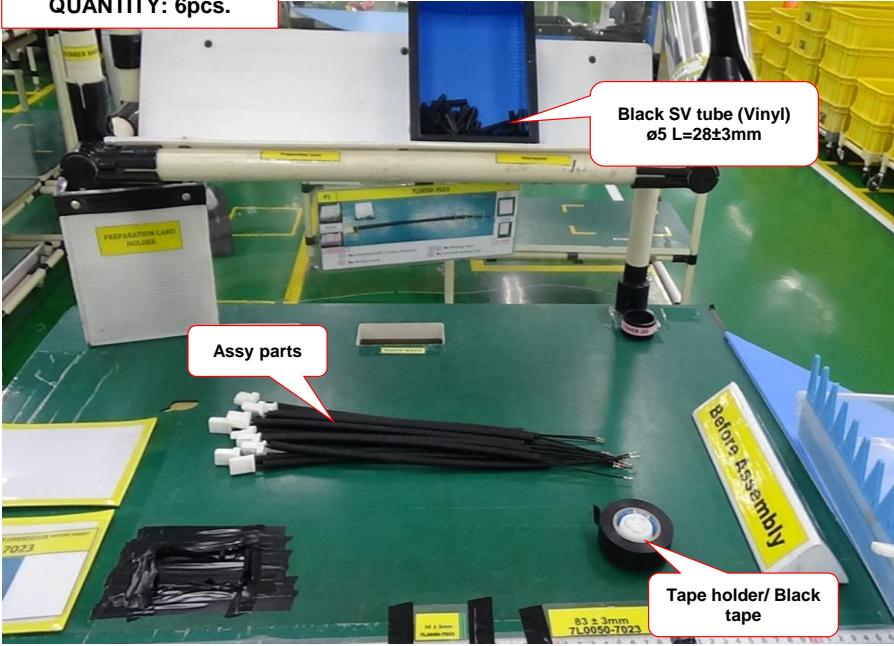



	WORK INSTRUCTION			Effectivity Date:	June 27, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 241B / 7L0050-7023	Customer: TRQSS	Car Model: LEXUS ES	Document No.:	WI-ENG-PDE-191		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	4	Page No.:	1 of 5

PARTS:		1. 1. Pre-asy parts (Connector 6098-3810 W, AVSSf 0.3 wires B L=358mm [2pcs], COT ø5 L=267±3mm (no slit); Black SV tube (Vinyl) ø5 L=28±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1	Table Lay-out	<div> <div>BATCHING QUANTITY: 6pcs.</div> <div>TABLE LAY-OUT</div>  <div>Black SV tube (Vinyl) ø5 L=28±3mm</div> <div>Assy parts</div> <div>Tape holder/ Black tape</div> </div>	<div> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to WI-ENG-PDE-190 for 7L0050-7023 Offline Process 1. No missing parts/tools 2. No excess parts/tools

Revision History							Prepared by	Reviewed by	Approved by	Noted by
06/27/24	4	Split type process transfer clamp taping to Clamp Assembly Process. Improve measurement and visual inspection/quality pointers	A.Hernandez	C. Villanueva	A. Arañes	n/a	 A.Hernandez	 C. Villanueva	 A. Arañes	n/a
01/18/23	3	Inclusion of Batching quantity: 6pcs. Process identification per table by providing table 1 and table 2. Inclusion of quality checkpoints. Change of wordings from black vinyl tube to Black Sv tube (vinyl) as standard description.	M.Catapang	J. Loterte	C. Villanueva	A. Arañes				
08/30/22	2	Merged P1 and P2 process due 1MP improvement project. Additional quality pointers in table lay-out and wire insertion refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance. Improve Visual/By two's inspection. Include the control numberb of 7L0050-7023 offline process. Additional table lay-out.	D. Castillo	J. Loterte	C. Villanueva	A. Arañes				
02/11/21	1	Transfer process owner from Production (WI-PRO-ASY-091) to Engineering (WI-ENG-PDE-191), Exclude wire insertion to connector process from Taping assembly to Kitting assembly process due to balancing from COT to wire near connector, apply some improvements and updated picturesconcern, removal of taping	J. Loterte	R. Peñaloza	A.Shimamura	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	July 27, 2018		

