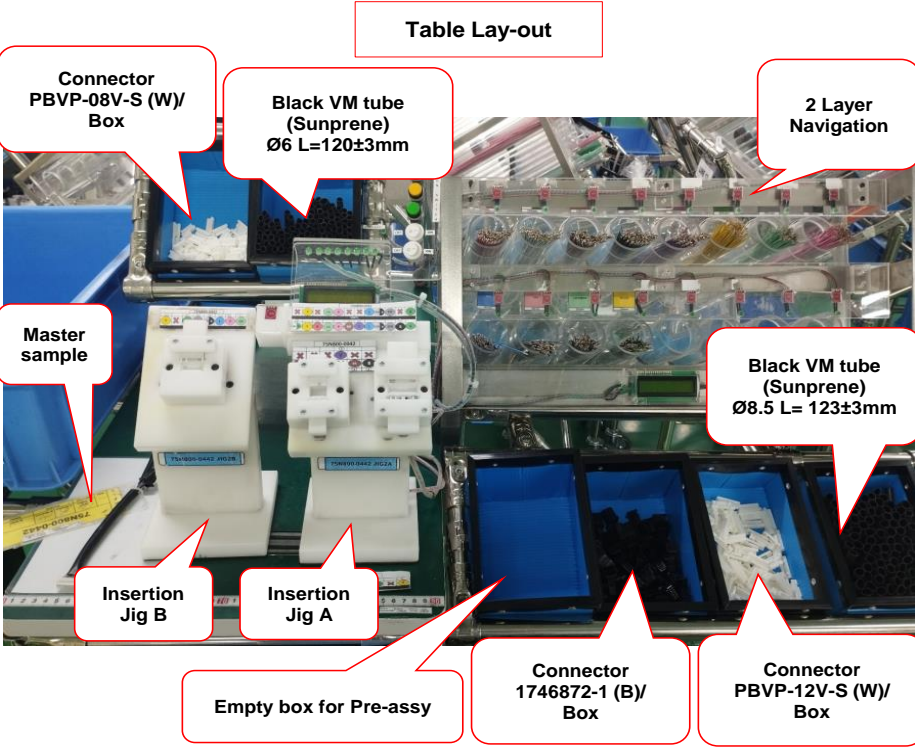
	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date:	February 04, 2025		
	Process Name/Title:				Validity Date:	n/a		
	Model code/Part number: 800B / 75N800-0442		Customer: TRJ	Car Model: LEXUS-NX	Document No.:	WI-ENG-PDE-131		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	8	Page No.:	1 of 17

PARTS:	1. Connector 1746872-1 (B); PBVP-12V-S (W); AVSS 0.3 R L=160±2mm; W/G L=160±2mm; BR L=160±2mm; B L=160±2mm; V L=160±2mm; G L=291±2mm; GR L=291±2mm; GR/B L=291±2mm; L L=291±2mm; P L=291±2mm; LG L=291±2mm; Y L=291±2mm; Black VM tube (Sunprene) Ø8.5 L=123±3mm; Black VM tube (Sunprene) Ø6 L=120±3mm; Connector PBVP-08V-S (W)			JIG:	1. Insertion jig 2. Steering navigator
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1 Table lay-out			<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No deformed terminal 2. No wrong usage of parts</p>

Revision History				Prepared by	Reviewed by	Approved by	Noted by
02/04/25	8	Change connector, terminal orientation and color sequence, improved the insertion jig as costumer claim countermeasure. Update Work procedue/Illustration and quality checkpionts. Incusion of table lay-out and inclusion of empty box for location of assy parts as countermeasure to customer claim. Improved Work procedure of Measurement.	D. Castillo	C. Villanueva	A. Arañes	n/a	
04/06/23	7	Improve the insertion jig and the procedure.	D. Castillo	J. Loterte	C. Villanueva	A. Arañes	
01/19/23	6	Changed term of Black sunprene tube to Black VM tube (Sunprene). Additional Quality pointers.	D. Castillo	J. Loterte	C. Villanueva	A. Arañes	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: June 24, 2020

