



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

September 13, 2024

Model code/Part number:

922B / 7L0124-7022A

Customer:

TRQSS

Car Model:

LEXUS NX

Document No.:

WI-ENG-PDE-1044C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1. Assy parts; Red tape; Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

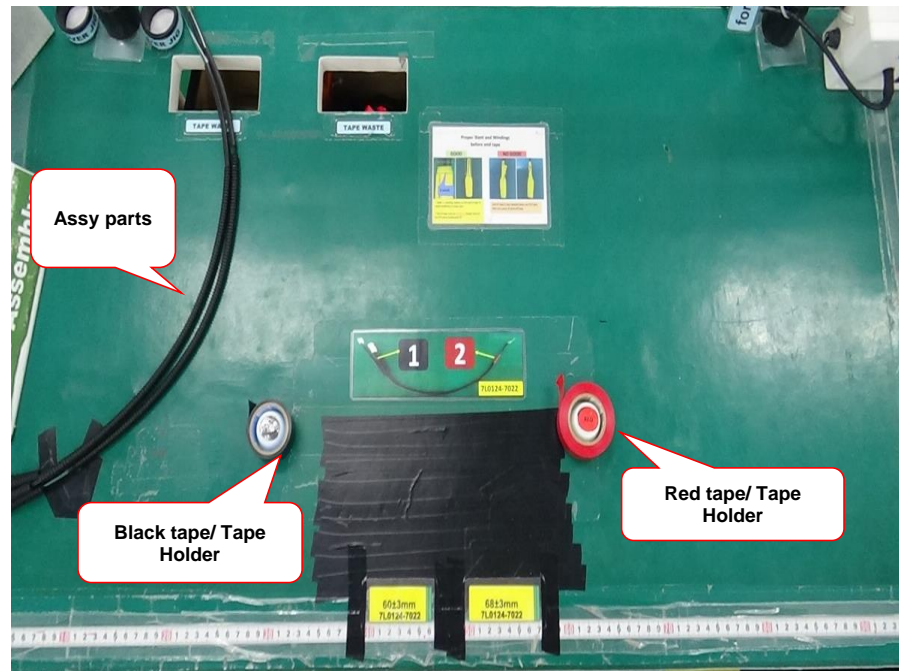
QUALITY POINTERS

1

P3

Table Lay-out

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 in assy parts
2. No excess tape/tape holder
3. No wrong position of tape holder

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 |  |  |  | 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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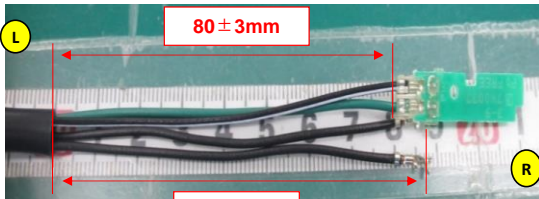
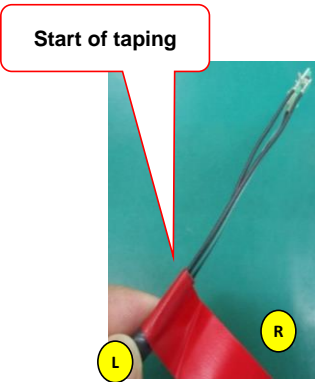
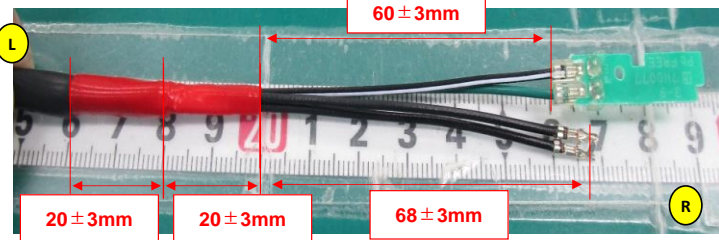

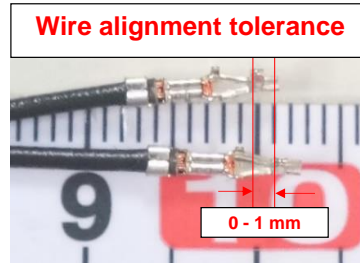
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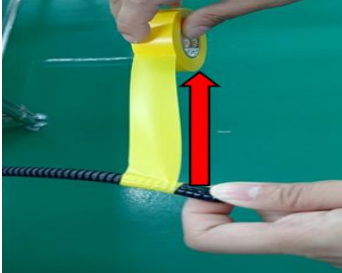



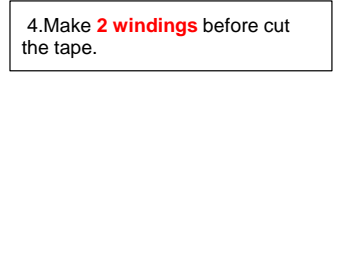
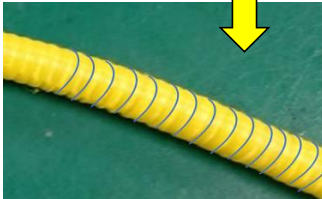
| PARTS: | | 1. Assy parts 2. Red tape | JIG: | n/a |
|--------|--|--|---|--|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
| 2 | P3 Taping 4 VM tube (Sunprene) to wire near terminal and hotmelted wire | <div><p>1. Hold VM tube (Sunprene) using left hand. Measure from VM tube (Sunprene) to end of hotmelted wire 80±3mm and Sunprene tube to terminal tip 88±3mm.</p></div> <div><p>2. Get Red tape using right hand, hold the VM tube (Sunprene) (ø5 L=96±3mm) using left hand. Fold the VM tube (Sunprene) and start taping using right hand.</p></div> <div><p>3. After taping check the measurement, wire alignment and taping condition.</p></div> | <div><p>Measuring tape</p></div> | <div><p>1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape</p></div> <div><p>Wire alignment tolerance</p></div> <div><p>Important reminders/Note/s:</p><p>1. Please use calibrated/verified measuring tape when getting the measurement.</p><p>Document references:</p><p>1. Please refer to WI-PRO-ASY-001 for taping procedure.</p></div> |


