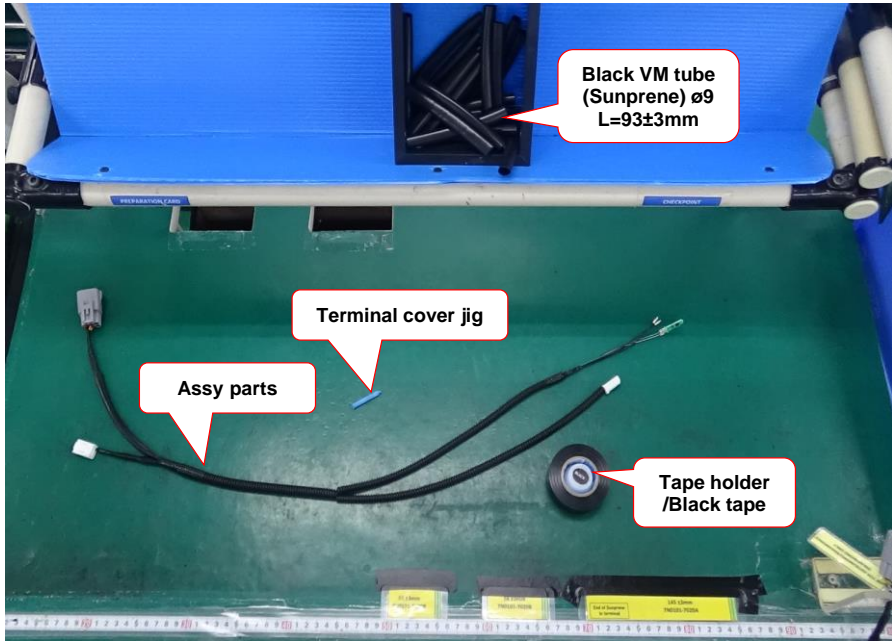



	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>October 22, 2024</b>		
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Process Name/Title:		Model code/Part number: <b>800B/900B/910B / 7N0101-7020D</b>	Customer: <b>TRJ</b>	Car Model: <b>LEXUS-NX/RX</b>	Document No.:	<b>WI-ENG-PDE-1134C</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	1	Page No.:

PARTS:		1. Assy parts      2. Black tape      3. Black VM tube (Sunprene) ø9 L=93±3mm		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P3	Table lay-out	<div><div>TABLE LAY-OUT</div></div>	<div><div><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div><div><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><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>	1. No missing parts/tools 2. No excess parts/tools

Revision History							Prepared by	Reviewed by	Approved by	Noted by
							 A. Hernandez	 C. Villanueva	 A. Arañes	n/a
10/22/24	1	Change from Pre-launch to Magnet. Improve Half-wrap taping method.	A. Hernandez	C. Villanueva	A. Arañes	n/a				
10/17/24	0	Initial Issue.	A. Hernandez	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 17, 2024		



# WORK INSTRUCTION

Process Name/Title:

## TAPING PROCESS ASSEMBLY

Effectivity Date:

October 22, 2024

Validity Date:

n/a

Model code/Part number:

800B/900B/910B / 7N0101-7020D

Customer: TRJ

Car Model:

LEXUS-NX/RX

Document No.:

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


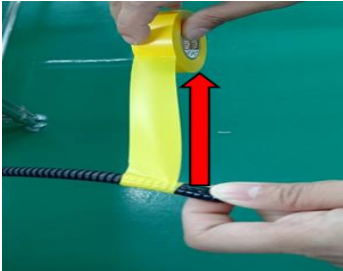


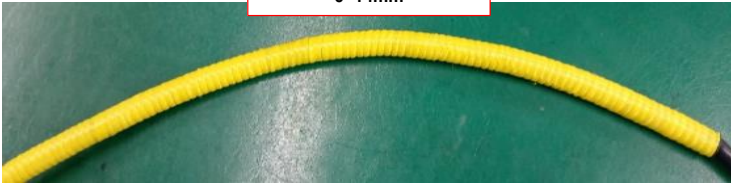

☒ MASSPRO

Revision No.:

