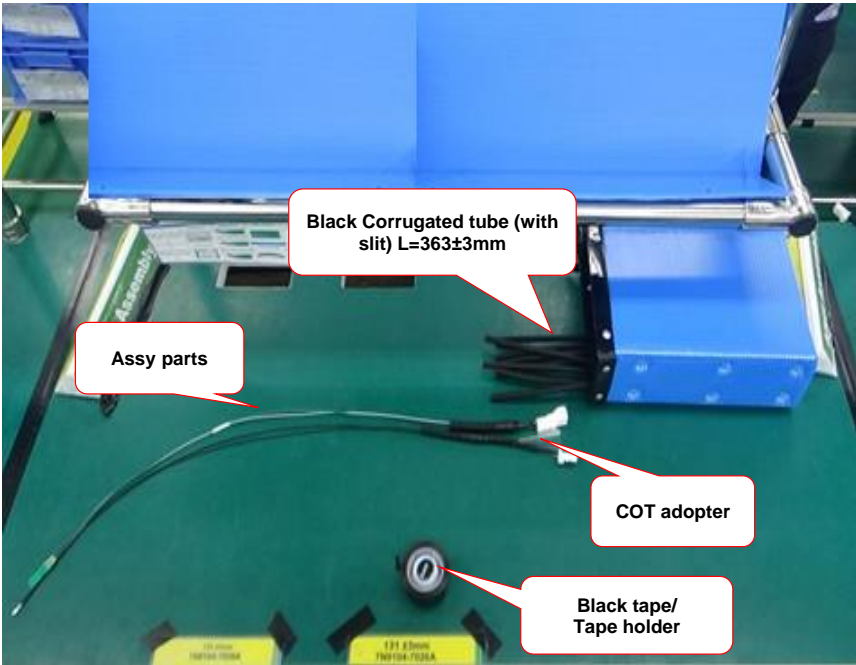
	<b>WORK INSTRUCTION</b>				Effectivity Date:		October 21, 2024	
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: <b>900B.910B / 7N0104-7020C</b>		Customer: <b>TRJ</b>		Car Model: <b>LEXUS-NX/RX</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.:		WI-ENG-PDE-1137B	
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<b>PARTS:</b>	1. Assy parts; Black corrugated tube L=363±3mm (with slit) ; Black tape			JIG:	1. COT adaptor
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
1	P2	Table Lay-out  	<div> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div> <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> <b>Alert level</b>            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	


  

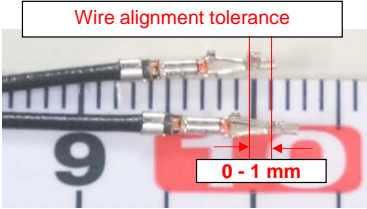
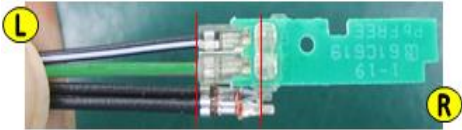


Revision History						Prepared by	Reviewed by	Approved by	Noted by
10/21/24	1	Change from Pre-launch to Masspro. Update Visual inspection/Quality checkpoints.	D. Castillo	C. Villanueva	A. Arañes	n/a			
10/17/24	0	Initial issue.	D. Castillo	C. Villanueva	A. Arañes	n/a			
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 17, 2024	

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	Process Name/Title:		Model code/Part number: <b>900B.910B / 7N0104-7020C</b>		Customer: <b>TRJ</b>		Car Model: <b>LEXUS-NX/RX</b>	
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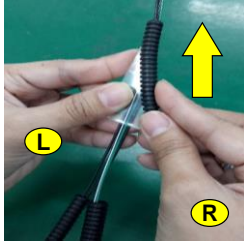
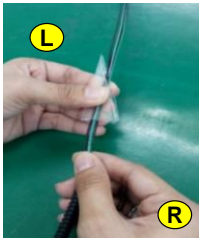
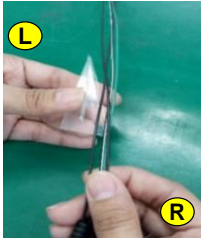