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number: 241B / 7L0050-7023

Customer: TRQSS

Car Model: LEXUS ES

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

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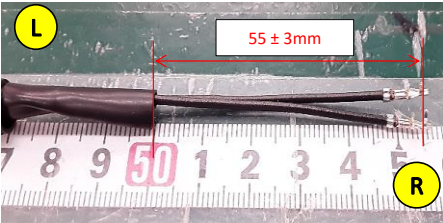
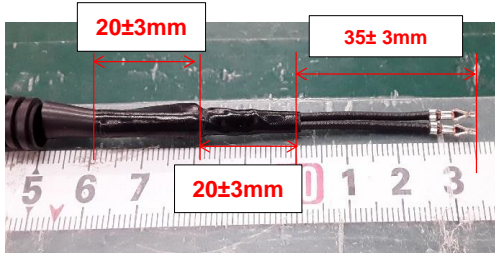

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PARTS:		1. Assy parts 2 Black tape [1pc]		3. Black SV tube (Vinyl) $\phi 5$ L=28 \pm 3mm	JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	Wire insertion to Black SV tube (Vinyl) $\phi 5$ L=28 \pm 3mm	<div></div> <div>1. Get the Black Vinyl tube $\phi 5$ L=28\pm3mm using right hand then insert black wires.</div>		n/a	1. No wrong usage of parts 2. No deformed terminal
3		Taping 1 SV tube (Vinyl) to wire near terminal	<div></div> <div>1. Measure the end of the SV tube (Vinyl) up to terminal pointed tip 55\pm3mm using both hands.</div> <div></div> <div>2. Hold the SV tube (Vinyl) using left hand and start taping using right hand.</div> <div>3. After taping, check the measurement, alignment and taping condition.</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 Important reminders/note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. Document references: 1. Please refer to WI-PRO-ASY-001 for taping procedure.

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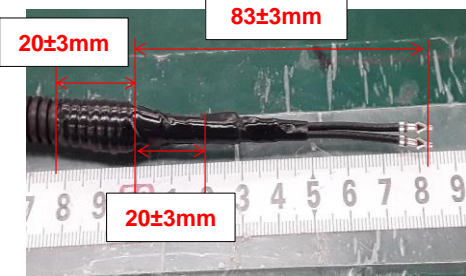

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape [1pc]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 Taping 2 COT to SV tube (Vinyl)	<div><p>1. Hold the corrugated tube using left hand, measure from COT up to the terminal pointed tip $83\pm3\text{mm}$ using both hands.</p></div> <div><p>20±3mm</p><p>83±3mm</p><p>20±3mm</p></div> <div>2. Hold the corrugated using left hand then start taping using right hand.</div> <div>3. After taping, check the measurement and taping condition.</div>		<div>Measuring tape</div> 	<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>Important reminders/note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document references: 1. Please refer to WI-PRO-ASY-001 for taping procedure.</div>

