


	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date:	January 16, 2025	
	Process Name/Title:				Validity Date:	n/a	
	Model code/Part number:	412D / 628128-0000A	Customer:	TRJ	Car Model:	LEXUS ES	
	Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO	Document No.:	WI-ENG-PDE-1173A			
					Revision No.:	1	Page No.: 1 of 13

PARTS:		1. Connector PARP-03V-E (L); Connector PARP-03V (W); AVSS 0.3 W wire L=314±2mm; AVSS 0.3 P-B wires L=268±2mm; N6GR VM tube (Sunprene) Ø4.5, L=184±3mm; Black VM tube (Sunprene) Ø4, L=78±3mm; Retainer (PMS-03V-S (W); AVSS 0.3 OR wire L=162±2mm; Connector 4A1330-0000 (W); Black VM tube (Sunprene) Ø6, L=47±3mm			JIG:	1. Insertion jig 2. Navigation
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
1	P1 Table lay-out	<div> <div>Connector 4A1330-0000 (W)/ Box</div> <div>TABLE LAY-OUT</div> <div>Black VM tube (Sunprene) Ø6, L=47±3mm/ Box</div> <div>2 layers Navigation</div> <div>Black VM tube (Sunprene) Ø4, L=78±3mm</div> <div>N6GR VM tube (Sunprene) Ø4.5, L=184±3mm</div> <div>Insertion jig (J1-B)</div> <div>Insertion jig (J1-A)</div> <div>Connector PARP-03V-E (L)</div> <div>Connector PARP-03V (W)</div> <div>Retainer (PMS-03V-S (W)</div> </div>			<div> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	1. No missing parts/tools 2. No excess parts/tools Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

Revision History							Prepared by	Reviewed by	Approved by	Noted by
										
01/16/25	1	Change document purpose from pre-launch to mass pro. Inclusion of table lay-out and insertion jig. Transfer to P2 process.	A.Hernandez	C. Villanueva	A.Arañes	n/a				
11/22/24	0	Initial issue.	A.Hernandez	C. Villanueva	A.Arañes	n/a	A.Hernandez	C. Villanueva	A.Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	November 22, 2024		

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Purpose:



PROTOTYPE



PRE-LAUNCH



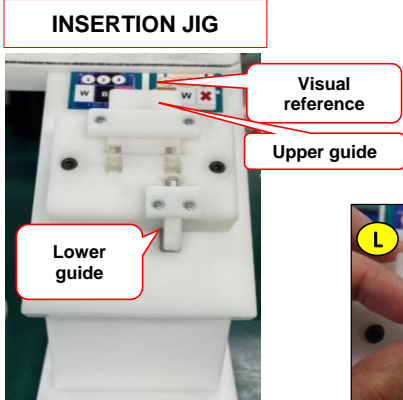
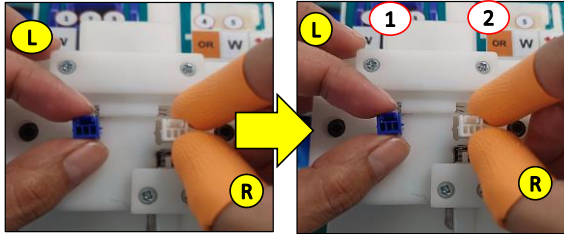


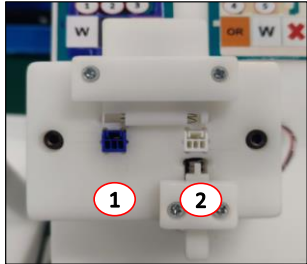
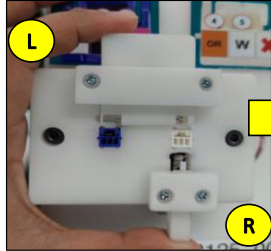
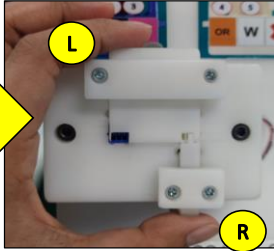
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PARTS:		1. Connector PARP-03V-E (L) 2. Connector PARP-03V (W)		JIG:	1. Insertion jig 2. Navigation
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<div><div>Connector setting to insertion jig Connector PARP-03V-E (L) and Connector PARP-03V (W)</div><div><div>INSERTION JIG</div><div></div><div><div>CONNECTOR ORIENTATION</div><div></div><div><div>STEERING NAVIGATION (2 layers)</div><div></div><div><div>CONTROLLER</div><div></div></div></div><div><div>1. Get 1pc. of connector PARP-03V-E (L) using left hand and 1pc. of Connector PARP-03V (W) then insert to insertion jig using both hands. <i>Note: Follow the connector orientation</i></div><div></div><div></div><div></div><div>3. Press the upper and lower guide using left hand in same timing. Holes that need to be insert are only open.</div></div></div></div></div>			1. Use the provided jig per model 2. No wrong usage of parts. 3. No wrong orientation of Connector. 4. No damaged connector.

