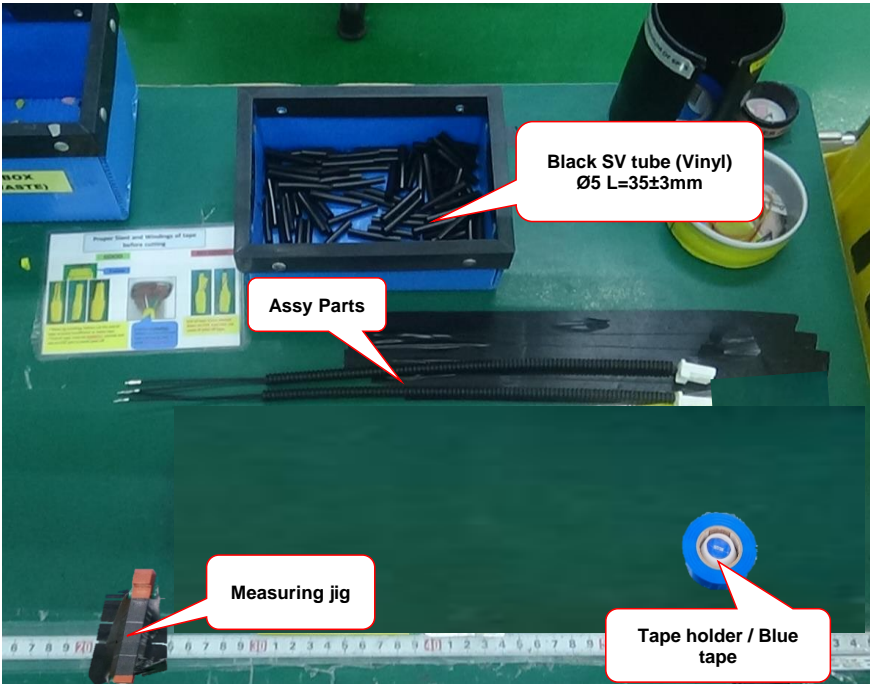



	<b>WORK INSTRUCTION</b> <b>TAPING ASSEMBLY PROCCESS</b>				Effectivity Date:		April 25, 2024	
	Process Name/Title:				Validity Date:		n/a	
	Model code/Part number: <b>100B / 7M0583-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS-UX</b>	Document No.:		<b>WI-ENG-PDE-222</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		6	Page No.: 1 of 6


<b>PARTS:</b>		1. Assy Parts; Black SV tube (Vinyl) Ø5 L=35±3mm; Blue tape		<b>JIG:</b>		1. Measuring jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>		<b>QUALITY POINTERS</b>	
1	P1	<div style="text-align: center;"> <b>TABLE LAY-OUT</b> </div> 		<div style="border: 1px solid red; padding: 5px;"> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div style="border: 1px solid red; padding: 5px;"> <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 style="border: 1px solid red; padding: 5px;"> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>		<b>Document references:</b> 1. Refer to WI-ENG-PDE-221 for Offline assembly process  1. No wrong use of parts 2. No deformed terminal	


