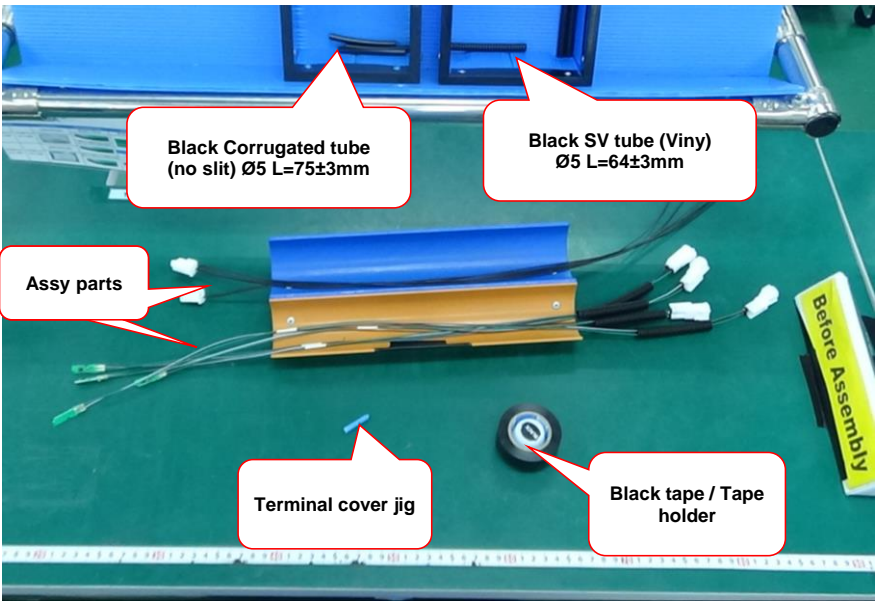


	<b>WORK INSTRUCTION</b>				Effectivity Date:		October 21, 2024	
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: <b>900B.910B / 7N0104-7020C</b>		Customer: <b>TRJ</b>		Car Model: <b>LEXUS-NX/RX</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.:		WI-ENG-PDE-1137A	
				Revision No.:		1		Page No.:
								1 of 6


<b>PARTS:</b>	1. Assy parts; Black Corrugated tube (no slit) Ø5 L=75±3mm; Black SV tube (Vinyl) Ø5 L=64±3mm; Black tape				JIG:	1. Terminal cover jig				
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>				<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>			
1	P1	Table Lay-out	<div style="text-align: center; border: 1px solid red; padding: 5px; margin-bottom: 10px;">TABLE LAY-OUT</div> 				<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> <b>Safety Instruction</b>            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;"> <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 solid 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-ENG-PDE-1136 for Offline assembly process					
					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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	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-1137A</b>	
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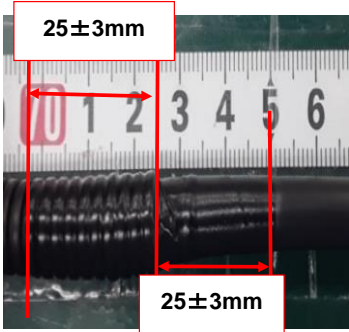

<b>PARTS:</b>	1. Black Corrugated tube (No slit) Ø5 L=75±3mm 2. Assy parts 3. Black tape 4. Black SV tube (Vinyl) Ø5 L=64±3mm				JIG:	1. Terminal cover jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
2	P1	Wire insertion to Black SV tube (Vinyl) Ø5 L=64±3mm	<div></div> <div>1. Get the Black SV tube (Vinyl) Ø5 L=64±3mm using right hand and insert <b>B-B wires</b> using left hand.</div>			n/a	1. No wrong use of part.
3		Wire insertion to Black Corrugated tube (No slit) Ø5 L=75±3mm	<div><div><div>1. Get the terminal cover jig using right hand then insert the <b>B-B wires</b> using left hand.</div></div><div><div>2. Get the Black COT Ø5 L=75±3mm using right hand and insert <b>B-B wires</b> using left hand.</div></div><div><div>3. After insertion, remove the terminal cover jig using right hand.</div></div></div>			<div>TERMINAL COVER JIG</div> 	1. No Wrong use of parts 2. No deformed terminal