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PARTS:

1. AVSS 0.3 W wire L=314±2mm
2. AVSS 0.3 P-B wires L=268±2mm

JIG:

1. Insertion jig
2. Navigation

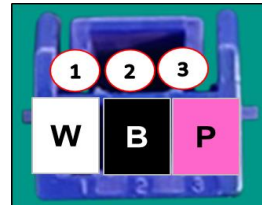
NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

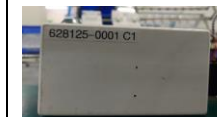
INSERTION SEQUENCE FROM LEFT
TO RIGHTTERMINAL
FACING

WIRE INSERTION ILLUSTRATION

1	2	3
W	B	P
314	268	268

STEERING NAVIGATION
(2 layers)

CONTROLLER



1. Use provided jig per model.
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion.
5. No deformed terminal
6. No stuck of terminal tip.

Important reminders/Note/s:

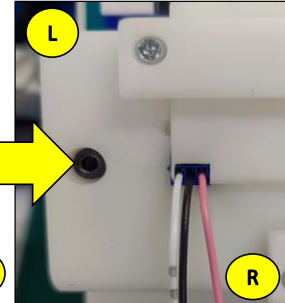
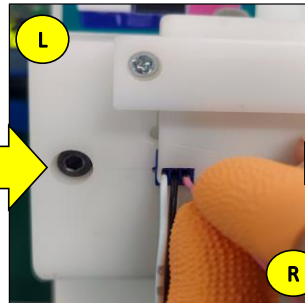
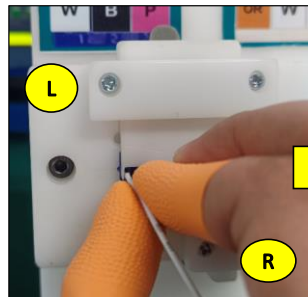
1. Please hold the wire near terminal.
2. Make sure wires are properly inserted.
- Conduct Pull-Push-Pull-Push after insertion.
- Do not exert extra force.
3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.
4. Insertion of wires must be from left to right.

Document references:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
2. Refer to WI-ENG-PDE-044 for the Steering Navigation Controller procedure.
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

3

P1

Wire insertion to
Connector PARP-03V (W)

1. Get the **W wire using left hand** and transfer to the right hand then insert to connector Conduct **2x** push pull after wire insertion. Repeat the process to **B and Pink wire**.
Note: Follow the insertion sequence based on the illustration.

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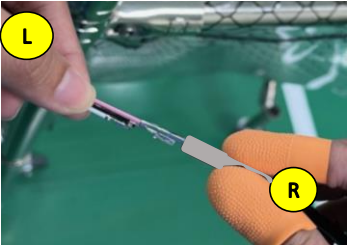
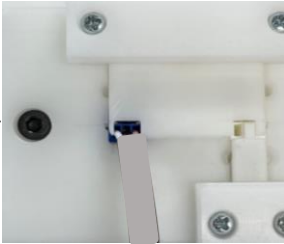
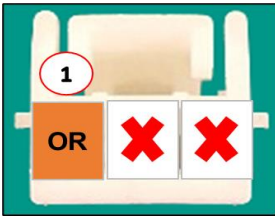