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

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Model code/Part number:

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☐ PROTOTYPE

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PARTS:

1. Connector 1746872-1 (B)
2. PBVP-12V-S (W)

JIG:

1. Insertion jig
2. Steering navigator

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

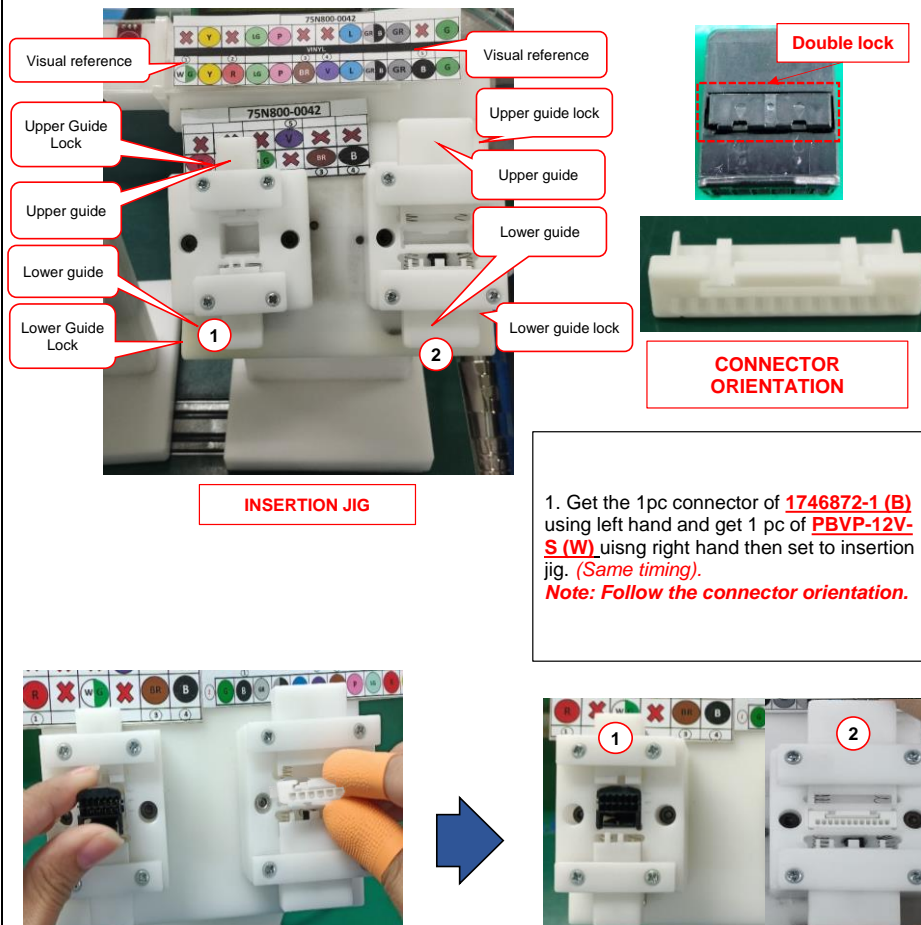
TOOLS/PPE

QUALITY POINTERS

2

P1

Connector setting to
insertion jig
1746872-1 (B)
PBVP-12V-S (W)



Double lock

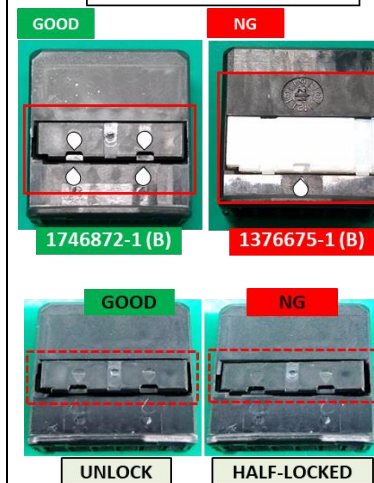
CONNECTOR
ORIENTATION

STEERING
NAVIGATION(2 layer)

CONTROLLER

- Important reminders/Note/s:**
1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.
 2. Check the connector before insertion.

