



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 11, 2024

Process Name/Title:

Model code/Part number:

900B/910B / 7N0070-7020C

Customer: TRJ

Car Model: LEXUS-NX/RX

Validity Date:

-

Document No.:

WI-ENG-PDE-460D

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

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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

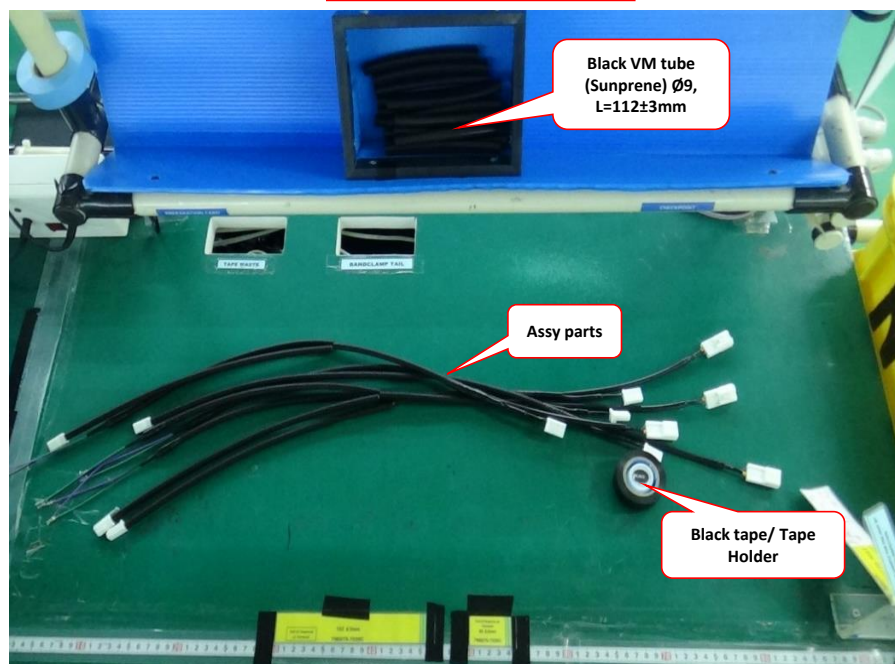
QUALITY POINTERS

1

P4

Table Lay-out

Table Lay-out



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.

1. No missing parts/tools.
2. no excess parts/tools.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

Revision History

Prepared by

Reviewed by

Approved by

Noted by

06/11/24

0

Initial Issue. Excluded process from P2 and P3 due to process improvement. Improved Measurement and Visual Inspection/ Quality checkpoint.

M. Ariola

C. Villanueva

A. Arañes

n/a

M. Ariola
C. Villanueva
A. Arañes

n/a

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

June 11, 2024

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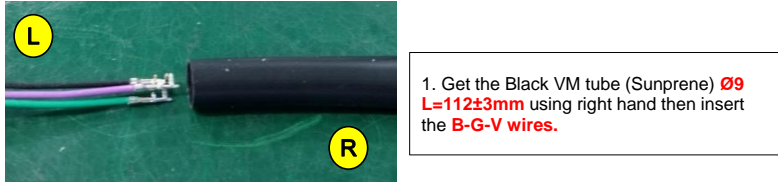
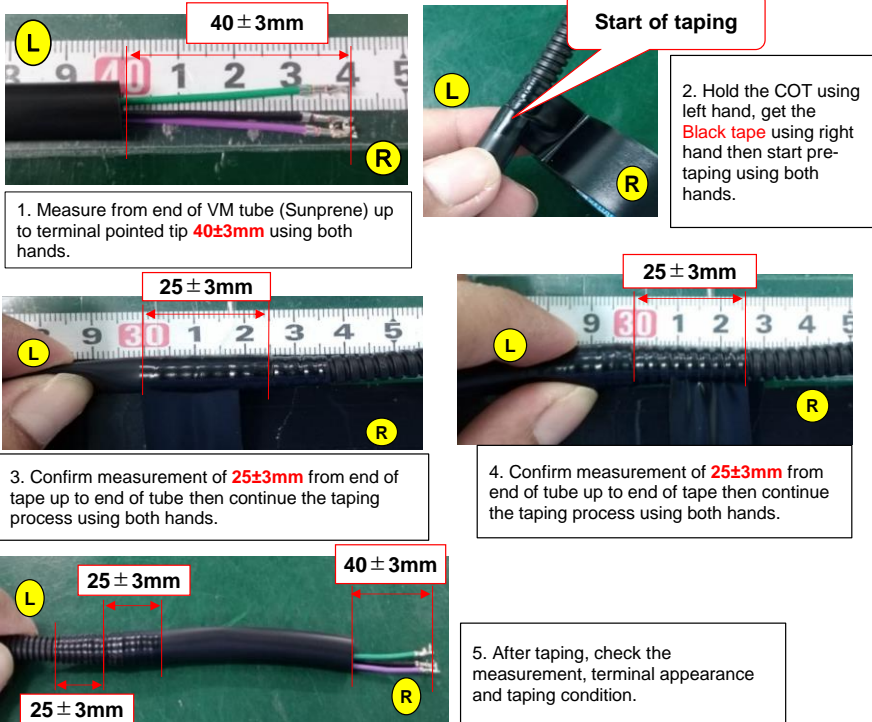

