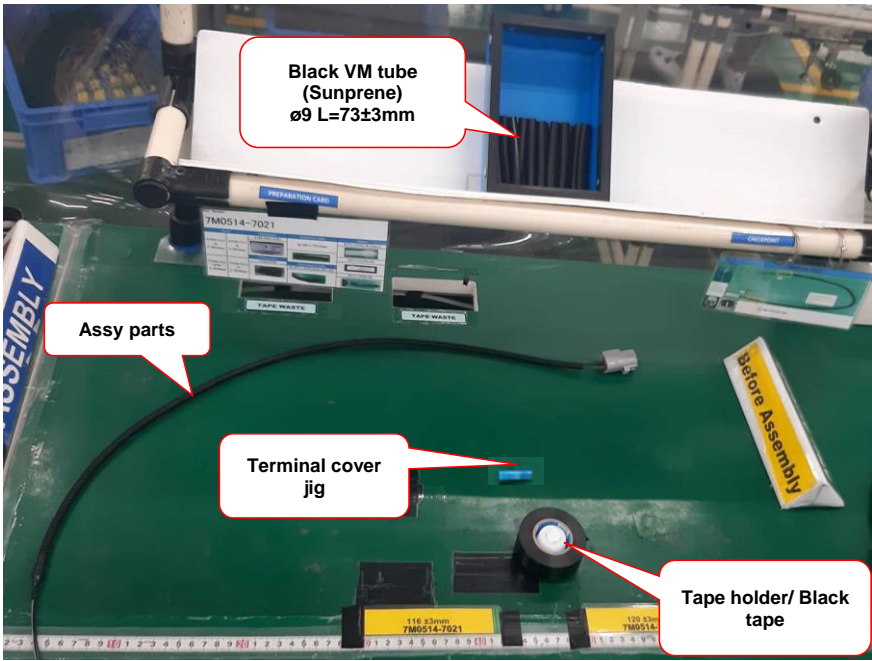

	WORK INSTRUCTION TAPING ASSEMBLY PROCESS			Effectivity Date:	October 21, 2024		
	Process Name/Title:			Validity Date:	n/a		
	Model code/Part number:	240B / 7M0514-7021B	Customer:	TRJ	Car Model:	LEXUS-ES	
	Purpose:			<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.:	WI-ENG-PDE-1125C
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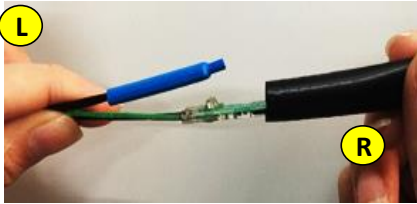


PARTS:		1. Assy parts; Black VM tube (Sunprene) ø9 L=73±3mm Black tape			JIG:	1. Terminal cover jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
1	P3	Table lay-out	<div>Table Lay-out</div> 			<div>Safety Instruction</div> Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) <div>Housekeeping</div> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. <div>Alert level</div> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	<div>Document reference/s:</div> 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance <div>1. No missing parts/tools 2. No excess parts/tools</div>

Revision History						Prepared by	Reviewed by	Approved by	Noted by
10/21/24	1	Change from Pre-launch to Masspro.			D.Castillo	C. Villanueva	A. Arañes	n/a	
10/17/24	0	Initial issue. Transfer wire insertion to VM tube and Taping 2 from P2. Separate clamp assembly due to process improvement.			D.Castillo	C. Villanueva	A. Arañes	n/a	
Eff. Date	Rev. No	Details of Change			Revised	Reviewed	Approved	Noted	Est. Date:
									October 17, 2024

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	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 240B / 7M0514-7021B		Customer: TRJ	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-1125C		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	2 of 6

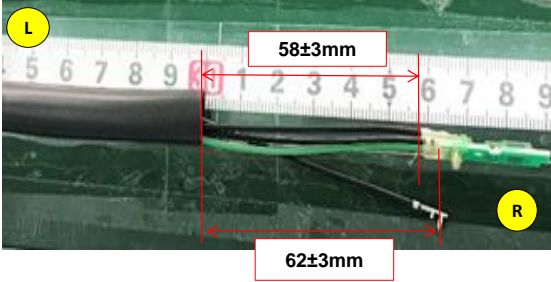
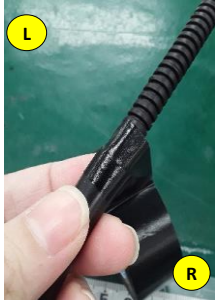
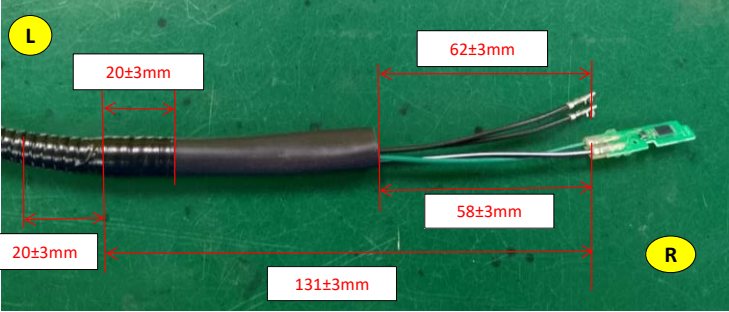


