WORK INSTRUCTION				Effectivity Date:	**June 6, 2024**
Process Name/Title:	**TAPING ASSEMBLY PROCESS**			Validity Date:	**n/a**
Model code/Part number:	**800B / 7N0068-7020A**	Customer: **TRJ**	Car Model: **LEXUS NX**	Document No.:	**WI-ENG-PDE-187B**
Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO		Revision No.: 3	Page No.: 1 of 7

PARTS: 1. Assy parts; Black VM tube (Sunprene) ø9 L=112±3mm; Black tape. **JIG:** n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2 — Table Lay-out (3)	**TABLE LAY-OUT** Black VM tube (Sunprene) ø9 L=112±3mm · Assy parts · Master sample · Black tape / Tape holder	**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/tools 2. No excess parts/tools

Revision History						Prepared by	Reviewed by	Approved by	Noted by
06/06/24	3	Improve Quality pointers on pages no.2,4 and 5 as document process improvements; Update Table lay-out. Inclusion of Quality checkpoints. Arranged process sequence. Transfer Taping 2 Black VM tube (Sunprene) to Black Corrugated tube process from WI-ENG-PDE-187C to WI-ENG-PDE-187B due to Process improvement.	D.Castillo	C. Villanueva	A. Arañes	n/a			
03/25/21	2	Change status from pre-launch to Masspro.	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes	*Castillo* D. Castillo	*C. Villanueva* C. Villanueva	*A. Arañes* A. Arañes
11/27/20	1	Change part number from 7N0068-7020 to 7N0068-7020A due to changes in tape color (refer to WI-ENG-PDE-187C).	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes			n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	November 6, 2020	

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	Model code/Part number: **800B / 7N0068-7020A**		Customer: **TRJ**	Car Model: **LEXUS NX**	Document No.:	**WI-ENG-PDE-187B**
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO		Revision No.: 3	Page No.: 2 of 7

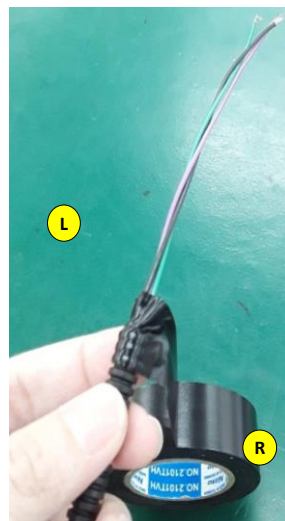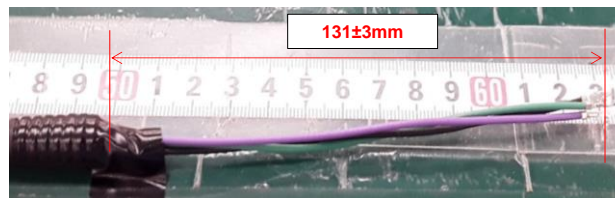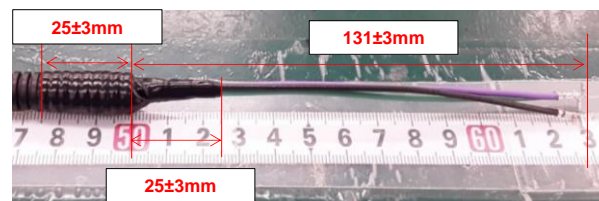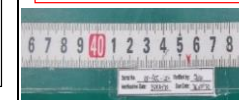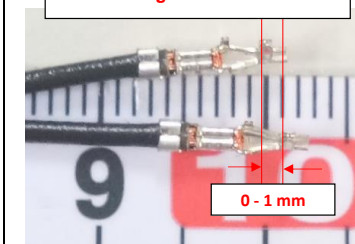| **PARTS:**	1. Assy parts 2. Black tape				**JIG:**	n/a
NO.	**PROCESS NAME**	**WORK PROCEDURE/ ILLUSTRATION**			**TOOLS/PPE**	**QUALITY POINTERS**
2	P2 Taping 1 COT to wire near terminal	L, R	1. Hold the assy parts using left hand. Get Black tape using right hand and start pre-taping. **131±3mm** 2. Measure from COT to Connector **131±3mm** using both hands and continue the taping process. **25±3mm** **131±3mm** **25±3mm** 3. Check the measurement, wire alignment and taping condition after taping.		**Measuring tape** 	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 ⚠ 3 *Important reminders/note/s:* *1.Please use calibrated/verified measuring tape when getting the measurement.* **Wire alignment tolerance** **0 - 1 mm**

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	Model code/Part number: **800B / 7N0068-7020A**	Customer: **TRJ**	Car Model: **LEXUS NX**	Document No.:	**WI-ENG-PDE-187B**
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 3	Page No.: 3 of 7

| PARTS: | 1. Black VM tube (Sunprene) ø9 L= 112±3mm
2. Assy parts | JIG: | n/a |

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 — Wire insertion to VM tube (Sunprene) ø9 L= 112±3mm	 1. Get the **VM tube (Sunprene) ø9 L= 112±3mm** using right hand and insert the wires using left hand. **VM tube (Sunprene)** — **20±5mm** — **40±3mm** — **Terminal pointed tip** — **COT** *Note:* *Dimension from terminal pointed tip to VM tube (Sunprene) must be L=40±3mm while the inserted VM tube (Sunprene) to COT must be L=20±5mm*	n/a	1. No wrong use of parts 2. No deformed terminal

