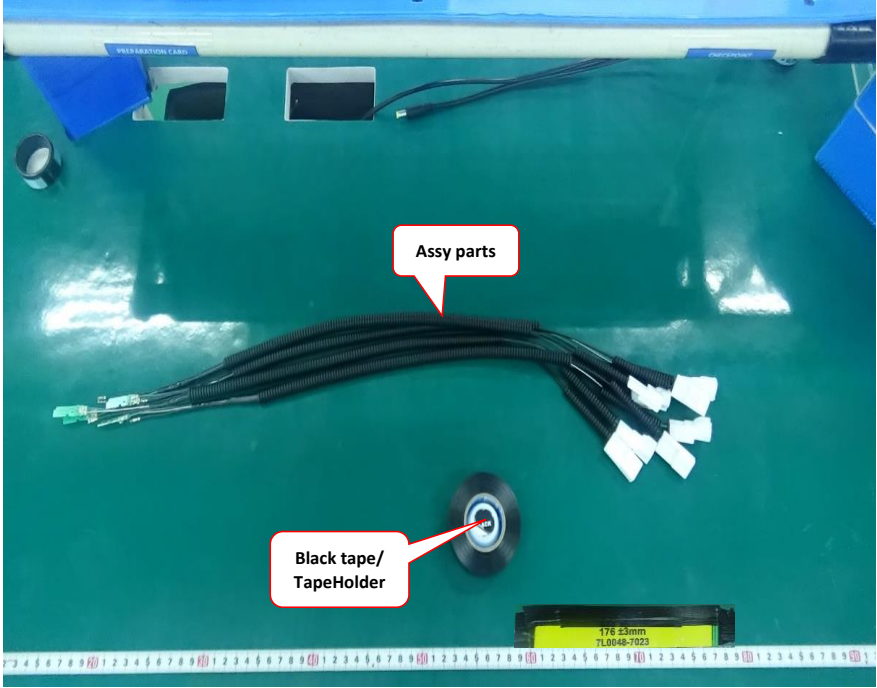


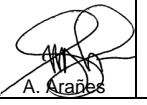

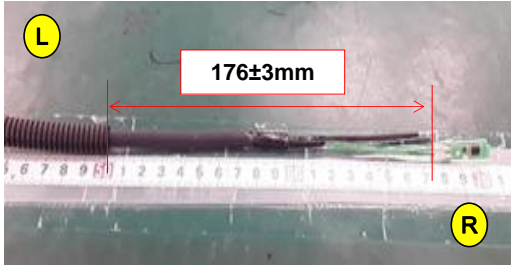

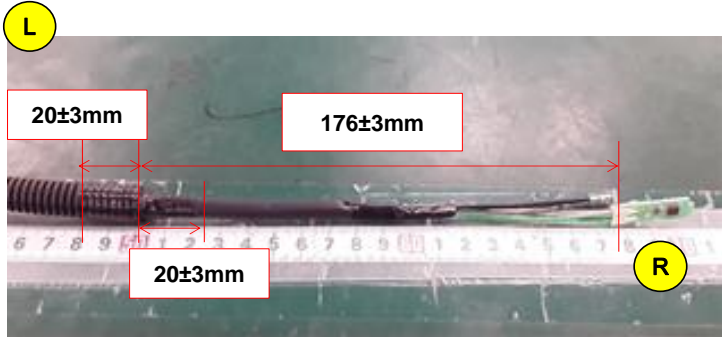

	WORK INSTRUCTION				Effectivity Date:		October 1, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 241B / 7L0048-7023A		Customer: TRQSS	Car Model: LEXUS-ES	Document No.:		WI-ENG-PDE-1069C	
	Purpose: <input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:		1	Page No.: 1 of 6

PARTS:		1. Assy parts; Black Tape				JIG:		n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	P3	<div>Table Lay-out</div> 				<div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p>		1. No missing parts/tools 2. No excess parts/tools	
				<div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p>					
				<div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>					
Revision History									
10/01/24	1	Changr from Pre-launch to Masspro.				D.Castillo	C. Villanueva	A. Arañes	n/a
09/24/24	0	Initial issue. Separate taping due to process improvement.				D.Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted
						Prepared by	Reviewed by	Approved by	Noted by
						 D. Castillo	 C. Villanueva	 A. Arañes	n/a
						Est. Date:	September 24, 2024		

