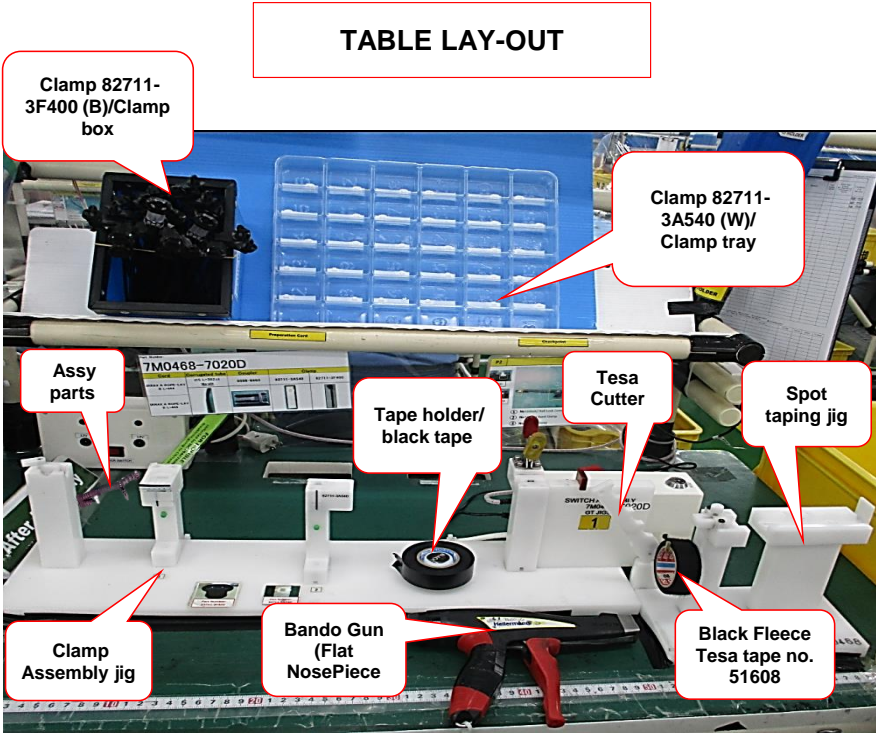


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	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 423B / 7M0468-7020D		Customer: TRJ	Car Model: LEXUS RX	Document No.:		WI-ENG-PDE-253B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		2	Page No.: 1 of 7

PARTS:		1. Assy parts; Clamp 82711-3F400 (B)/Clamp box; Clamp 82711-3A540 (W)/ Clamp tray; Black Fleece Tesa tape no. 51608; Tesa Cutter			JIG:		1. Clamp assembly jig 2. Spot taping jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE		QUALITY POINTERS	
1	P2	<div>TABLE LAY-OUT</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>		1. No missing parts/ tools. 2. No excess parts/tools.	


Revision History								Prepared by	Reviewed by	Approved by	Noted by
10/30/24	2	Inclusion of Quality checkpoints.				D.Castillo	C. Villanueva	A. Arañes	n/a		
3/19/21	1	Transfer process owner from Production (WI-PRO-ASY-113B) to Engineering (WI-ENG-PDE-252B). Change part number. Standardize the color of clamp in accordance with color standardization of plastic parts (Please refer to GL-COM-003 for Color Standardization for Plastic Parts).				D. Castillo	C.Villanueva	A. Shimamura	A. Arañes		
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	November 5, 2018

