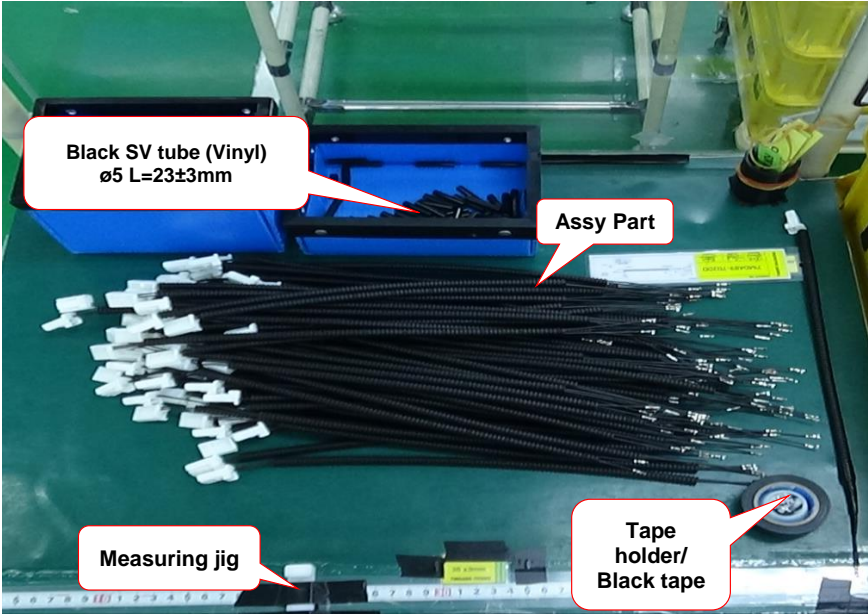



	<b>WORK INSTRUCTION</b>				Effectivity Date: <b>May 24, 2024</b>	
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date: <b>n/a</b>	
	Model code/Part number: <b>946B / 7N0074-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS-ES</b>	Document No.: <b>WI-ENG-PDE-122</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: <b>6</b>		Page No.:	1 of 6

<b>PARTS:</b> 1. Assy Parts; Black SV tube (Vinyl) ø5 L=23±3mm; Black Tape		JIG: 1. Measuring jig		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
1	P1 <div style="border: 1px solid black; padding: 5px; text-align: center;">6</div> Table Lay-out	<div style="border: 1px solid black; padding: 5px; text-align: center;">TABLE LAY-OUT</div> 	<div style="border: 1px dashed red; padding: 5px;"> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div style="border: 1px dashed red; padding: 5px;"> <b>Housekeeping</b>            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 dashed red; padding: 5px;"> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>	<b>Document reference/s:</b>  1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance  2. Refer to WI-ENG-PDE-847 for Offline Assembly process  1. No missing parts/tools 2. No excess parts/tools


  


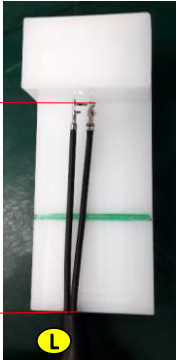
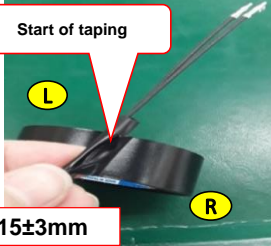
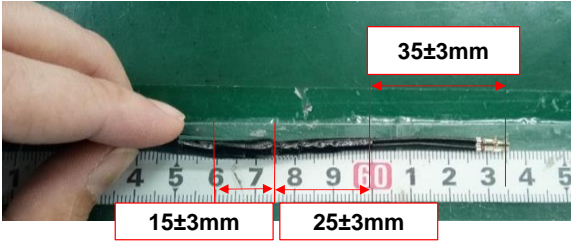

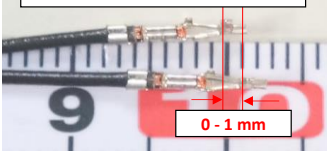
Revision History								Prepared by	Reviewed by	Approved by	Noted by		
05/24/24	6	Transfer some process to Offline assembly process and Clamp assembly process due to process change. Update table lay-out. Improved Measurement and Visual inspection. Inclusion of car model "LEXUS-ES".				D. Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
02/28/23	5	Set new std. taping of vinyl tube 24mm and below. Change measurement of Taping : Black SV tube (Vinyl) to wire near terminal on page 6 process no 7. Standardize tube description: SV tube (Vinyl).				M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
02/02/23	4	Inclusion of Batching quantity: 9pcs. Process identification per table by providing table 1 and table 2. Inclusion of quality checkpoints.				M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	May 22, 2020		