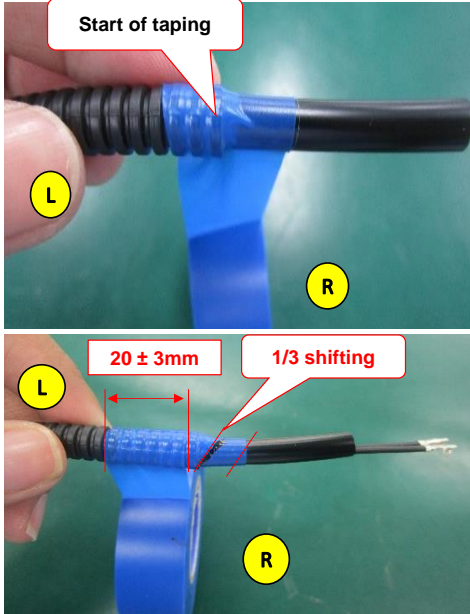

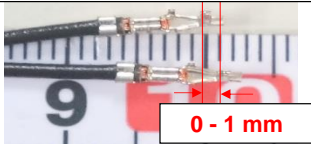
  

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
04/25/24	6	Inclusion of Car model "LEXUS-UX". Transfer Wire insertion to corrugated tube process to Offline assembly process (WI-ENG-PDE-221). Update Measurement and Visual inspection.				D. Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a		
05/17/23	5	Inclusion of table lay-out and quality check points; improvement of important reminders/note/s; improvement of by two's inspection; standardize term for SV tube (Vinyl)				J. Loterte	C. Villanueva	A. Arañes	n/a						
07/08/21	4	Revised due to removal of marking.				M. Catapang	C. Villanueva	A. Shimamura	A. Arañes						
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	October 19, 2018				

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	<b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a							
	Process Name/Title:			Model code/Part number:	<b>100B / 7M0583-7020A</b>	Customer:	<b>TRJ</b>	Car Model:	<b>LEXUS-UX</b>	Document No.:	<b>WI-ENG-PDE-222</b>	
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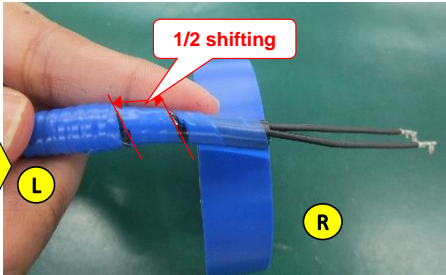
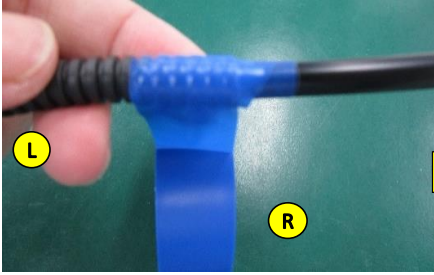
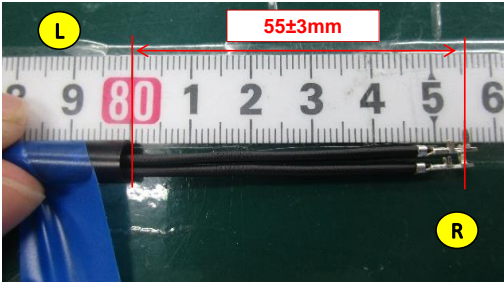
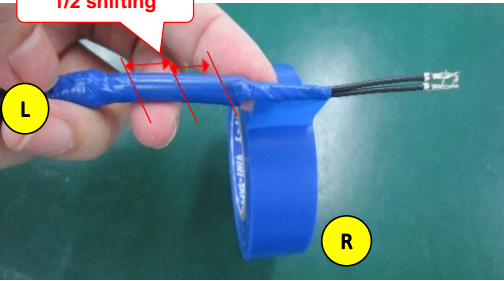

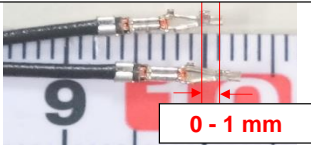
<b>PARTS:</b>	1. Assy parts 2. Black SV tube (Vinyl) Ø5 L=35±3mm 3. Blue tape [1pc]			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	P1	Wire insertion to SV tube (Vinyl) Ø5 L=35±3mm	 <div>1. Get the <b>SV tube (Vinyl) Ø5 L=35±3mm</b> using right hand then insert the <b>B-B wires</b> using left hand.</div>	n/a	1. No wrong use of parts 2. No deformed terminal
3		Full taping (From COT to SV tube (vinyl), SV tube (vinyl) to wires near terminal)	 <div>1. Fix the COT and SV tube (Vinyl) using both hands then get the <b>Blue tape</b> and start pre-taping.</div> <div>2. Wind the tape <b>1/3 shifting</b> going to left side, must be tape width on COT.</div>	<div>MEASURING TAPE</div> 	<b>Important reminders/Note/s:</b> 1. Use <b>BLUE TAPE</b> only. 2. Must be no gap between COT and vinyl tube. 2. Please use calibrated/verified measuring tape when getting the measurement. <b>Document reference/s:</b> 1. Refer to <b>WI-PRO-ASY-001</b> for taping procedure. 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>Wire alignment tolerance</div> 

