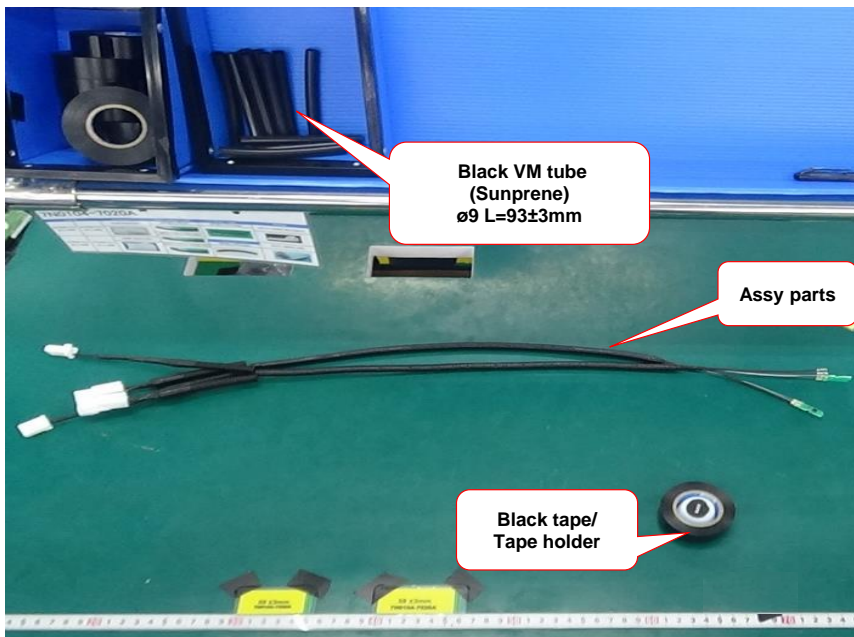


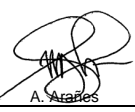
	<b>WORK INSTRUCTION</b>				Effectivity Date:		October 21, 2024	
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Model code/Part number: <b>900B.910B / 7N0104-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS-NX/RX</b>	Document No.:		<b>WI-ENG-PDE-1137C</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		1	Page No.: 1 of 7

<b>PARTS:</b>		1. Assy parts; Black VM tube (Sunprene) ø9 L=93±3mm; 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	P3	<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>1. No missing parts/tools 2. No excess parts/tools</p>	


  

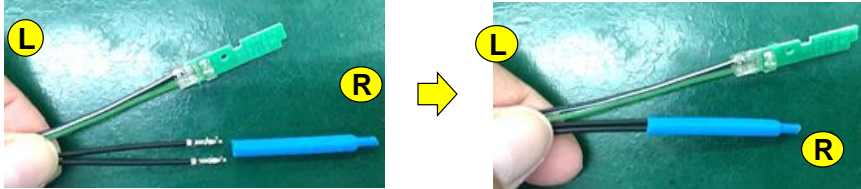
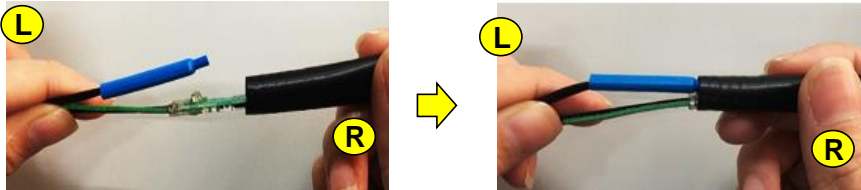
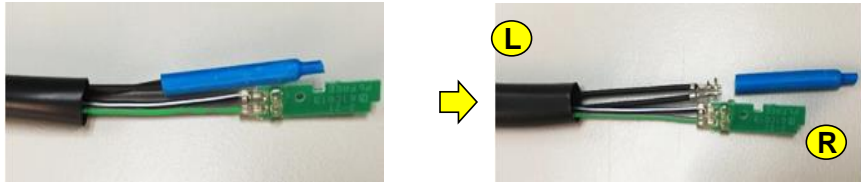

Revision History						Prepared by	Reviewed by	Approved by	Noted by	
10/21/24	1	Change from Pre-launch to Masspro. Update Visual inspection/Quality checkpoints.	D. Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
10/17/24	0	Initial issue.	D. Castillo	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 17, 2024		

