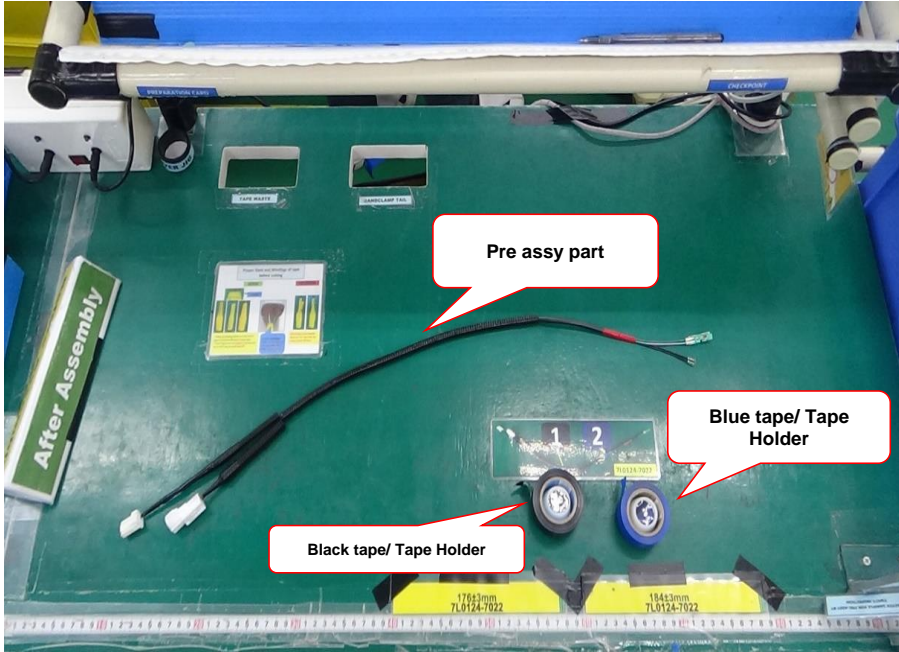
	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date:		September 13, 2024	
	Process Name/Title:				Validity Date:		n/a	
	Model code/Part number: 922B / 7L0124-7022A		Customer: TRQSS		Car Model: LEXUS NX		Document No.: WI-ENG-PDE-1044D	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		1		Page No.: 1 of 6	


PARTS:		1. Assy parts; Blue tape; Black tape		JIG:		n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
1	P4	<p>TABLE LAY-OUT</p> 	<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>1. No missing parts in assy parts 2. No excess tape/tape holder 3. No wrong position of tape holder</p>			

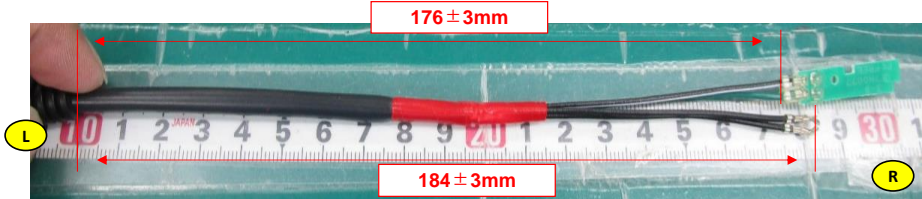

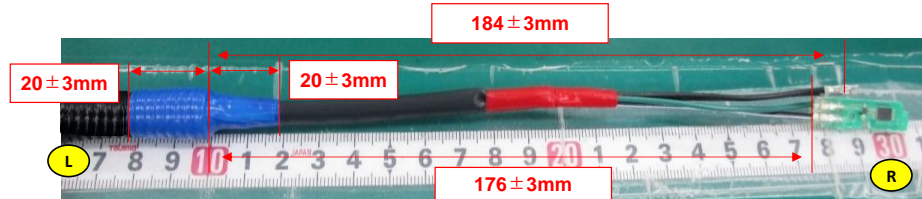

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
09/13/24	1	Change from Pre-launch to Masspro.						D.Castillo	C.Villanueva	A. Arañes	n/a				
09/10/24	0	Initial issue.						D.Castillo	C.Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change						Revised	Reviewed	Approved	Noted	Est. Date:		Septmeber 10, 2024	

