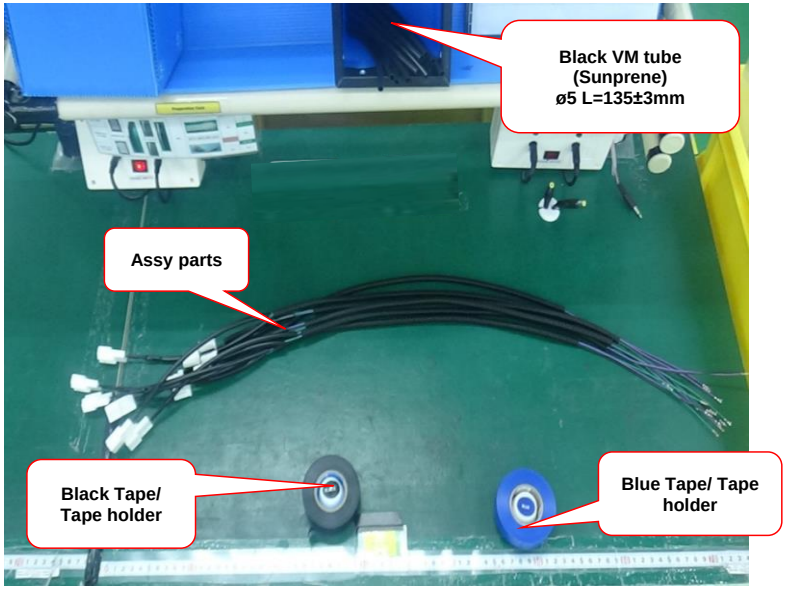
	WORK INSTRUCTION			Effectivity Date:	October 09, 2024		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number:	220D / 7L0135-7021	Customer: TRQSS	Car Model: LEXUS-LM	Document No.:	WI-ENG-PDE-661B	
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	2	Page No.: 1 of 7

PARTS:	1. Assy parts; Black VM tube (Sunprene) ø5 L=135±3mm; Black Tape; Blue Tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	2 P2	Table Lay-out	**Table Lay-out**  	**Safety Instruction** Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) **Housekeeping** 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. **Alert level** For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	1. No missing parts/tools 2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
10/09/24	2	Separate clamp assy and transfer Process 2-5 from P1 due to process improvement. Improved Work procedure of Y-taping, Table lay-out, Measurement and Visual inspection/Quality checkpoints. Inclusion of car model "LEXUS-LM".	D.Castillo	C. Villanueva	A. Arañes	n/a
04/04/23	1	Change purpose from Pre-Launch to Masspro. Inclusion of Good and No Good Illustration and Note for spot taping.	M. ariola	J. Loterte	C. Villanueva	A. Arañes
03/24/23	0	Initial issue. Removal of taping from Black VM tube to wire near terminal and replaced by spot taping on VM tube (Sunprene).	M. ariola	J. Loterte	C. Villanueva	A. Arañes

Prepared by	Reviewed by	Approved by	Noted by
D. Castillo	C. Villanueva	A. Arañes	n/a
Est. Date:	March 24,2023		

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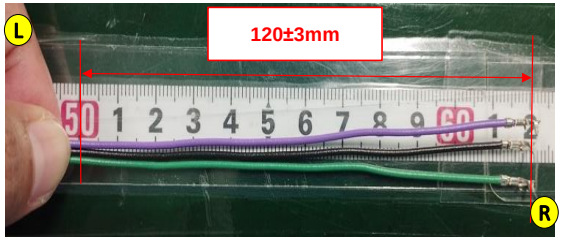
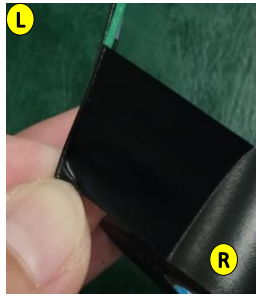
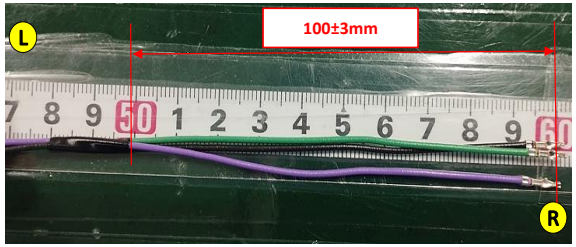
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	2	Page No.:	2 of 7

PARTS:	1. Assy parts 2. Black tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	△2 P2	Spot taping 1	 1. Hold the wires using both hands and measure from wire up to terminal pointed tip **120±3mm.**  2. Hold the wires uding left hand , get the **Black tape** using right hand. Make **2 windings** of tape then cut the tape.  3. After taping, Check the measurement. wire alignment and taping condition.	**MEASURING TAPE** 	1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape

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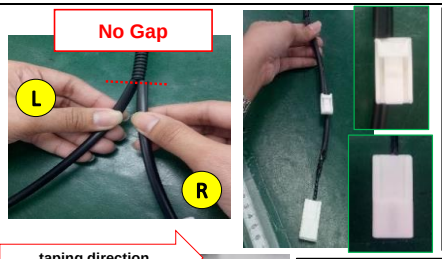
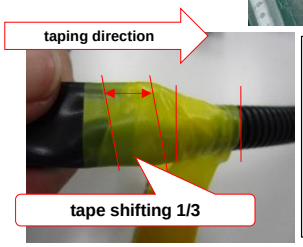
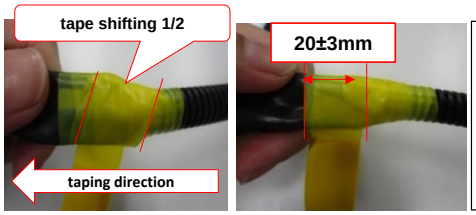
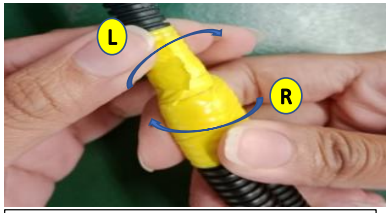
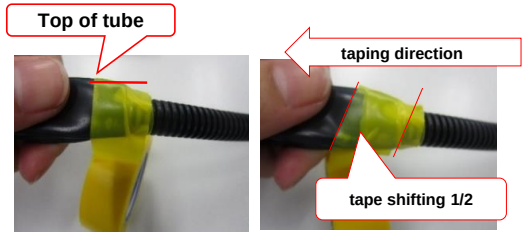
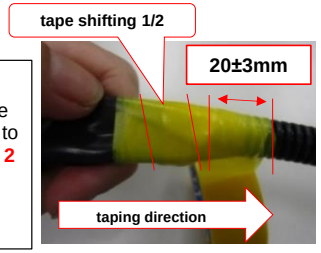
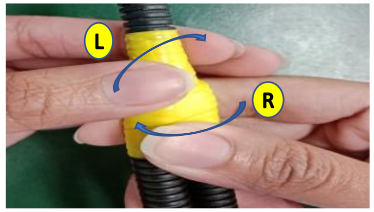
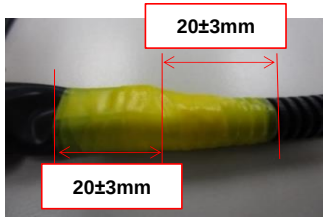
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	2	Page No.:	3 of 7

PARTS:	1. Assy parts 2. Black tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	2 P2	Y-Taping	 1. Fix the two SV tubes (Vinyl) and COT using both hands. *See illustration for correct facing of connector.*  3. Winding the tape **1/3 shifting** going to the right side until reach the other side of tube. Make **2 windings**, width must be **20±3mm**.  4. Winding the tape **1/2 shifting** going to the left side. Make **2 windings**, width must be **20±3mm.**  6. conduct proper pressing of end tape using left hand **(top part)**		***Document reference/s:*** ***1. Refer to WI-PRO-ASY-001C for taping procedure (special).*** ***Important reminders/Note/s:*** ***1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.*** ***2. Please use calibrated/verified measuring tape when getting the measurement.***
			 2. Start taping at the middle of combined tubes, attach the tape on the top of tube. Then make pre-tape **2 windings.** Winding the tape **1/2 shifting** going to the left side. Make **2 windings**, width must be **20±3mm.** ***Note**: Do not exert excessive force during pulling & winding of tape.*  5. Winding the tape **1/2 shifting** going to the right side until it reach the other side of tube. Make **3 winds,** width must be **20±3mm.** Then cut the tape.  7. conduct proper pressing of end tape using left hand **(Middle part)** 8. conduct proper pressing of end tape using left hand **(bottom part)**		1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape  9. Check the Measurment and condition of tape.

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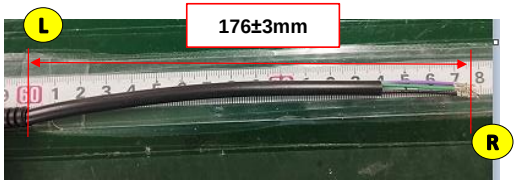
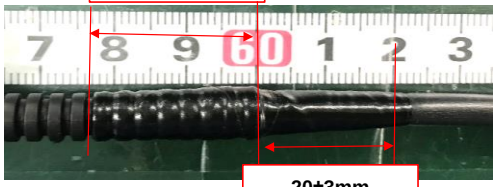
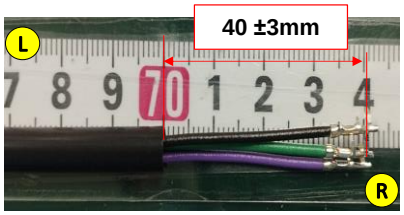
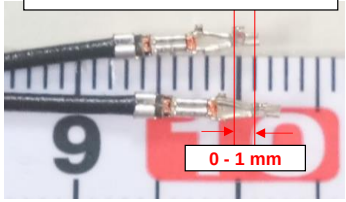
	Model code/Part number:	220D / 7L0135-7021	Customer: TRQSS / Car Model: LEXUS-LM	Document No.:	WI-ENG-PDE-661B		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	2	Page No.:	4 of 7

PARTS:	1. Assy parts 2. Black tape	3. Black VM tube (Sunprene) ø5 L=135±3mm	JIG:	n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	2 Wire insertion to Black VM tube (Sunprene) ø5 L=135±3mm	 1. Get the Black VM tube (Sunprene) **ø5 L=135±3mm** using right hand and insert to **B-V-G wires**.	n/a	1. No wrong usage of parts 2. No deformed terminal
5	2 P2 Taping 2 Corrugated tube to VM tube (Sunprene)	 1. Hold the COT using left hand and measure from the end of Corrugated tube up to the terminal tip **176±3mm**. 2. Hold the Corrugated tube using left hand then start taping using both hands.   3. After taping, check the taping condition and terminal appearance.	**MEASURING TAPE** 	***Important reminders and Note/s:*** ***1. Please use calibrated/verified measuring tape when getting the measurement.*** ***Document reference/s:*** ***1. Refer to WI-PRO-ASY-001 for taping procedure.*** 1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape **Wire alignment tolerance** 

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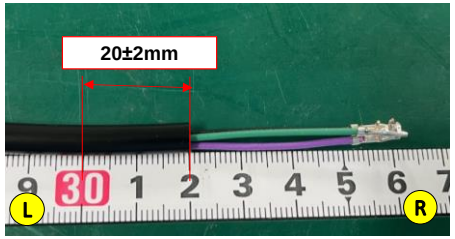
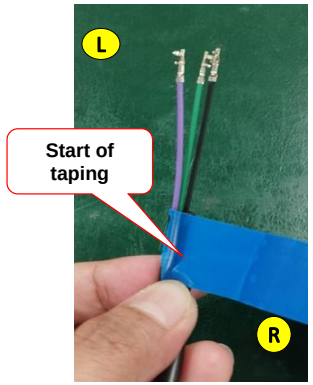
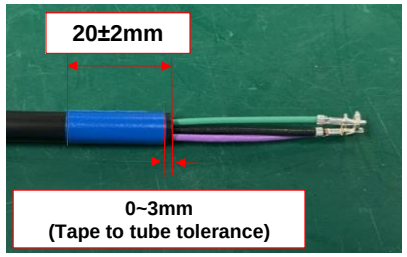
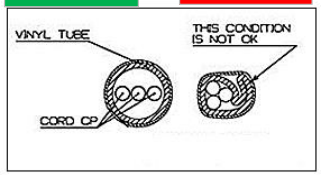
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	2 / Page No.: 5 of 7

PARTS:	1. Assy parts 2. Blue tape	JIG:	n/a

NO.	PROCESS NAME		2 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P2	Spot taping 2	 1. Measure the end of the VM tube (Sunprene) up to the terminal tip **20±2mm**.  2. Get the **Blue tape** using right hand then conduct 2 winding of spot taping using both hands.  3. After taping, check the measurement, taping condition.	**MEASURING TAPE** 	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 ***Important reminders/Note/s:*** ***1. Use BLUE TAPE only*** ***2. Please use calibrated/verified measuring tape when getting the measurement.*** ***3. Do not compress/fold the VM tube (Sunprene) during spot taping of BLUE TAPE. Wire must be free to move inside the tube.*** **SPOT TAPING ILLUSTRATION** **GOOD** / **NO GOOD** 

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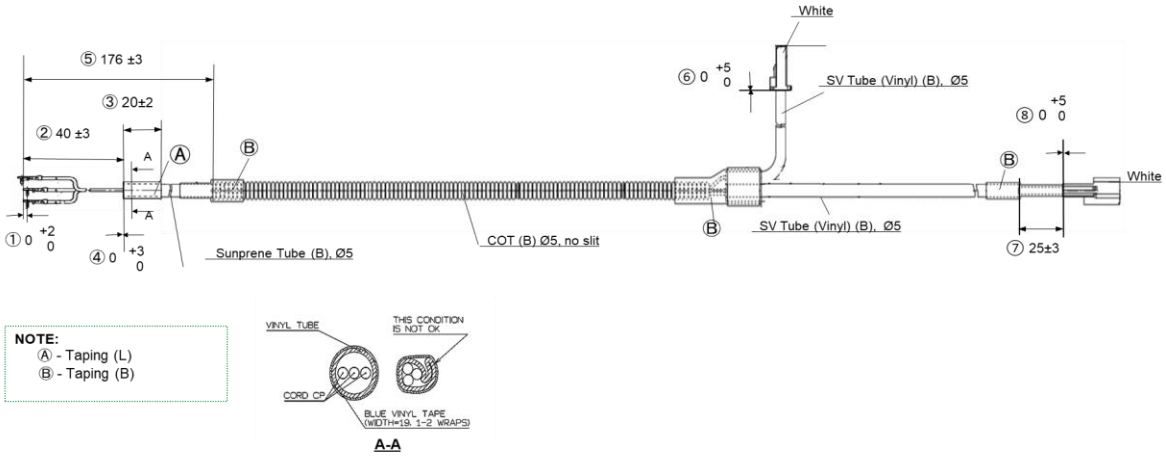
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	2	Page No.: 6 of 7

PARTS:	1. Assy parts	JIG:	n/a

NO.	PROCESS NAME		2 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P2	Measurement		**MEASURING TAPE** 	***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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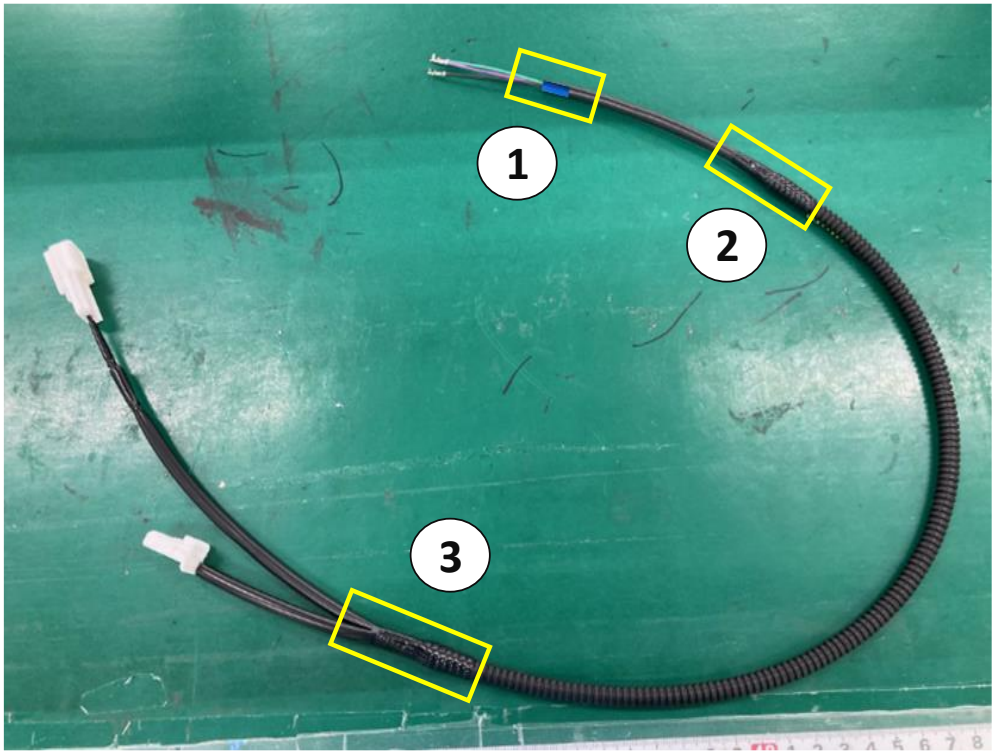
PARTS:	1. Assy parts	JIG:	n/a

2 **VISUAL INSPECTION/ QUALITY CHECKPOINTS**

TAPING - P2	7L0135-7021



1 **No Missing tape/ No Wrong color of tape (Blue tape)**

2 3 **No Missing tape/ No Wrong color of tape (Black tape)**

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