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY


	WORK INSTRUCTION			Effectivity Date:	October 1, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 241B / 7L0048-7023A		Customer: TRQSS	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-1069C	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	2 of 6

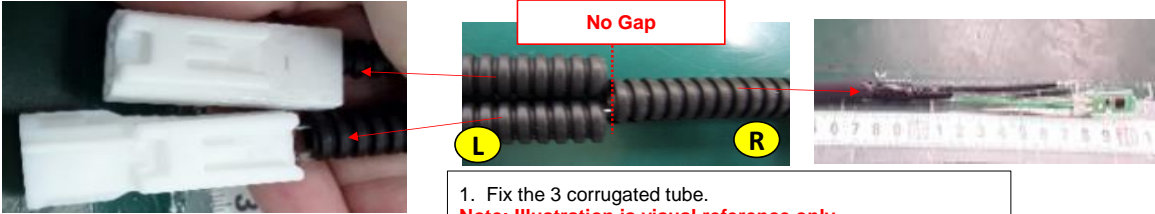
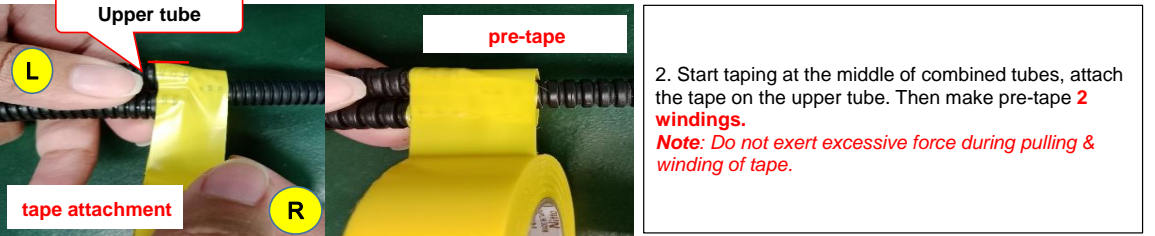
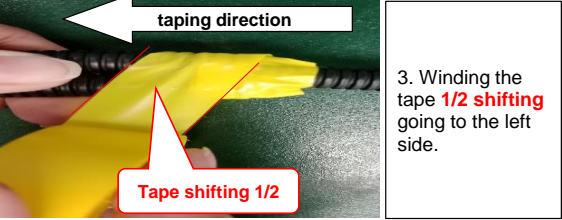
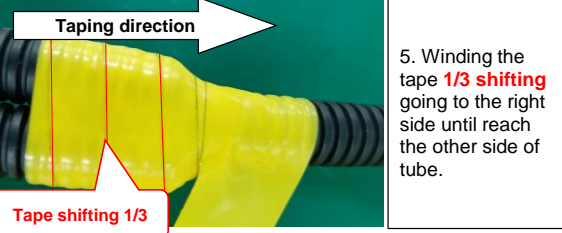
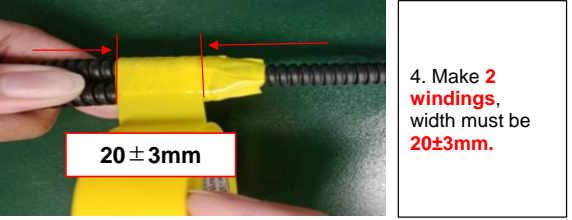
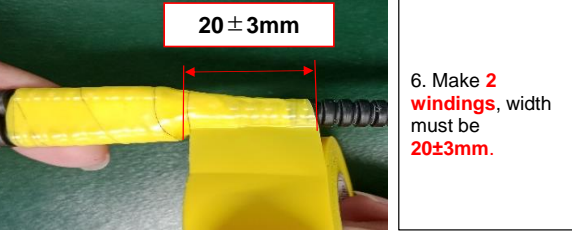
PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P3 Taping 2 Black corrugated tube to VM tube (Sunprene) near terminal	<div></div> <div>1. Hold the COT using left hand. Measure from end of COT to terminal pointed tip and edge of Hot melted wire 176±3mm.</div> <div></div> <div>2. Hold the COT using left hand. Get the Black tape using right hand and start taping using both hands.</div> <div></div> <div>3. After taping, check the measurements and taping condition.</div>		<div>MEASURING TAPE</div> 	<p>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <ul style="list-style-type: none">1. No flip-out tape2.No peel-off tape3. No loose tape4. No wrong dimension5. No wrong use of tape6. No missing tape

