

	WORK INSTRUCTION				Effectivity Date:		April 01, 2025	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 900B/ 910B / 7N0072-7020C		Customer: TRJ		Car Model: LEXUS-NX/RX	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.: WI-ENG-PDE-461B		Revision No.: 5		Page No.: 1 of 4	

PARTS:		1. Assy parts 2. Black tape				JIG:		n/a	
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Table Lay-out 	<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px solid red; padding: 5px;"> 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 1. No missing parts/tools. 2. No excess parts/tools.


Revision History						Prepared by		Checked by		Reviewed by		Approved by	
04/01/25	5	Improve Work procedure of Taping 1. Additional Quality pointers "No insufficient tape" (Page 2-3) as countermeasure to customer claim. Improved Visual inspection/Quality checkpoint.	D.Castillo	J. Loterte	C. Villanueva	A. Arañes							
07/31/24	4	Transfer Wire insertion to Black VM tube, Black COT to VM tube taping to P4 (WI-ENG-PDE-461D) ; Black SV tube to wire near connector taping (6098-3810 (W)) to P3 (WI-ENG-PDE-416C) and transfer Black SV tube to wire near connector taping (6098-3802 (W)) from P3 to P2 due to process improvement. Inclusion of car model "LEXUS-NX/RX". Update Table lay-out and Visual inspection/Quality checkpoints. Change tolerance from 0-5mm to 5-7mm to avoid broken connector and tension in V-wire due to end tape.	D.Castillo	n/a	C.Villanueva	A. Arañes							
08/15/23	3	Change from 2MP to 3MP. Transferred process of Y-taping 1 and 2 to P3; Transferred process no.1, 15,16 and 17 from P1 to P2 due to change process distribution; Transferred process of Clamp setting; Clamp Assembly; Visual/By two's inspection and measurement from P2 to CLAMP ASSEMBLY PROCESS. Standardized tube description: SV tube (Vinyl); VM tube (Sunprene); Change table lay-out.	M.Ariola	J. Loterte	C.Villanueva	A. Arañes							
Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved	Est. Date:	April 22, 2022					

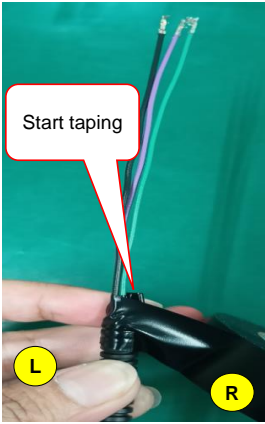
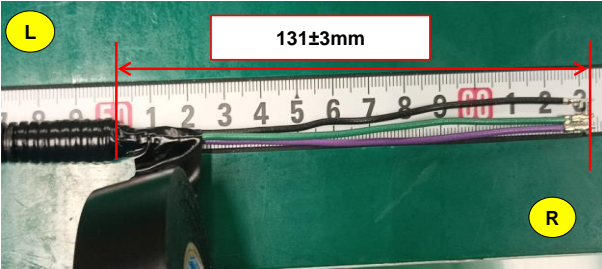
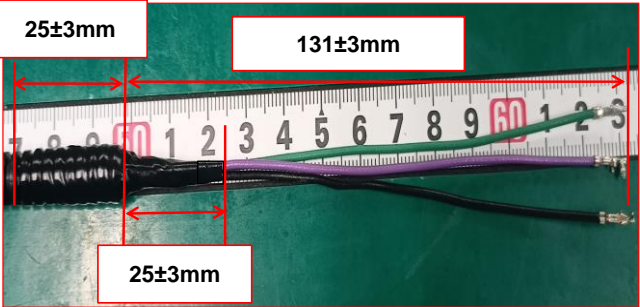

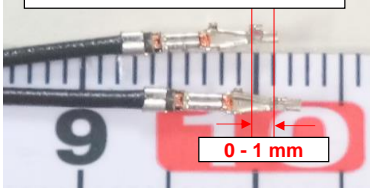
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	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Process Name/Title:			Document No.:	WI-ENG-PDE-461B		
	Model code/Part number: 900B/ 910B / 7N0072-7020C		Customer: TRJ	Car Model: LEXUS-NX/RX	Revision No.: 5 Page No.: 2 of 4		
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO							