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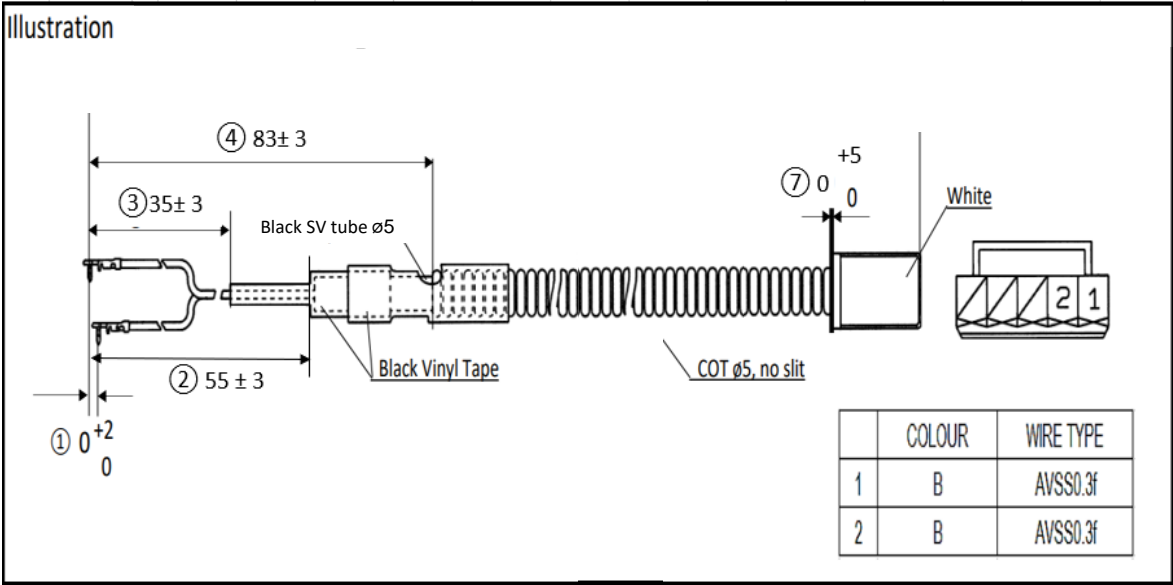
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PARTS:		1. Assy parts 2. Black tape [1pc]		JIG:	n/a
NO.	PROCESS NAME	4 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	4 QUALITY POINTERS
5	P1	<div><div>4</div><div>Measuring tape</div><div></div><div>Illustration</div><div></div></div>		<div>Important reminders 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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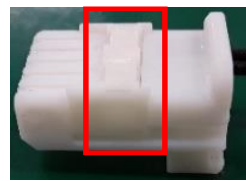
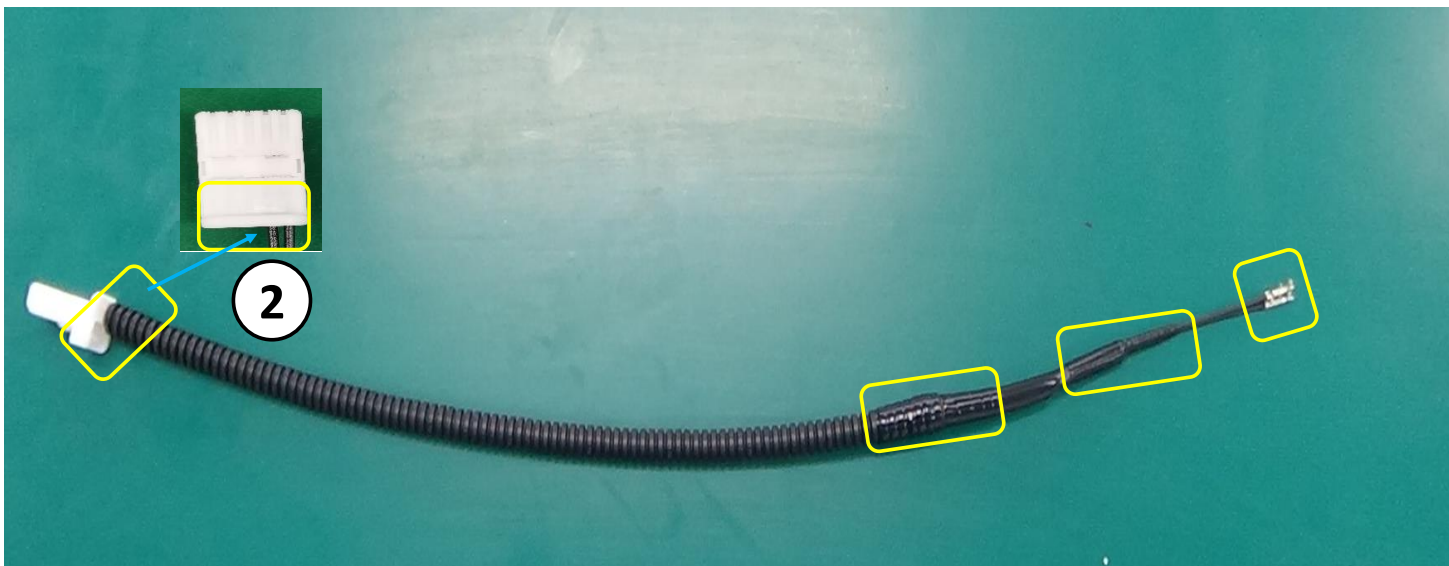
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**P1****7L0050-7023****1****GOOD****NO GOOD****2****GOOD****NO GOOD****1** No **Unlock/ Half Lock Connector****3** No **Terminal Backing Out****5** No **Deformed Terminal****2** No **Wrong Insert****4** No **Missing Tape**

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