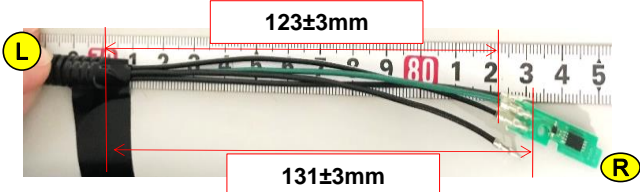
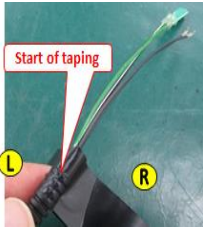
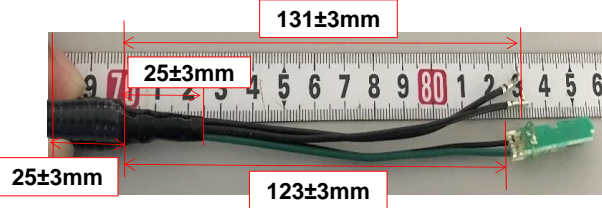

<b>PARTS:</b>		1. Assy parts 2. Black tape		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	P2	Spot taping		n/a	<div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</div> <div></div>
		<div><div>1. Fix the hotmelted wire and terminal pointed tip using both hands.</div><div>2. Hold the wires using left hand, get the <b>Black tape</b> using right hand then make <b>2 windings</b> of tape using both hands. <i>Note: Position of spot taping must be right beside white tape.</i></div></div>			

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	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>October 21, 2024</b>		
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>900B.910B / 7N0104-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS-NX/RX</b>	Document No.:	<b>WI-ENG-PDE-1137B</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	3 of 5


<b>PARTS:</b>	1. Assy parts 2. Black tape			JIG:	1. COT Adaptor
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
3	Wire insertion to Black Corrugated tube (w/slit) ø5 L=363±3mm	<div></div> <div>1. Hold the COT adaptor using left hand. Combined the <b>2 assy parts</b> and put inside the COT adaptor using right hand</div> <div>2. Hold the COT adaptor with wires using left hand, get the <b>Black Corrugated tube (w/slit) ø5 L=363±3mm</b> using right hand and insert to COT adaptor. Pull the adaptor and push the COT (<b>same timing</b>) using both hands. Make sure all wires are inserted.</div>		<div>COT Adaptor</div> 	1. No wrong use of parts 2. No wires left in between the COT with slit
4	P2 Taping 4 Black Corrugated tube (w/slit) to wire near PCB and terminal tip	<div></div> <div>1. Hold the corrugated tube using left hand then start taping using right hand.</div> <div>2. Measure from end of the corrugated tube up to terminal pointed tip <b>131±3mm</b> and corrugated tube up to hotmelted wires <b>123±3mm</b> then continue the taping process using both hands.</div> <div></div> <div>3. After taping, check the measurement, terminal alignment and taping condition.</div>		<div>Measuring tape</div> 	<b>Important reminders/Note/s:</b>  1. Please use calibrated/verified measuring tape when getting the measurement  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  <b>Document references:</b> 1. Please refer to <b>WI-PRO-ASY-001</b> for taping procedure.


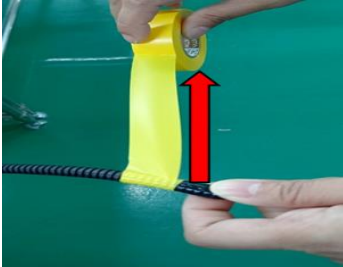


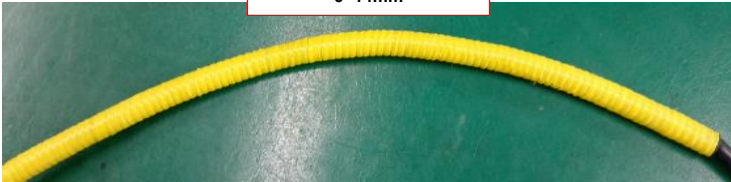
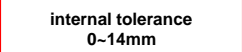

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	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>October 21, 2024</b>		
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>900B.910B / 7N0104-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS-NX/RX</b>	Document No.:	<b>WI-ENG-PDE-1137B</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	4 of 5