1

Page No.:

2 of 6

PARTS:		1. Assy parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	<div>1</div> <div>P3</div> Half-wrap taping	 <p>1. Attach the tape, then make <b>2 windings</b>.</p>	 <p>2. Pull the tape around <b>150mm~200mm</b>.</p>	 <p>3. Hold the other side of the harness on the table and apply force to rotate the tape to make halfwrap shifting until cover the COT with slit.s</p>	<p><b>Document reference/s:</b></p> <p><b>1. Refer to WI-PRO-ASY-001C for taping procedure (special).</b></p> <p><b>1. Use Yellow tape for easy visualization of tape shifting, but actual should be <u>BLACK TAPE</u>.</b></p> <p><b>2. Internal tolerance for halfwrap taping shifting should be 0~14mm only.</b></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>
		 <p>4. Make <b>2 windings</b> before cut the tape.</p>	 <p>5. After taping, check the condition of tape. <b>THERE MUST BE NO EXPOSED COT BETWEEN HALF WRAP TAPING.</b></p>		

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**WORK INSTRUCTION****TAPING PROCESS ASSEMBLY**

Effectivity Date:

October 22, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number: 800B/900B/910B / 7N0101-7020D

Customer: TRJ

Car Model: LEXUS-NX/RX

Document No.:

WI-ENG-PDE-1134C

Purpose:




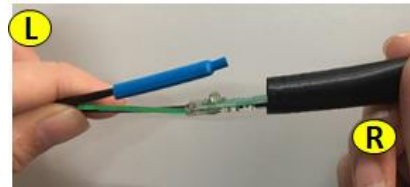
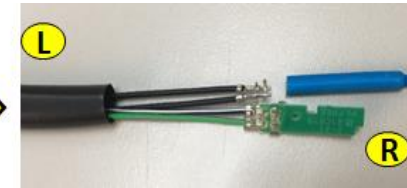


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

3 of 6

PARTS:		1. Assy parts 2. Black VM tube (Sunprene) $\varnothing 9$ L=93 $\pm$ 3mm		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P3  Wire insertion to Black VM tube (Sunprene) $\varnothing 9$ L=93 $\pm$ 3mm	<div></div> <div>1. Get the terminal cover jig using right hand then insert the terminal <b>B-B wires</b> using left hand.</div> <div></div> <div>2. Hold the Black VM tube (Sunprene) <math>\varnothing 9</math> L=93<math>\pm</math>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>TERMINAL COVER JIG</div> 	1. No wrong usage of parts 2. No deformed terminal

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# WORK INSTRUCTION

## TAPING PROCESS ASSEMBLY

Process Name/Title:

Model code/Part number: 800B/900B/910B / 7N0101-7020D

Customer: TRJ

Car Model: LEXUS-NX/RX

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

October 22, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1134C

Revision No.:

1

Page No.:

4 of 6

PARTS:  
1. Assy parts  
2. Black Tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

P3

Taping 2  
Black sunprene tube to  
Black COT near PCB and  
terminal

**50 ± 3mm**

**58 ± 3mm**

**25 ± 3mm**

**Start of taping**

2. Hold the tubes using left hand, get the **Black tape** using right hand then start pre-taping using both hands.

3. Confirm measurement of **25 ± 3mm** from end of tape up to end of tube then continue the taping process using both hands.

**25 ± 3mm**

4. Confirm measurement of **25 ± 3mm** from end of tube up to end of tape then continue the taping process using both hands.

**25 ± 3mm**

**50 ± 3mm**

**58 ± 3mm**

5. After taping, check the measurement, terminal appearance and taping condition.

1. Measure from end of VM tube (Sunprene) up to terminal pointed tip **58 ± 3mm**; and tube up to PCB **50 ± 3mm** using both hands.

