



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-460A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

5

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PARTS:

1. Assy parts; Connector 6098-3810(W); Connector 6098-3802(W); Black SV tube(Vinyl) Ø5 L=69±3mm; Black Corrugated tube Ø5 L=171±3mm; Black SV tube(Vinyl) Ø5 L=182±3mm; Black Corrugated tube Ø5 L=275±3mm; AVSSf 0.3 B-G L=679±3mm

JIG:

1. Terminal cover jig
2. Insertion jig with switch cover
3. Locking jig

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

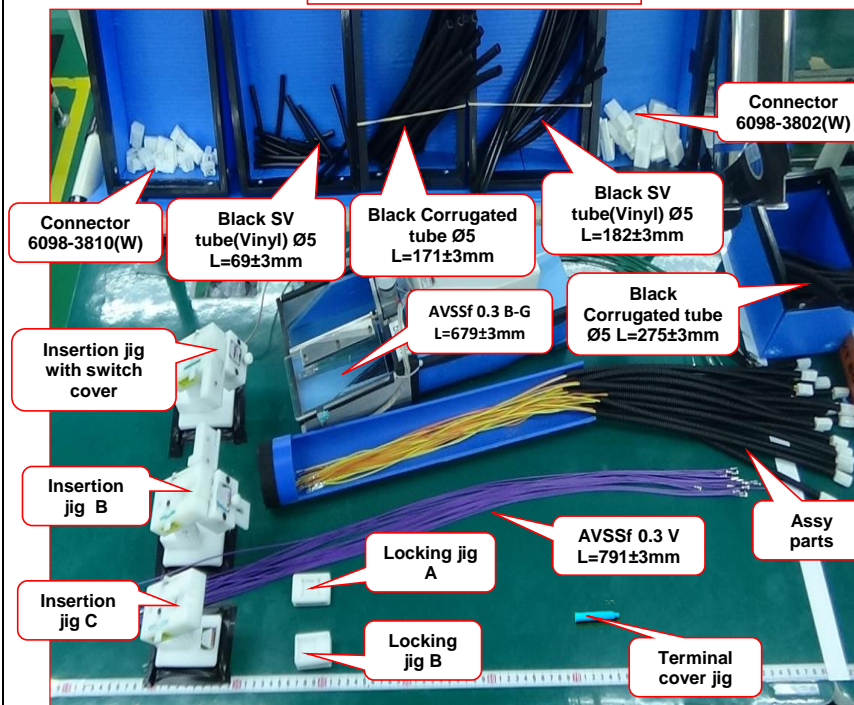
QUALITY POINTERS

1

P1

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.

Alert level

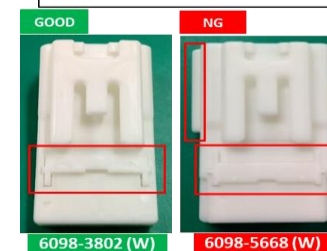
For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

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

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance

CONNECTOR ILLUSTRATION



CONNECTOR ILLUSTRATION



Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
06/11/24	5	Transferred to new format. Change MP from 4 to 5 (with offline). Transferred process of WI-ENG-PDE-528 to WI-ENG-PDE-460A; Removed process no.7 to 9 from WI-ENG-PDE-460A to WI-ENG-PDE-528, Change process sequence due to process improvement. Change table lay-out, Improve Measurement and Quality pointers.	M.Ariola	C. Villanueva	A.Arañes	n/a				
08/15/23	4	Change MP from 2MP to 3MP; Exluded process no. 2,3, 4 and 5 from OFFLINE ASSEMBLY PROCESS transfer to P1: Inclusion of locking process of connector 6098-2220 (W); Inclusion of Quality checkpoints on page no.18; Transfer process of 1,15;16 and 17 to P2; process no. 18 to P3 due to Change process distribution. Change table lay-out. Standardized tube description: SV tube (Vinyl); VM tube (Sunprene).	M.Ariola	J. Loterte	C. Villanueva	A.Arañes	M.Ariola	C. Villanueva	A.Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	April 12, 2022		