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	WORK INSTRUCTION			Effectivity Date:	September 13, 2024		
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	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. Blue tape [1pc]		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS		
2	P4 Taping 5 Black corrugated tube to Black VM tube (Sunprene)	<div><p>1. Measure from end of VM tube (Sunprene) up to edge of hotmelted wire 176±3mm and up to terminal pointed tip 184±3mm using both hands.</p></div> <div><p>2. Get the Blue tape using right hand then start taping process using both hands.</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>	<div>Measuring tape</div> 	<p>Important reminders/Note/s:</p> <p>1. 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 use of tape 6. No wrong dimension</p> <p>Document references:</p> <p>1. Please refer to WI-PRO-ASY-001 for taping procedure.</p>		

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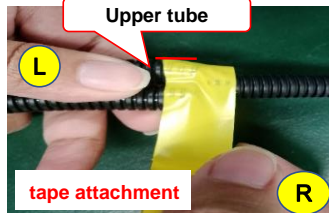
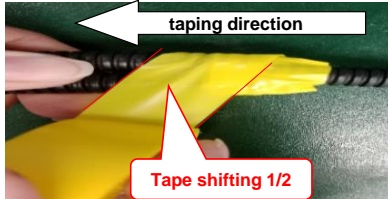
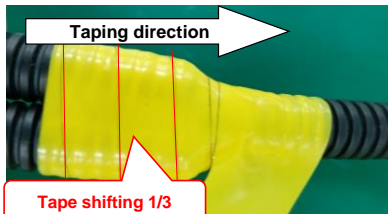
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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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
3	P4	Y-Taping	<div><div><p>Connector facing</p></div><div><p>Upper tube</p><p>pre-tape</p><p>tape attachment</p></div><div><p>taping direction</p><p>Tape shifting 1/2</p></div><div><p>Taping direction</p><p>Tape shifting 1/3</p></div><div><p>1. Fix the 3 corrugated tube. Note: Connector facing must be same with the illustration.</p><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><p>3. Winding the tape 1/2 shifting going to the left side.</p><p>4. Make 2 windings, width must be 25±3mm.</p><p>5. Winding the tape 1/3 shifting going to the right side until reach the other side of tube.</p><p>6. Make 2 windings, width must be 25±3mm.</p></div><div><p>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension-out tape 6. No exposed wire 7. No gap between tubes 8. Must follow the connector facing</p><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></div></div>		

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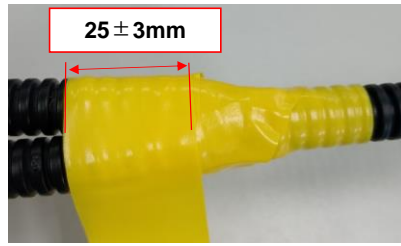
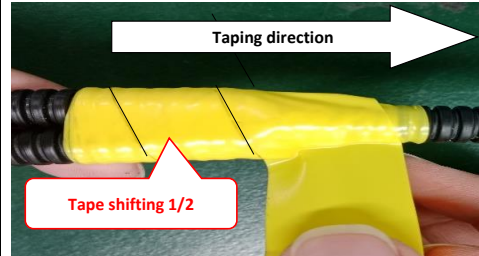
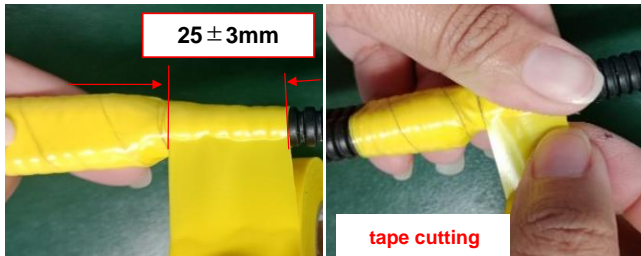
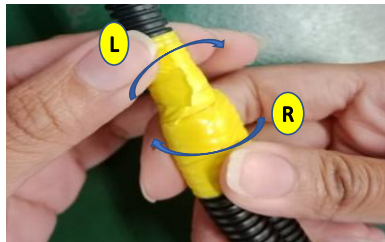
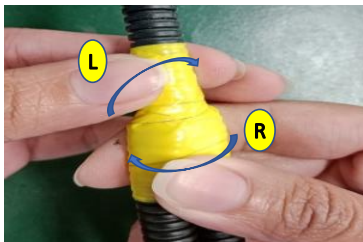
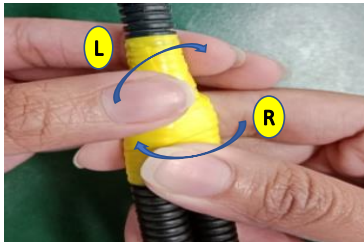
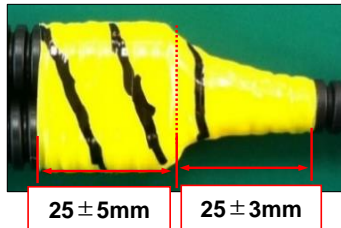
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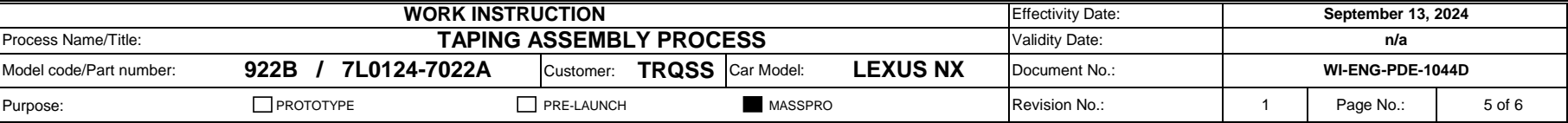
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PARTS:		1. Assy parts 2. Black tape [1pc]		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
3	P4	Y-Taping (Continuation)	<div></div> <div>7. Winding the tape 1/2 shifting going to the left side.</div>	<div></div> <div>8. Make 2 windings, width must be 23±2mm.</div>	<div>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension-out tape 6. No exposed wire 7. No gap between tubes</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</div> <div>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.</div>	
			<div></div> <div>9. Winding the tape 1/2 shifting going to the right side until it reach the other side of tube</div>	<div></div> <div>10. Make 3 winds, width must be 25±3mm. Then cut the tape.</div>		
			<div></div> <div>11. conduct proper pressing of end tape using left hand (top part)</div>	<div></div> <div>12. conduct proper pressing of end tape using left hand (Middle part)</div>		<div></div> <div>13. conduct proper pressing of end tape using left hand (bottom part)</div>
			<div></div> <div>14. Check the Measurement and condition of tape.</div>			

