
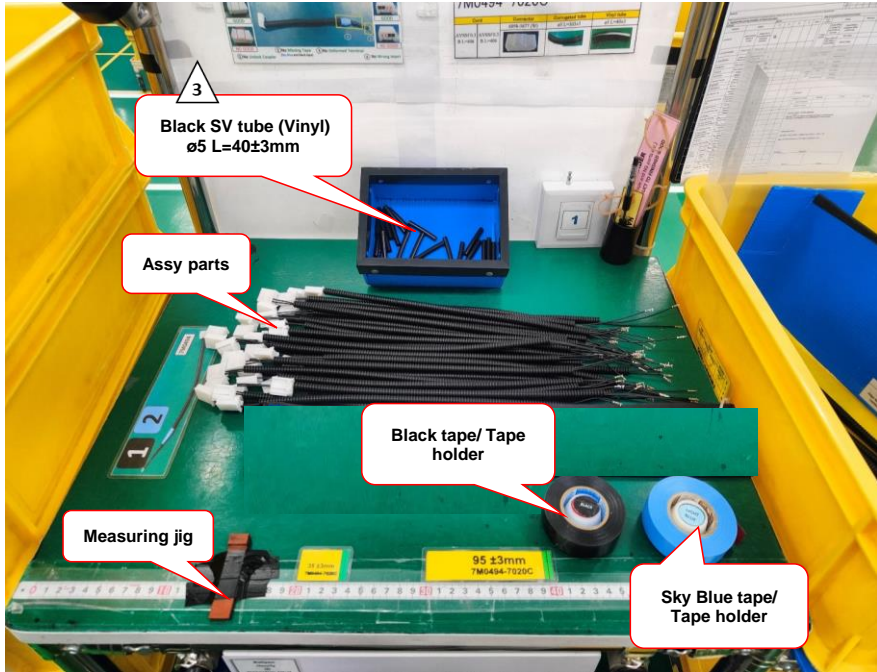


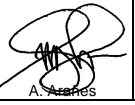



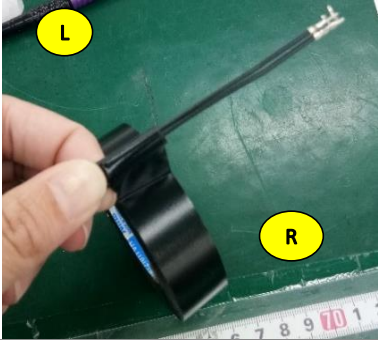
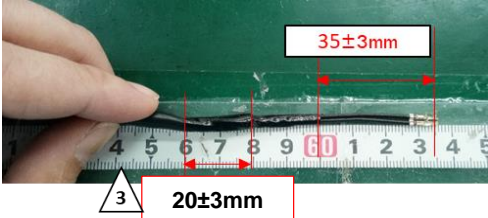

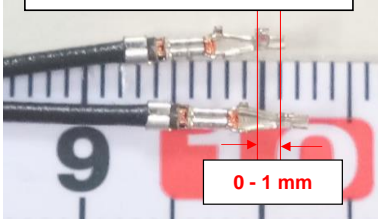
	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date: April 16, 2024	
	Process Name/Title:				Validity Date: n/a	
	Model code/Part number: 240B / 7M0494-7020C		Customer: TRJ	Car Model: LEXUS ES	Document No.: WI-ENG-PDE-276	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: 3		Page No.:	1 of 5

PARTS: 	1. Pre-assy parts: Connector 6098-5677 (W); AVSSf 0.3 wires B L=406mm [2pcs]; Black Corrugated tube ø5 L=303±3mm (no slit); Black SV tube (Vinyl) ø5 L=40±3mm; Black tape; Sky Blue tape				JIG:	1. Measuring jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS		
1	P1 Table Lay-out	<div style="border: 1px solid red; padding: 5px; text-align: center; margin-bottom: 10px;"> TABLE LAY OUT </div> 	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> 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 dashed 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
04/16/24	3	Change term from Vinyl tube to SV tube (Vinyl). Remove By two's inspection and change Quality checkpoints to Visual inspection. Inclusion of car model "LEXUS ES". Change tape width to 20±3mm.	D.Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a	
06/05/23	2	Inclusion of quality checkpoints; improve table lay-out, important reminders/note/s and document references, by two's inspection and work procedure/illustrations; standardize term of SV tube (vinyl)	J. Loterte	C. Villanueva	A. Arañes	n/a					
09/09/21	1	Change status from Pre-launch to Masspro.	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes					
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	May 24, 2021			

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	WORK INSTRUCTION			Effectivity Date:	April 16, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 240B / 7M0494-7020C		Customer: TRJ	Car Model: LEXUS ES	Document No.: WI-ENG-PDE-276		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	3	Page No.:	2 of 5