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	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>May 24, 2024</b>		
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Process Name/Title:		Model code/Part number: <b>946B / 7N0074-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS-ES</b>		Document No.: <b>WI-ENG-PDE-122</b>
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	6	Page No.:	2 of 6

<b>PARTS:</b>	1. Assy parts 2. Black SV tube (Vinyl) ø5 L= 23±3mm 3. Black tape			JIG:	1. Measuring jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	Wire insertion to Black SV tube (Vinyl) ø5 L= 23±3mm	 <div>1. Get the vinyl tube <b>ø5 L= 23±3mm</b> using right hand then insert the <b>B-B wires</b>.</div>		n/a	1. No wrong use of parts 2. No deformed terminal
3	P1 Taping 1 Black SV tube (Vinyl) to wire near terminal	 <div>1. Hold the Black SV tube (Vinyl) using left hand and put into measuring jig to get the measurement of <b>60±3mm</b> from end of SV tube (Vinyl) up to terminal pointed tip.</div>  <div>2. Get the <b>Black tape</b> and attach at <b>15±3mm</b> measurement of Black SV tube (Vinyl) then continue the taping process using both hands.</div>  <div>3. After taping, check the measurement, taping condition and wire alignment.</div>		<div><b>MEASURING JIG</b></div> 	<div>1. No peel-off tape 2. No flip-to tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension</div> <div><b>Important reminder/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b> <b>2. Use provided jig per model to avoid wrong measurement</b></div> <div><b>Document references:</b> <b>1. Please refer to WI-PRO-ASY-001 for taping procedure.</b></div> <div><div>Wire alignment tolerance</div></div>

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

May 24, 2024

Validity Date:

n/a

Model code/Part number:

946B / 7N0074-7020A

Customer:

TRJ

Car Model:

LEXUS-ES

Document No.:

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

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### PARTS:

1. Assy parts
2. Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

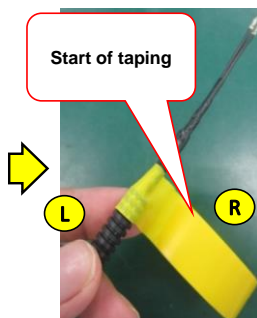
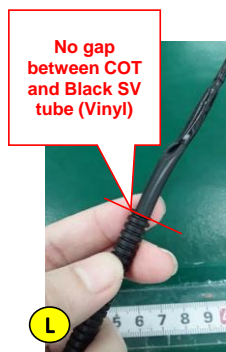
TOOLS/PPE

QUALITY POINTERS

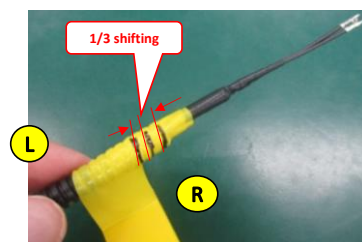
4

P1

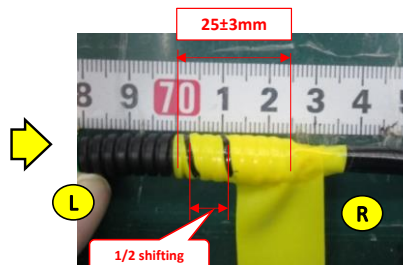
Taping 2  
Black corrugated tube to  
Black SV tube (Vinyl)



1. Fix the Corrugated tube and Black SV tube (Vinyl) using both hands and begin taping process. Make **1 wind** before shifting.



2. Make **1/3 shifting** on COT to make **25mm** width then make **2x winding** on COT.



3. Make **1/2 shifting** going to right side then measure from end of tape up to end of COT **25mm** then continue the taping process.

### MEASURING TAPE



### Important reminders/Note/s:

1. Use **YELLOW TAPE** for easy visualization of shifting lines, but actual should be **BLACK TAPE**.
2. Please use calibrated/verified measuring tape when getting the measurement.