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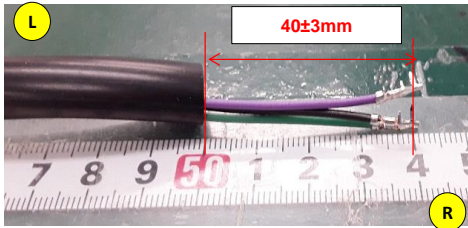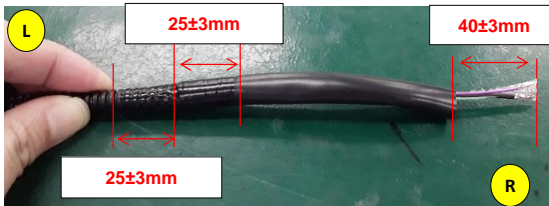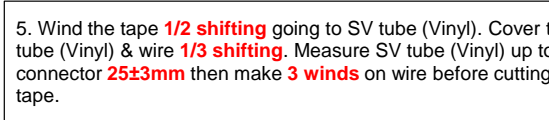
	WORK INSTRUCTION	Effectivity Date:	**June 6, 2024**
Process Name/Title:	**TAPING ASSEMBLY PROCESS**	Validity Date:	**n/a**
Model code/Part number: **800B / 7N0068-7020A**	Customer: **TRJ** Car Model: **LEXUS NX**	Document No.:	**WI-ENG-PDE-187B**
Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	3 Page No.: 4 of 7

PARTS:	1. Assy parts 2. Black tape			JIG:	n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	△3 P2 Taping 2 Black VM tube (Sunprene) to Black Corrugated tube	**40±3mm** 1. Hold the assy parts using left hand. Measure from VM tube (Sunprene) to terminal pointed tip **40±3mm.** 2. Hold the assy parts using left hand. Get the Black tape and start taping using right hand. **25±3mm** **40±3mm** **25±3mm** 3. After taping, check the measurement and taping condition. 5. Wind the tape **1/2 shifting** going to SV tube (Vinyl). Cover the SV tube (Vinyl) & wire **1/3 shifting**. Measure SV tube (Vinyl) up to connector **25±3mm** then make **3 winds** on wire before cutting of tape. 6. After taping, Check the measurement and taping condition.	**Measuring tape**	1. Check the tape from COT to VM tube (Sunprene) (Conduct bending for verification) 2.No flip out tape. 3.No tape peeling. 4.No loose tape *Important reminders/note/s:* *1.Please use calibrated/verified measuring tape when getting the measurement.*

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	Model code/Part number: **800B / 7N0068-7020A**	Customer: **TRJ**	Car Model: **LEXUS NX**	Document No.: **WI-ENG-PDE-187B**
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO	Revision No.: 3	Page No.: 5 of 7

| PARTS: | 1. Assy parts
2. Black tape | | JIG: | n/a |

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2 — Y-Taping	**No wide interval** 1. Fix the corrugated tube and SV tube (Vinyl). Follow the correct connector orientation. **Note**: Do not exert excessive force during pulling & winding of tape **25±3mm** 2. Start taping at the middle of combined **COT & SV tube (Vinyl),** then wind the tape going to 2 corrugated tubes (**3 windings) width must be 25mm.** **tape width** 3. Wind the tape **1/3 shifting** until it reach the SV tube (Vinyl), **width must be tape width.** 4. Wind the tape backward **1/2 shifting.** **taping direction** **tape shifting 1/2 below** **Tape shifting 9mm below** **tape shifting 1/3 below** **25±3mm** **25±3mm** **25±3mm** **25±3mm** **0 ~ 5mm** 5. Wind the tape **1/2 shifting** going to SV tube (Vinyl). Cover the SV tube (Vinyl) & wire **1/3 shifting**. Measure SV tube (Vinyl) up to connector **25±3mm** then make **3 winds on wire before cutting of tape.** 6. After taping, Check the measurement and taping condition.	**Measuring tape**	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. *Important reminders/note/s:* *1.Please use calibrated/verified measuring tape when getting the measurement.* *2. Used yellow tape to easily visualize the tape shifting but actual should be BLACK TAPE.* *Document references:* *1. Refer to WI-PRO-ASY-001 for Taping process* **CONNECTOR ORIENTATION**

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	Model code/Part number: **800B / 7N0068-7020A**	Customer: **TRJ**	Car Model: **LEXUS NX**	Document No.:	**WI-ENG-PDE-794**
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☑ MASSPRO			Revision No.: 0	Page No.: 6 of 7
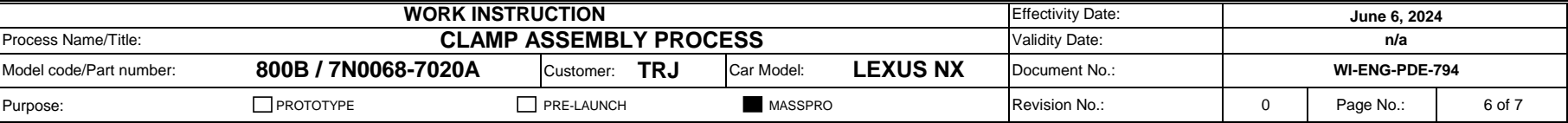
PARTS:	n/a			JIG:	n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	CLAMP ASSY	Measurement	**MEASURING TAPE**	*Important reminders and note/s:* *1. Please use calibrated/verified measuring tape when getting the measurement.* *2. For Hatsumono, Nakamono and Owarimono.* *Document reference/s:* *1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection* 1.No wrong dimension

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PARTS:	n/a		JIG:	n/a

△3 **VISUAL INSPECTION/ QUALITY CHECKPOINTS**

P2   7N0068-7020A

GOOD | NG
Full Lock | Half Lock

(1) No Unlock/Halflock connector

(2) No Missing Sunprene tube L=112mm

(3) No Missing Tape (COT to Sunprene tube)

(4) No Missing Tape (Y-taping)

(5) No Deformed terminal

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