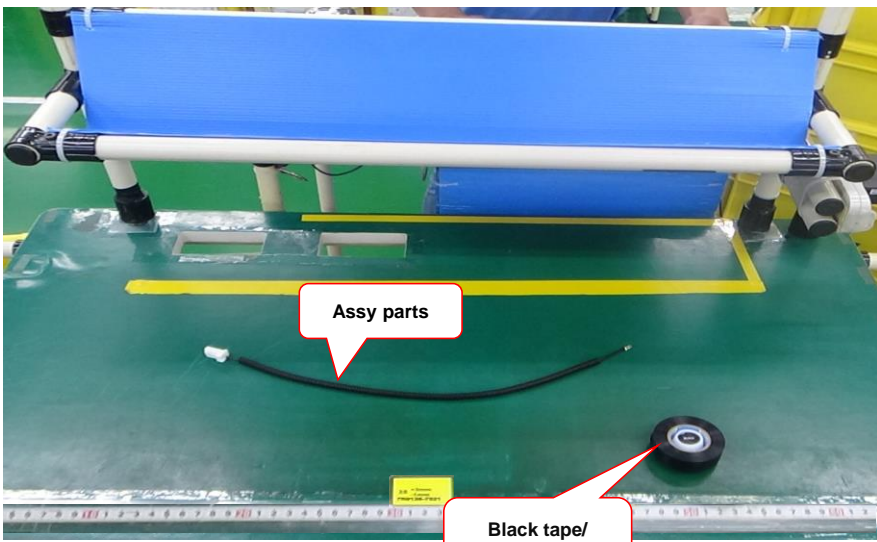


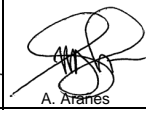
	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>June 11, 2024</b>		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>200D / 7R0129-7020</b>	Customer: <b>TRMX</b>	Car Model: <b>Lexus (TOYOTA)LM</b>	Document No.:	<b>WI-ENG-PDE-437</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	4	Page No.:	1 of 4

<b>PARTS:</b>		1. All parts: Assy parts; Black tape [1pc]				JIG:		n/a		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>				<b>TOOLS/PPE</b>		<b>QUALITY POINTERS</b>		
1	P1	<div style="text-align: center;"> <div style="border: 1px solid red; padding: 5px; display: inline-block;">Table Lay-out</div>   </div>				<div style="border: 1px dashed red; padding: 5px;"> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 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 dashed red; padding: 5px; margin-top: 10px;"> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>		<b>Document references:</b> <b>1. Refer to WI-ENG-PDE-545 Offline Assembly Process</b>  1. No missing parts/tools 2. No excess parts/tools		
Revision History										
06/11/24	4	Separate Clamp setting, Clamp assembly and By two's inspection to Clamp assembly process due to process improvement. Update table lay-out and quality checkpoints. Inclusion of car name "Lexus (TOYOTA)LM"				D.Castillo	C.Villanueva	A. Arañes	n/a	<div style="display: flex; justify-content: space-between;"> <div>           Prepared by              D. Castillo         </div> <div>           Reviewed by              C. Villanueva         </div> <div>           Approved by              A. Arañes         </div> <div>           Noted by            n/a         </div> </div>
04/24/23	3	Inclusion of quality checkpoints				M.Catapang	J.Loterte	C.Villanueva	A. Arañes	
09/30/22	2	Improve quality pointers: References in process no.1,2,3,4,5 and 6 due to document improvement. Change of tolerance from end of tape up to terminal pointed tip 35+3mm/-3mm to 35+3mm/-1mm as countermeasure due to encountered minimum dimension. Work procedure/illustration in process no.5 - visual/by two's inspection.				M.Catapang	J.Loterte	C.Villanueva	A. Arañes	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date: March 5, 2022

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## WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

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Model code/Part number:

200D / 7R0129-7020

Customer:

TRMX

Car Model:

Lexus (TOYOTA)LM

Document No.:

WI-ENG-PDE-437

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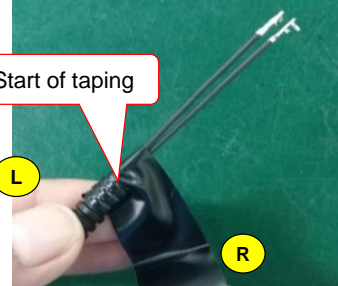
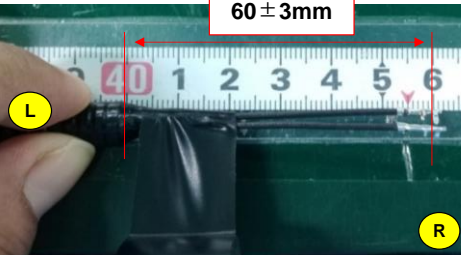

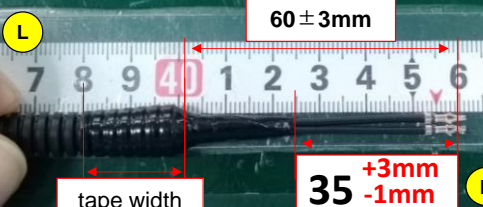

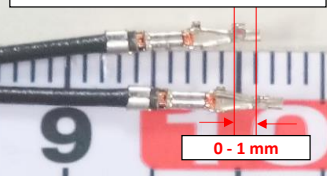
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PARTS:	1. Assy parts 2. Black tape [1pc]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Taping 1 COT to wire near terminal	<div data-bbox="560 375 940 670"><p>Start of taping</p></div> <div data-bbox="974 391 1456 670"><p>60 ± 3mm</p></div> <div data-bbox="560 694 940 821"><p>1. Hold the COT using left hand, get the <b>Black tape</b> using right hand then start pre-taping using both hands.</p></div> <div data-bbox="974 694 1456 821"><p>2. Measure from end of COT up to terminal pointed tip <b>60±3mm</b> then continue the taping process using both hands.</p></div> <div data-bbox="560 837 1064 1093"><p>35 +3mm/-1mm</p></div> <div data-bbox="1086 869 1456 1093"><p>3. Confirm measurement of <b>35+3mm/-1mm</b> from end of tape up to terminal pointed tip then continue the taping process using both hands.</p></div> <div data-bbox="560 1109 1064 1332"><p>60 ± 3mm</p><p>tape width</p><p>35 +3mm/-1mm</p></div> <div data-bbox="1086 1109 1456 1332"><p>4. After taping, check the measurement, taping condition and terminal alignment and appearance.</p></div>	<p>MEASURING TAPE</p> 	<div data-bbox="1747 391 2094 606"><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div> <ol style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong dimension</li><li>6. No wrong use of tape</li></ol> <p><b>Important reminders/Note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p><b>Document references:</b></p> <p>1. Refer to WI-ENG-PDE-588 for Tape and tube end standard tolerance</p> <p>2. Refer to WI-PRO-ASY-001 for taping procedure.</p>

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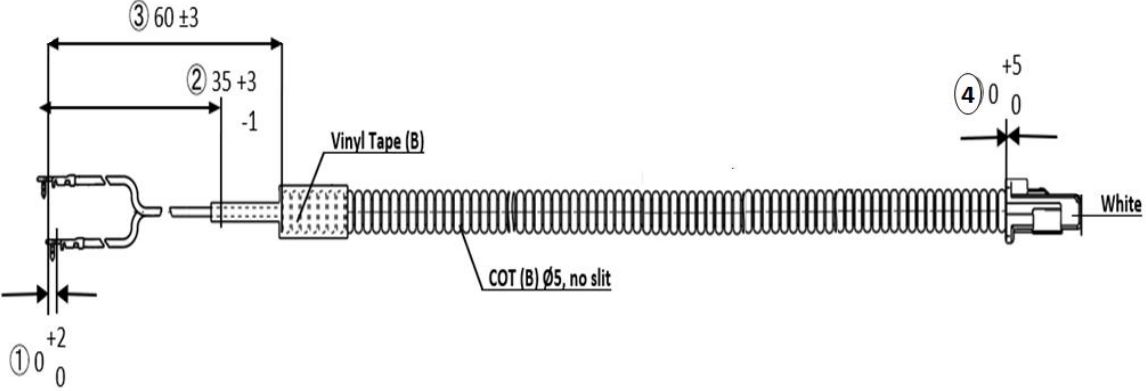

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<b>PARTS:</b>	1. Assy parts			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<div>1</div> <b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
3	P1 Measurement		<div>MEASURING TAPE</div> 	<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>	

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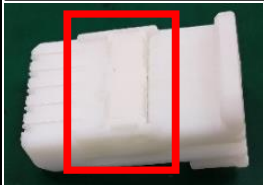
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P1****7R0129-7020****GOOD****NO GOOD****GOOD****NO GOOD****1****No Unlock/Halflock Connector****No Wrong Insert****No Terminal Backing Out****2****No Missing Tape****3****No Deformed Terminal**

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