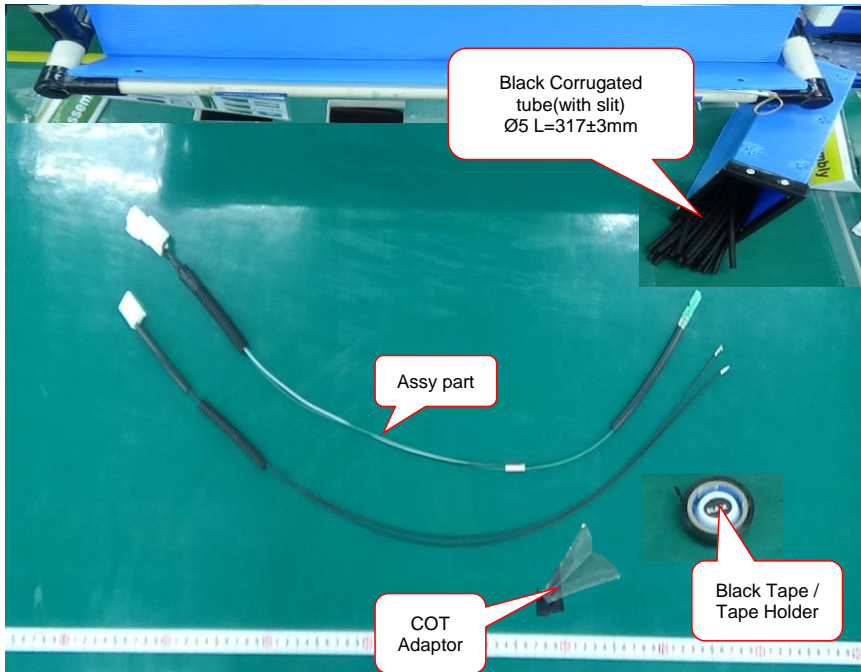


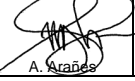



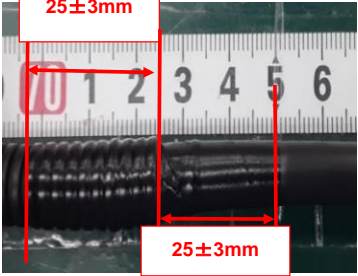

	WORK INSTRUCTION				Effectivity Date:		July 04, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 922B / 7L0124-7022		Customer: TRQSS		Car Model: LEXUS NX		Document No.: WI-ENG-PDE-266B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		4		Page No.: 1 of 6	

PARTS:		1. Assy parts; Black tape [2pcs]; Black Corrugated tube(with slit) Ø5 L=317±3mm		JIG:		1. COT Adaptor	
NO.	PROCESS NAME	<div style="border: 1px solid black; padding: 2px; display: inline-block;">4</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
1	P2 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 5's. 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>	1. No missing parts in assy parts 2. No excess tape/tape holder			

Revision History							Prepared by	Reviewed by	Approved by	Noted by
07/04/24	4	Transfer Black corrugated tube to Black SV tube (Vinyl) Black SV tube (Vinyl) to wire near connector from P1 and transfer Taping 4 to P3 due to process improvement. Inclusion of car model " LEXUS-NX". Improved Table lay-out and Visual inspection/Quality checkpoints.				D.Castillo	C.Villanueva	A. Arañes	n/a	<div style="text-align: center;">  D.Castillo </div> <div style="text-align: center;">  C.Villanueva </div> <div style="text-align: center;">  A. Arañes </div>
02/10/23	3	Work instruction improvement: Change process sequence (Page 2) and remove some process due to additional MP from 3MP to 4MP. Change term Black sunprene tube to Black VM tube (Sunprene). Inclusion of Quality checkpoint (Page 4).				D.Castillo	J.Loterte	C.Villanueva	A. Arañes	
10/18/21	2	Change part number due to design change.				D.Castillo	J.Loterte	C.Villanueva	A. Arañes	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date: June 5, 2021

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	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 922B / 7L0124-7022		Customer: TRQSS	Car Model: LEXUS NX	Document No.: WI-ENG-PDE-266B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	4	Page No.:	2 of 6

