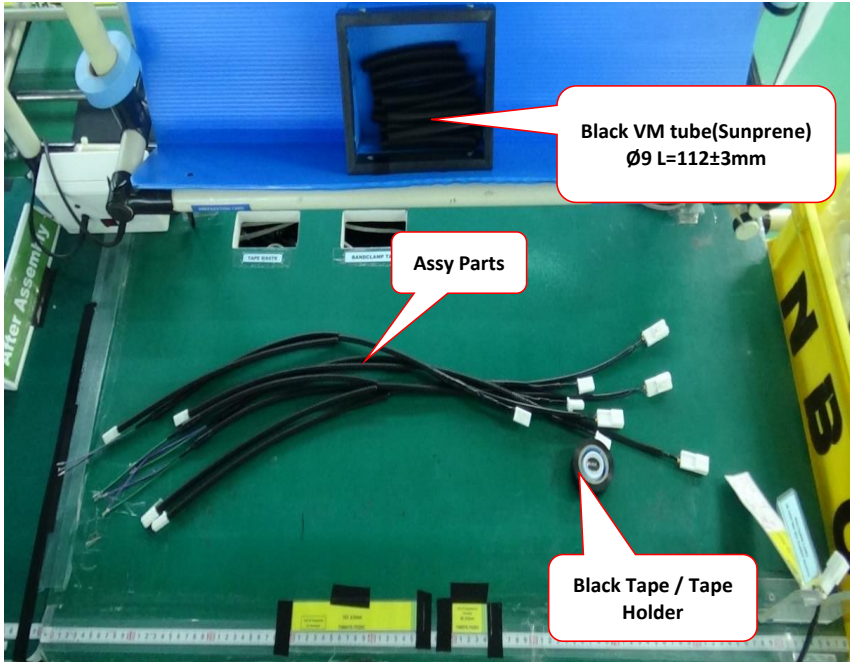


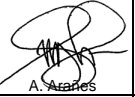


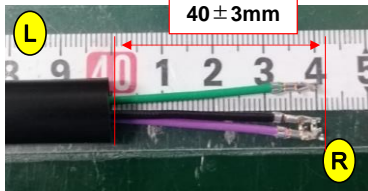





	WORK INSTRUCTION				Effectivity Date:		July 31, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 900B/ 910B / 7N0072-7020C		Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:		WI-ENG-PDE-461D	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		0	Page No.: 1 of 5

PARTS:		1. Assy Part; Black Tape; Black VM tube(Sunprene) Ø9 L=112±3mm		JIG:		n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1	P4	<div style="border: 1px solid red; padding: 5px; text-align: center;">TABLE LAY-OUT</div> 		<div style="border: 1px solid red; padding: 5px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px;"> Housekeeping 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 solid red; padding: 5px;"> Alert level 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					
07/31/24	0	Initial issue. Transfer VM tube insertion and COT to VM tube taping from P2 (WI-ENG-PDE-461B) and transfer Y-taping 2 from P3 (WI-ENG-PDE-461C) due to process improvement.						D.Castillo	C.Villanueva	A. Arañes	N/A	 D. Castillo		 C. Villanueva		 A. Arañes		N/A	
Eff. Date	Rev. No	Details of Change						Revised	Reviewed	Approved	Noted	Est. Date:		July 31, 2024					

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			Effectivity Date:	July 31, 2024		
	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Process Name/Title:			Document No.:	WI-ENG-PDE-461D		
	Model code/Part number: 900B/ 910B / 7N0072-7020C		Customer: TRJ	Car Model: LEXUS-NX/RX	Revision No.:	0	Page No.:
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO							

PARTS:	1. Assy parts 2.Black Tape 3. Black VM tube (Sunprene) Ø9 L=112±3mm			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Black VM tube (Sunprene) Ø9 L=112±3mm	 <p>1. Get the Black VM tube (Sunprene) Ø9 L=112±3mm using right hand then insert the B-G-V wires(Assy Part).</p>		n/a	1. No wrong use of parts 2. No deformed terminal
3	P4 Taping 4 Black corrugated tube to VM tube (Sunprene)	 <p>1. Measure from end of VM tube (Sunprene) up to terminal pointed tip 40±3mm using both hands.</p>  <p>2. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.</p>  <p>3. Confirm measurement of 25±3mm from end of tape up to end of tube then continue the taping process using both hands.</p>  <p>4. Confirm measurement of 25±3mm from end of tube up to end of tape then continue the taping process using both hands.</p>  <p>5. After taping, check the measurement, terminal appearance and taping condition.</p>		<div>MEASURING TAPE</div>  <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>	<p>Important reminders and Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</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