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	<b>WORK INSTRUCTION</b>			Effectivity Date:	April 25, 2024		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>100B / 7M0583-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS-UX</b>	Document No.: <b>WI-ENG-PDE-222</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	6	Page No.:	3 of 6

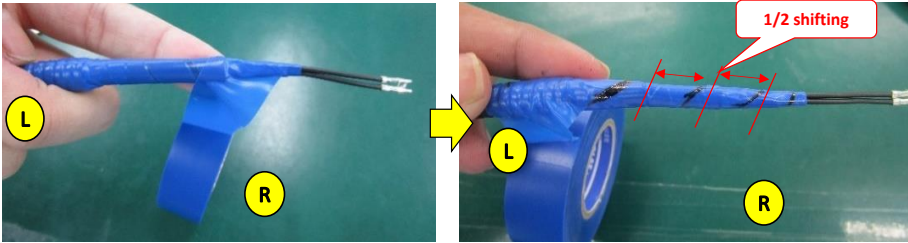
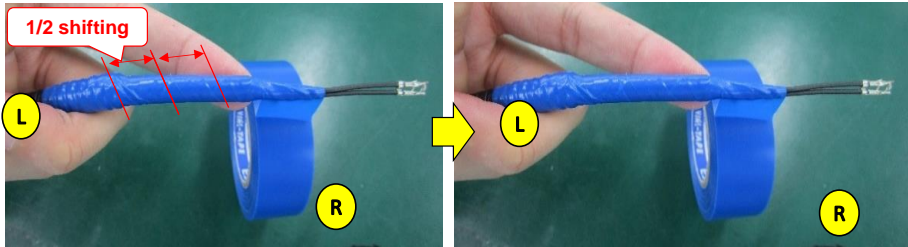
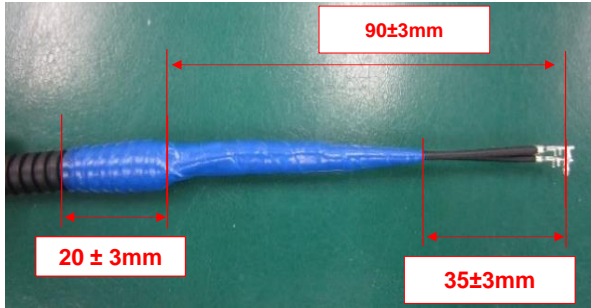

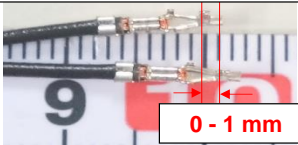
<b>PARTS:</b>		1. Assy parts 2. Blue tape [1pc]		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
3	P1  Full taping (From COT to SV tube (vinyl), SV tube (vinyl) to wires near terminal) (Continuation)	<div><p>3. Make <b>2 winds</b> before shifting then make <b>1/2 shifting</b> going to right side until it reach the end of SV tube (vinyl).</p><p>4. Measure from end of SV tube (vinyl) up to terminal pointed tip <b>55±3mm</b> then continue the taping process.</p><p>5. Hold the SV tube (vinyl) using left hand and fold using right hand. Continue <b>1/2 shifting</b> until it reach the wire. Make <b>1 wind</b> on wire (must be tape width).</p></div>	<div><b>MEASURING TAPE</b></div> 	<div><b>Important reminders/Note/s:</b> 1. Use <b>BLUE TAPE</b> only. 2. Must be no gap between COT and vinyl tube. 2. Please use calibrated/verified measuring tape when getting the measurement.</div> <div><b>Document reference/s:</b> 1. Refer to <b>WI-PRO-ASY-001</b> for taping procedure.</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><b>Wire alignment tolerance</b></div> 	