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Connector 6098-3810 (W)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	5 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1	<div>Connector setting to Insertion jig 6098-3810 (W)</div> <div><div>INSERTION JIG ORIENTATION</div><div><div><div>I-mark</div><div>Lock</div></div><div><div>Double lock</div></div><div>CONNECTOR ORIENTATION</div></div><div><div><div><div>↑</div><div>L</div><div>Press</div></div><div><div>↑</div><div>L</div><div>Press</div></div><div><div>↓</div><div>L</div><div>Release</div></div><div><div>R</div></div></div><div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6098-3810 (W) using right hand and release the lock using left hand. Note: Follow the connector orientation.</div><div><div><div><div>R</div><div>Holes</div></div><div><div>3. Push the guide using right thumb, hole for G wires will be opened.</div></div></div></div></div></div></div>	n/a	<div>1. Use the provided jig per model</div> <div>2. No wrong orientation of connector</div> <div>3. No wrong use of connector</div> <div>4. No damaged connector</div> <div>Connector Orientation Illustration</div> <div><div><div>I-mark was align</div><div>1 hole were only open</div><div>GOOD</div></div><div><div>I-mark is NOT align</div><div>1 hole were open</div><div>NG</div></div><div>CONNECTOR ILLUSTRATION</div><div><div><div>GOOD</div><div>6098-3810 (W)</div></div><div><div>NG</div><div>6098-5677 (W)</div></div></div></div>

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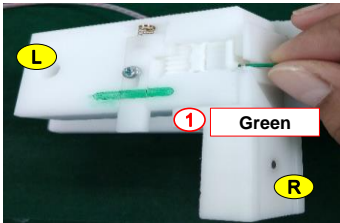
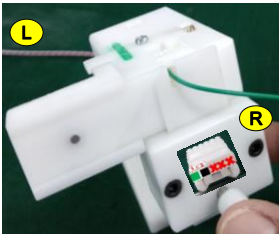
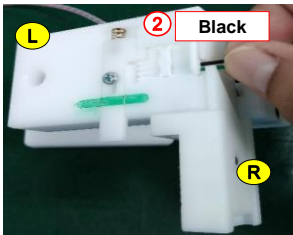
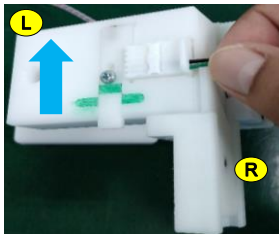
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PARTS:	1. AVSSf 0.3 G-B wires L=679±3mm			JIG:	1. Insertion jig
NO.	PROCESS NAME	5 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to Connector 6098-3810 (W)	<div><p>WIRE FACING</p></div> <div><p>1. Get the Green wire then insert to terminal slot 1 using right hand.</p></div> <div><p>2. Press the button using right thumb. The slot for B wires will be opened.</p></div> <div><p>3. Get the Black wire then insert to terminal slot 2 using right hand.</p></div> <div><p>4. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</p></div>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal during insertion. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 3. Insertion must be from left to right.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance. 2. Please refer to GL-PRO-ASY-029 for Pull-Push procedure</p>

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☐ PRE-LAUNCH

☒ MASSPRO

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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	5 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 <div>5 Connector lock</div>	<div><div><div><div><div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><di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PARTS:		1. Assy parts 2. Black SV tube (Vinyl) $\varnothing 5$ L=69 \pm 3mm		3. Black Corrugated tube $\varnothing 5$ L=171 \pm 3mm (No slit)		JIG:	1. Terminal cover jig
NO.	PROCESS NAME		5 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS
5	P1	<div>5</div> <div>Wire insertion to Black SV tube (Vinyl) $\varnothing 5$ L=69\pm3mm</div>	<div></div> <div>1. Get the Black SV tube (Vinyl) $\varnothing 5$ L=69\pm3mm using right hand then insert the G-B wires.</div>		n/a		1. No wrong use of parts 2. No deformed terminals.
6		<div>5</div> <div>Wire Insertion to Black Corrugated tube $\varnothing 5$ L=171\pm3mm (No Slit)</div>	<div></div> <div>1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the B-G-V wires using left hand.</div> <div></div> <div>2. Get the corrugated tube (no slit) $\varnothing 5$ L=171\pm3mm (no slit) using right hand then insert the B-G-V wires using left hand.</div>		<div>TERMINAL COVER JIG</div> <div></div>		<div>Document reference/s:</div> <div>1. Refer to WI-PRO-CNC-017 for Wire and Strip length Tolerance</div> <div>1. No wrong use of parts 2. No deformed terminal</div>