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| | Model code/Part number: 922B / 7L0124-7022A | | Customer: TRQSS | Car Model: LEXUS NX | Document No.: | WI-ENG-PDE-1044C | | |
| | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO | | | | Revision No.: | 1 | Page No.: | 3 of 4 |

| | | | |
|---|------------------------|--|--|
| PARTS: 1. Assy parts 2. Black tape [1pc] | | JIG: n/a | |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE |
| 2 | P3 Half-wrap taping | <div>  <p>1. Attach the tape, then make 2 windings.</p> </div> <div>  <p>2. Pull the tape around 150mm~200mm.</p> </div> <div>  <p>3. Hold the other side of the harness on the table and apply force to rotate the tape to make halfwrap shifting until cover the COT with slit.s</p> </div> <div>  <p>4. Make 2 windings before cut the tape.</p> </div> <div>  <p>5. After taping, check the condition of tape. THERE MUST BE NO EXPOSED COT BETWEEN HALF WRAP TAPING.</p> </div> <div>  <p>6. Conduct 3x pressing at the end of Taping to prevent peel off and loose tape using left thumb.</p> </div> <div>  <p>Appearance after Taping</p> </div> | <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>Important reminders/Note/s:</p> <p>1. Use <u>Yellow tape</u> for easy visualization of tape shifting, but actual should be <u>BLACK TAPE</u>.</p> <p>2. Internal tolerance for halfwrap taping shifting should be 0~14mm only.</p> <p>1. No loose/tight tape 2. No flip-out tape 3. No peel-off tape 4. No exposed COT between tape windings</p> |

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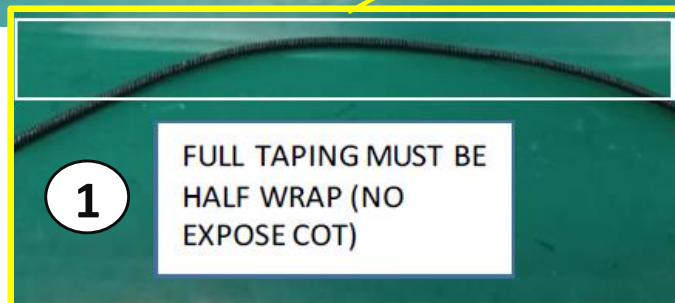
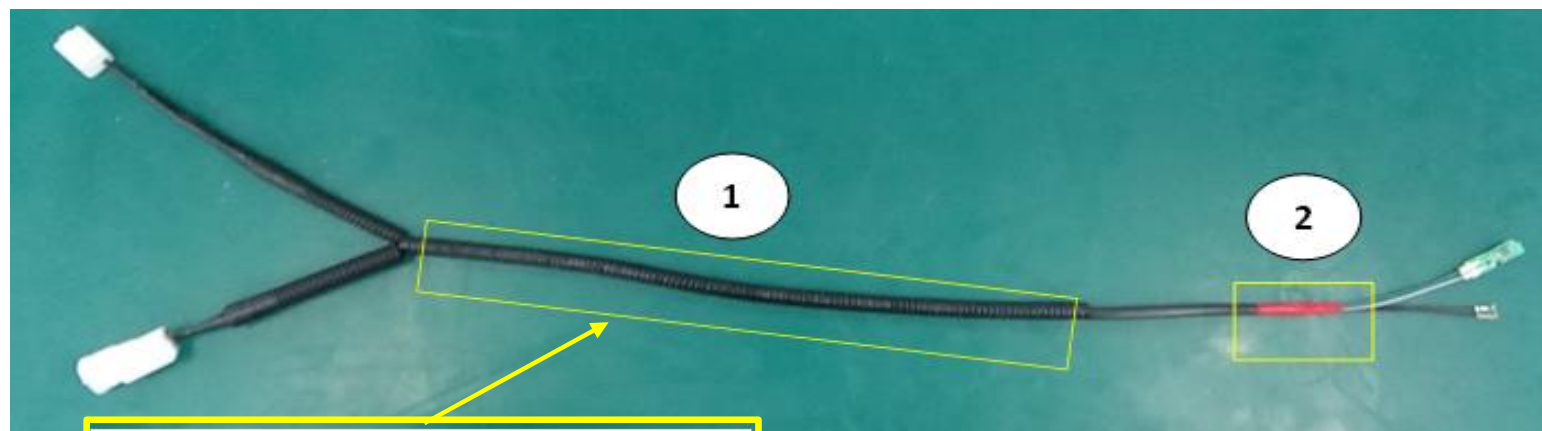
JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING - P3

7L0124-7022A



2 No Missing Tape
No wrong use tape (Red)



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