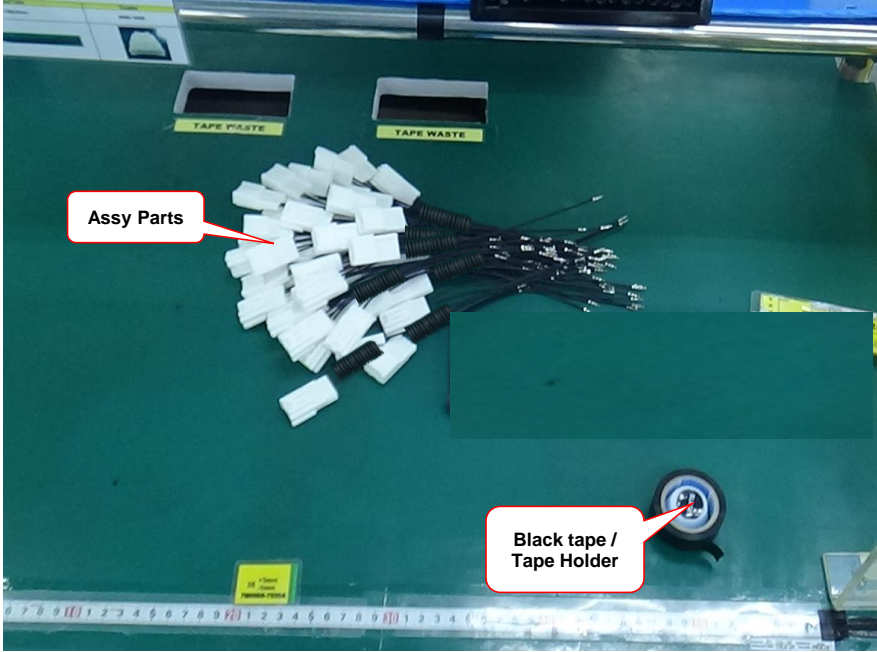
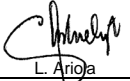

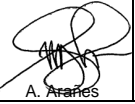
	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>May 22, 2024</b>		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>100B / 7M0585-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS UX</b>	Document No.:	<b>WI-ENG-PDE-220</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	6	Page No.:	1 of 5


<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	P1	<p><b>TABLE LAY-OUT</b></p> 	<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>	<p><b>Document reference/s:</b> 1. Refer to <b>WI-ENG-PDE-219 7M0585-7020A</b> - Offline Assembly process.</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>	

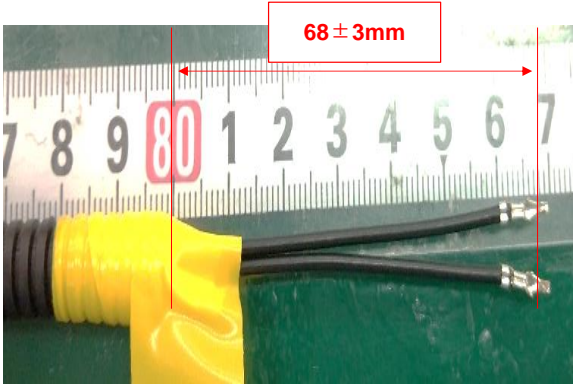
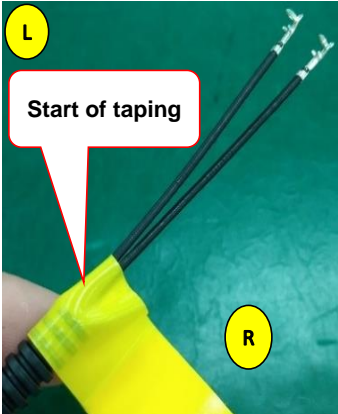

  

Revision History								Prepared by	Reviewed by	Approved by	Noted by		
05/22/24	6	Improved Measurement and Visual Inspection. Inclusion of car model "LEXUS UX". Removal by two's.				L. Ariola	C. Villanueva	A. Arañes	n/a	 L. Ariola	 C. Villanueva	 A. Arañes	n/a
05/11/23	5	Inclusion of quality checkpoints.				M. Catapang	J. Loterte	A. Shimamura	A. Arañes				
9/09/22	4	Additional table lay-out. Improve quality pointers: Reminders/notes and references in process no.1,3,4 and 5 due to document improvement. Work procedure/illustration in process4. Change of tolerance from end of tape up to terminal pointed tip 35+3mm/-3mm to 35+3mm/-1mm as countermeasure due to encountered minimum dimension.				M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	May 17, 2018		