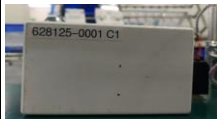
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PARTS:		1. Assy parts 2. Dark Brown VM tube (Sunprene) Ø4.5, L=184±3mm 3. Connector PARP-03V (W)		JIG:	1. Insertion jig 2. Navigation									
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS									
4	Wire insertion to N6GR VM tube (Sunprene) Ø4.5, L=184±3mm	<div><div></div><div></div><div>1. Hold the wires using left hand, get the N6GR VM tube (Sunprene) Ø4.5, L=184±3mm using right hand then insert the wires using left hands</div></div>		n/a	1. No wrong usage of parts. 2. No deformed terminal. 3. No tangled wires.									
5	P1 Wire insertion to Connector PARP-03V (W)	<div><div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div><div></div><div></div><div>TERMINAL FACING</div><div>WIRE INSERTION ILLUSTRATION</div><table><tr><td>1</td><td></td><td></td></tr><tr><td>OR</td><td>X</td><td>X</td></tr><tr><td>162</td><td></td><td></td></tr></table><div>1. Get the OR wire using right hand then insert to connector. Conduct 2x push pull after wire insertion. Note: Follow the insertion sequence based on the illustration.</div></div>		1			OR	X	X	162			<div>STEERING NAVIGATION (2 layers)</div> <div></div> <div>CONTROLLER</div> <div></div>	1. Use provided jig per model. 2. No wrong usage of parts 3. One by one insertion 4.No wrong insertion. 5. No deformed terminal 6. No stuck of terminal tip. Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector. 4. Insertion of wires must be from left to right. Document references: 1. Refer to WI-PRO-CNC-017 2. Refer to WI-ENG-PDE-044 for the Steering Navigation Controller procedure. 3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
1														
OR	X	X												
162														

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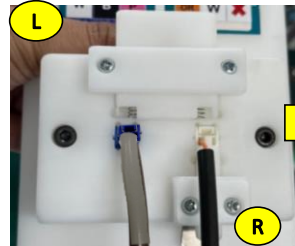
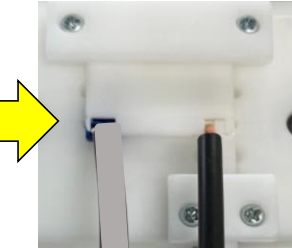
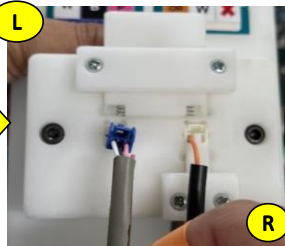
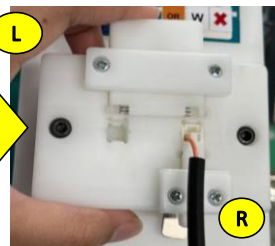
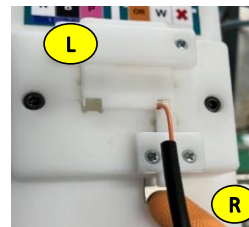
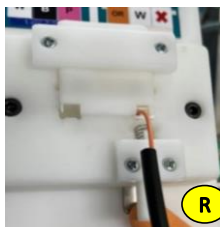
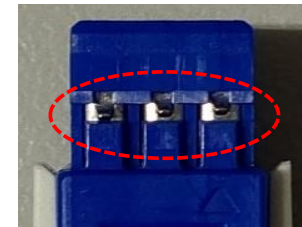
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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) Ø4, L=78±3mm		JIG:	1. Insertion jig 2. Navigation
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1	<div><div></div><div></div><div></div><div></div><div></div><div><p>1. Hold the wires using left hand, get the Black VM tube (Sunprene) Ø4, L=78±3mm using right hand then insert the wires using left hands</p><p>2. Press the upper button using both hands. Remove the 1st Connector with inserted wires using right hand. After removal of harness, Press the Upper guide using left hand. Note: Second connector with inserted wire and Black VM tube (Sunprene) should stay on the jig.</p><div><div></div><div></div><div><p>3. Press the lower button using right hand. Check the terminal tip condition, must be visible.</p></div></div></div><div><p>n/a</p></div><div><div><p>1. No wrong orientation of connector 2. No wrong use of parts 3. No deformed terminal 4. No wrong wire facing</p><p>Terminal tip must be visible.</p></div></div></div>			