MEASURING TAPE



**Important reminders/Note/s:**  
1. 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 dimension
6. No wrong use of tape

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## WORK INSTRUCTION

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Process Name/Title:

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Customer: TRJ

Car Model: LEXUS-NX/RX

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

October 22, 2024

Validity Date:

n/a

Document No.:

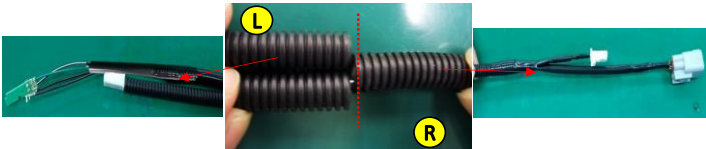
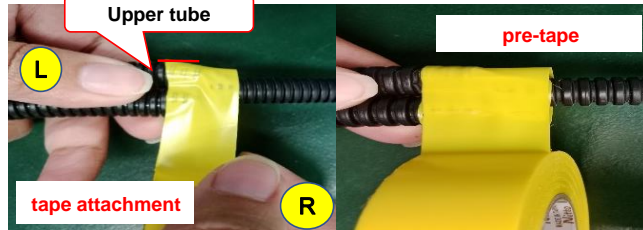
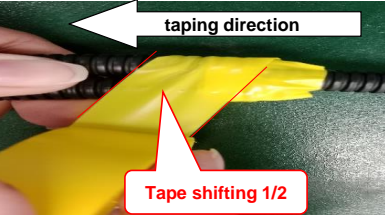
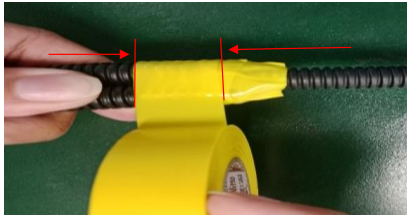
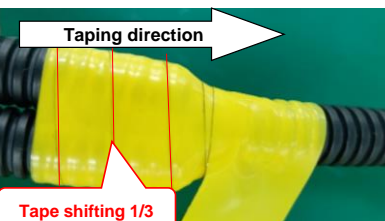
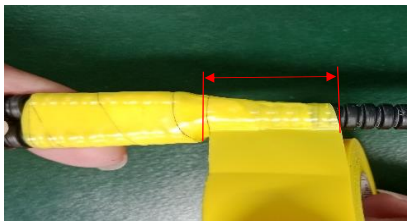
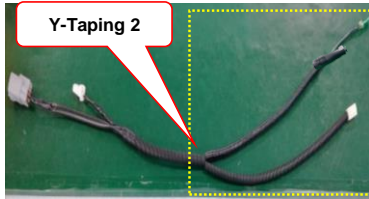
WI-ENG-PDE-1134C

Revision No.:

1

Page No.:

5 of 6

PARTS:		1. Assy parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P3	Y-Taping 2			
		<div><div>No gap between tubes</div><div></div><div>1. Fix the corrugated tube.</div><div>1. Fix the 3 corrugated tube. Note: Follow the correct facing. (If need to standard)</div></div> <div><div>Upper tube</div><div>pre-tape</div><div>tape attachment</div><div></div><div>2. Start taping at the middle of combined tubes, attach the tape on the upper tube. Then make pre-tape 2 windings. Note: Do not exert excessive force during pulling &amp; winding of tape.</div></div> <div><div>taping direction</div><div>Tape shifting 1/2</div><div></div><div>3. Winding the tape 1/2 shifting going to the left side.</div><div></div><div>4. Make 2 windings, width must be 23±2mm.</div></div> <div><div>Taping direction</div><div>Tape shifting 1/3</div><div></div><div>5. Winding the tape 1/3 shifting going to the right side until reach the other side of tube.</div><div></div><div>6. Make 2 windings, width must be 25±3mm.</div></div>		<div>Important reminders/Note/s:</div> <div>1. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines, but actual should be <b>BLACK TAPE</b>.</div> <div>2. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>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</div> <div><div>Y-Taping 2</div><div></div></div>	

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## WORK INSTRUCTION

## TAPING PROCESS ASSEMBLY

Process Name/Title:

Model code/Part number: 800B/900B/910B / 7N0101-7020D

Customer: TRJ

Car Model: LEXUS-NX/RX

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

October 22, 2024

Validity Date:

n/a

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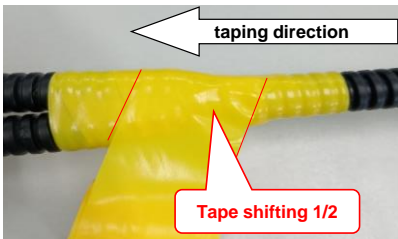
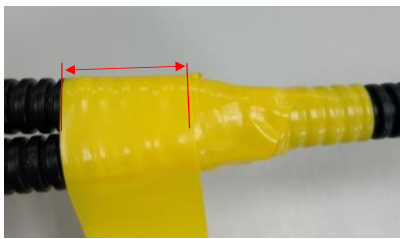
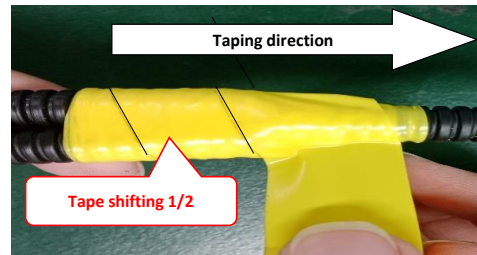

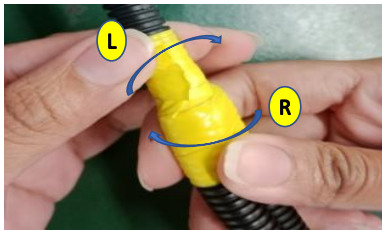
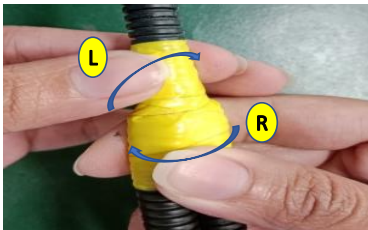
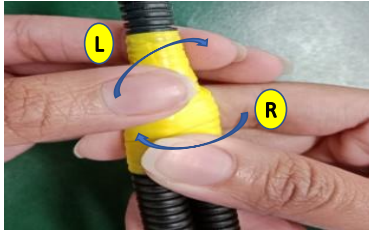
WI-ENG-PDE-1134C

Revision No.:

1

Page No.:

5 of 6

PARTS:		1. Assy parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P3	Y-Taping 2 (Continuation)	<div></div> <div><p>7. Winding the tape <b>1/2 shifting</b> going to the left side.</p></div> <div></div> <div><p>8. Make <b>2 windings</b>, width must be <b>23±2mm</b>.</p></div>		<p><b>Important reminders/Note/s:</b></p> <p>1. Use <u>YELLOW TAPE</u> for easy visualization of shifting lines, but actual should be <u>BLACK TAPE</u>.</p> <p>2. 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> <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></div> <div><p>9. Winding the tape <b>1/2 shifting</b> going to the right side until it reach the other side of tube</p></div> <div></div> <div><p>10. Make <b>3 winds</b>, width must be <b>25±3mm</b>. Then cut the tape.</p></div>		
			<div></div> <div><p>11. conduct proper pressing of end tape using left hand (<b>top part</b>). <b>Note: Reference only.</b></p></div> <div></div> <div><p>12. conduct proper pressing of end tape using left hand (<b>Middle part</b>). <b>Note: Reference only.</b></p></div> <div></div> <div><p>13. conduct proper pressing of end tape using left hand (<b>bottom part</b>). <b>Note: Reference only.</b></p></div>		

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# WORK INSTRUCTION

Process Name/Title:

## TAPING PROCESS ASSEMBLY

Effectivity Date:

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Validity Date:

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Model code/Part number: 800B/900B/910B / 7N0101-7020D

Customer: TRJ

Car Model: LEXUS-NX/RX

Document No.:

WI-ENG-PDE-1134C

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

6 of 6

### PARTS:

1. Assy parts

JIG:

n/a

### VISUAL INSPECTION / QUALITY CHECKPOINTS

P3

7N0101-7020D



1 2 3

**No Missing Tape(Black Tape) Correct Facing Of Y-Taping**

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