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PARTS:		1. Black VM tube (Sunprene) Ø9 L=112±3mm 2. Assy parts 3. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Black VM tube (Sunprene) Ø9 L=112±3mm			n/a	1. No wrong use of parts 2. No deformed terminal
3	P4 Taping 1 Black COT to Black sunprene tube near terminal				Important reminders/Note/s: <i>1. Please use calibrated/verified measuring tape when getting the measurement.</i> 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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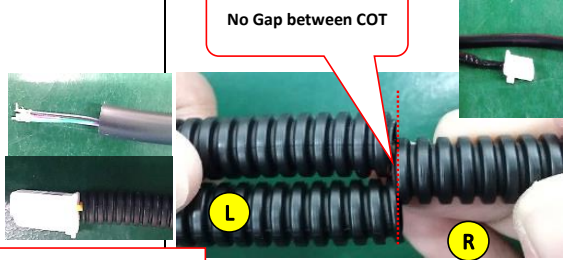

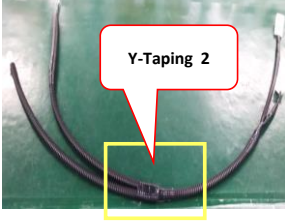
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PARTS:		1. Assy parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P4	Y-Taping 2	<div><p>No Gap between COT</p><p>Y-Taping orientation</p><p>1. Fix the corrugated tube .</p><p>taping direction</p><p>tape shifting 1/3 below</p><p>25±3mm</p><p>taping direction</p><p>tape shifting 1/2</p><p>4.Winding the tape backward 1/2 shifting.</p><p>2. Start taping at the middle of combined Corrugated tubes, then winding the tape going to 2 corrugated tubes, width must be 25±3mm.</p><p>3. Winding the tape 1/3 shifting until it reach the other side of corrugated tube, width must be 25mm.</p><p>Tape shifting 9mm below</p><p>25±3mm</p><p>25±3mm</p><p>5. Winding the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.</p><p>Note: Do not exert excessive force during pulling & winding of tape</p><p>25±3mm</p></div>	<div><p>MEASURING TAPE</p></div>	<div><p>Important reminders/Note/s:</p><p>1. Use YELLOW TAPE for easy visualization of shifting lines, But actual should BLACK TAPE.</p><p>2. Please use calibrated/verified measuring tape when getting the measurement.</p><p>Y-Taping 2</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></div>

