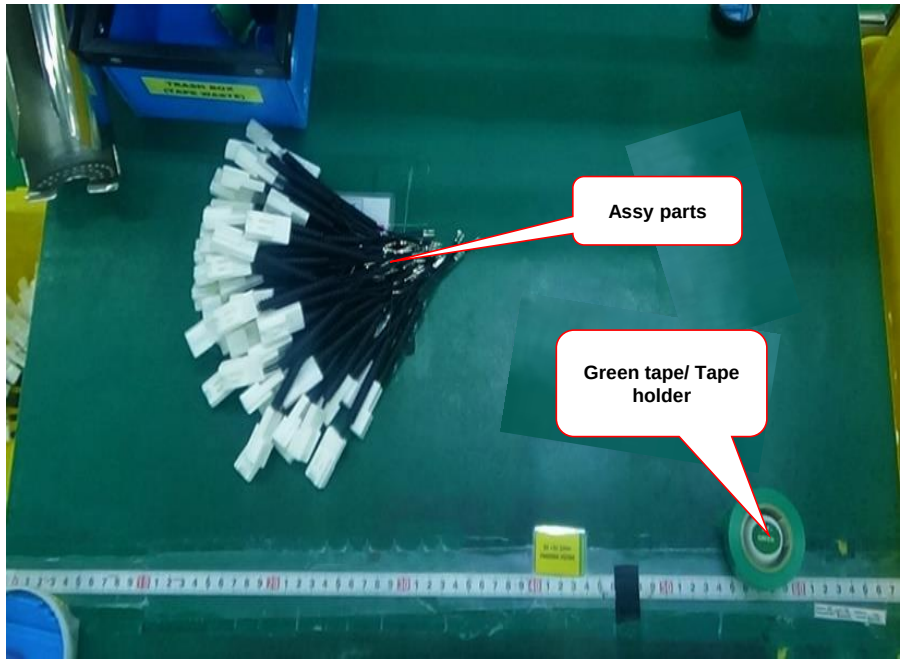
	WORK INSTRUCTION			Effectivity Date:	April 30, 2024		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 100B / 7M0584-7020A	Customer: TRJ	Car Model: LEXUS UX	Document No.:	WI-ENG-PDE-203		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	8	Page No.:	1 of 4

PARTS:	1. Assy parts; Green tape [1pc.]			JIG:	n/a
NO.	**PROCESS NAME**		**8 WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
1	P1	Table Lay-out	**TABLE LAY-OUT**  	**Safety Instruction** Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) **Housekeeping** 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. **Alert level** For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	***Document references:*** *1. Refer to **WI-ENG-PDE-202 7M0584-7020A** - Offline assembly process.* 1. No missing parts/tools 2. No excess parts/tools

Revision History							Prepared by	Reviewed by	Approved by	Noted by
04/30/24	8	Inclusion of Car model "LEXUS-UX". Transfer Wire insertion to corrugated tube process to Offline assembly process (WI-ENG-PDE-202). Improved Table lay-out, Taping 1 COT to wire near terminal pointed tip, Measurement and Visual inspection.	D. Castillo	C. Villanueva	A. Arañes	n/a	D. Castillo	C. Villanueva	A. Arañes	n/a
04/24/23	7	Inclusion of quality checkpoints	J. Loterte	C. Villanueva	A. Arañes	n/a				
09/17/22	6	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	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	November 05, 2018		

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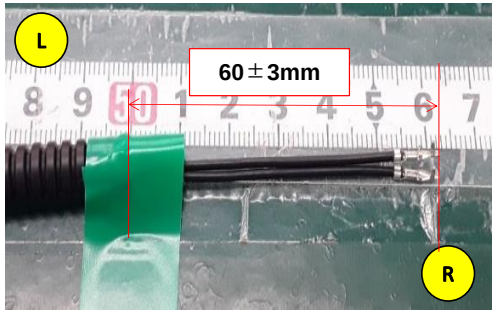
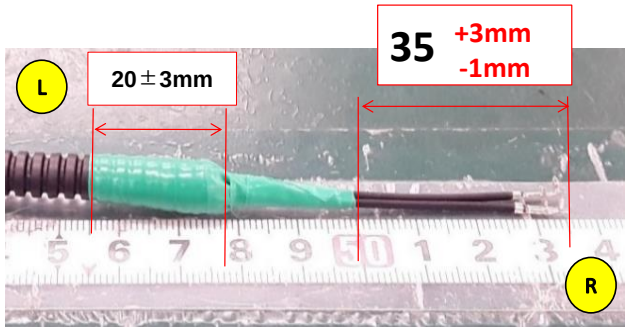
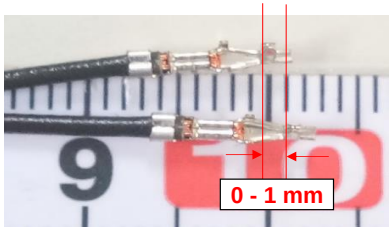
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 100B / 7M0584-7020A	Customer: TRJ	Car Model: LEXUS UX	Document No.:	WI-ENG-PDE-203		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	8	Page No.:	2 of 4

