
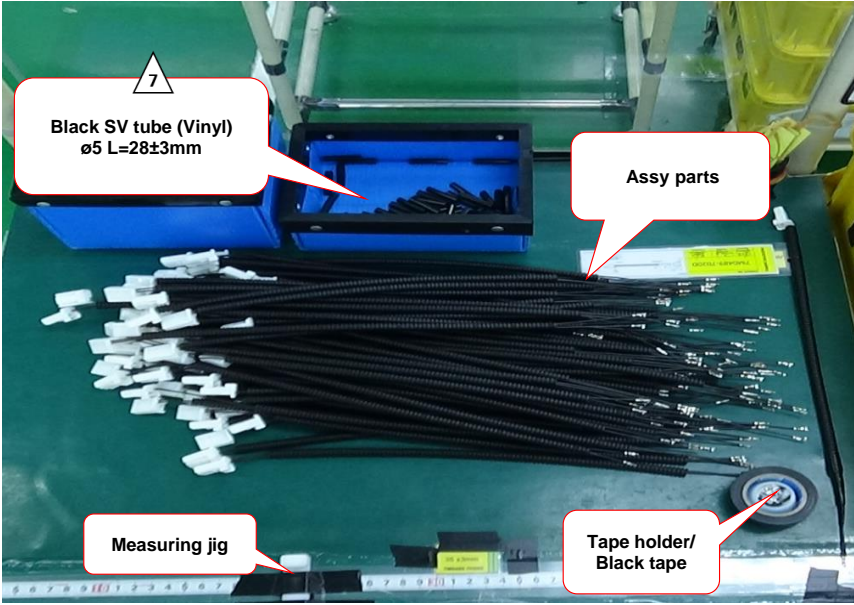
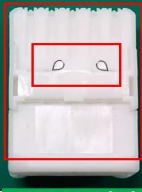
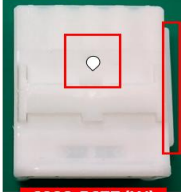





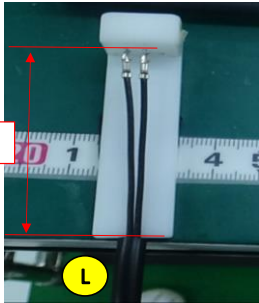
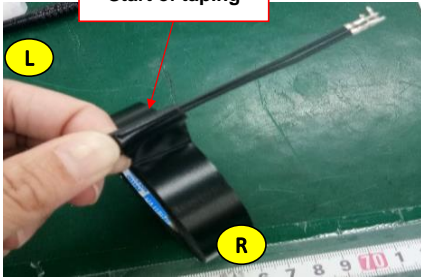
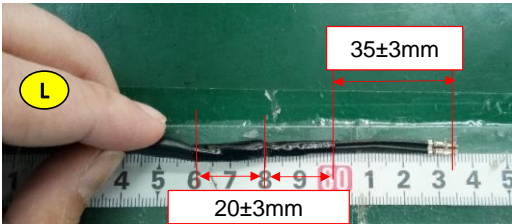
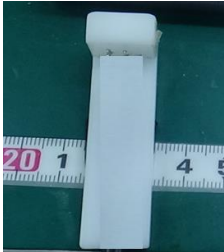

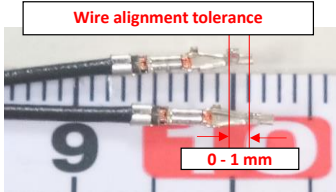
	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date:	May 24, 2024		
	Process Name/Title:				Validity Date:	n/a		
	Model code/Part number: 240B / 7M0489-7020D		Customer: TRJ	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-073		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	7	Page No.:	1 of 5