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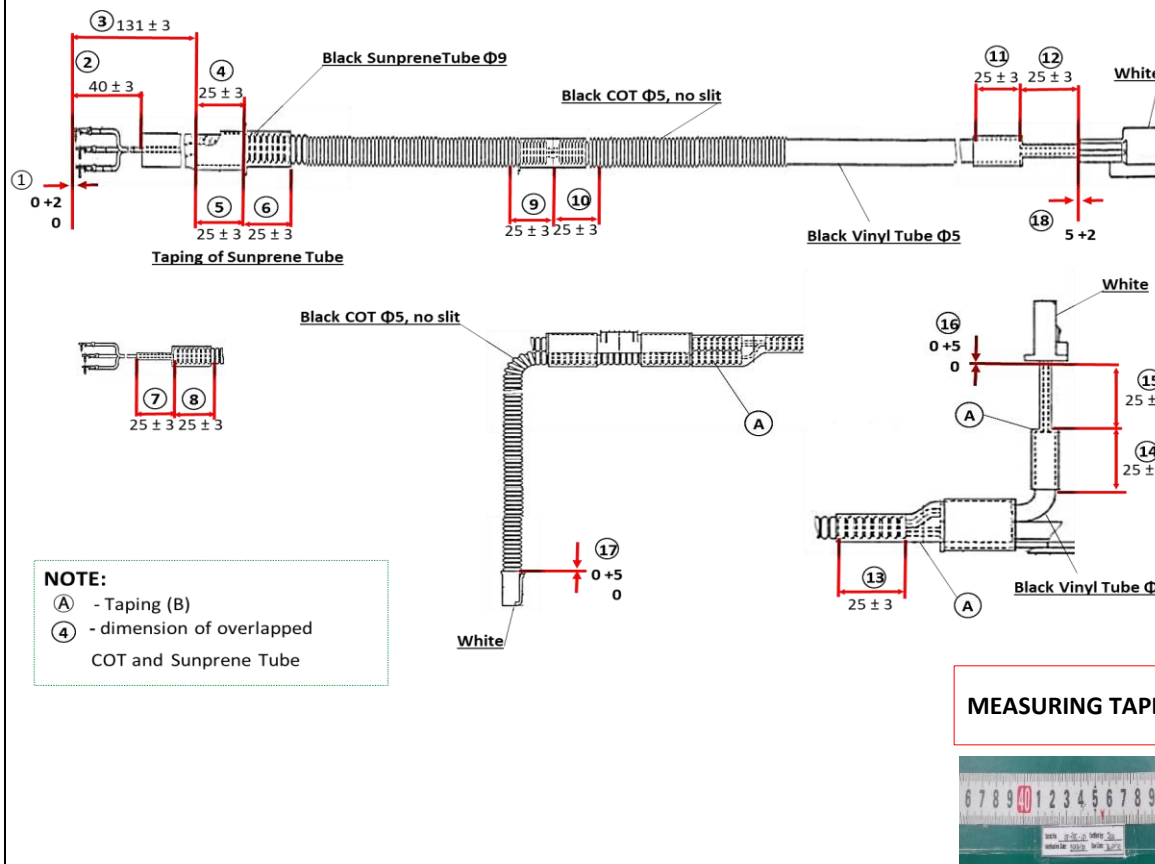
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PARTS:		n/a	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P4	Measurement		



1. No wrong dimension

Important reminders/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

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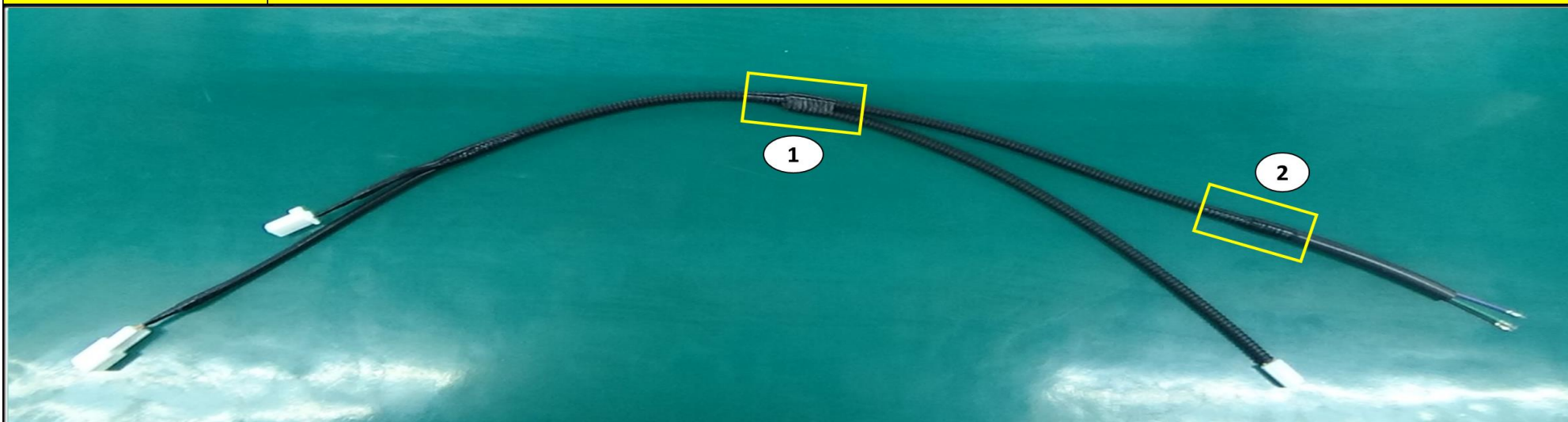
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PARTS:

1. Assy parts

JIG:

n/a

QUALITY CHECKPOINTS**P4****7N0070-7020C**

1

2

No Missing tape (Y taping)

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