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	<b>WORK INSTRUCTION</b>			Effectivity Date:	April 25, 2024		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>100B / 7M0583-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS-UX</b>	Document No.: <b>WI-ENG-PDE-222</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	6	Page No.:	4 of 6

<b>PARTS:</b>	1. Assy parts 2. Blue tape [1pc]			JIG:	n/a			
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
3	P1  Full taping (From COT to SV tube (vinyl) , SV tube (vinyl) to wires near terminal) (Continuation)	<div></div> <div>6. Wind the tape <b>1/2 shifting</b> going to left side until it reach the COT then make <b>2 winds</b> before shifting.</div> <div></div> <div>7. Continue <b>1/2 shifting</b> going to right side until tape width in wires. Make <b>3 winds</b> before cutting of tape.</div> <div></div> <div>8. After taping, check the dimension, wire alignment and taping condition.</div>			<div><b>MEASURING TAPE</b></div> 	<div><b>Important reminders/Note/s:</b> 1. Use <b>BLUE TAPE</b> only. 2. Must be no gap between COT and vinyl tube. 2. Please use calibrated/verified measuring tape when getting the measurement.</div> <div><b>Document reference/s:</b> 1. Refer to <b>WI-PRO-ASY-001</b> for taping procedure.</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><b>Wire alignment tolerance</b> <b>0 - 1 mm</b></div>		

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

April 25, 2024

Model code/Part number:

**100B / 7M0583-7020A**

Customer:

**TRJ**

Car Model:

**LEXUS-UX**

Document No.:

**WI-ENG-PDE-222**

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**PARTS:**

1. Assy parts

JIG:

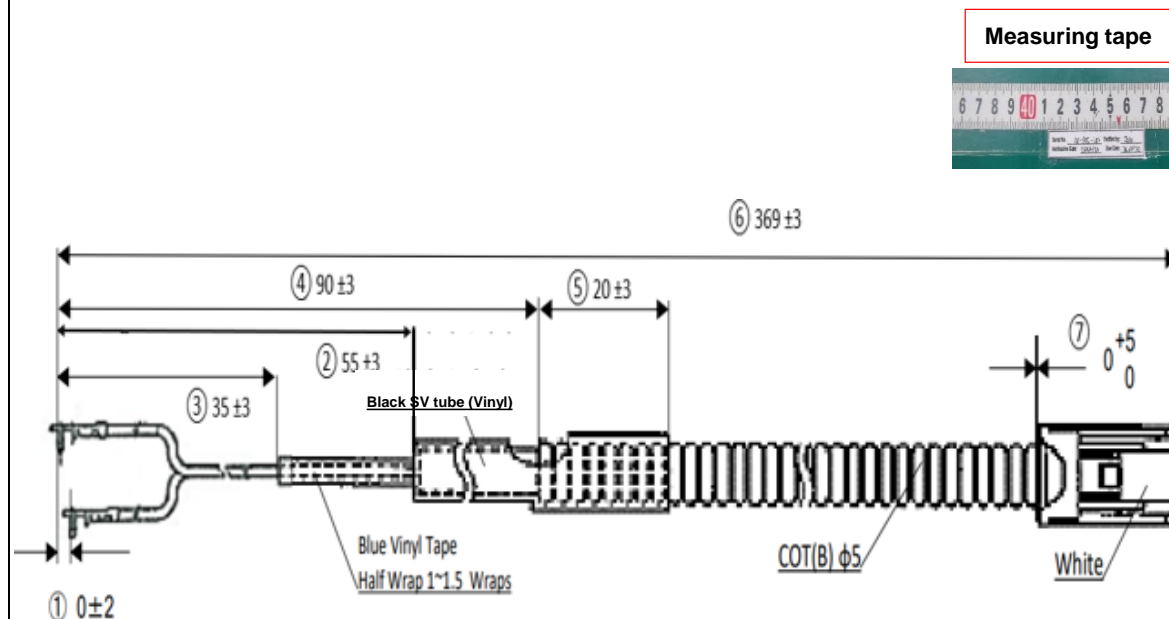
n/a

**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

4

P1

Measurement

**Important reminders and note/s:**

1. Please use calibrated/verified measuring tape when getting the measurement.
2. For Hatsumono, Nakamono and Owarimono.

**Document reference/s:**

1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection

1. No wrong dimension

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Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