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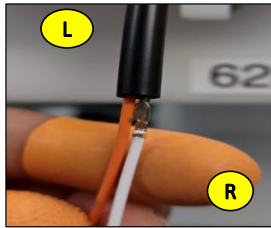
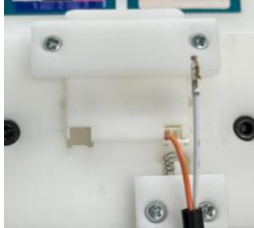
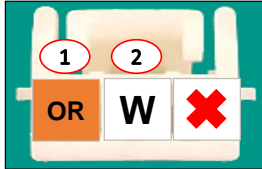
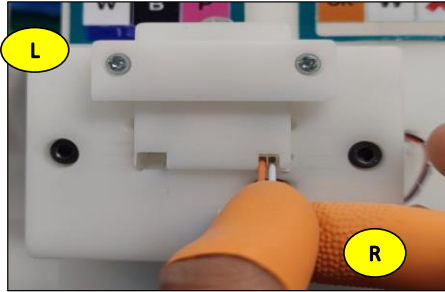
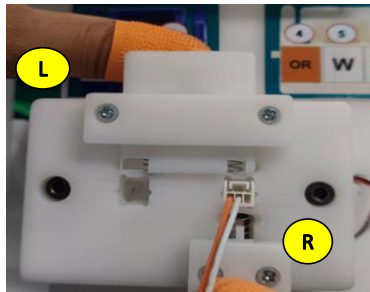



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PARTS:		1. Assy parts		JIG:	1. Insertion jig 2. Navigation
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	Wire insertion to Assy parts	  <div>1. Hold the Black VM tube (Sunprene) using left hand and insert the wire of assy parts using right hand.</div>		<div>STEERING NAVIGATION (2 layers)</div>	1. No wrong usage of parts. 2. No deformed terminal. 3. No tangled wires.
8	P1 Wire insertion to Connector PARP-03V (W)	<div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div>  <div>1 2 3 OR W X 177 399</div> <div>TERMINAL FACING</div> <div>WIRE INSERTION ILLUSTRATION</div>   <div>1. Get the W wire using right hand then insert to connector. Conduct 2x push pull after wire insertion. Note: Follow the insertion sequence based on the illustration.</div> <div>2. Press the upper button using left hand. Remove the 2nd connector with inserted wires using right hand. Check the terminal tip condition, must be visible.</div>		<div>CONTROLLER</div>  	1. Use provided jig per model. 2. No wrong usage of parts 3. One by one insertion 4. No wrong insertion. 5. No deformed terminal 6. No stuck of terminal tip. Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector. 4. Insertion of wires must be from left to right. Document references: 1. Refer to WI-PRO-CNC-017 2. Refer to WI-ENG-PDE-044 for the Steering Navigation Controller procedure. 3. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 

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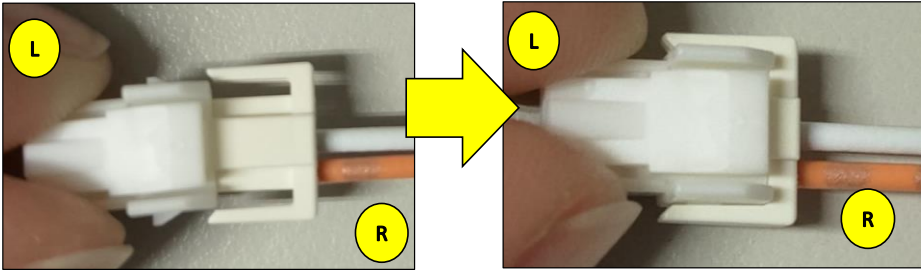
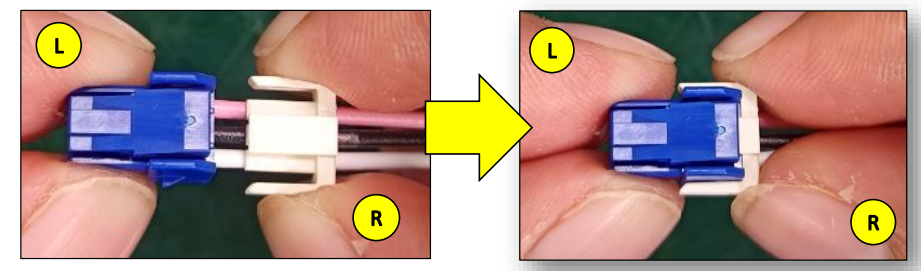
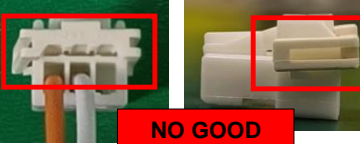
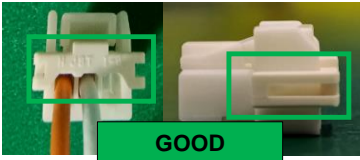
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PARTS:	1. Retainer (PMS-03V-S (W)) [2pcs] 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P1 Retainer attachment (PMS-03V-S (W))	<div></div> <div><p>1. Hold the Connector using left hand, get the Retainer PMS-03V-S (W) then insert the clamp using right hand.</p><p>Note: Sound will be heard if properly inserted.</p></div> <div></div> <div><p>2. Hold the Connector using left hand, get the Retainer PMS-03V-S (W) then insert the clamp using right hand.</p><p>Note: Sound will be heard if properly inserted. (After insertion, set aside the assy parts)</p></div>	n/a	<p>1. Retainer must be fully inserted 2. No missing retainers 3. No Unlock/halflocked</p> <div><p>RETAINER ORIENTATION</p></div>