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	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-1137A</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	3 of 6


<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>
4	P1 Taping 1 Black corrugated tube to Black SV tube (Vinyl) near connector	<div><div>1. Fix the corrugated tube and SV tube (Vinyl) using both hands. Make sure no gap between corrugated tube and SV tube (Vinyl).</div><div>2. Get the <b>Black tape</b> and start taping process using both hands.</div><div>3. After taping, check the measurement and taping condition.</div></div> <div><div>MEASURING TAPE</div></div>		<p><b>Important reminders/Note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement. 2. Must be no gap between COT and SV tube (vinyl).</p> <p><b>Document references:</b></p> <p>1. Please refer to <b>WI-PRO-ASY-001</b> 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 use of tape 6. No wrong dimension</p>	

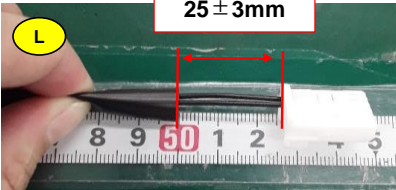
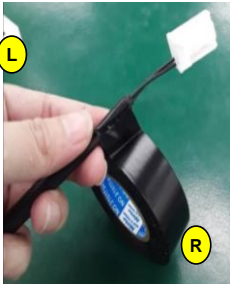
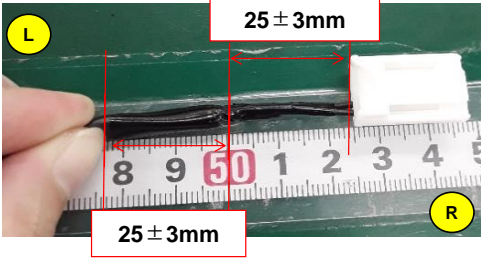

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	4 of 6


<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	P1 Taping 2 Black SV tube (Vinyl) to wire near connector	<div><p>25 ± 3mm</p><p>1. Hold SV tube (Vinyl) using left hand, measure from SV tube (Vinyl) up to end of connector <b>25±3mm</b>.</p></div> <div><p>2. Get <b>Black tape</b> using right hand, hold the SV tube (Vinyl) (<b>ø5 L=64±3mm</b>) using left hand then fold the vinyl tube and start taping using right hand.</p></div> <div><p>25 ± 3mm</p><p>25 ± 3mm</p><p>3. After taping, check the measurement and taping condition.</p></div>	<div><b>MEASURING TAPE</b></div> 	<p><b>Important reminders/Note/s:</b></p> <p><b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></p> <p><b>Document references:</b></p> <p><b>1. Please refer to WI-PRO-ASY-001 for taping procedure.</b></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>	

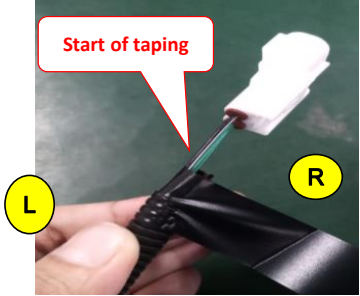
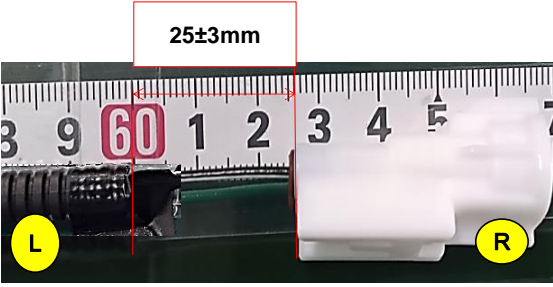
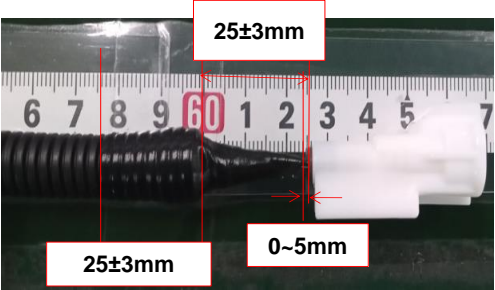