PARTS:  1. Assy Parts; Black SV tube (Vinyl) ø5 L=28±3mm; Black tape		JIG:	1. Measuring jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
1	P1 Table Lay-out	<div style="text-align: center;">  </div>	<div style="border: 1px dashed red; padding: 5px;"> <p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>
		QUALITY POINTERS Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. 2. Refer to WI-ENG-PDE-837 for Offline Assdembly process 1. No missing parts/tools 2. No excess parts/tools <div style="text-align: center;"> CONNECTOR ILLUSTRATION <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <div style="background-color: green; color: white; padding: 2px;">GOOD</div>  <div style="background-color: green; color: white; padding: 2px;">6098-3810 (W)</div> </div> <div style="text-align: center;"> <div style="background-color: red; color: white; padding: 2px;">NG</div>  <div style="background-color: red; color: white; padding: 2px;">6098-5677 (W)</div> </div> </div> </div>	

Revision History				Prepared by	Reviewed by	Approved by	Noted by
05/24/24	7	Transfer some process to Offline assembly process and Clamp assembly process due to process change. Change term from Vinyl tube to SV tube (Vinyl). Update table lay-out. Improved measurement and Visusal inspection. Inclusion of car model "LEXUS-ES".	D.Castillo	C.Villanueva	A. Arañes	n/a	
01/26/23	6	Inclusions; Batching Quantity [9pcs] as countermeasure for audit findings; Quality checkpoints.	M. Ariola	J. Loterte	C.Villanueva	A. Arañes	
11/04/22	5	Improve Quality pointers: Reminders/Note/s on page no. 1,2,3,4,6,7,9,10,11 and 12; Improve work procedure Illustration on process no. 4- Connector lock and on process no.12- Visual/By two's inspection.	M. Ariola	J. Loterte	C.Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: December 4, 2020

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	WORK INSTRUCTION				Effectivity Date:	May 24, 2024				
	TAPING ASSEMBLY PROCESS				Validity Date:	n/a				
	Process Name/Title:		Model code/Part number: 240B / 7M0489-7020D		Customer: TRJ	Car Model: LEXUS-ES		Document No.:	WI-ENG-PDE-073	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		7	Page No.:	2 of 5	


PARTS:	<div></div> <div>1. Assy part 2. Black SV tube (Vinyl) ø5 L=28±3mm</div>	3. Black Tape	JIG:	1. Measuring jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	<div></div> <div>Wire Insertion to SV tube (Vinyl) ø5 L=28±3mm</div>	<div></div> <div>1. Hold the assy part B-B wires using left hand then insert SV tube (Vinyl) ø5 L=28±3mm using right hand.</div>	n/a	1. No wrong usage of parts 2. No deformed terminal
3	P1 <div></div> <div>Taping 1 SV tube (Vinyl) to wire near terminal</div>	<div></div> <div>55±3mm</div> <div>1. Measure from SV tube (vinyl) to terminal tip 55±3mm using both hands.</div> <div></div> <div>Start of taping</div> <div>2. Hold the SV tube (vinyl) using left hand, get Black tape using right hand and begin taping process.</div> <div></div> <div>35±3mm 20±3mm</div> <div>3. After taping, check the measurement, wire alignment and taping condition.</div>	<div></div> <div>Measuring jig</div> <div></div> <div>Measuring tape</div>	1. No wrong use of tape 2. No loose tape 3. No flip-out tape 4. No peel-off tape 5. No missing tape 6. No wrong dimension <div></div> <div>Wire alignment tolerance 0 - 1 mm</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. Refer to WI-PRO-ASY-001 for Taping process</div>

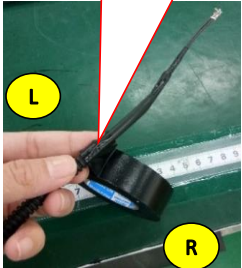
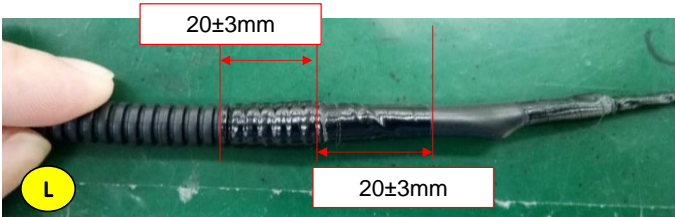

