



WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:

May 24, 2024

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

100B / 7M0593-7021

Customer: TRJ

Car Model:

LEXUS UX

Document No.:

WI-ENG-PDE-444C

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

2

Page No.:

1 of 8

PARTS: 1. Assy parts; Black tape

JIG:

1. T-Taping jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

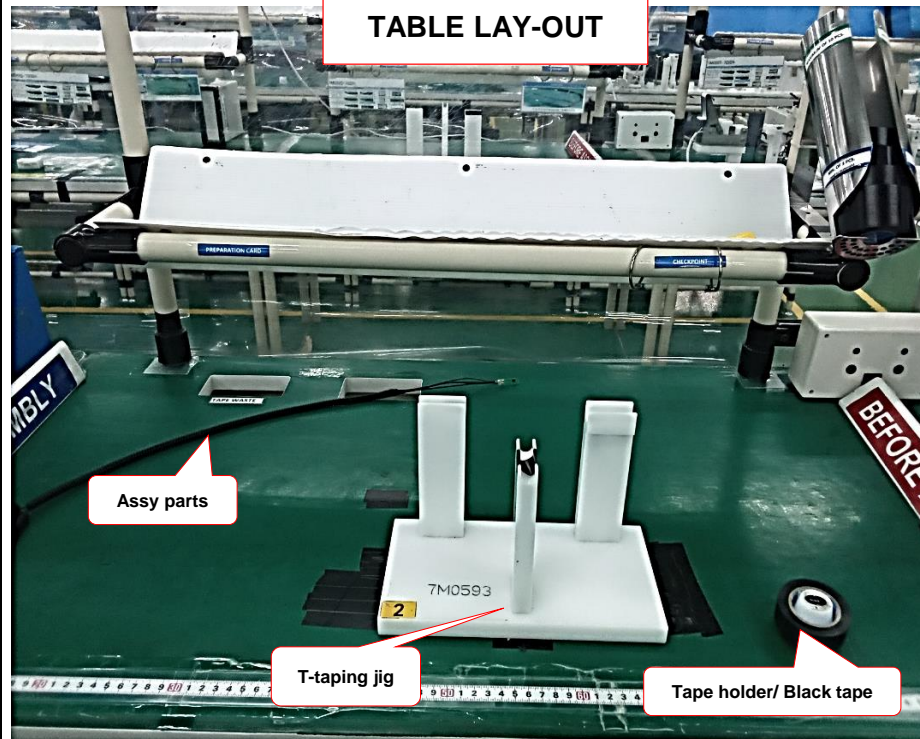
TOOLS/PPE

QUALITY POINTERS

1

P3

Table Lay-out



Safety Instruction

Be sure to wear prescribed 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	Prepared by	Reviewed by	Approved by	Noted by
05/24/24	2	Transfer to New format. Inclusion of Car model "LEXUS UX".	A.Hernandez	C.Villanueva	A. Arañes	n/a				
02/15/23	1	Inclusion of Quality checkpoints; Improve Quality pointers on pages no.2,4,5,6 and 7.	M. Ariola	J. Loterte	C.Villanueva	A. Arañes	A.Hernandez	C.Villanueva	A.Arañes	n/a
03/05/22	0	Initial Issue.	M. Ariola	J. Loterte	C.Villanueva	A. Arañes				

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

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 24, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

100B / 7M0593-7021

Customer: TRJ

Car Model:

LEXUS UX

Document No.:

WI-ENG-PDE-444C

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

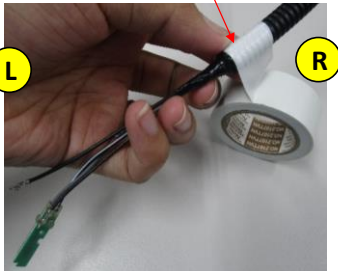
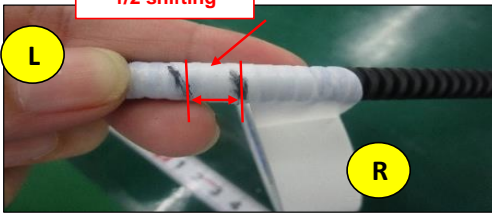
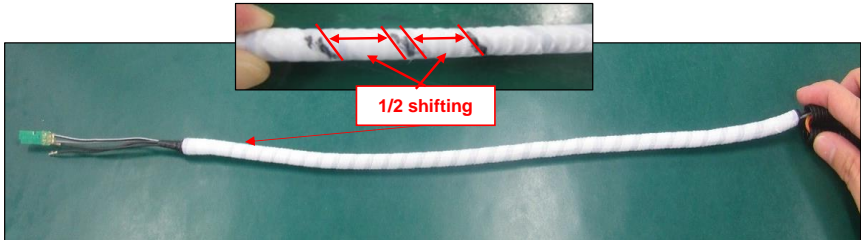
☒ MASSPRO

Revision No.:

2

Page No.:

2 of 8

PARTS:	1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3 Half-wrap taping	<div><div><div>Start of taping</div></div><div><div>1/2 shifting</div></div><div><div>1. Hold the corrugated tube using left hand and begin taping using right hand.</div><div>2. Make 1/2 shifting. Repeat the process until the end of corrugated tube. Make 3 winds and then cut the tape.</div></div><div><div></div><div><div>1/2 shifting</div></div><div><div>3. Check the taping condition.</div></div></div></div>	n/a	<p>Important reminders/note/s:</p> <p>1. Used WHITE TAPE to easily visualize the tape shifting. But actual should be Black.</p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No exposed COT</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

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 24, 2024

Process Name/Title:

Model code/Part number:

100B / 7M0593-7021

Customer: TRJ

Car Model:

LEXUS UX

Validity Date:

n/a

Document No.:

WI-ENG-PDE-444C

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

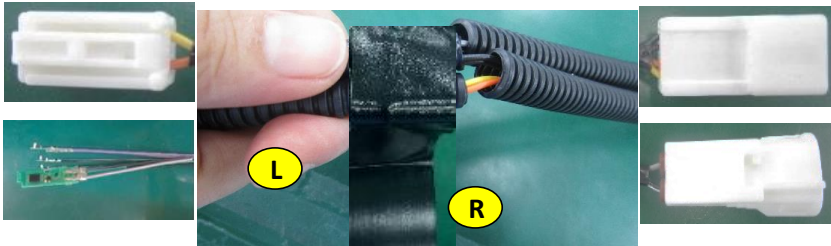
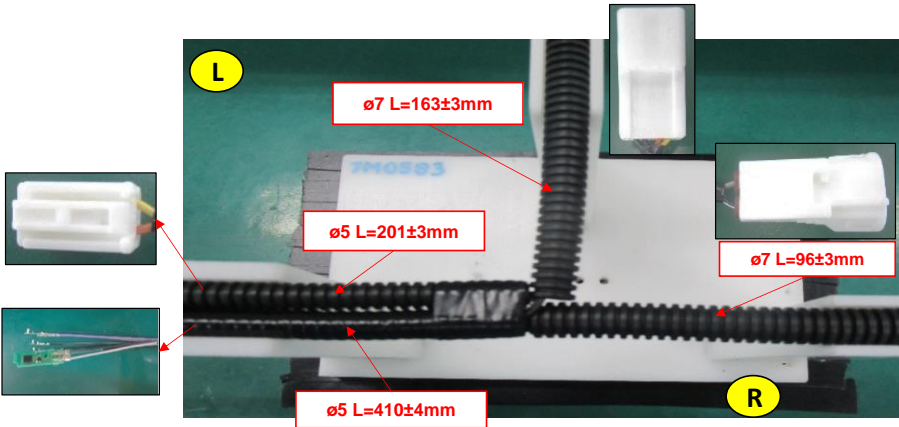

☒ MASSPRO

Revision No.:

2

Page No.:

3 of 8

PARTS:		1. Black tape		JIG:	1. T-Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P3	T-taping	<div><p>1. Align both COT ø5. (<i>Follow the correct orientation of connector</i>). Tape 2 winds using black tape then cut the tape.</p><p>2. Arrange the 4 corrugated tube to form inverted T into jig using left and right hand.</p></div>	<div><p>T-TAPING JIG</p></div>	<p>1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use 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**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 24, 2024

Validity Date:

n/a

Model code/Part number:

100B / 7M0593-7021

Customer: TRJ

Car Model:

LEXUS UX

Document No.:

WI-ENG-PDE-444C

Purpose:

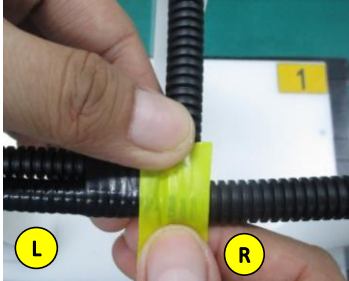
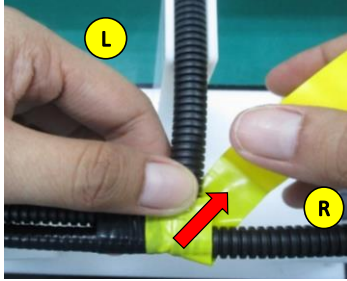
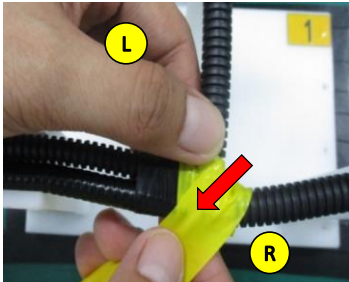
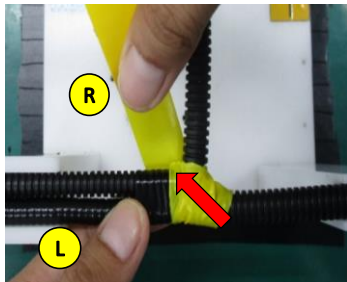

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

4 of 8

PARTS:	1. Black tape			JIG:	1. T-Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P3 T-taping (Continuation)	<div></div> <div>3. Start taping at the middle to fix the 4 corrugated tubes using right hand.</div> <div></div> <div>4. Wind the tape from front to back at the right side</div> <div></div> <div>5. Wind the tape from back to front (cross pattern)</div> <div></div> <div>6. Wind the tape from front to back at the left side</div>		<div>T-TAPING JIG</div> 	<p>Important reminders/note/s:</p> <p>1. Used WHITE TAPE to easily visualize the tape shifting. But actual should be Black.</p> <p>1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. 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****TAPING ASSEMBLY PROCESS**

Process Name/Title:

Effectivity Date:

May 24, 2024

Model code/Part number:

100B / 7M0593-7021

Customer: TRJ

Car Model:

LEXUS UX

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

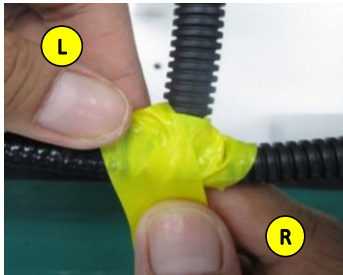
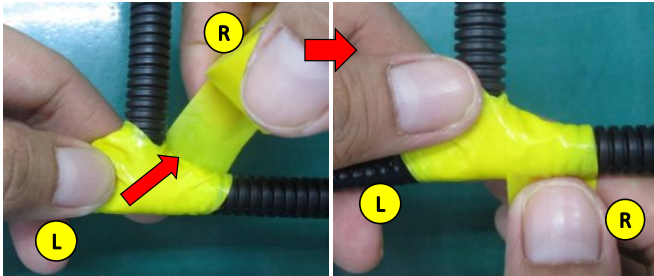
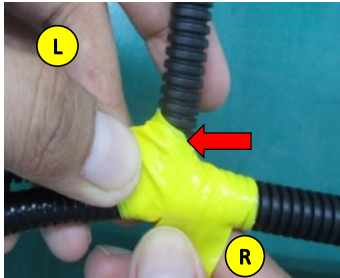
WI-ENG-PDE-444C