PARTS:		1. Assy parts 2. Black VM tube (Sunprene) ø9 L=73±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P3 Wire insertion to Black VM tube (Sunprene) ø9 L=73±3mm	<div></div> <div>1. Get the terminal cover jig using right hand then insert the terminal B-B wires using left hand.</div> <div></div> <div>2. Hold the Black VM tube (Sunprne) ø9 L=73±3mm using right hand then Insert first the hotmelted wires and then next the B-B wires with cover jig using left hand.</div> <div></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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	Model code/Part number: 240B / 7M0514-7021B		Customer: TRJ	Car Model: LEXUS-ES	Document No.: WI-ENG-PDE-1125C		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	3 of 6


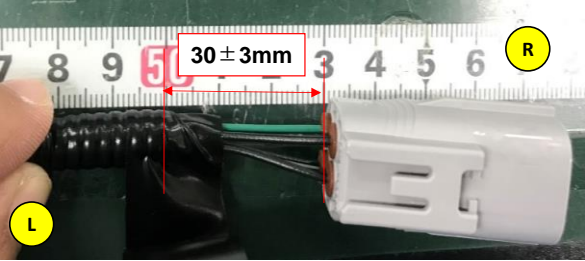
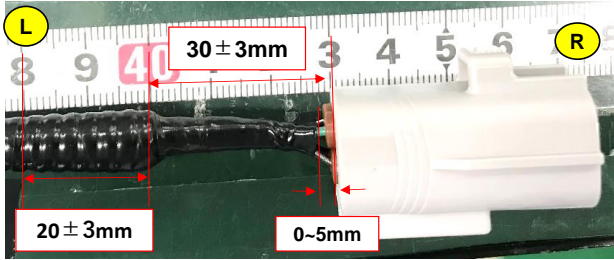


PARTS:		1. Assy parts 2. Black tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS		
3	P3 Taping 2 Black Corrugated tube to VM tube (Sunprene)	<div></div> <div></div> <div></div> <div>1. Hold the assy parts using left hand. Measure from VM tube (Sunprene) to terminal pointed tip 62±3mm and VM tube (Sunprene) to PCB 58±3mm.</div> <div>2. Hold the assy parts using left hand. Get the Black tape and start taping using right hand.</div> <div>3. After taping, check the measurement and taping condition.</div>	<div>MEASURING TAPE</div> 	<div>BENDING POSITION</div>  <div>Conduct slightly bending</div> <div>1. Check the tape from COT to SV/VM tube (Conduct bending for verification) 2.No flip out tape. 3.No tape peeling. 4.No loose tape 5. No missing tape 6. No wrong dimension 7. No wrong use of tape</div> <div>Important reminder/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document references: 1. Please refer to WI-PRO-ASY-001 for taping procedure. 2. GL-PRO-ASY-005 for Bending Guidelines to Check Missing tape</div>		

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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 Taping 3 Black Corrugated tube to wire near connector 6188-0066 (GR)	<div><p>Start of taping</p></div> <div><p>30 ± 3mm</p></div> <div><p>20 ± 3mm 0~5mm</p></div> <div><p>1. Hold the COT using left hand, get the Black tape using right then start pre-taping at the middle of COT and wires using both hands.</p><p>2. Measure from end of COT up to edge of connector 30±3mm using both hands.</p><p>3. After taping, check the measurement and taping condition.</p></div> <td><div>MEASURING TAPE</div></td> <td colspan="3"><p>Important reminders/Note/s:</p><p>1. Please use calibrated/verified measuring tape when getting the measurement.</p><p>Document reference/s:</p><p>1. Please refer to WI-PRO-ASY-001 for taping procedure.</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></td>			<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s:</p> <p>1. Please refer to WI-PRO-ASY-001 for taping procedure.</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>		


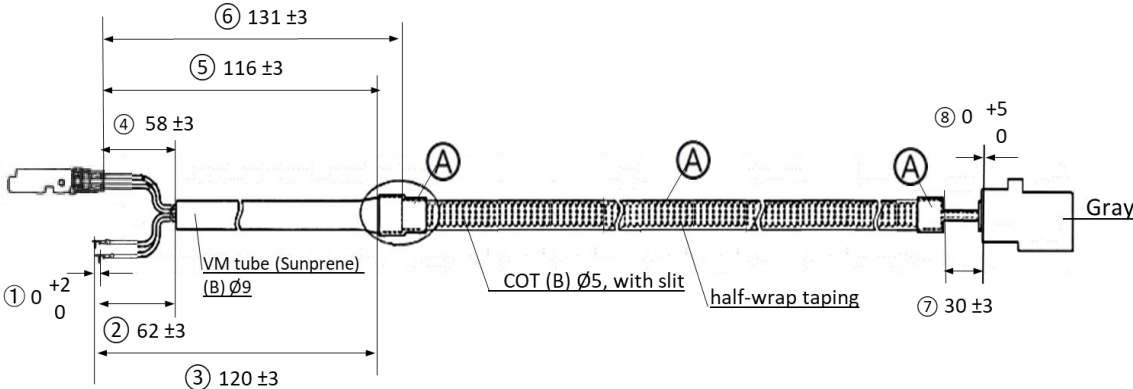
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	Model code/Part number: 240B / 7M0514-7021B	Customer: TRJ	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-1125C		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	5 of 6

PARTS:		1. Assy parts			JIG:	n/a	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
5	P3	Measurement	<div> <div>MEASURING TAPE</div>   <div> NOTE: Ⓐ - Taping (B) * Unit of dimension is in millimeter (mm) </div> </div>				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

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 21, 2024

Model code/Part number:

240B / 7M0514-7021BCustomer: **TRJ**

Car Model:

LEXUS-ES

Document No.:

WI-ENG-PDE-1125C

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P3****7M0514-7021B****1****2****No Missing Tape**

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