Model code/Part number: 900B/ 910B / 7N0072-7020C

Customer: TRJ

Car Model: LEXUS-NX/RX

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

July 31, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-461D

Revision No.:

0

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

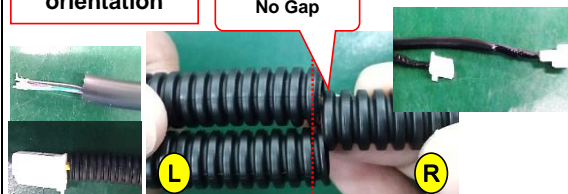
4

P4

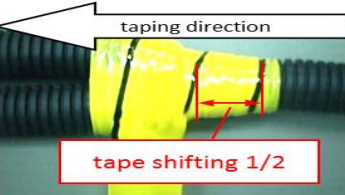
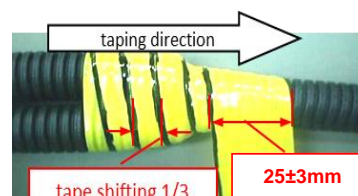
Y-Taping 2

Y-Taping
orientation

No Gap



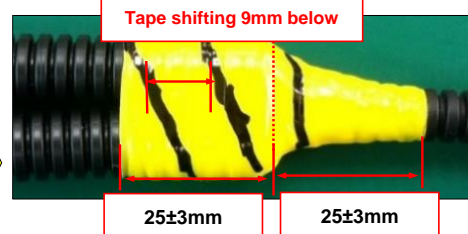
1. Fix the corrugated tube .



4. Winding the tape backward 1/2 shifting.

2. Start taping at the middle of combined Corrugated tubes, then winding the tape going to 2 corrugated tubes, width must be **25±3mm**.

3. Winding the tape 1/3 shifting until it reach the other side of corrugated tube, width must be **25±3mm**.



5. Winding the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.

Note: Do not exert excessive force during pulling & winding of tape

25±3mm

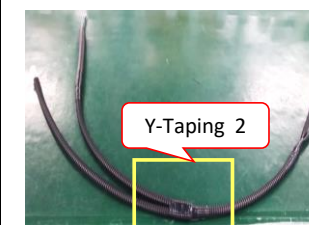
Measuring tape



Important reminders/Note/s:

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


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


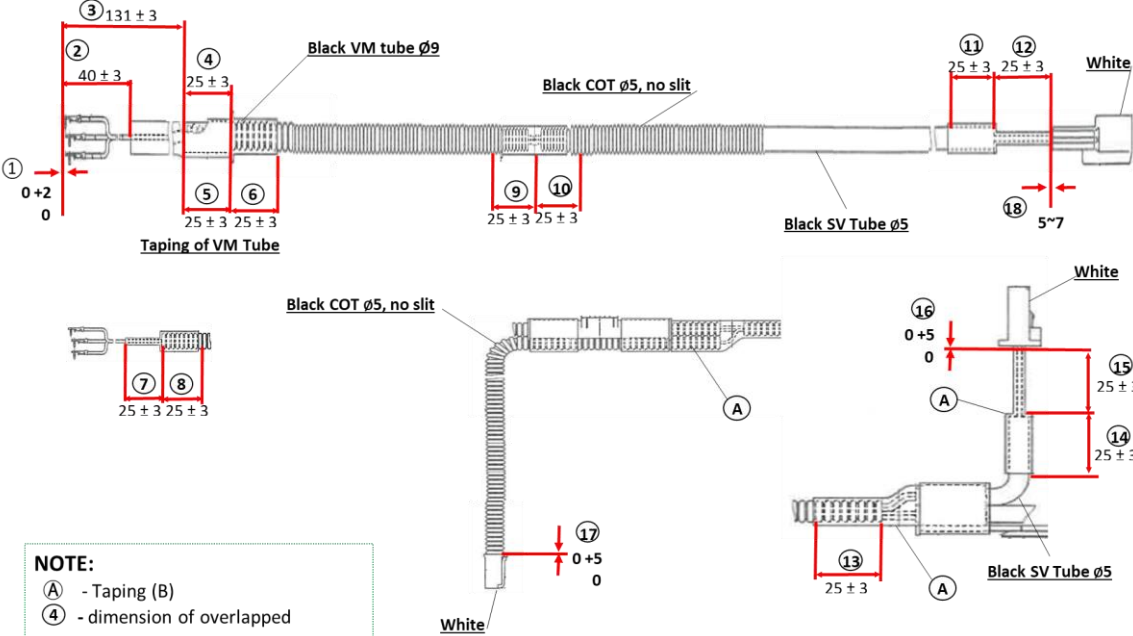


CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

	WORK INSTRUCTION			Effectivity Date:	July 31, 2024		
	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Process Name/Title:			Document No.:	WI-ENG-PDE-461D		
	Model code/Part number: 900B/ 910B / 7N0072-7020C		Customer: TRJ	Car Model: LEXUS-NX/RX	Revision No.: 0 Page No.: 4 of 5		
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO							

PARTS:		1. Assy parts		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS		
5	P4	Measurement	<div><div>MEASURING TAPE</div></div>  <div>NOTE: (A) - Taping (B) (4) - dimension of overlapped</div>	<div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension</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**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

July 31, 2024

Validity Date:

n/aModel code/Part number: **900B/ 910B / 7N0072-7020C**Customer: **TRJ**Car Model: **LEXUS-NX/RX**

Document No.:

WI-ENG-PDE-461D

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

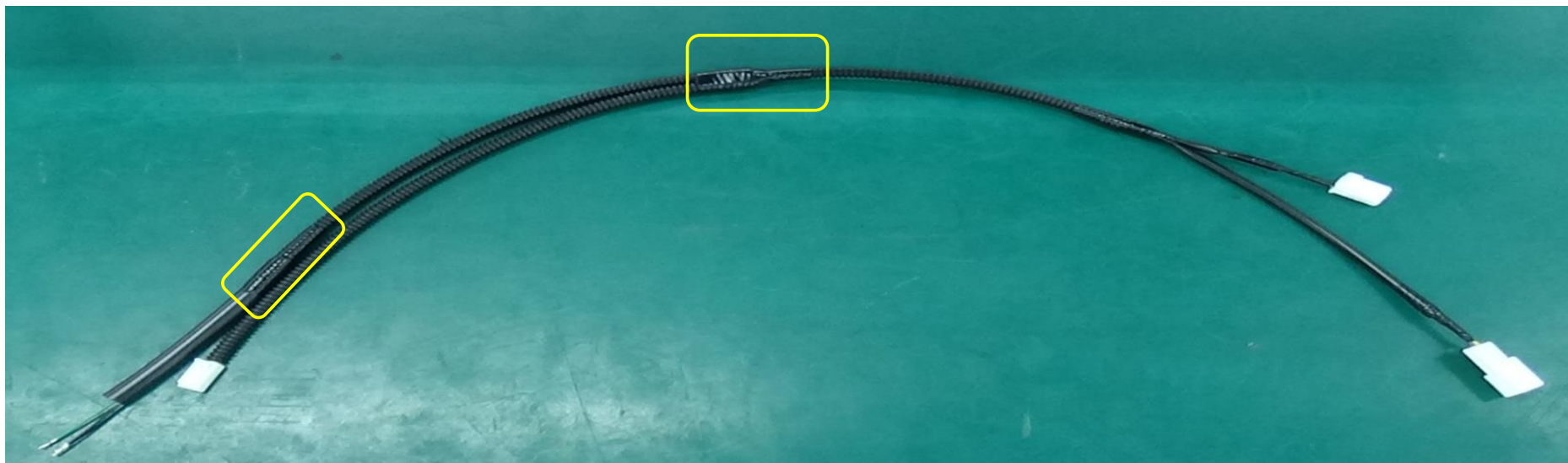
Page No.:

5 of 5**PARTS:**

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**P4****7N0072-7020C****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