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	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>May 22, 2024</b>		
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>100B / 7M0585-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS UX</b>	Document No.: <b>WI-ENG-PDE-220</b>		
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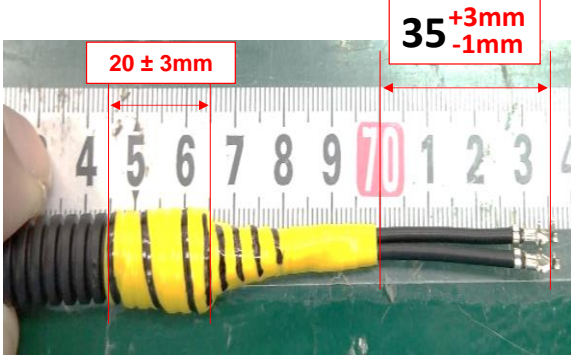

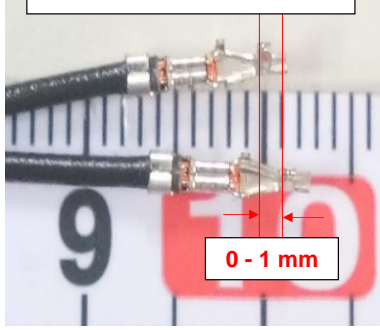
<b>PARTS:</b>		1. Assy parts 2. Black tape		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	P1  Taping 1 COT to wire near terminal pointed tip	<div></div> <div>1. Hold the COT using left hand. Get the <b>Black tape</b> and conduct pre-taping between COT and wire using both hands.</div> <div>2. Hold the corrugated tube using left hand and measure from end of COT to terminal pointed tip of Black wires <b>68±3mm</b> then continue the taping process.</div>		<div>MEASURING TAPE</div> 	<b>Important reminders/Note/s:</b> <b>1. Use <u>YELLOW TAPE</u> for easy visualization of shifting lines, but actual should be <u>BLACK TAPE</u>.</b> <b>2. Please use calibrated/verified measuring tape when getting the measurement.</b>  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

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	WORK INSTRUCTION			Effectivity Date:	May 22, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 100B / 7M0585-7020A		Customer: TRJ	Car Model: LEXUS UX	Document No.:	WI-ENG-PDE-220	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	6	Page No.:	3 of 5


PARTS:		1. Assy parts 2. Black tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
3	P1  Taping 1 COT to wire near terminal pointed tip (Continuation)	<div></div> <div>3. Wind the tape upward <b>1/2 shifting</b> until it reach the end of the corrugated tube.</div> <div></div> <div>4. Wind the tape <b>1/3 shifting</b> (4 windings) until it reach the <b>35+3mm/-1mm</b> measurement from end of taping up to the pointed tip (<b>make 3 windings and cut</b>).</div> <div></div> <div>5. After taping, check the taping condition, measurement and wire alignment.</div>		<div>MEASURING TAPE</div> 	<div><b>Important reminders/Note/s:</b> 1. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines, but actual should be <b>BLACK TAPE</b>. 2. Please use calibrated/verified measuring tape when getting the measurement.  <b>Document references:</b> 1. Refer to <b>GL-PRO-ASY-029</b> for Pull-Push procedure. 2. Refer to <b>WI-ENG-PDE-588</b> for Tape and tube end standard tolerance</div> <div>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> <div><b>Wire alignment tolerance</b></div> 	

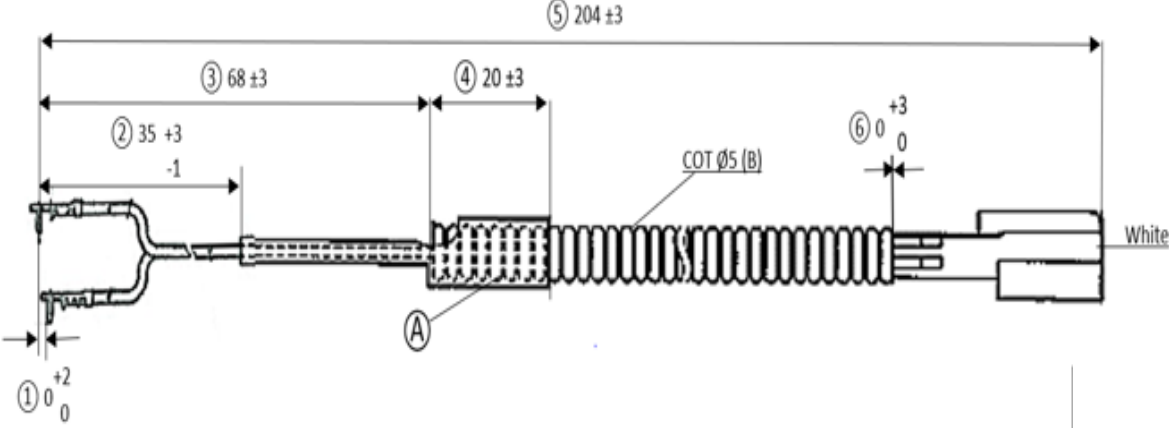

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	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>May 22, 2024</b>			
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a			
	Process Name/Title:		Model code/Part number: <b>100B / 7M0585-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS UX</b>	Document No.:	<b>WI-ENG-PDE-220</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	6	Page No.:	4 of 5	

<b>PARTS:</b>	1. Assy parts			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
4	P1	Measurement	<div>Measuring tape</div>  <p><b>NOTE:</b> ① - Taping (B) for item number ②, Dimension tolerance is different from the master drawing due to Internal change only.</p>	 <p><b>Important reminders and note/s:</b> 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b> 1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection.</p>	1. No wrong dimension

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

May 22, 2024

Validity Date:

n/a

Model code/Part number:

**100B / 7M0585-7020A**Customer: **TRJ**

Car Model:

**LEXUS UX**

Document No.:

**WI-ENG-PDE-220**

Purpose:

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Revision No.:

6

Page No.:

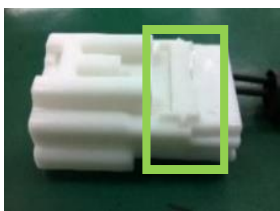
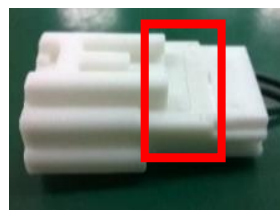
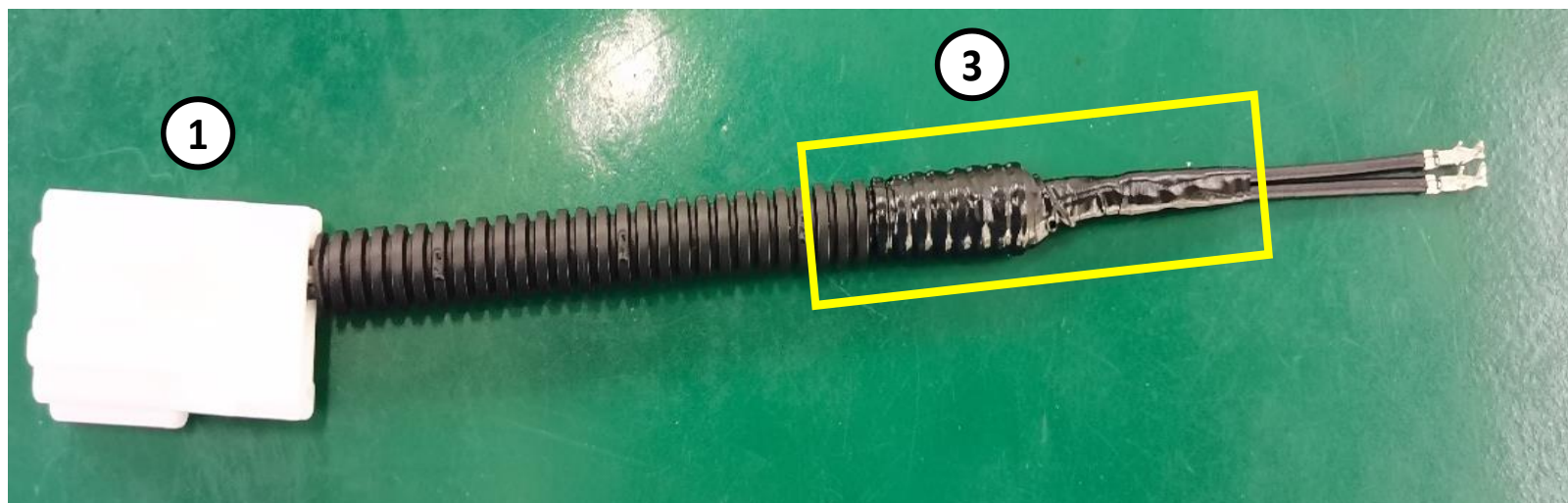
5 of 5

**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING-P1****7M0585-7020A****GOOD****NO GOOD****① No Deformed Terminal****② No Unlocked/Half-locked Connector****③ No Missing Tape and No Wrong use of tape**

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