<b>PARTS:</b>	1. Assy parts 2. Black tape			JIG:	n/a	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
5	P2 Half-wrap taping	<div><p>1. Attach the tape, then make <b>2 windings</b>.</p></div> <div><p>2. Pull the tape around <b>150mm~200mm</b>.</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 <b>2 windings</b> before cut the tape.</p></div> <div><p>5. After taping, check the condition of tape. <b>THERE MUST BE NO EXPOSED COT BETWEEN HALF WRAP TAPING.</b></p></div> <div><p>internal tolerance 0~14mm</p></div> <div><p>Appearance after Taping</p></div>				<p><b>Document reference/s:</b></p> <p>1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p><b>Important reminders/Note/s:</b></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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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**October 21, 2024**

Model code/Part number:

**900B.910B / 7N0104-7020C**

Customer:

**TRJ**

Car Model:

**LEXUS-NX/RX**

Document No.:

**WI-ENG-PDE-1137B**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

**1**

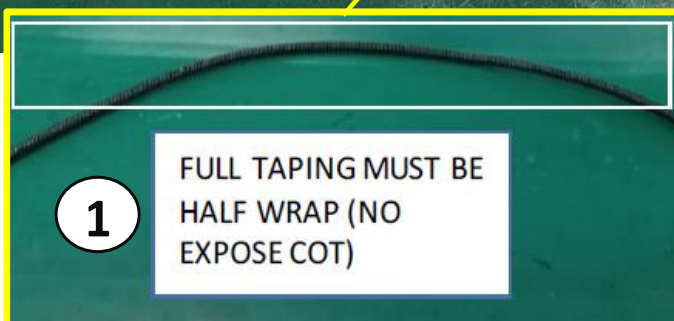
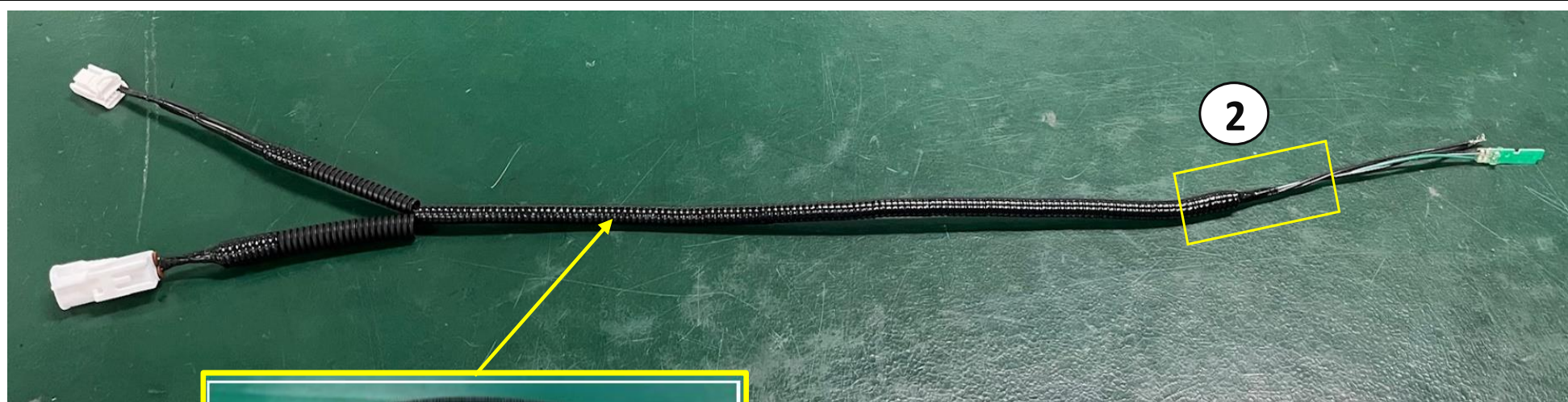
Page No.:

**5 of 5****PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P2****7N0104-7020C****1****FULL TAPING MUST BE  
HALF WRAP (NO  
EXPOSE COT)****2****No Missing Tape**

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