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

	WORK INSTRUCTION			Effectivity Date:	October 1, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 241B / 7L0048-7023A		Customer: TRQSS	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-1069C	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	3 of 6


PARTS:	1. Assy parts 2. Black tape			JIG:	n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
3	P3	Y-Taping	<div><p>1. Fix the 3 corrugated tube. Note: Illustration is visual reference only.</p></div> <div><p>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 & winding of tape.</p></div> <div><p>3. Winding the tape 1/2 shifting going to the left side.</p></div> <div><p>5. Winding the tape 1/3 shifting going to the right side until reach the other side of tube.</p></div> <div><p>4. Make 2 windings, width must be 20±3mm.</p></div> <div><p>6. Make 2 windings, width must be 20±3mm.</p></div>	<p>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>Important reminders/Note/s: 1. Use yellow tape for easy visualization of tape shifting, but actual should be BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none">1. No loose tape2. No flip-out tape3. No peel-off tape4. No wrong use of tape5. No wrong dimension-out tape6. No exposed wire7. No gap between tubes			


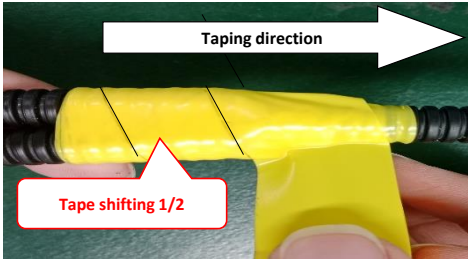
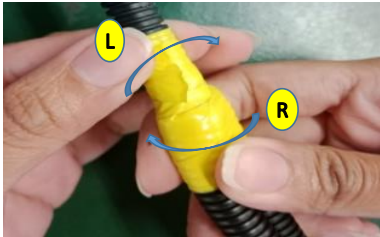
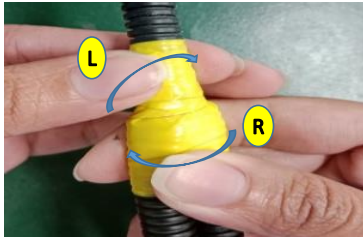
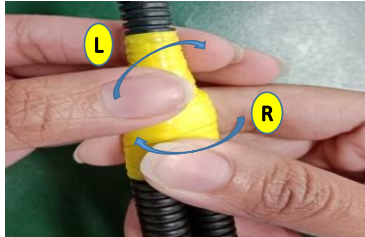
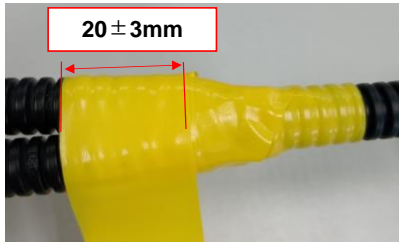
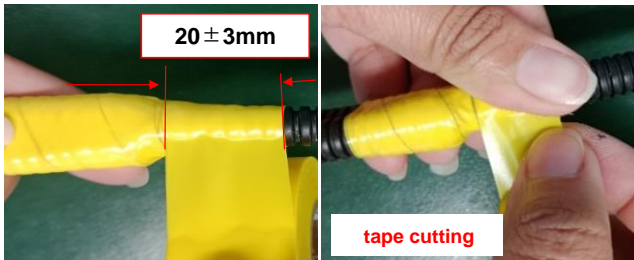
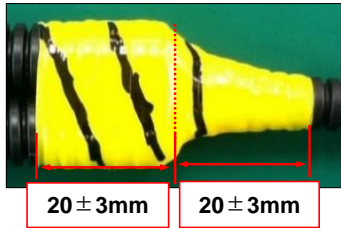
CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)

