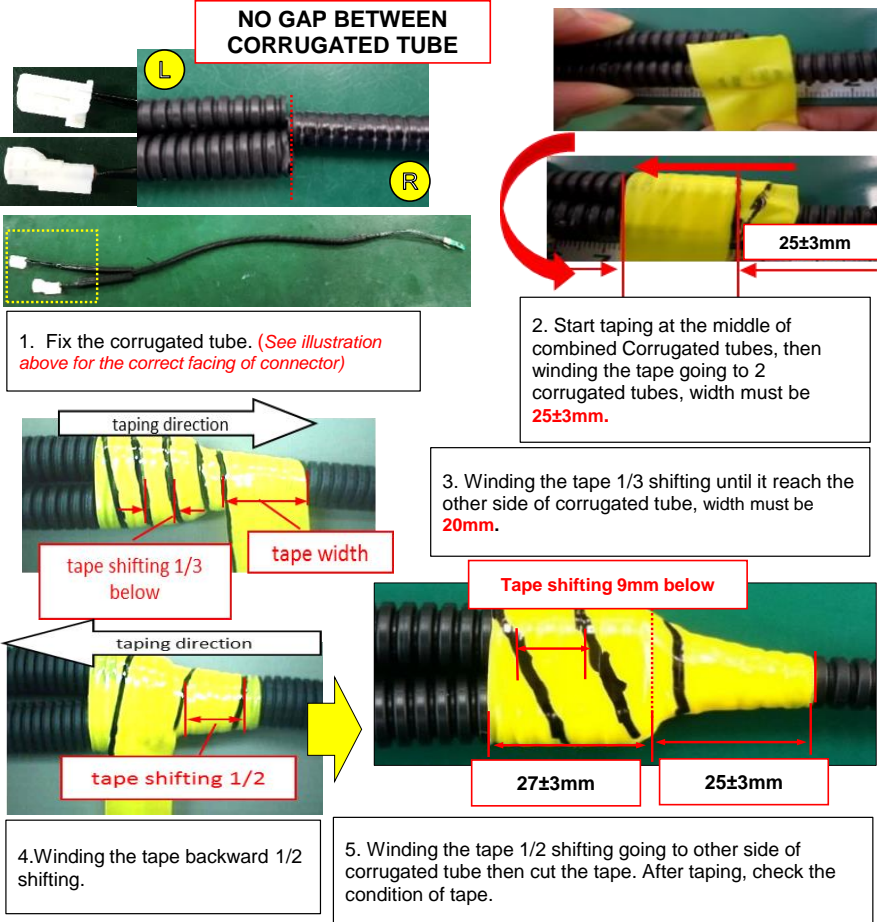

PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3 Taping 1 Black Corrugated tube to VM tube (Sunprene)	<div><p>1. Hold the COT using left hand and insert the VM tube (Sunprene) $\varnothing 9$ L=93\pm3mm .</p><p>NOTE: COT must be inserted to VM tube (Sunprene) (20\pm3mm).</p></div> <div><p>VM tube to terminal pointed tip</p><p>58\pm3mm</p><p>50\pm3mm</p><p>VM tube to edge of PCB</p><p>3. Hold the assy parts using left hand. Measure from VM tube (Sunprene) to terminal pointed tip 58\pm3mm.</p></div> <div><p>25\pm3mm</p><p>58\pm3mm</p><p>50\pm3mm</p><p>25\pm3mm</p><p>5. After taping, check the measurement and taping condition.</p></div> <div><p>4. Hold the assy parts using left hand. Get the Black tape and start taping using right hand.</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. Check the tape from COT to Vinyl (Conduct bending for verification) 2.No flip out tape. 3.No tape peeling. 4.No loose tape</p>

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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	P3	Y-Taping	<div><p>NO GAP BETWEEN CORRUGATED TUBE</p><p>1. Fix the corrugated tube. (See illustration above for the correct facing of connector)</p><p>2. Start taping at the middle of combined Corrugated tubes, then winding the tape going to 2 corrugated tubes, width must be 25±3mm.</p><p>3. Winding the tape 1/3 shifting until it reach the other side of corrugated tube, width must be 20mm.</p><p>4. Winding the tape backward 1/2 shifting.</p><p>5. Winding the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.</p><p>MEASURING TAPE</p></div>	<div><p>Connector Orientation</p><ul style="list-style-type: none">1. No peel-off tape2. No flip out tape3. No loose tape4. No wrong use of tape5. No wrong dimension6. No missing tape<p>Important reminders/Note/s</p><ul style="list-style-type: none">1. Please use calibrated/verified measuring tape when getting the measurement.2. Used YELLOW TAPE to easily visualize the tape shifting, but actual should be BLACK TAPE3. Do not exert excessive force during pulling and winding of tape</div>	

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PARTS:

1. Assy parts

JIG:

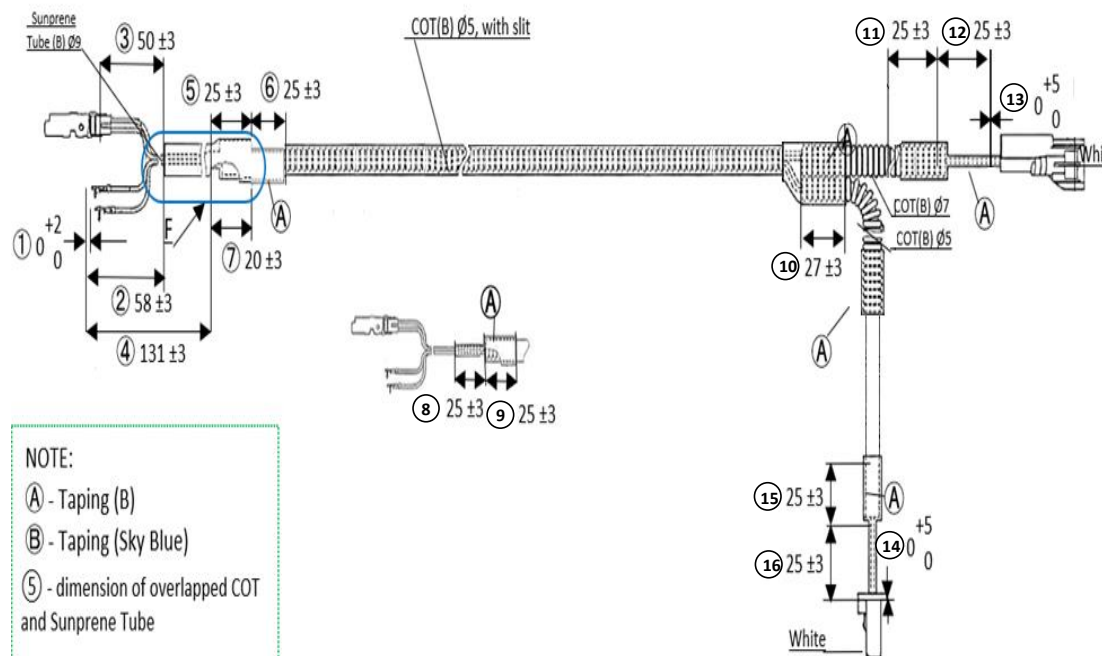
n/a

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

4

CLAMP
ASSY

Measurement



1. No wrong dimension.

Important reminders and note/s:

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

2. For Hatsumono, Nakamono and Owarimono.

Document reference/s:

1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection

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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

P3

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1 No Missing Y-Taping

2 No Missing tape to COT to VM tube (Sunprene)

3 No Missing tape to COT to VM tube (Sunprene)

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