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	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>October 21, 2024</b>		
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>900B.910B / 7N0104-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS-NX/RX</b>	Document No.:	<b>WI-ENG-PDE-1137C</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	2 of 7


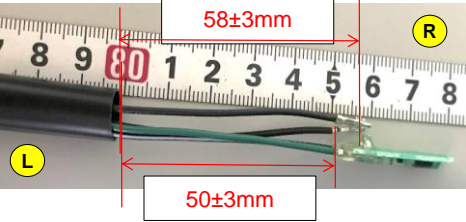



<b>PARTS:</b>		1. Assy part 2. Black VM tube (Sunprene) ø9 L=93±3mm		JIG:	1. Terminal cover jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
2	P3 Wire insertion to Black VM tube (Sunprene) ø9 L=93±3mm	<div></div> <div>1. Get the terminal cover jig using right hand then insert the terminal <b>B-B</b> wires using left hand.</div> <div></div> <div>2. Hold the Black VM tube (Sunprene) ø9 L=93±3mm using right hand then Insert first the <b>hotmelted wires</b> and then next the <b>B-B wires</b> with cover jig using left hand.</div> <div></div> <div>3. After insertion, remove the terminal cover jig using right hand.</div>		<div><b>TERMINAL COVER JIG</b></div> 	1. No wrong use of parts 2. No deformed terminal	

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	WORK INSTRUCTION			Effectivity Date:	October 21, 2024		
	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Process Name/Title:		Model code/Part number: 900B.910B / 7N0104-7020C	Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:	WI-ENG-PDE-1137C
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	3 of 7

PARTS:	1. Assy parts			JIG:	n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
3	P3 Taping 5 Black Corrugated tube to VM tube (Sunprene)	<div><p>1. Hold the COT using left hand and insert the VM tube (Sunprene) <math>\phi 9</math> L=93<math>\pm</math>3mm .</p><p><b>NOTE: COT must be inserted to VM tube (Sunprene) (20<math>\pm</math>3mm).</b></p></div> <div><p>2. Hold the assy parts using left hand. Measure from VM tube (Sunprene) to terminal pointed tip 58<math>\pm</math>3mm and from VM tube to hotmelted wire 50<math>\pm</math>3mm.</p></div> <div><p>4. After taping, check the measurement and taping condition.</p></div> <div><p>3. Hold the assy parts using left hand. Get the Black tape and start taping using right hand.</p></div>		<div>MEASURING TAPE</div> 	<p><b>Important reminders/Note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p><b>Document references:</b></p> <p>1. Please refer to <b>WI-PRO-ASY-001</b> for taping procedure.</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>		


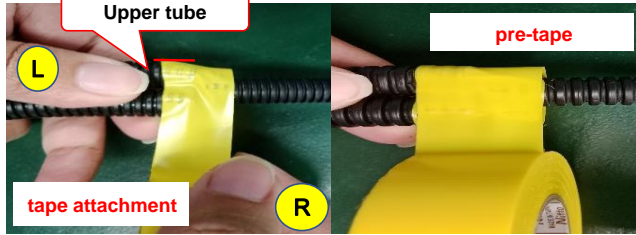
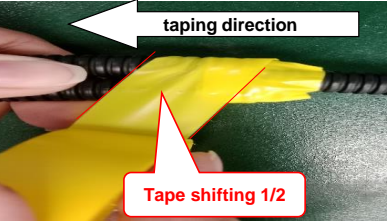
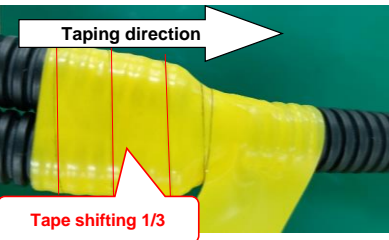
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	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>October 21, 2024</b>			
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	<b>n/a</b>			
	Process Name/Title:		Model code/Part number: <b>900B.910B / 7N0104-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS-NX/RX</b>	Document No.:	<b>WI-ENG-PDE-1137C</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	4 of 7	