April 25, 2024

Validity Date:

n/a

Model code/Part number:

**100B / 7M0583-7020A**Customer: **TRJ**

Car Model:

**LEXUS-EX**

Document No.:

**WI-ENG-PDE-222**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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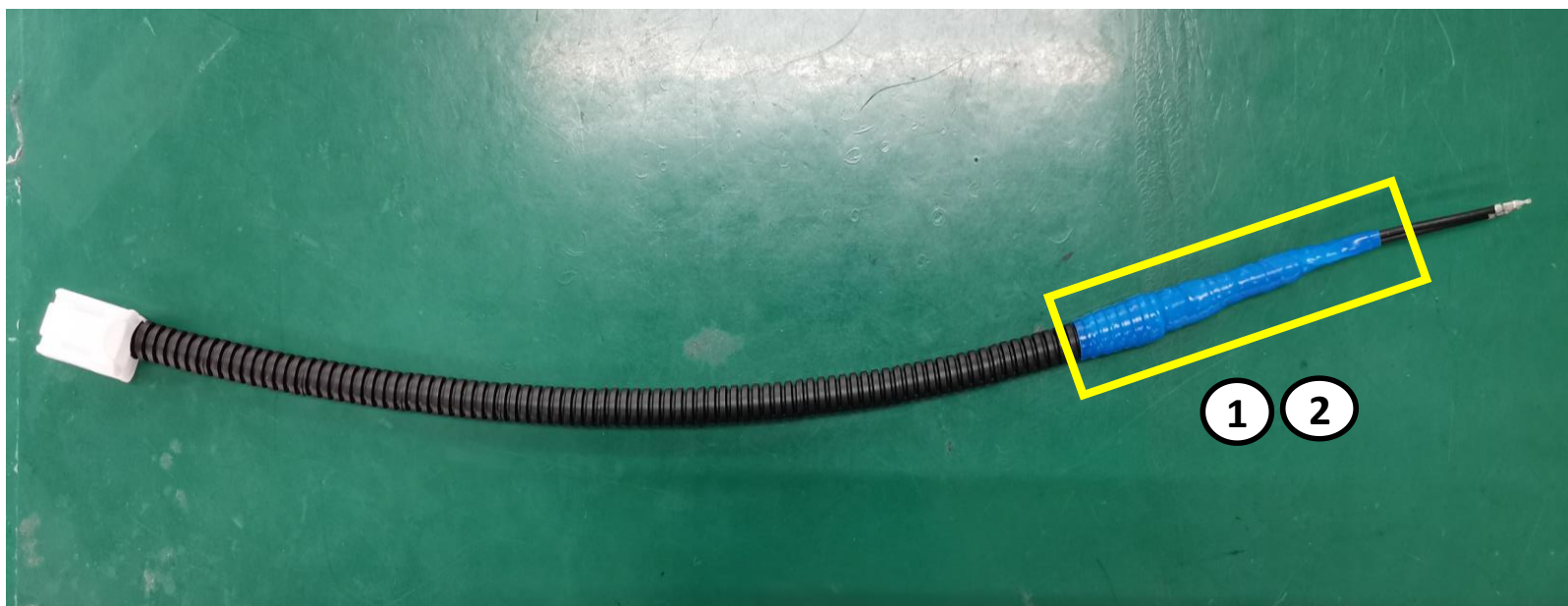
6 of 6

**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION****TAPING-P1****7M0583-7020A****1****No Missing Tape (Blue tape)****2****No Wrong use of tape**

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