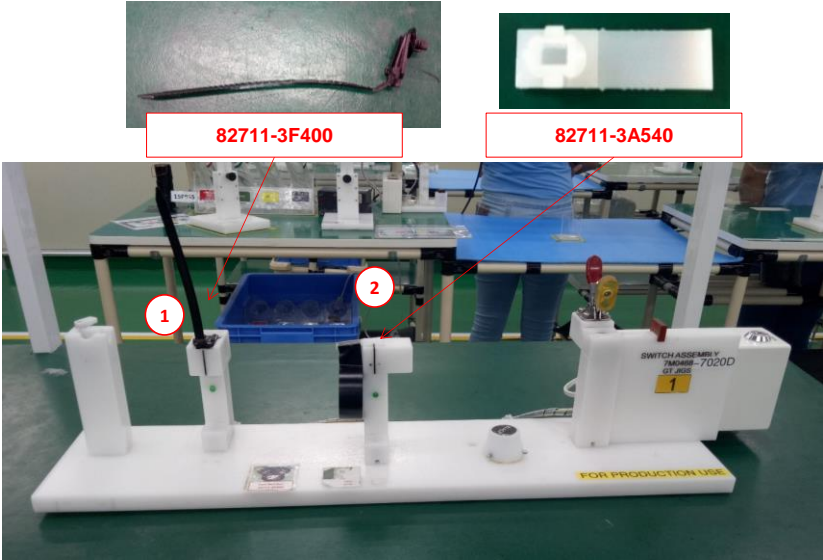


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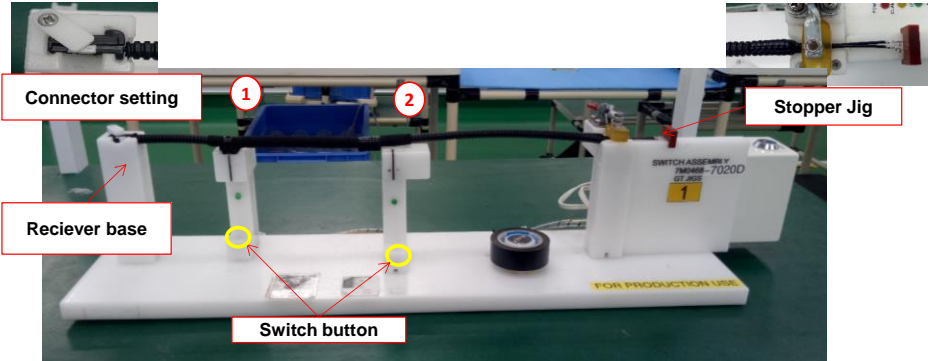
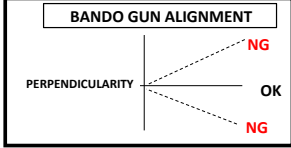


PARTS:	1. Black tape [1pc] 3. Assy parts 2. Clamp 82711-3A540 (W) 4. Clamp 82711-3F400 (B)			JIG:	1. Clamp Assembly jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
2	P2	Clamp Setting	<div></div> <div>1. Get 1pc of clamp 82711-3F400 (B) using right hand and set to clamp location 1 using both hands.</div> <div></div> <div>2. Get 1pc of clamp 82711-3A540 (W) using right hand and set to clamp location 2 using both hands.</div> <div>3. Initially attach Black tape on clamp location 2 using both hands.</div>			n/a	<div>STANDARD TAPING FOR CLAMP</div> <div></div> <div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div> <div>Important reminders/note/s: <i>1.Please check the Clamp first before start of assembly to avoid wrong use of clamp.</i></div>

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PARTS:	1. Assy parts			JIG:	1. Clamp Assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	Clamp Assembly	<div><p>1. Get the assy parts (<i>see above picture for correct setting</i>) and then put it on jig using both hands. First, set the connector to receiver base then lock and set the B/B wires with terminal end together within the stopper then press by Toggle clamp. Continue if the sequence light in location 1 is on.</p><p>2. Check if all LED light for POWER ON and CLAMP was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p><p>3. Initially tighten the band clamp on location 1 using both hands.</p><p>4. Get the bando gun and cut the band clamp (82711-3F400) using right hand. Press the sequence light button after cutting. Continue if the sequence light move to location 2.</p><p>5. Hold the tape on clamp location 2 then start taping (3 windings) using both hands. Press the switch button after taping. Go buzzer will be heard.</p><p>6. Conduct POINT CHECKING before removing the harness from jig.</p></div> <div><p>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</p></div>	<div><p>Important reminders/note/s:</p><p>1. Make sure no gap between stopper jig and terminal tip.</p><p>1. No wrong use of tape 2. No missing tape 3. No damage clamp 4. No missing clamp 5. No skip process 6. No loose band clamp 7. No super tight band cut</p></div>	