Revision No.:

2

Page No.:

5 of 8

PARTS:	1. Black tape [1pc]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3 T-taping (Continuation)	<div><div>7. Wind the tape from back to front (cross pattern)</div><div>8. Repeat the process from 4-6, 3 times then remove from jig.</div></div> <div><div>9. Tape the right side corrugated tube (3 winds), width must be same as tape (19mm)</div></div> <div><div>10. From the right side, wind the tape 2/3 shifting going to center</div></div>	n/a	Important reminders/note/s: <i>1. Used YELLOW TAPE to easily visualize the tape shifting. But actual should be Black.</i> 1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. No wrong dimension

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

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

100B / 7M0593-7021

Customer: TRJ

Car Model:

LEXUS UX

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

May 24, 2024

Validity Date:

n/a

Document No.:

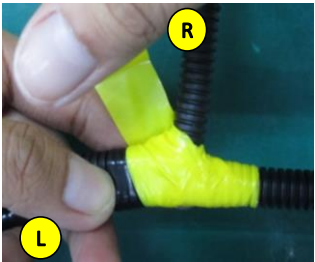
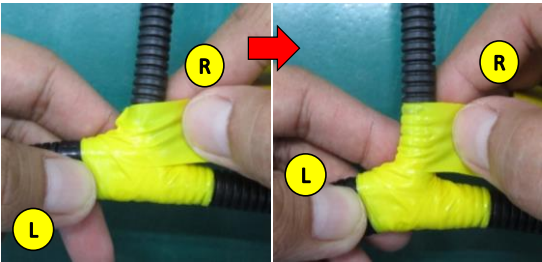
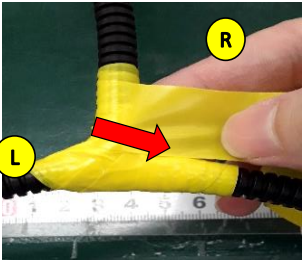
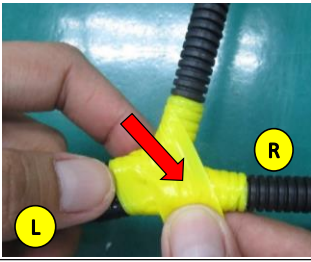
WI-ENG-PDE-444C

Revision No.:

2

Page No.:

6 of 8

PARTS:	1. Black tape [1pc]			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P3 T-taping (Continuation)	<div></div> <div></div> <div></div> <div></div>		n/a	Important reminders/note/s: <i>1. Used YELLOW TAPE to easily visualize the tape shifting. But actual should be Black.</i> 1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. No wrong dimension

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****TAPING ASSEMBLY PROCESS**

Effectivity Date:

May 24, 2024

Process Name/Title:

Model code/Part number:

100B / 7M0593-7021

Customer: TRJ

Car Model:

LEXUS UX

Validity Date:

n/a

Document No.:

WI-ENG-PDE-444C

Purpose:

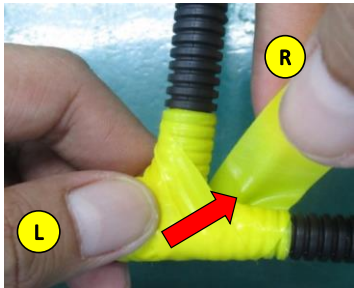
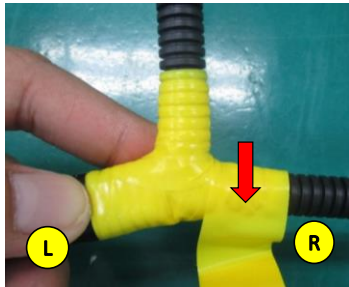
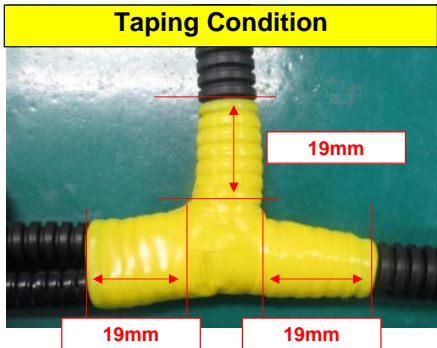