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	5 of 6

<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>	
6	P1 Taping 3 Black Corrugated tube to Wire near Connector	<div><div>1. Hold the Corrugated tube using left hand then start taping using right hand.</div></div> <div><div>2. Measure from end of the COT up to connector <b>25±3mm</b> then continue the taping process using both hands.</div></div> <div><div>3. After taping, check the measurement and taping condition.</div></div>	<div><b>MEASURING TAPE</b></div> 	<b>Important reminders/Note/s:</b>  <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b>  <b>Document references:</b> <b>1. Please refer to WI-PRO-ASY-001 for taping procedure.</b>  1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension	

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

October 21, 2024

Validity Date:

n/a

Model code/Part number:

900B.910B / 7N0104-7020C

Customer: TRJ

Car Model:

LEXUS-NX/RX

Document No.:

WI-ENG-PDE-1137A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

6 of 6

PARTS:

1. Assy parts

JIG:

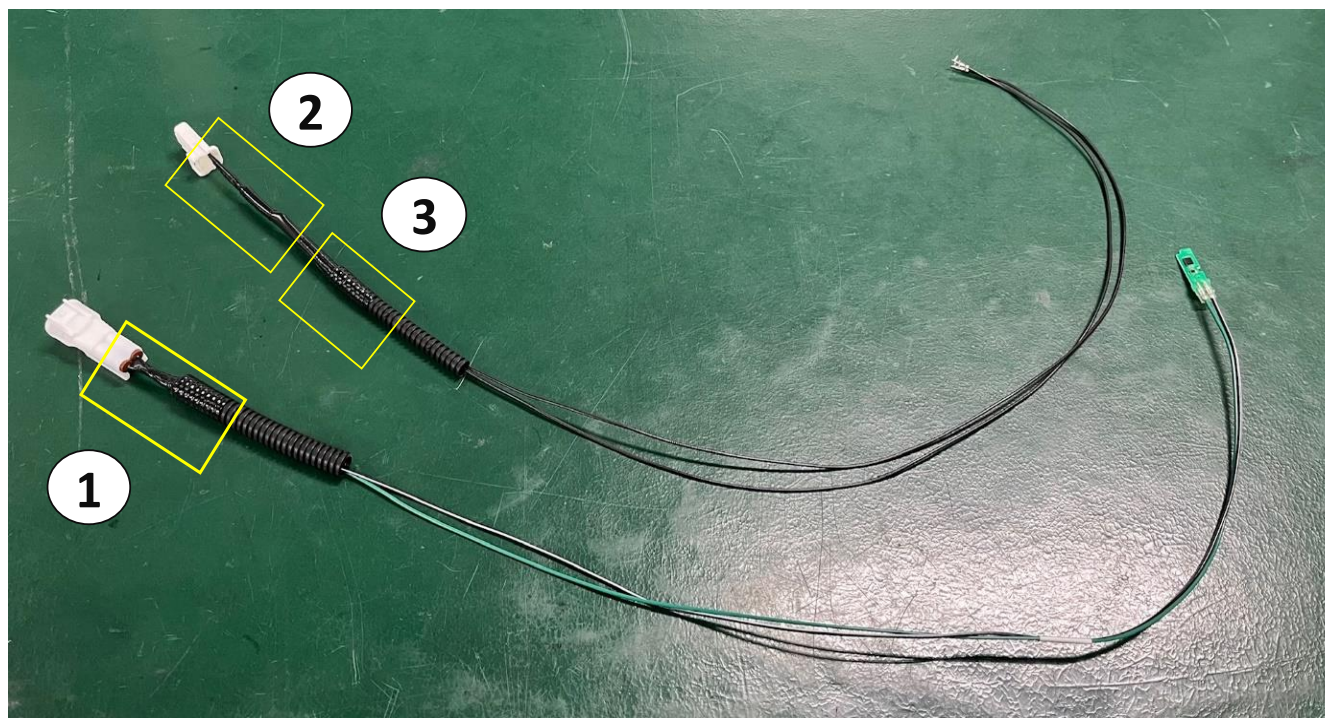
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### VISUAL INSPECTION/ QUALITY CHECKPOINTS

# TAPING - P1

# 7N0104-7020C



1 2 3

No Missing Tape

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