<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>		
4	P3	Y-Taping	<div>     </div>	<div> <p>1. Fix the 3 corrugated tube. <i>Note: Follow the Connector facing</i></p> <p>2. Start taping at the middle of combined tubes, attach the tape on the upper tube. Then make pre-tape <b>2 windings</b>. <i>Note: Do not exert excessive force during pulling &amp; winding of tape.</i></p> <p>3. Winding the tape <b>1/2 shifting</b> going to the left side.</p> <p>4. Make <b>2 windings</b>, width must be <b>25±3mm</b>.</p> <p>5. Winding the tape <b>1/3 shifting</b> going to the right side until reach the other side of tube.</p> <p>6. Make <b>2 windings</b>, width must be <b>25±3mm</b>.</p> </div>	<div> <p>1. No loose tape</p> <p>2. No flip-out tape</p> <p>3. No peel-off tape</p> <p>4. No wrong use of tape</p> <p>5. No wrong dimension-out tape</p> <p>6. No exposed wire</p> <p>7. No gap between tubes</p> <p>8. Follow the connector facing</p> <p><b>Document reference/s:</b></p> <p>1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p><b>Important reminders/Note/s:</b></p> <p>1. Use <u>yellow tape</u> for easy visualization of tape shifting, but actual should be <u>BLACK TAPE</u>.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> </div>	

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## WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

October 21, 2024

Model code/Part number:

900B.910B / 7N0104-7020C

Customer:

TRJ

Car Model:

LEXUS-NX/RX

Document No.:

WI-ENG-PDE-1137C

Purpose:

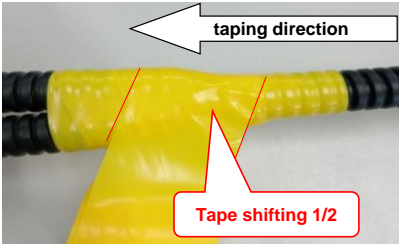
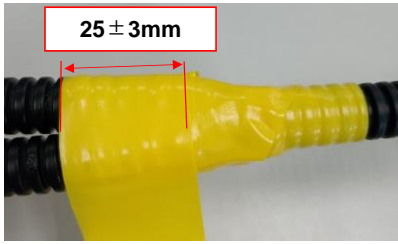
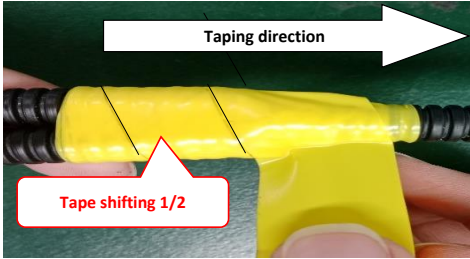
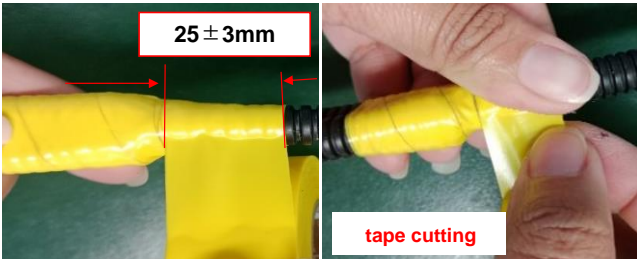
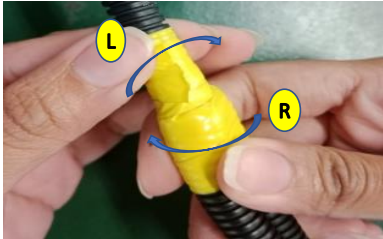
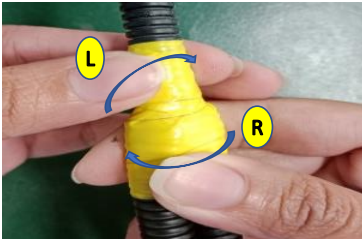
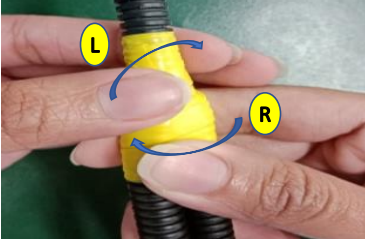
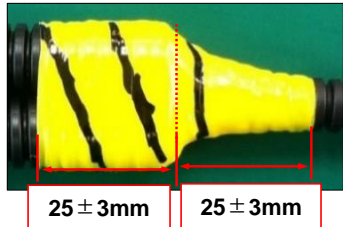
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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1