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

7 of 8

PARTS:	1. Black tape [1pc]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3 T-taping (Continuation)	<div></div> <div>15. Wind the tape from front to back side (cross pattern)</div> <div></div> <div>16. Tape the right side corrugated tube (3 winds), width must be same as tape (19mm)</div> <div></div> <div>17. .After taping, check the measurement and condition of tape.</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>2. Used YELLOW TAPE to easily visualize the tape shifting. But actual should be Black.</p> <p>1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. 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:

May 24, 2024

Validity Date:

n/a

Model code/Part number:

100B / 7M0593-7021Customer: **TRJ**

Car Model:

LEXUS UX

Document No.:

WI-ENG-PDE-444C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

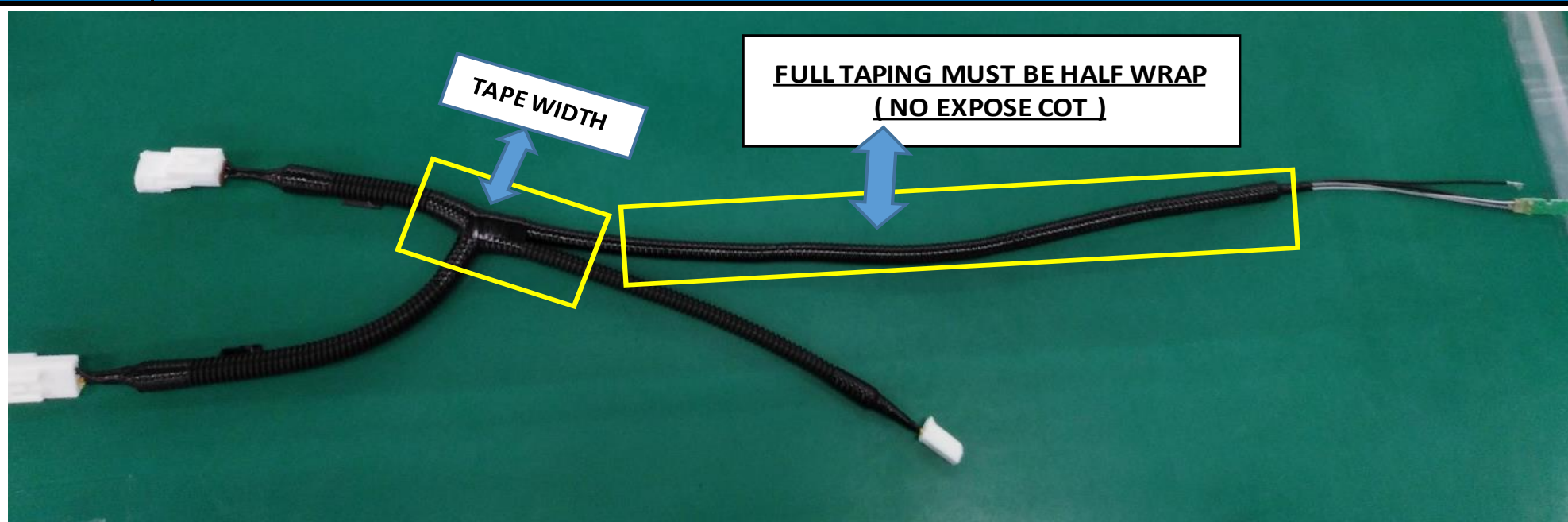
8 of 8

PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**P3****7M0593-7021****1****No MISSING TAPE****CORRECT FACING OF T-TAPING**

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