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WI-ENG-PDE-460A

Purpose:





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PARTS:		1. Assy parts	2.Black SV tube (Vinyl) Ø5 L=182±3mm	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1	 Wire insertion to corrugated tube L=171+3mm (no slit) (Assy Part)	 <div>1. Hold the assy part using left hand then insert Y-OR wires to corrugated tube L-171 ±3mm (Assy part) using right hand.</div>	n/a	1. No wrong use of parts 2. No deformed terminals.
8		 Wire insertion to Black SV tube (Vinyl) Ø5 L=182±3mm	 <div>1. Hold the Black SV tube (Vinyl) Ø5 L=182±3mm using right hand then insert (Y-OR and V wire) using left hand.</div>	n/a	1. No wrong use of parts 2. No deformed terminals

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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:

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Document No.:

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Purpose:

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PARTS:		1. Connector 6098-3802 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1	<div><div>CONNECTOR SETTING TO INSERTION JIG</div><div><div>INSERTION JIG</div><div>WIRE FACING</div><div>CONNECTOR ORIENTATION</div><div>INSERTION JIG ORIENTATION</div><div>Visual reference</div><div>I-mark</div><div>Lock</div></div><div><div>1. Press the Lock of insertion jig using left hand.</div><div>2. Get the connector 6098-3802 (W) using right hand and insert to insertion jig. Release the lock after insertion.</div><div>3. Push the lower wire guide upward using right hand. Slot for yellow wire will be open.</div></div></div>		n/a	<div><div>CONNECTOR ILLUSTRATION</div><div><div>GOOD</div><div>NG</div></div><div><div>6098-3802 (W)</div><div>6098-5668 (W)</div></div></div> <div>1. Use provided jig per model 2. No wrong orientation of connector</div>

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Model code/Part number: **900B/910B / 7N0070-7020C**Customer: **TRJ**Car Model: **LEXUS-NX/RX**

Document No.:

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Purpose:




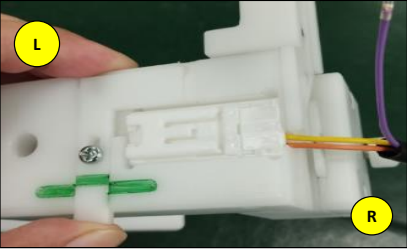
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PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	P1	<div><div>WIRE FACING</div></div> <div><div>1. Hold the insertion jig using left hand. Insert the Yellow wire to connector using right hand. <i>Note: Conduct Pull-Push-Pull-Push after insertion.</i></div></div> <div><div>2. Press the lower wire guide using right thumb. Slot for Orange wire will be open. <i>Note: Conduct Pull-Push-Pull-Push after insertion.</i></div></div> <div><div>3. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</div></div>		n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>Important reminders/Note/s: <i>1. Please hold the wire near terminal during insertion. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</i></div> <div>Document reference/s: <i>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i></div>

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Document No.:

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Purpose:

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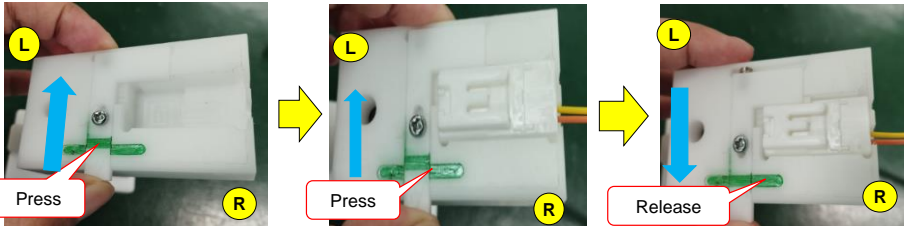