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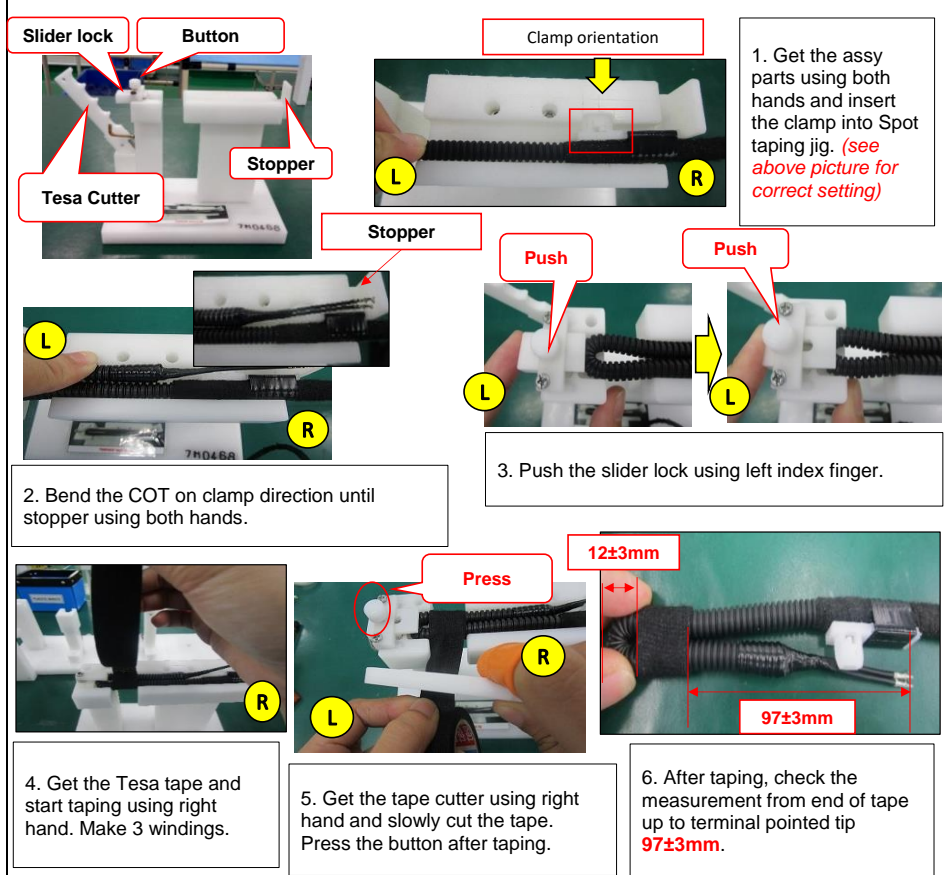


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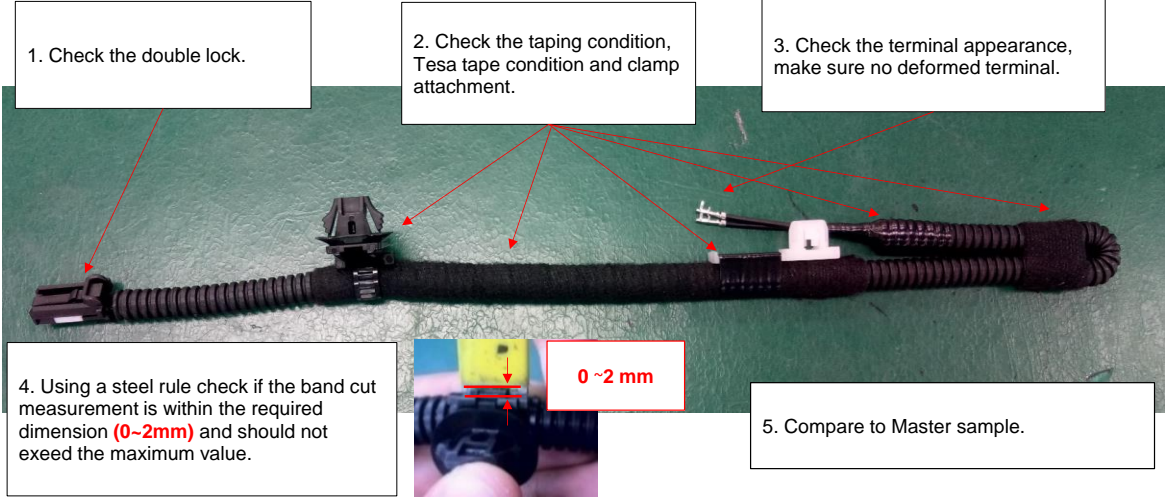

PARTS:		1. Assy parts		JIG:	Spot taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Spot taping	<div></div>	<div></div>	<div>TESA TAPE CONDITION  Whitish appearance of Tesa Tape due to thickness variation Judgement: GOOD</div> <div><ul style="list-style-type: none">1. No peel-off tape2. No flip-out tape3. No loose tape4. No wrong use of tape5. No wrong dimension6. No missing tape</div>

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PARTS:	n/a			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
5	P2	Visual/By two's inspection	<div><div>1. Check the double lock.</div><div>2. Check the taping condition, Tesa tape condition and clamp attachment.</div><div>3. Check the terminal appearance, make sure no deformed terminal.</div><div>4. Using a steel rule check if the band cut measurement is within the required dimension (0~2mm) and should not exceed the maximum value.</div><div>5. Compare to Master sample.</div></div>	<div><div>MASTER SAMPLE</div><div>Document reference/s: <i>1.Please refer to GL-PRO-ASY-007 for By Two's Inspection of Sub-assy.</i></div></div>	

