
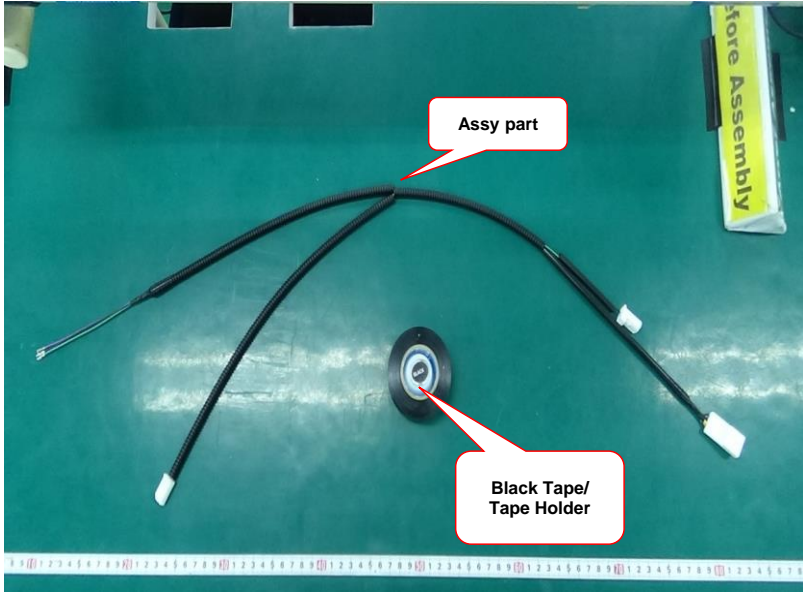




	WORK INSTRUCTION				Effectivity Date: July 31, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date: n/a	
	Model code/Part number: 900B/ 910B / 7N0072-7020C		Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.: WI-ENG-PDE-461C	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO		Revision No.: 1		Page No.: 1	of 4

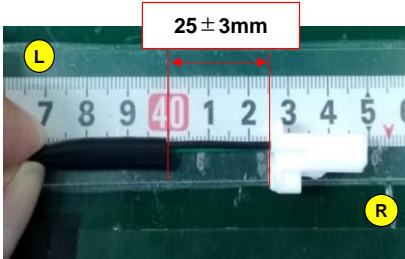
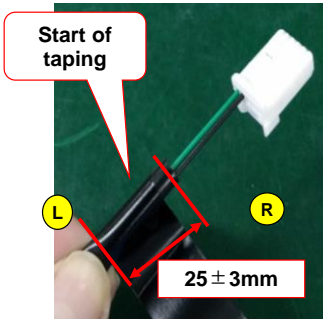
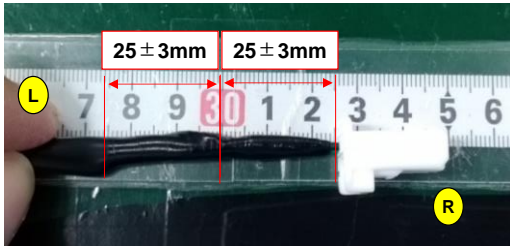

PARTS: 1. Assy part; Black tape		JIG: n/a	
NO.	PROCESS NAME	<div style="text-align: center;">  WORK PROCEDURE/ ILLUSTRATION </div>	TOOLS/PPE
1	P3 Table Lay-out	<div style="text-align: center;"> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;">TABLE LAY-OUT</div>  </div>	<div style="border: 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 5s. 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>
		QUALITY POINTERS	
		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	Reviewed by	Approved by	Noted by
07/31/24	1	Transfer Black SV tube to wire near connector taping (6098-3810 (W)) from P2 (WI-ENG-PDE-416B); transfer Black SV tube to wire near connector taping (6098-3802 (W)) to P2; separate Y-taping 2 to P4 (WI-ENG-PDE-416D) due to process improvement. Inclusion of car model "LEXUS-NX/RX". Update Table lay-out and Visual inspection/Quality checkpoints.	D.Castillo	C.Villanueva	A. Arañes	N/A	 D. Castillo	 C. Villanueva	 A. Arañes	N/A	
08/15/23	0	Initial Issue. Change MP from 2MP to 3MP. Transfer process of Taping SV tube (Vinyl) to wire near connector from P1 to P3; Transferred process of Y-taping 1&2 from P2 to P3 due to change process distribution. Inclusion of Quality checkpoints on page no.5; Change table lay-out; Standardized tube description: SV tube (Viny).	M.Ariola	J. Loterte	C.Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	August 15, 2023			

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	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 900B/ 910B / 7N0072-7020C		Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:	WI-ENG-PDE-461C	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	2 of 4

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS		
2	P3 Taping 3 Black SV tube (Vinyl) to wire near connector	<div><p>25 ± 3mm</p><p>1. Measure from end of SV tube (Vinyl) up to edge of connector 25±3mm using both hands.</p></div> <div><p>Start of taping</p><p>25 ± 3mm</p><p>2. Hold the SV tube (Vinyl) using left hand, get the Black tape using right hand then start taping process using both hands.</p></div> <div><p>25 ± 3mm 25 ± 3mm</p><p>3. After taping, check the measurement and taping condition.</p></div>	<div><p>MEASURING TAPE</p></div>	<p>Important reminders and Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</p>		

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model code/Part number: 900B/ 910B / 7N0072-7020C

Customer: TRJ

Car Model: LEXUS-NX/RX

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

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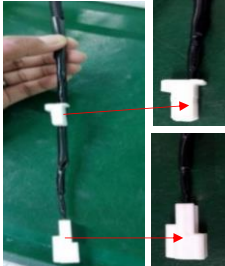




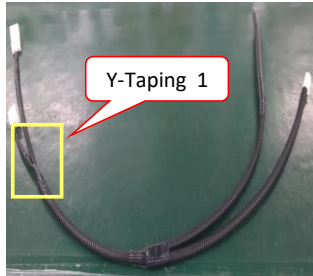
WI-ENG-PDE-461C

Revision No.:

1

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	P3	Y-Taping 1			
		<div><div></div><div></div><div><div>1. Fix the two SV tube (Vinyl) and COT using both hands. <i>See illustration for correct facing of connector.</i></div></div></div> <div><div>tape shifting 1/2 below</div><div></div><div>25 ± 3mm</div><div>taping direction</div></div> <div><div>tape shifting 1/3 below</div><div></div><div>25 ± 3mm</div><div>taping direction</div></div> <div><div>2. Hold two SV tube (Vinyl) using left hand and fix to COT. Make 1 winding for pre-tape before shifting then wind the tape down to vinyl tube until 25±3mm.</div><div>3. From SV tube (Vinyl) , make 1/3 shifting to COT until 25±3mm. Wind the tape 1 time before shifting.</div></div>		<div>Measuring tape</div> <div></div> <div>Y-TAPING ORIENTATION</div> <div></div>	<div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</div> <div>Important reminders/Note/s:</div> <div>1. Use YELLOW TAPE for easy visualization of shifting lines, But actual should BLACK TAPE ONLY.</div> <div>2. Please use calibrated/verified measuring tape when getting the measurement.</div> <div></div> <div>Y-Taping 1</div>

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Effectivity Date:

July 31, 2024

Validity Date:

n/aModel code/Part number: **900B/ 910B / 7N0072-7020C**Customer: **TRJ**Car Model: **LEXUS-NX/RX**

Document No.:

WI-ENG-PDE-461C

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

4 of 4**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P3****7N0072-7020C****1 2****No Missing Tape**

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