PARTS:	1. Assy parts 2. Black tape			JIG:	n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
2	P2 Taping 2 Black corrugated tube to Black SV tube (Vinyl)	<div><div>1. Fix the corrugated tube and SV tube (Vinyl) using both hands. Make sure no gap between corrugated tube and vinyl tube.</div><div>2. Get the Black tape 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>Important reminders/note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. Must be no gap between COT and Vinyl tube.</p> <p>Document references:</p> <p>1. Please 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 use of tape 6. No wrong dimension</p>				

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Effectivity Date:

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Model code/Part number:

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Customer:

TRQSS

Car Model:

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Revision No.:

4

Page No.:


3 of 6

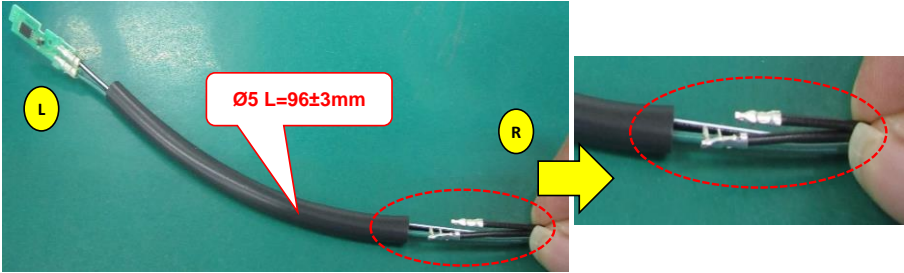

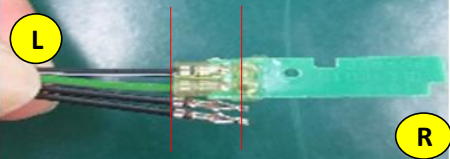


PARTS:	1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 <div>4</div> Taping 3 Black SV tube (Vinyl) to wire near connector	<div>L</div> <div>25 ± 3mm</div> <div>Start of taping</div> <div>L</div> <div>R</div> <div>2. Get Black tape using right hand, hold the SV tube (Vinyl) (ø5 L=64±3mm) using left hand then fold the SV tube (Vinyl) and start taping using right hand.</div> <div>1. Hold vinyl tube using left hand, measure from SV tube (Vinyl) up to end of connector 25±3mm.</div> <div>L</div> <div>25 ± 3mm</div> <div>0~5mm</div> <div>20 ± 3mm</div> <div>3. After taping check the measurement, wire alignment and taping condition.</div>	<div>Measuring tape</div> <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> <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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	Process Name/Title:		Model code/Part number: 922B / 7L0124-7022		Customer: TRQSS	Car Model: LEXUS NX	Document No.:	WI-ENG-PDE-266B	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO		Revision No.:	4	Page No.:

PARTS:		1. Assy parts 2. Black tape			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	Wire Insertion to assy parts	<div>  </div> <div> 1. Hold the Black VM tube (Sunprene) Ø5 L=96±3mm using left hand then continue to insert the assy parts using right hand. </div>			n/a	1. No wrong usage of parts 2. No wrong insertion
5	P2  Spot taping	<div>  </div> <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 Black tape using right hand then make 2 windings of tape using both hands. <i>Note: Position of spot taping must be right beside Black tape.</i> </div> <div> 3. Check the wire alignment and taping condition. </div>			n/a	1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No wrong use of tape

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**WORK INSTRUCTION**

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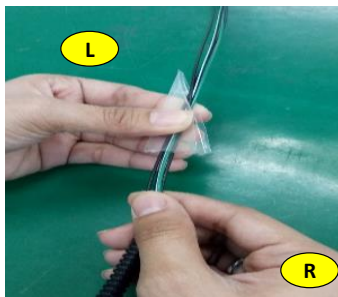
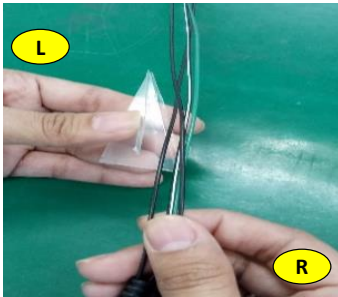
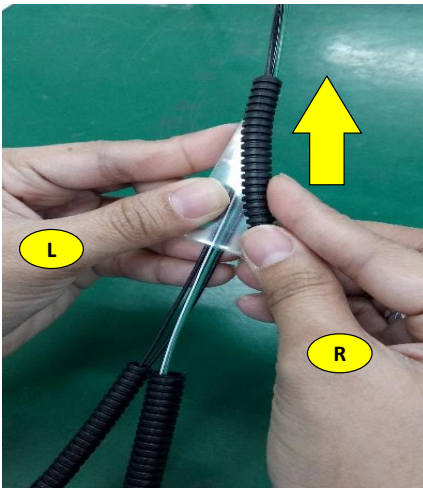

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Revision No.:

4

Page No.:

5 of 6

PARTS:		1. Black Corrugated tube(with slit) Ø5 L=317±3mm		JIG:	1. COT Adaptor
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P2 Wire insertion to Black Corrugated tube (w/slit) ø5 L=317±3mm	<div></div> <div>1. Hold the COT adaptor using left hand. Combined the 2 assy parts and put inside the COT adaptor using right hand</div> <div></div> <div>2. Hold the COT adaptor with wires using left hand, get the Black Corrugated tube (w/slit) ø5 L=317±3mm using right hand and insert to COT adaptor. Pull the adaptor and push the COT (same timing) 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

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Document No.:

WI-ENG-PDE-266B

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Revision No.:

4

Page No.:

6 of 6

PARTS:

1. Assy parts

JIG:

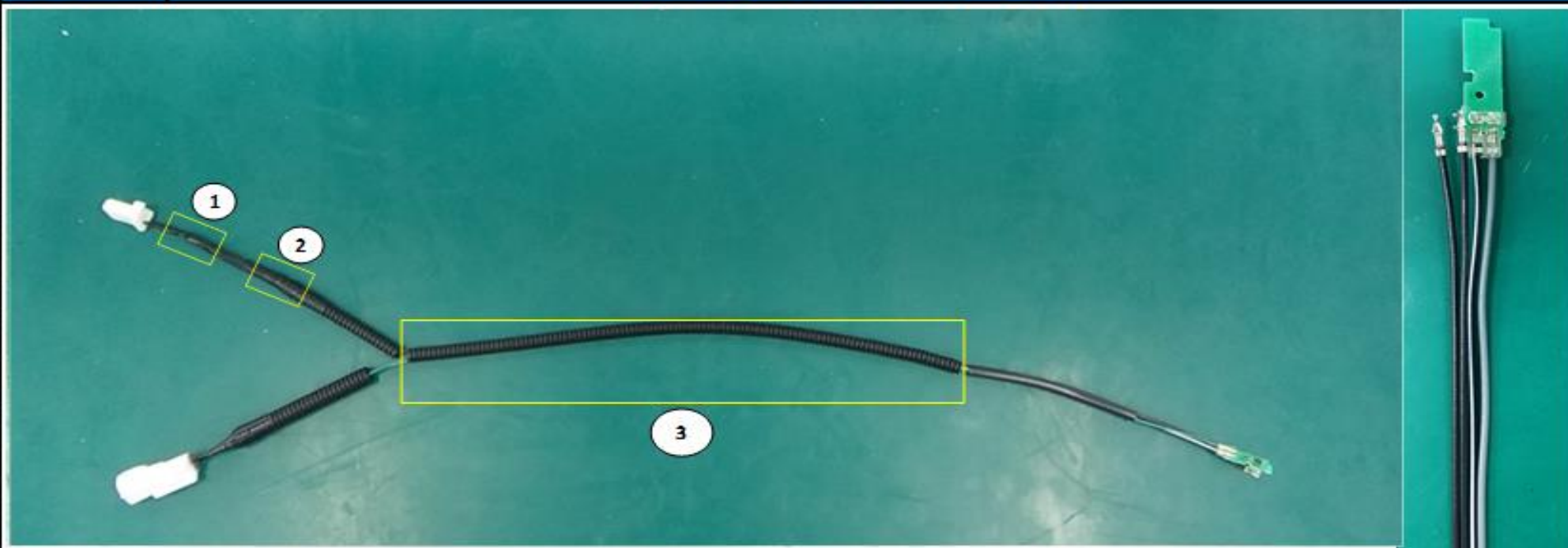
n/a



VISUAL INSPECTION/ QUALITY CHECKPOINTS

P2

7L0124-7022



1

2

No MISSING TAPE

3

No MISSING COT

Proper alignment of
B-B wires and hotmelt

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