PARTS:	<div>3</div> <div>1. Black SV tube (Vinyl) ø5 L=40±3mm</div> <div>2. Assy parts</div> <div>3. Black tape</div>	JIG:		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	<div>3</div> <div>Wire Insertion to Black SV tube (Vinyl) ø5 L=40±3mm</div>	<div></div> <div>1. Get the Black SV tube (Vinyl) ø5 L=40±3mm using right hand then insert the Black wires.</div>	n/a	<div>1. No deformed terminal</div> <div>2. No wrong usage of parts</div>
3	<div>P1</div> <div>Taping 1 SV tube (Vinyl) to wire near terminal</div>	<div><div>55±3mm</div></div> <div>1. Measure from SV tube (Vinyl) to terminal tip 55±3mm using both hands.</div> <div></div> <div>2. Hold the SV tube (Vinyl) using left hand, get Black tape using right hand and begin taping process.</div> <div><div>35±3mm</div><div>20±3mm</div></div> <div>3. After taping, check the measurement, terminal appearance and taping condition.</div>	<div>Measuring tape</div> <div></div>	<div>Wire alignment tolerance</div> <div><div>0 - 1 mm</div></div> <div>Important reminders/note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document references;</div> <div>1. Please refer to WI-PRO-ASY-001 for taping procedure.</div> <div>1. No flip-out tape</div> <div>2. No peel-off tape</div> <div>3. No loose tape</div> <div>4. No missing tape</div> <div>5. No wrong use of tape</div> <div>6. No wrong dimension</div>

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

April 16, 2024

Model code/Part number:

240B / 7M0494-7020C

Customer: TRJ

Car Model:

LEXUS ES

Document No.:

WI-ENG-PDE-276

Purpose:



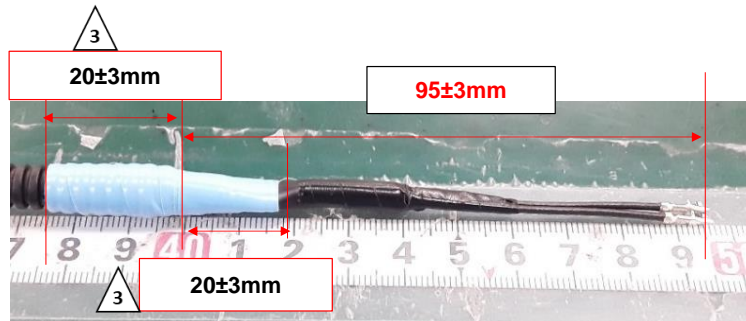

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PARTS:		1. Sky Blue tape 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 Taping 2 Corrugated tube to SV tube (Vinyl)	<div></div> <div><p>1. Fix the Corrugated tube and SV tube (Vinyl) using left hand, measure from COT to terminal pointed tip 95mm.</p></div> <div></div> <div><p>2. Get the Sky Blue tape using right hand and begin the taping process.</p></div> <div></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>		<div></div>	<p>Important reminders/note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document references;</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 use of tape 6. No wrong dimension</p>

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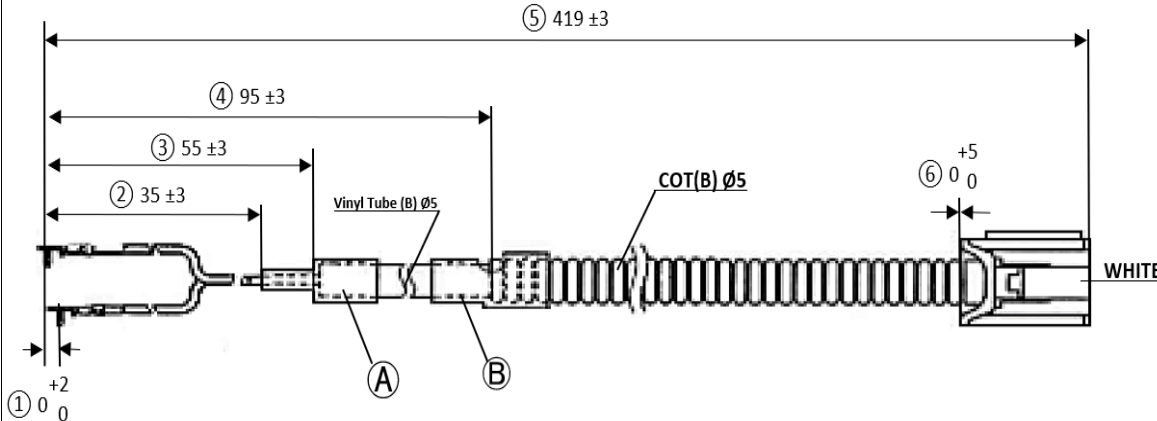

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1 <div>3</div>	<div>Measurement</div> <div></div> <div><div>NOTE:</div><div>(A) - Taping (B)</div><div>(B) - Taping (Sky blue)</div></div>	<div>Measuring tape</div> <div></div>	<div>Important reminders and note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension</div>

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**WORK INSTRUCTION**

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Effectivity Date:

April 16, 2024

Validity Date:

n/a

Model code/Part number:

240B / 7M0494-7020CCustomer: **TRJ**

Car Model:

LEXUS ES

Document No.:

WI-ENG-PDE-276

Purpose:

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PARTS:

1. Assy parts

JIG:

n/a

**QUALITY CHECKPOINTS****TAPING - P1****7M0494-7020C**

① **No Missing Tape**
(Sky Blue and black tape)

② **No Wrong color of tape**

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