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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 (Continuation)	<div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div>			<p>7. Winding the tape <b>1/2 shifting</b> going to the left side.</p> <p>8. Make <b>2 windings</b>, width must be <b>23±2mm</b>.</p> <p>9. Winding the tape <b>1/2 shifting</b> going to the right side until it reach the other side of tube</p> <p>10. Make <b>3 winds</b>, width must be <b>25±3mm</b>. Then cut the tape.</p> <p>11. conduct proper pressing of end tape using left hand (<b>top part</b>)</p> <p>12. conduct proper pressing of end tape using left hand (<b>Middle part</b>)</p> <p>13. conduct proper pressing of end tape using left hand (<b>bottom part</b>)</p> <p>14. Check the Measurement and condition of tape.</p>

1. No loose tape
2. No flip-out tape
3. No peel-off tape
4. No wrong use of tape
5. No wrong dimension-out tape
6. No exposed wire
7. No gap between tubes
8. Follow the connector facing

## Document reference/s:

1. Refer to WI-PRO-ASY-001C for taping procedure (special).

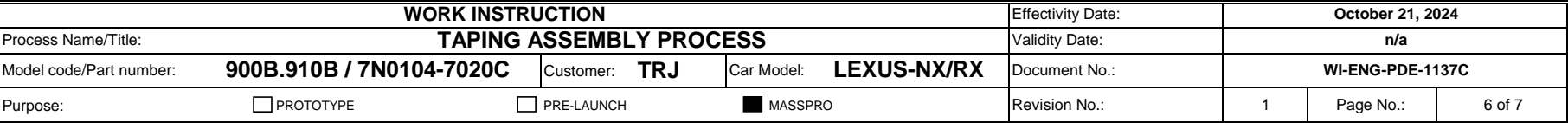
## Important reminders/Note/s:


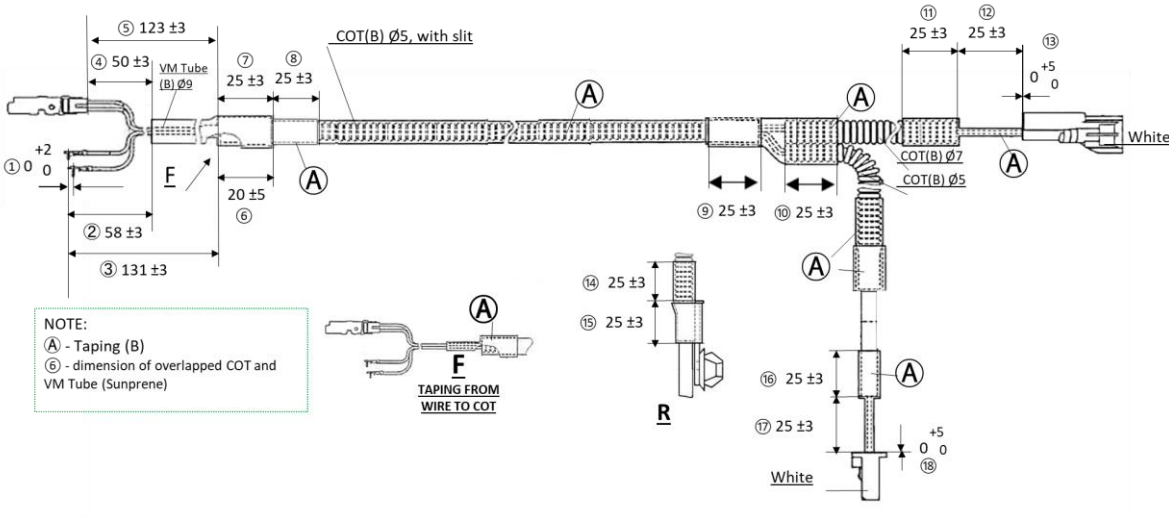
1. Use yellow tape for easy visualization of tape shifting, but actual should be **BLACK TAPE**.
2. Please use calibrated/verified measuring tape when getting the measurement.

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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>  <div><p>NOTE:</p><p>(A) - Taping (B)</p><p>(B) - dimension of overlapped COT and VM Tube (Sunprene)</p></div>			<p>1. No wrong dimension.</p> <p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p>

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**WORK INSTRUCTION**

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**TAPING ASSEMBLY PROCESS**

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

Car Model:

**LEXUS-NX/RX**

Document No.:

**WI-ENG-PDE-1137C**

Purpose:

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**7 of 7****PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P3****7N0104-7020C****1****2****No Missing Tape**

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