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**WORK INSTRUCTION**

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TAPING ASSEMBLY PROCESS

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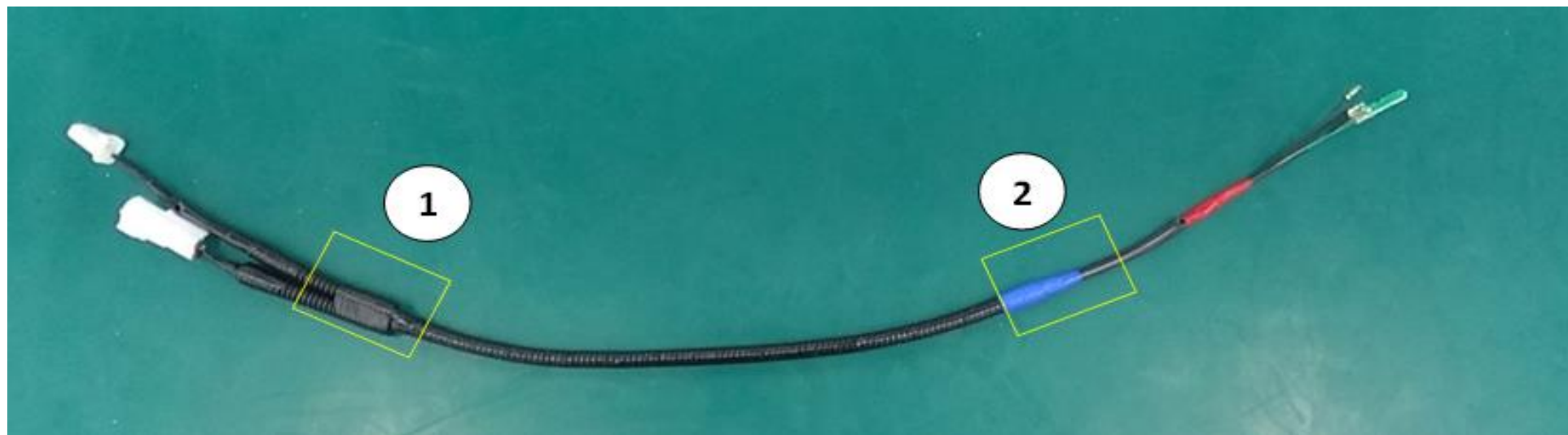
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P4****7L0124-7022A****1****No Missing Tape**
No wrong use of tape (Black)**2****No Missing Tape**
No wrong use tape (Blue)

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