MASTER COPY

DCC Stamp


	WORK INSTRUCTION			Effectivity Date:	October 1, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 241B / 7L0048-7023A		Customer: TRQSS	Car Model: LEXUS-ES	Document No.: WI-ENG-PDE-1069C		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	4 of 6

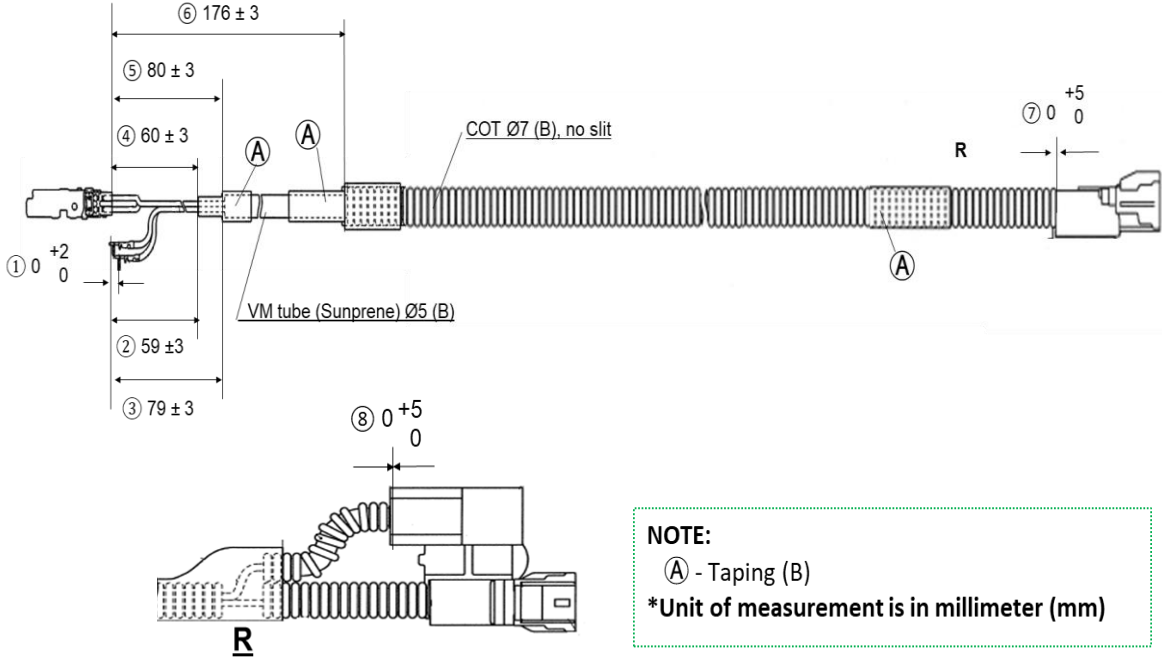

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
3	P3 Y-Taping (Continuation)	<div></div> <div></div> <div></div> <div></div> <div></div>		<div></div> <div></div>	<p>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>Important reminders/Note/s: 1. Use yellow tape for easy visualization of tape shifting, but actual should be <u>BLACK TAPE</u>. 2. Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none">1. No loose tape2. No flip-out tape3. No peel-off tape4. No wrong use of tape5. No wrong dimension-out tape6. No exposed wire7. No gap between tubes <div></div> <p>14. Check the Measurement and condition of tape.</p>	

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

	WORK INSTRUCTION			Effectivity Date:	October 1, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 241B / 7L0048-7023A		Customer: TRQSS	Car Model: LEXUS-ES	Document No.: WI-ENG-PDE-1069C		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	5 of 6

PARTS:	1. Assy parts			JIG:	n/a			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
4	P3	Measurement	<div></div>			<div>MEASURING TAPE</div> 	<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>	

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 1, 2024

Model code/Part number:

241B / 7L0048-7023A

Customer:

TRQSS

Car Model:

LEXUS-ES

Document No.:

WI-ENG-PDE-1069C

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

6 of 6

PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P3****7L0048-7023A**

1

2

No Missing Tape (Black tape)

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp