

	WORK INSTRUCTION				Effectivity Date:	May 24, 2024		
	TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Process Name/Title:				Document No.:	WI-ENG-PDE-121		
	Model code/Part number: 946B / 7N0073-7020		Customer: TRJ	Car Model: LEXUS-ES	Revision No.:	6	Page No.:	1 of 5
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO								


PARTS:	1. Assy Parts; Black SV tube (Vinyl) ø5 L=54±3mm; Black Tape			JIG:	1.Measuring jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
1	P1	<div style="text-align: center;"> <div style="border: 1px solid red; padding: 2px; display: inline-block;">TABLE LAY-OUT</div> </div>	<div style="border: 1px dashed 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 dashed 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 dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to WI-ENG-PDE-840 for Offline assembly process 1. No missing parts/tools 2. No excess parts/tools	


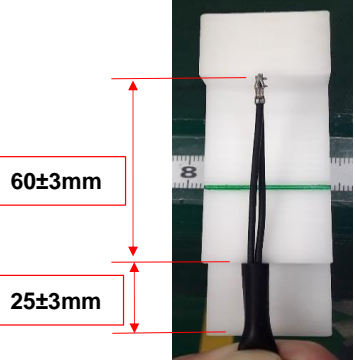

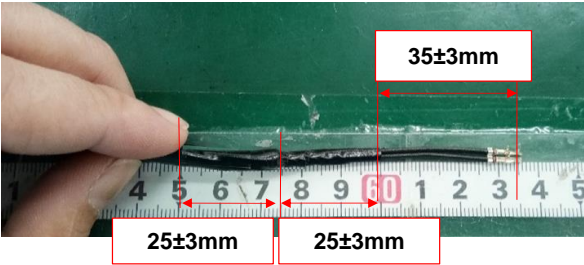
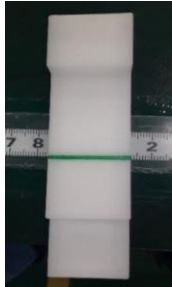

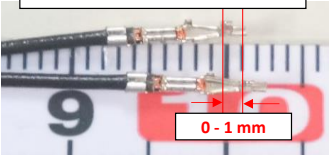
Revision History								Prepared by	Reviewed by	Approved by	Noted by
05/24/24	6	Transfer some process to Offline assembly process and Clamp assembly process due to process change. Update table lay-out. Improved Measurement and Visual inspection. Inclusion of car model "LEXUS-ES".	D.Castillo	C.Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a	
05/09/23	5	Work instruction improvement: Inclusion of batching. Update table lay-out (page 1) and Quality checkpoints (page 11).	D. Castillo	J. Loterte	C.Villanueva	A. Arañes					
04/28/23	4	Inclusion of quality checkpoints	J. Loterte	C.Villanueva	A. Arañes	n/a					
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	December 04, 2020			

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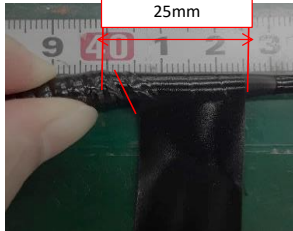
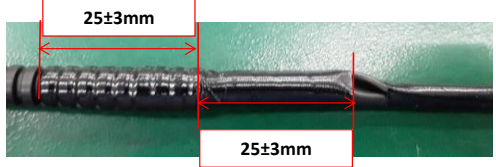
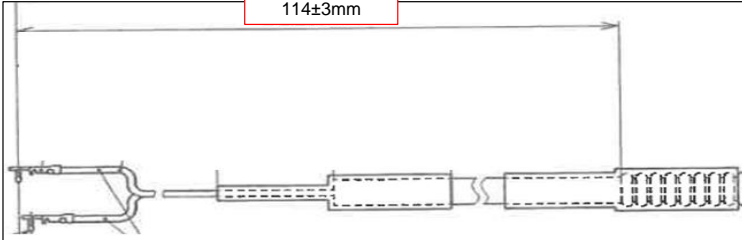
PARTS:	1. Assy Parts 2. Black SV tube (Vinyl) ø5 L=54±3mm 3. Black tape			JIG:	1. Measuring jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to SV tube (Vinyl) ø5 L= 54±3mm	 <div>1. Hold the assy part with B-B wires using left hand then insert SV tube (Vinyl) ø5 L=54±3mm using right hand.</div>		n/a	1. No wrong use of parts 2. No deformed terminal
3	P1 Taping 1 Black SV tube (Vinyl) to wire near terminal	<div><div>1. Hold the SV tube (Vinyl) tube using left hand and put into measuring jig. End of vinyl to terminal tip 60±3mm. Vinyl taping 25±3mm.</div><div>2. Get Black tape, hold the SV tube (Vinyl) using left hand then start taping using right hand.</div><div>3. After taping, check the measurement, wire alignment and tape condition.</div></div>		<div>MEASURING JIG </div> <div>MEASURING TAPE </div>	<div>1. No peel-off tape 2. No flip-ot tape 3. No loose tape 4. No wrong use of tape 5. No wrong tape measurement</div> <div>Important reminder/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Use provided jig per model to avoid wrong measurement</div> <div>Document references: 1. Please refer to WI-PRO-ASY-001 for taping procedure.</div> <div><div>Wire alignment tolerance 0 - 1 mm</div></div>

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	6	Page No.:	3 of 5


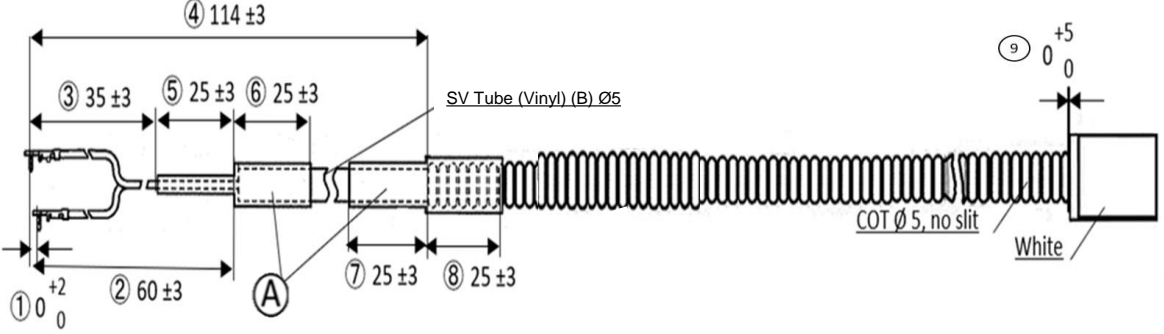
PARTS:	1. Assy Parts 2. Black tape			JIG:	n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
4	P1 Taping 2 Corrugated tube to SV tube (Vinyl)	<div><div></div><div><p>1. Fix the Corrugated tube and SV tube (Vinyl) using both hands and begin taping process. Start taping process between COT and vinyl tube.</p></div><div></div><div><p>2. Make 2 times 1/3 shifting on COT to make 25mm width then 2 times winding on COT. Make 1/2 shifting to the right to reach SV tube (Vinyl).</p></div><div></div><div><p>3. Make 2 times 1/3 shifting on SV tube (Vinyl) to make 25mm width. Wind the tape 3 times then cut the tape.</p></div><div></div><div></div><div><p>4. Check the measurement and taping condition after taping. NOTE: Taping must be tape width 25±3mm</p></div></div> <div><p>Important reminder/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p><p>Document references: 1. Please refer to WI-PRO-ASY-001 for taping procedure.</p><p>1. No peel-off tape 2. No flip-out tape 3. No loose tape 4. No wrong use of tape 5. No wrong tape measurement</p></div>					

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PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
5	P1	Measurement	<div><div>MEASURING TAPE</div></div>  <div>NOTE: Ⓐ - Taping (B)</div>	<div>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</div> <div>1. No wrong dimension</div>	

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**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**

Effectivity Date:

May 24, 2024Model code/Part number: **946B / 7N0073-7020**Customer: **TRJ**Car Model: **LEXUS-ES**

Validity Date:

n/aPurpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

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5 of 5**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION****TAPING - P1****7N0073-7020****1****No Missing Tape/Wrong use of tape**

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