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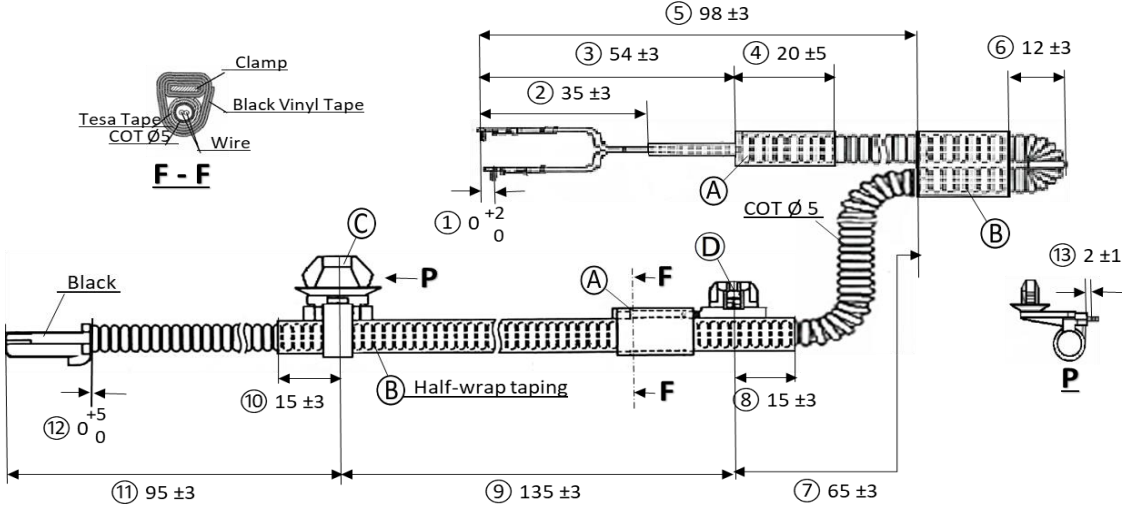
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P2	Measurement	<div><div>MEASURING TAPE</div></div>  <div><p>NOTE:</p><ul style="list-style-type: none">(A) - Vinyl Taping (B)(B) - Tesa Taping (B)(C) - Clamp (B)(D) - Clamp (W)</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 measurement</p>

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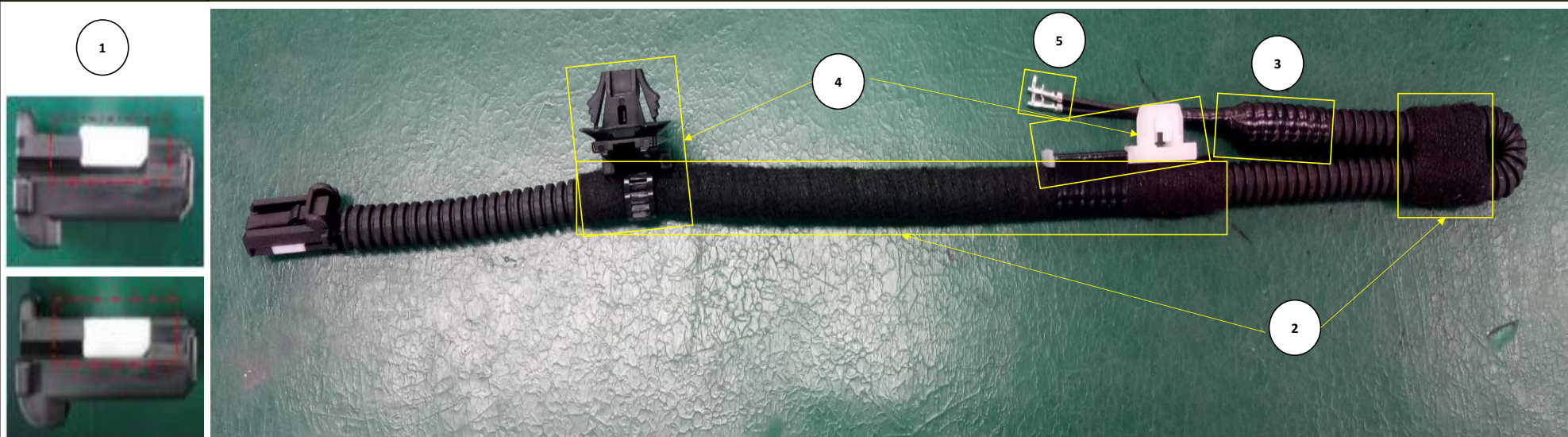
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1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING ASSY****7M0468-7020D****1****No Unlock/Halflock connector****3****No Missing Tape
(COT to wire near terminal)****5****No Deformed terminal****2****No Missing Tape (TESA tape)****4****No Missing Clamp
(Clamp (W) & Band Clamp (B))**

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