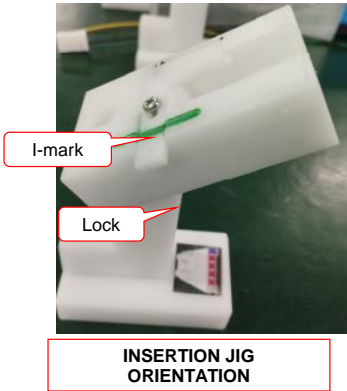
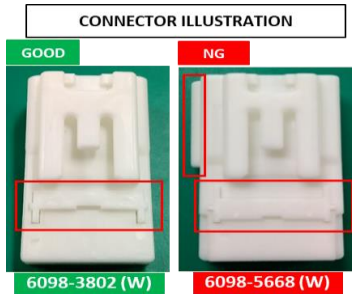
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PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1	<div><div>1. Press the Lock of insertion jig using left hand.</div><div>2. Get the connector 6098-3802 (W) using right hand and insert to insertion jig. Release the lock after insertion.</div></div>		n/a	<div><p>CONNECTOR ILLUSTRATION</p><p>1. Use provided jig per model 2. No wrong orientation of connector</p></div>

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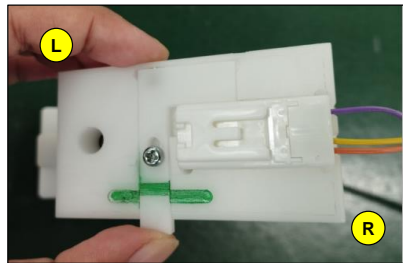
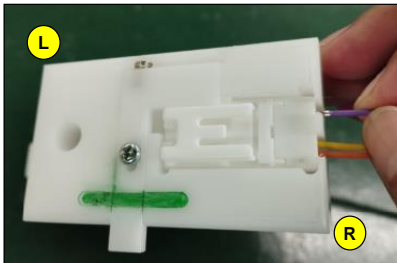
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PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
12	P1	<div></div> <div>1. Get the assy part and hold the Violet wire then insert to terminal connector using right hand. Note:Conduct Pull-Push-Pull-Push after insertion.</div> <div>2. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</div>		n/a	<p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal during insertion. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>Document reference/s:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p>

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Purpose:

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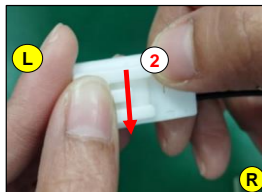
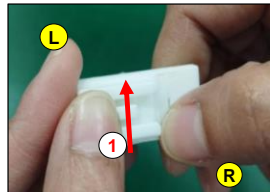
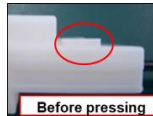



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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
13	P1 Connector lock	<div><div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div><div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div><div><p>Right thumb-Lower Left thumb-middle</p><p>3. Press the lower parts of connector using right hand while left hand holding the middle.</p></div><div><p>Right thumb-upper Left thumb-middle</p><p>4. Press the upper part of connector using right hand while left hand holding the middle.</p></div><div><p>Right thumb-middle Left thumb-middle</p><p>5. Lift then press the connector in the middle using left and right hand.</p></div><div><p>6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div></div>		n/a	<p>Important reminders/Note/s:</p> <p>1. Manual locking may cause damaged connector lock.</p> <p>1. Use the provided locking jig per model 2. No unlock/half-lock connector</p> <div><div><p>Before pressing</p></div><div><p>After pressing</p></div><div><div><p>GOOD Full Lock</p></div><div><p>NG Half Lock</p></div></div></div>

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PARTS:		1. Assy parts		JIG:	1. Terminal cocver jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
14	P1 5 Wire insertion to Black corrugated tube ø5 L=275±3mm (no slit)	 <p>1. Get the corrugated tube ø5 L=275±3mm (no slit) using right hand then insert the B-G-V wires using left hand.</p>  <p>2. After insertion, remove the terminal cover jig using right hand.</p>		<div>TERMINAL COVER JIG</div> 	1. No wrong use of parts 2. No Deformed terminal

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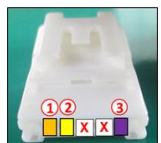
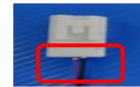
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**P1****7N0070-7020C****1****GOOD****NO GOOD****GOOD****NO GOOD****2****GOOD****NO GOOD****GOOD****GOOD****NO****NO****1** No **Wrong insert****3** No **Terminal Backing****2** No **Unlock/Halflock****4** No **Deformed terminal**

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