PARTS:	1. Assy parts 2. Green tape [1pc]			JIG:	n/a
NO.	**PROCESS NAME**		**8 WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
2	P1	Taping 1 COT to wire near terminal pointed tip	 1. Hold the COT using left hand. Get the **Green tape** and conduct pre-taping between COT and wire using both hands  2. Hold the corrugated tube using left hand and measure from end of COT to terminal pointed tip of Black wires **60±3mm** and proceed to taping process.  4. After taping, check the measurement, wire alignment 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.* ***Document references:*** *1. Refer to **WI-ENG-PDE-588** for Tape and tube end standard tolerance.* *2. Refer to **WI-PRO-ASY-001** for taping procedure.* **Wire alignment tolerance** 

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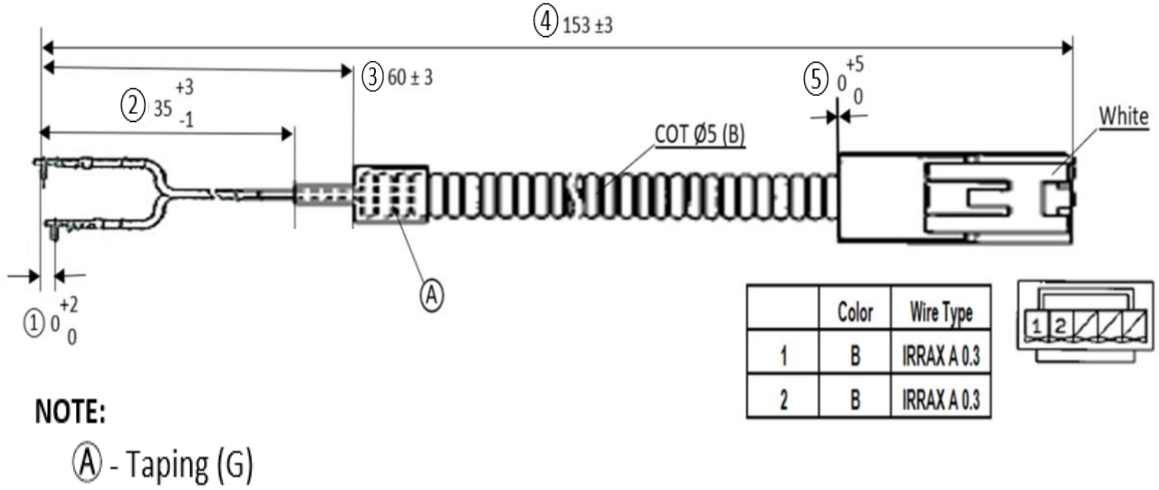
PARTS:	1. Assy Parts		JIG:	n/a
NO.	**PROCESS NAME**	**8 WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
3	P1 Measurement		**Measuring tape**	***Important reminders and note/s:*** *1. Please use calibrated/verified measuring tape when getting the measurement.* *2. For Hatsumono, Nakamono and Owarimono.* ***Document reference/s:*** *1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection* 1. No wrong dimension

	Color	Wire Type
1	B	IRRAX A 0.3
2	B	IRRAX A 0.3

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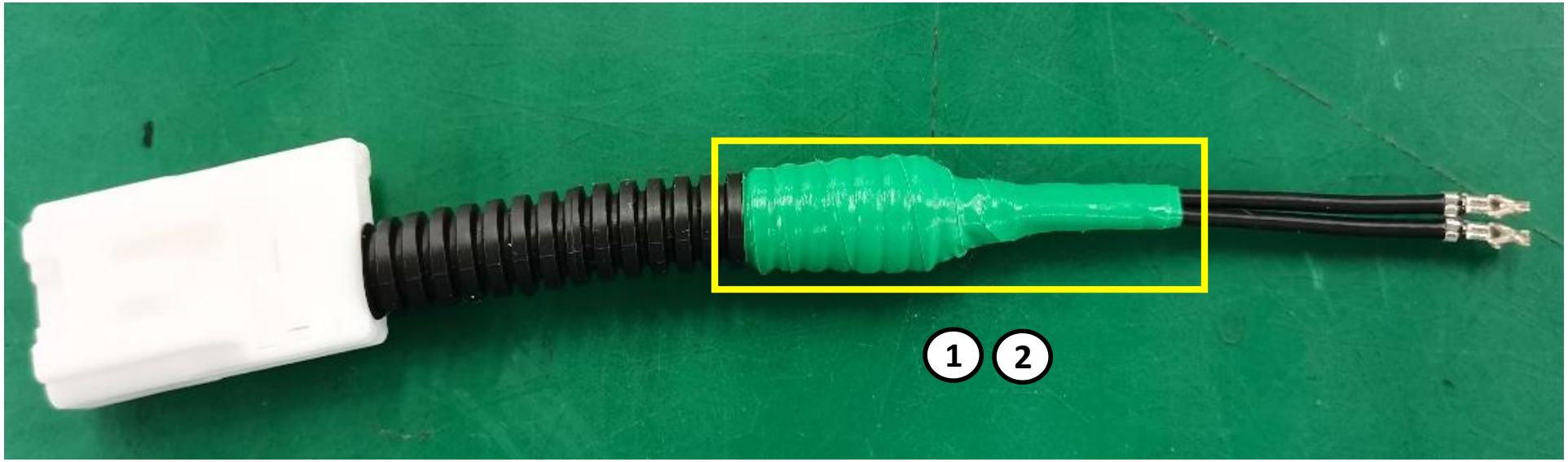
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	8	Page No.:	4 of 4

PARTS:	1. Assy parts	JIG:	n/a

8 **QUALITY CHECKPOINTS**

TAPING-P1	7M0584-7020A



1 **No Missing Tape (Green tape)**

2 **No Wrong use of tape**

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