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	WORK INSTRUCTION			Effectivity Date:	May 24, 2024							
	TAPING ASSEMBLY PROCESS			Validity Date:	n/a							
	Process Name/Title:			Model code/Part number:	240B / 7M0489-7020D	Customer:	TRJ	Car Model:	LEXUS-ES	Document No.:	WI-ENG-PDE-073	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	7	Page No.:	3 of 5			

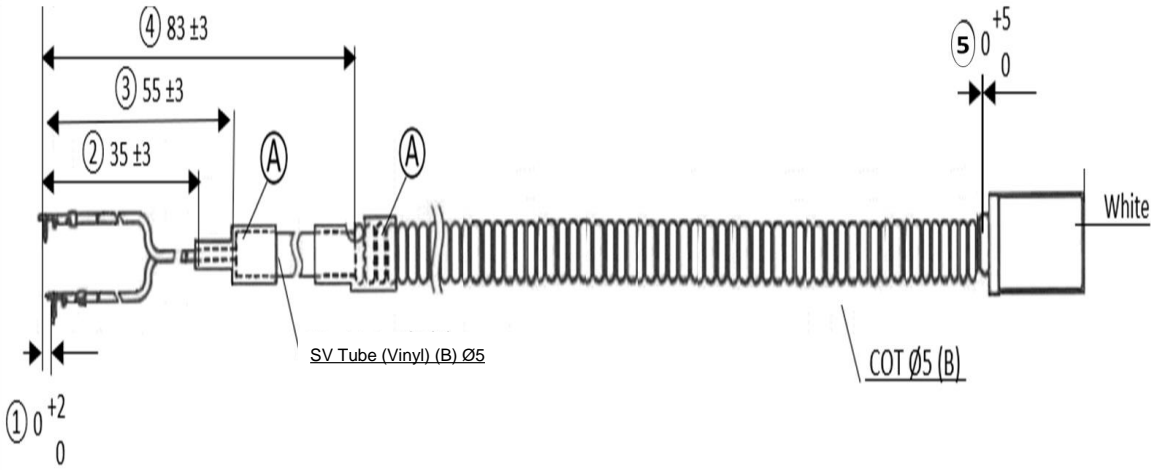

PARTS:		1. Assy Parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 <div>△ 7</div> Taping 2 Corrugated tube to SV tube (Vinyl)	<div>No gap between COT and SV tube (vinyl)</div>  <div>1. Fix the Corrugated tube and SV tube (vinyl) using left hand, get the Black tape using right hand and begin the taping process.</div>  <div>2. After taping, check the measurement and taping condition.</div>		<div>Measuring tape</div> 	Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. Document references: 1. Refer to WI-PRO-ASY-001 for Taping process 1. No wrong use of tape 2. No loose tape 3. No flip-out tape 4. No peel-off tape 5. No missing tape 6. No wrong dimension

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	WORK INSTRUCTION			Effectivity Date:	May 24, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 240B / 7M0489-7020D		Customer: TRJ	Car Model: LEXUS-ES	Document No.: WI-ENG-PDE-073		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	7	Page No.:	4 of 5

PARTS:	1. Assy parts			JIG:	n/a		
NO.	PROCESS NAME	<div><div>7</div>WORK PROCEDURE/ ILLUSTRATION</div>	TOOLS/PPE	QUALITY POINTERS			
5	P1	Measurement <div><div>NOTE: Ⓐ - Taping (B)</div></div>	<div>MEASURING TAPE</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>			

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**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 24, 2024

Validity Date:

n/a

Model code/Part number:

240B / 7M0489-7020DCustomer: **TRJ**

Car Model:

LEXUS-ES

Document No.:

WI-ENG-PDE-073

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

7

Page No.:

5 of 5**PARTS:**

1. Assy parts

JIG:

n/a**VISUAL INSPECTION****TAPING - P1****7M0489-7020D****1****No Missing tape/Wrong use of tape**

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