1. No peel-off tape
2. No flip-to tape
3. No loose tape
4. No wrong use of tape
5. No wrong dimension

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

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n/a

Model code/Part number:

946B / 7N0074-7020A

Customer:

TRJ

Car Model:

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### PARTS:

1. Assy parts
2. Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

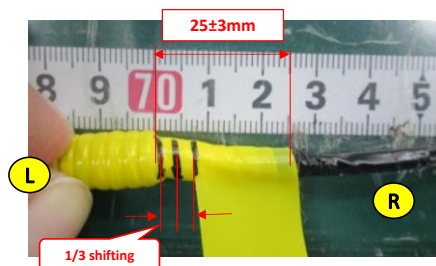
TOOLS/PPE

QUALITY POINTERS

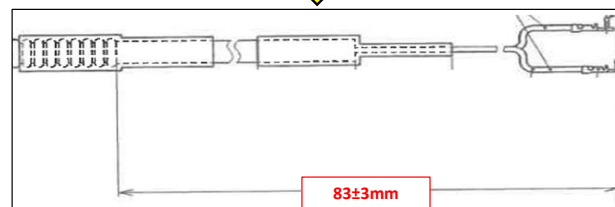
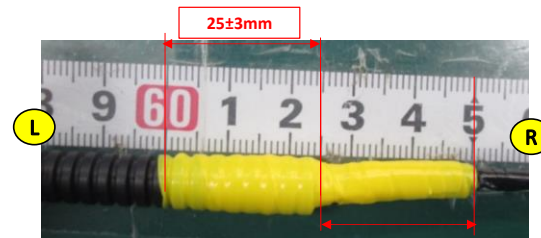
4

P1

Taping 2  
Black corrugated tube to  
Black SV tube (Vinyl)  
(Continuation)



4. Make **1/3 shifting** on Black SV tube (Vinyl) to make **25mm** width. Make **3 windings** of tape before cut.



5. After taping, check the measurement and taping condition.

### MEASURING TAPE



### Important reminders/Note/s:


1. Use **YELLOW TAPE** for easy visualization of shifting lines, but actual should be **BLACK TAPE**.
2. Please use calibrated/verified measuring tape when getting the measurement.


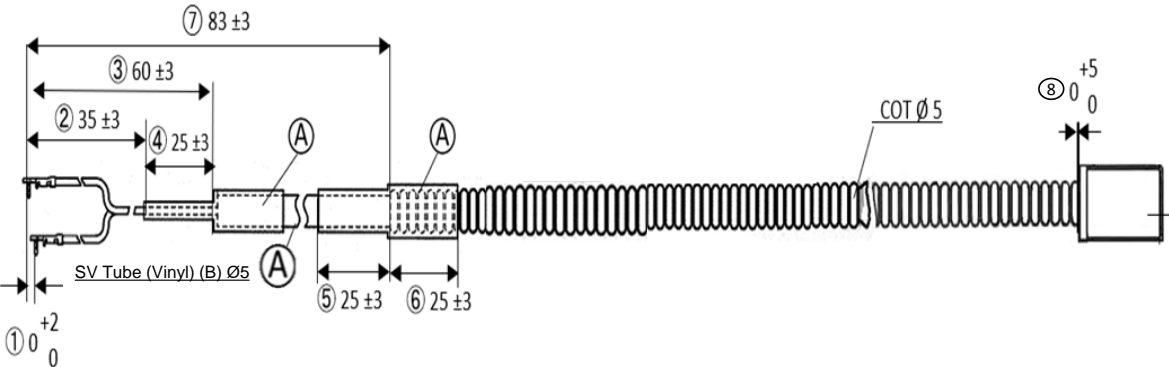
1. No peel-off tape
2. No flip-to tape
3. No loose tape
4. No wrong use of tape
5. No wrong dimension

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	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>May 24, 2024</b>		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>946B / 7N0074-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS-ES</b>	Document No.: <b>WI-ENG-PDE-122</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	6	Page No.:	5 of 6

<b>PARTS:</b>	1. Assy parts			JIG:	n/a		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>			
5	P1	Measurement	<div>MEASURING TAPE</div>   <div>NOTE: A - Taping (B)</div>	<div><b>Important reminders and note/s:</b></div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>2. For Hatsumono, Nakamono and Owarimono.</div> <div><b>Document reference/s:</b></div> <div>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension</div>			

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**May 24, 2024**

Validity Date:

**n/a**

Model code/Part number:

**946B / 7N0074-7020A**Customer: **TRJ**

Car Model:

**LEXUS-ES**

Document No.:

**WI-ENG-PDE-122**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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**6**

Page No.:

**6 of 6****PARTS:**

1. Assy parts

JIG:

**n/a****VISUAL INSPECTION****TAPING - P1****7N0074-7020A****1****No Missing Tape/Wrong use of tape**

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