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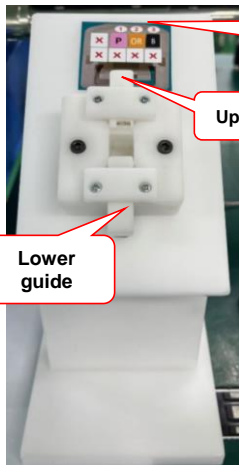
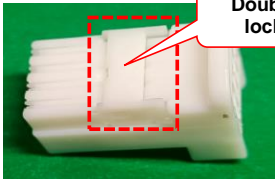
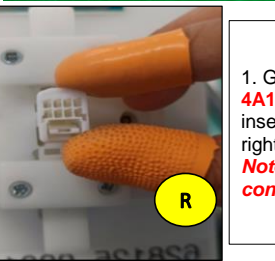
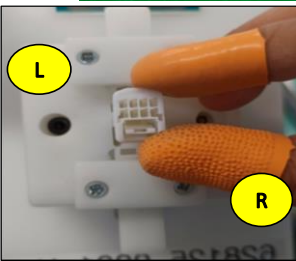
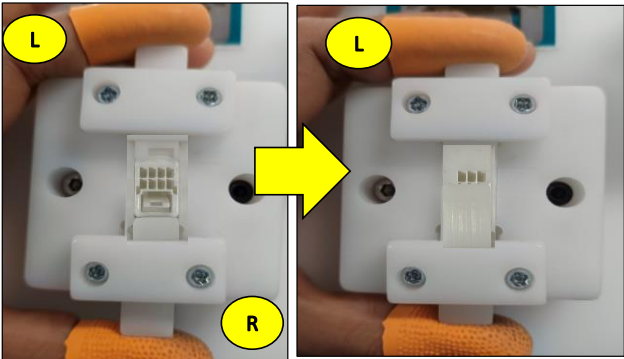
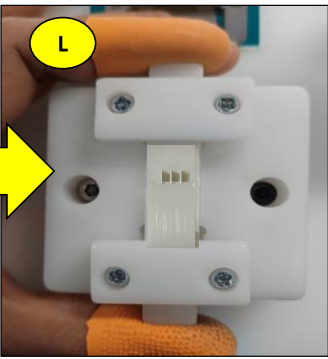
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PARTS:		1. Connector 4A1330-0000 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	P1	<div><div>INSERTION JIG</div><div></div><div></div><div></div><div></div><div></div><div></div><div>1. Get the Connector 4A1330-0000 (W) and insert to insertion jig using right hand. Note: Follow the connector orientation.</div><div>2. Press the upper and lower guide (same timing) using left hand. Holes to be insert are only open.</div></div>		n/a	<p>1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector.</p> <p>Important reminders/Note/s: 1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector. 2. Follow the connector orientation 3. Check the Connector before insertion.</p>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

January 16, 2025

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

412D / 628128-0000A

Customer: TRJ

Car Model:

LEXUS ES

Document No.:

WI-ENG-PDE-1173A

Purpose:



PROTOTYPE



PRE-LAUNCH



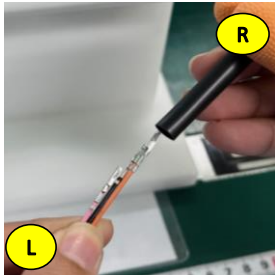


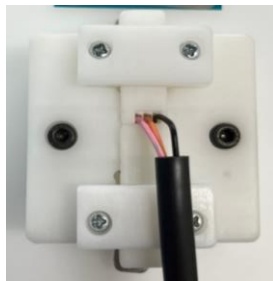
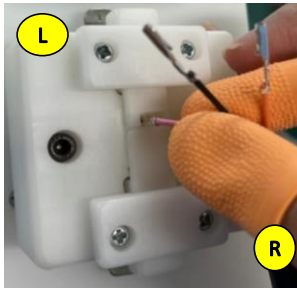
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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) Ø6, L=47±3mm		JIG:	1. Insertion jig																
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS																
11	Wire insertion Black VM tube (Sunprene) Ø6, L=47±3mm	<div></div> <div>1. Hold the wires of assy parts using right hand, get the Black VM tube (Sunprene) Ø6, L=47±3mm using left hand then insert the wires (Assy parts) using both hands.</div>		n/a	1. Use provided jig per model. 2. No wrong usage of parts 3. One by one insertion 4.No wrong insertion. 5. No deformed terminal 6. No stuck of terminal tip.																
12	P1 Wire insertion to Connector 4A1330-0000 (W)	<div><div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div></div> <div><div>WIRE INSERTION ILLUSTRATION</div><table><tr><td></td><td>1</td><td>2</td><td>3</td></tr><tr><td>X</td><td>P</td><td>OR</td><td>B</td></tr><tr><td></td><td>268</td><td>162</td><td>268</td></tr><tr><td>X</td><td>X</td><td>X</td><td>X</td></tr></table></div> <div><div>TERMINAL FACING</div></div> <div></div> <div>1. Insert the wires from Black VM tube (Sunprene). Hold the R wire and insert to terminal slot no.1 using right hand. Repeat the process for OR and B wires.</div>			1	2	3	X	P	OR	B		268	162	268	X	X	X	X	n/a	1. Use provided jig per model. 2. No wrong usage of parts 3. One by one insertion 4.No wrong insertion. 5. No deformed terminal 6. No stuck of terminal tip. Important reminders/Note/s: 1. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force. 2. Please hold the wires near terminal during insertion. 3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector. 4. Insertion of wires must be from left to right. Document reference/s: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.
	1	2	3																		
X	P	OR	B																		
	268	162	268																		
X	X	X	X																		

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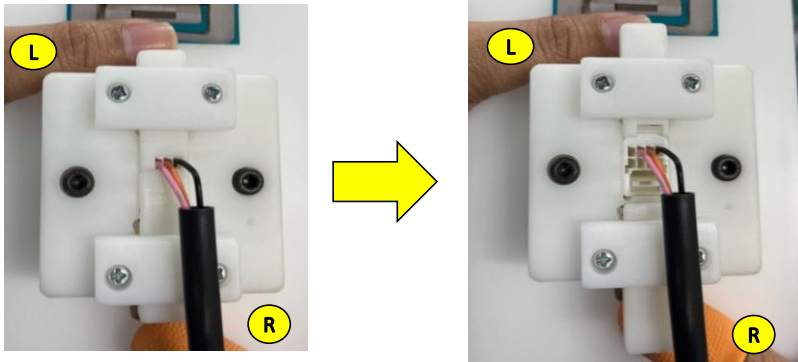
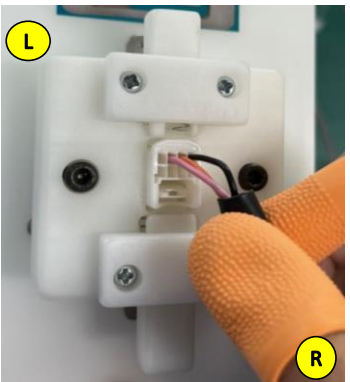
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PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
13	P1 Wire insertion to Connector 4A1330-0000 (W) (Continuation)	<div></div> <div>2. Press the upper and lower button (same timing) using both hands.</div> <div></div> <div>3. Remove the assy parts using right hand and check if the connector is totally locked.</div>		n/a	<div>1. Use provided jig per model. 2. No wrong usage of parts 3. One by one insertion 4.No wrong insertion. 5. No deformed terminal 6. No stuck of terminal tip.</div> <div>Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector. 4. Insertion of wires must be from left to right.</div> <div>Document reference/s: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</div>

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PRE-LAUNCH



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PARTS:

1. Assembled parts
2. Master sample

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

14

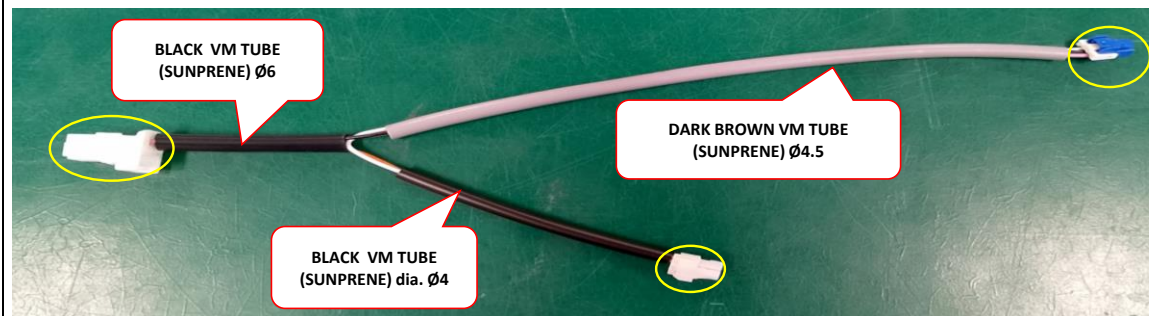
P1

Visual/By two's Inspection

1. Check the connector lock.
Locking of connector is included
in Steering Electrical test.

2. Check the wire alignment.
Must be no tangled wires.

3. Check the Terminal if with
Backing out (Not fully inserted) or
no deformed terminal.



4. Check the orientation of
harness.

5. Compare to **Master sample** by
tapping



1. No skip process during inspection.

Document reference/s:

1. Refer to WI-QAD-QAC-252 Steering
Electrical Test

MASTER SAMPLE



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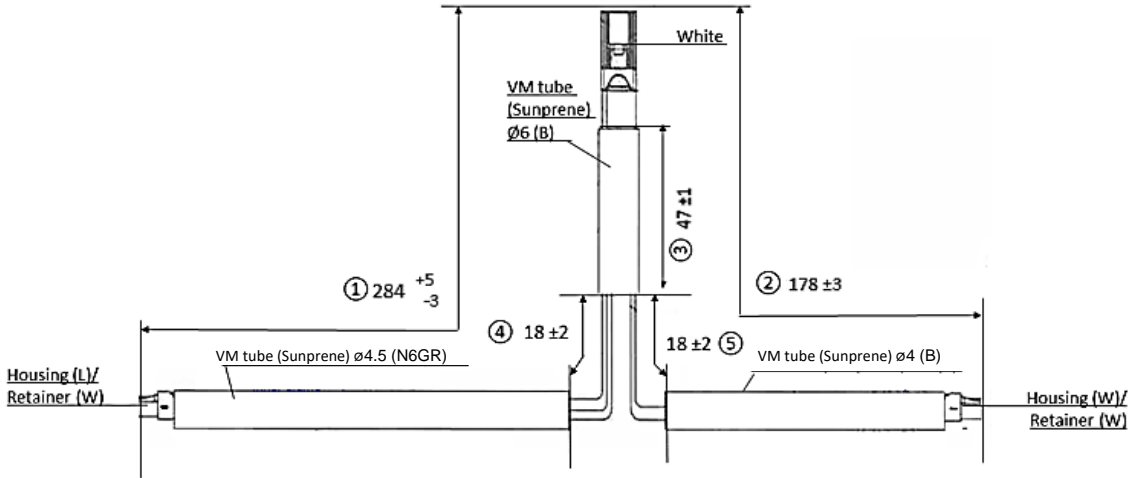
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
12	P1	Measurement	<div>MEASURING TAPE</div>  	<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting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

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