PARTS:		1. Assy parts 2. Black tape		JIG:	n/a	
NO.	PROCESS NAME	<div>5</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS		
2	P2 Taping 1 Black Corrugated tube to wire near terminal	<div><p>1. Hold the assy parts using left hand. Get the Black tape using right hand then start taping between COT to wire using both hands.</p><p>2. Measure form end of COT up to terminal pointed tip 131±3mm then continue the taping process using both hands</p><p>3. After taping, check the measurement, terminal alignment and taping condition.</p></div>	<div>MEASURING TAPE</div> <div></div> <div>5</div>	<p>Important reminders/Note/s:</p> <p>1. <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p> <p>Document references:</p> <p>1. <i>Refer to WI-PRO-ASY-001A for Taping process</i></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 tape7. No insufficient tape <div><div>Wire alignment tolerance</div></div>		

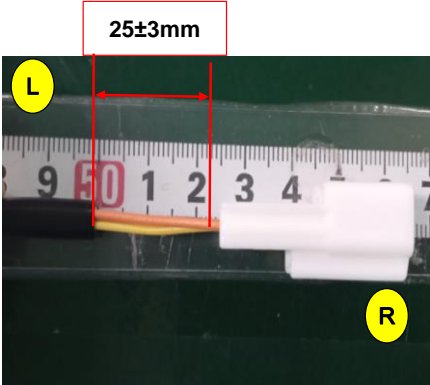
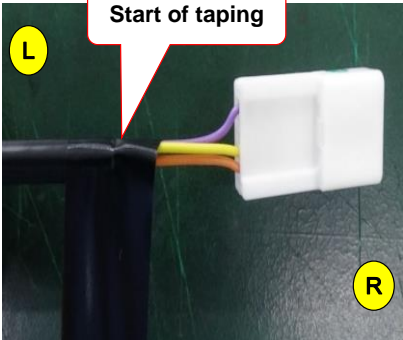
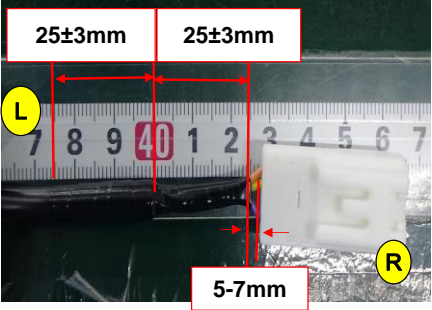

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	Model code/Part number: 900B/ 910B / 7N0072-7020C		Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.: WI-ENG-PDE-461B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	5	Page No.:	3 of 4

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	P2 Taping 2 Black SV tube (Vinyl) to wire near connector	<div><p>25±3mm</p><p>1. Measure from end of SV tube (Vinyl) up to end of connector 25±3mm using both hands.</p></div> <div><p>Start of taping</p><p>2. Hold the assy parts using left hand. Get Black tape using right hand and start pre-taping between SV tube (Vinyl) and wires.</p><p>(Note: Do not fold the SV tube (Vinyl) ø5 with 3 wires)</p></div> <div><p>25±3mm 25±3mm</p><p>5-7mm</p><p>3. After taping, check the measurement and taping condition.</p></div>	<div>MEASURING TAPE</div>  <div>5</div>	<p>Important reminders and Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. Change tolerance From 0-5mm to 5-7mm to avoid broken connector and tension in V-wire due to end tape.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001B for taping procedure.</p> <ul style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension7. No insufficient tape	

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**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

April 01, 2025

Model code/Part number:

900B/ 910B / 7N0072-7020CCustomer: **TRJ**

Car Model:

LEXUS-NX/RX

Document No.:

WI-ENG-PDE-461B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

5

Page No.:

4 of 4**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P2****7N0072-7020C****1 2****No Missing Tape**

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