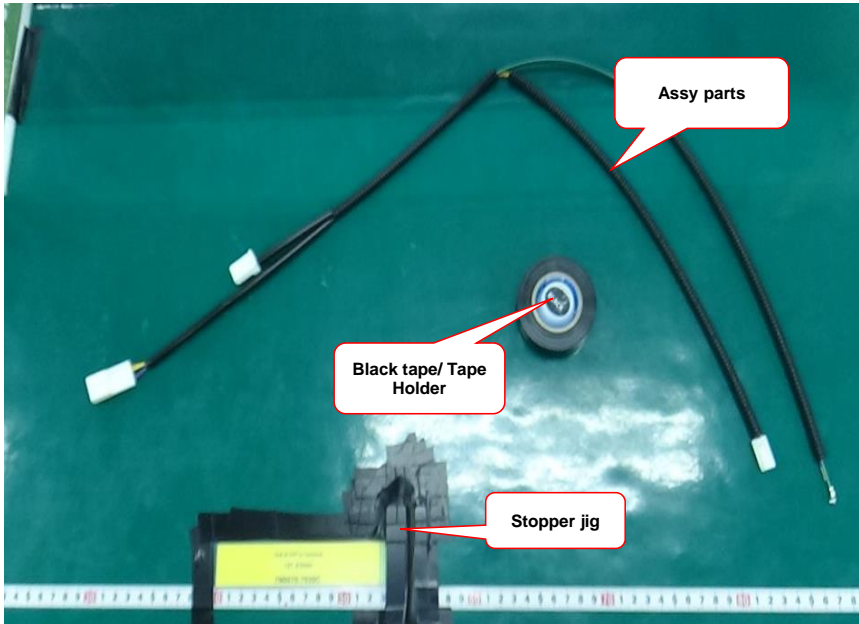
	<b>WORK INSTRUCTION</b>				Effectivity Date:		June 11, 2024	
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		-	
	Model code/Part number: <b>900B/910B 7N0070-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS-NX/RX</b>	Document No.:		<b>WI-ENG-PDE-460B</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		6	Page No.: 1 of 4

<b>PARTS:</b>		1. Assy parts; Black tape		<b>JIG:</b>		n/a	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>		<b>QUALITY POINTERS</b>	
1	P2	<div style="border: 1px solid red; padding: 5px; text-align: center;"> <b>TABLE LAY-OUT</b> </div> 		<div style="border: 1px dashed red; padding: 5px;"> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div style="border: 1px dashed red; padding: 5px;"> <b>Housekeeping</b>            1. Maintain and always practice 5's.            2. Personal things on the workplace is prohibited. Keep it in your locker.         </div> <div style="border: 1px dashed red; padding: 5px;"> <b>Alert level</b>            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	
6/11/24	6	Removed process of Taping Black COT to Black sunprene tube near terminal and Taping Black SV tube (Vinyl) to wire near connector 6098-3810 then transferred to P3; Transferred process of Taping Black SV tube (Vinyl) to wire near connector 6098-3802 from P3 due to new process distribution. Change tolerance from end tape to connector from ~5mm to 5~7mm.				M. Ariola	C. Villanueva	A. Arañes	n/a		
8/15/23	5	Change from 2MP to 3MP. Transferred process of Y-taping 1 and 2 to P3; Transferred process no.1, 15,16 and 17 from P1 to P2 due to change process distribution; Transferred process of Clamp setting; Clamp Assembly; Visual/By two's inspection and measurement from P2 to CLAMP ASSEMBLY PROCESS. Standardized tube description: SV tube (Vinyl); VM tube (Sunprene); Change table lay-out.				M. Ariola	J. Loterte	C. Villanueva	A. Arañes	n/a	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	April 12, 2022

<b>CONFIDENTIAL:</b> Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.	<div style="border: 2px solid green; padding: 5px; display: inline-block;"> <b>NBC (Philippines)</b>  <b>MASTER COPY</b> </div>	DCC Stamp
--	---	-----------



# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

June 11, 2024

Process Name/Title:

Model code/Part number: 900B/910B

7N0070-7020C

Customer: TRJ

Car Model: LEXUS-NX/RX

Validity Date:

-

Document No.:

WI-ENG-PDE-460B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

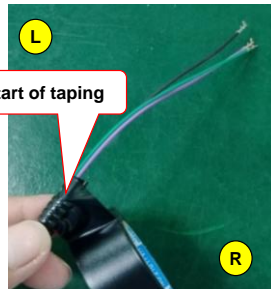
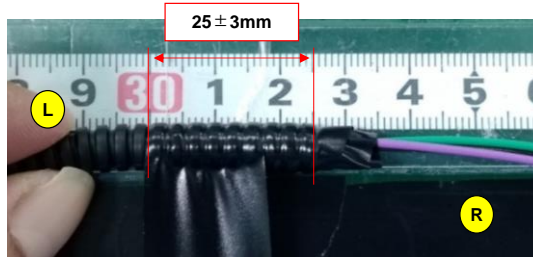
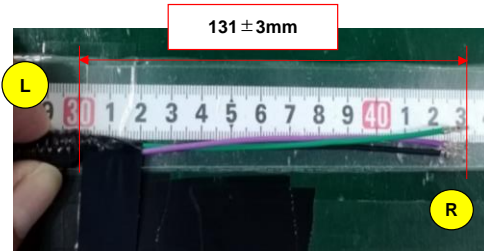

☒ MASSPRO

Revision No.:

6

Page No.:

2 of 4

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2  Taping 1 Black COT to wire near terminal	<div><div></div><div></div><div><p>1. Hold the COT using left hand, get the <b>Black tape</b> using right hand then start pre-taping using both hands.</p><p>2. Confirm measurement of <b>25±3mm</b> from end of tape up to COT then continue the taping process using both hands.</p></div><div></div><div><p>3. Measure from end of COT up to terminal pointed tip <b>131±3mm</b> then continue the taping process using both hands.</p></div></div> <div><div>MEASURING TAPE</div></div> <div><p><b>Important reminders/Note/s:</b></p><p>1. 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></div>			

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)  
**MASTER COPY**

DCC Stamp



## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

June 11, 2024

Process Name/Title:

Model code/Part number: 900B/910B

7N0070-7020C

Customer: TRJ

Car Model: LEXUS-NX/RX

Validity Date:

-

Document No.:

WI-ENG-PDE-460B

Purpose:

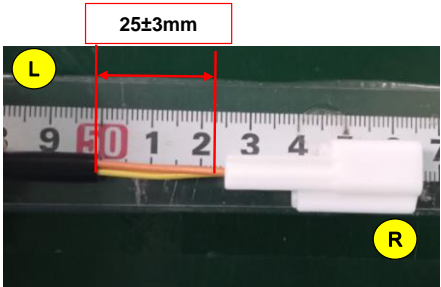
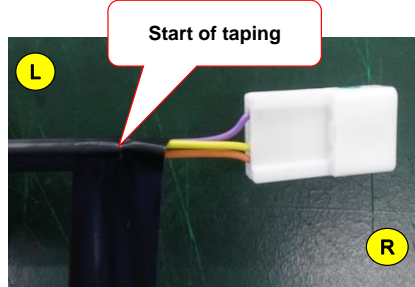
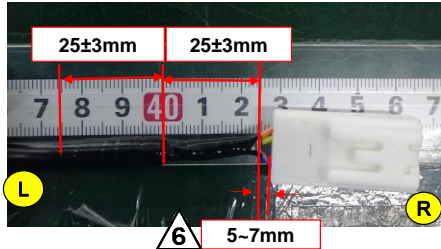
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

6

Page No.:

3 of 4

PARTS:		1. Assy parts 2. Black tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 Taping 2 Black SV tube (Vinyl) to wire near connector	<div><p>25±3mm</p><p>1. Measure from end of SV tube (Vinyl) up to end of connector <b>25±3mm</b> using both hands.</p></div> <div><p>Start of taping</p><p>2. Hold the assy parts using left hand. Get <b>Black tape</b> using right hand and start pre-taping between SV tube (Vinyl) and wires. <b>(Note: Do not fold the SV tube (Vinyl) ø5 with 3 wires)</b></p></div> <div><p>25±3mm 25±3mm</p><p>5~7mm</p><p>3. After taping, check the measurement and taping condition. <b>Note : Taping must be tape width 25±3mm.</b></p></div>	n/a	<p><b>Important reminders/Note/s:</b></p> <p>1. 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 use of tape 6. No wrong dimension</p> <p><b>Note : Change of tolerance -From 0~5mm to 5~7mm to avoid broken connector and tension in V-wires due to end tape.</b></p>

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)

MASTER COPY

DCC Stamp

**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

June 11, 2024

Validity Date:

-

Model code/Part number: **900B/910B****7N0070-7020C**Customer: **TRJ**Car Model: **LEXUS-NX/RX**

Document No.:

**WI-ENG-PDE-460B**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

6

Page No.:

4 of 4

**PARTS:**

n/a

JIG:

n/a

**VISUAL INSPECTION / QUALITY CHECKPOINTS****P2****7N0070-7020C****1 2 No Missing Tape**

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)****MASTER COPY**

DCC Stamp