CONNECTOR ILLUSTRATION



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Purpose:

☐ PROTOTYPE

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PARTS:

1. AVSS 0.3 R L=160±2mm; W/G L=160±2mm; BR L=160±2mm; B L=160±2mm; V L=160±2mm

JIG:

1. Insertion jig
2. Steering navigator

NO.

PROCESS NAME

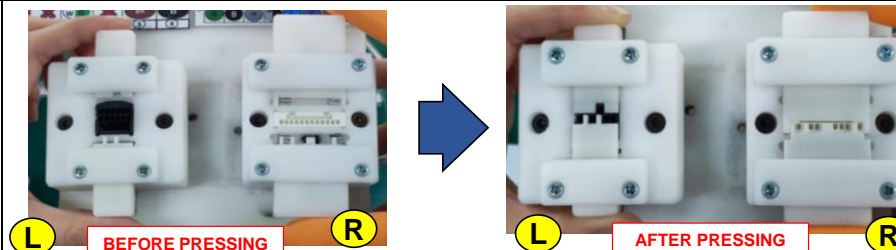
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

8

Connector setting to
insertion jig
1746872-1 (B)
PBVP-12V-S (W)
(Continuation)



2. Press the upper and lower guide using both hands same timing. Holes that need to be insert are only open.

STEERING
NAVIGATION(2 layer)



CONTROLLER



1. Use the provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No damaged connector

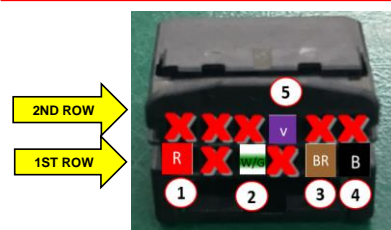
1. Use provided jig per model
2. No wrong usage of parts
3. No wrong insertion
4. No deformed terminal
5. No stuck of terminal tip
6. One by one insertion.

P1

Wire insertion to connector
1746872-1 (B)

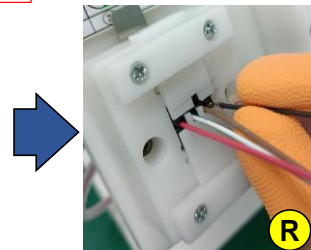
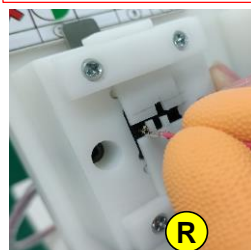
INSERTION SEQUENCE FROM LEFT TO RIGHT

WIRE INSERTION ILLUSTRATION



X	X	X	5	X	X
1		2	V	3	4
R	X	W/G	X	BR	B
160		160		160	160

FIRST ROW (LEFT TO RIGHT)



1. Get the **R wire** using right hand and insert to terminal **slot 1**. Repeat the process for **W/G-BR-B wires**.
Note: Follow the insertion sequence based on the illustration.

TERMINAL
FACING

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Model code/Part number:

800B / 75N800-0442

Customer:

TRJ

Car Model:

LEXUS-NX

Document No.:

WI-ENG-PDE-131

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:

1. AVSS 0.3 R L=160±2mm; W/G L=160±2mm; BR L=160±2mm; B L=160±2mm; V L=160±2mm

JIG:

1. Insertion jig
2. Steering navigator

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

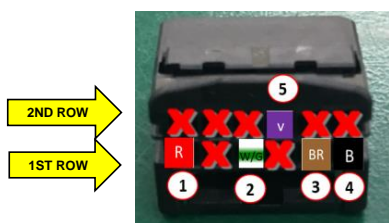
3

P1

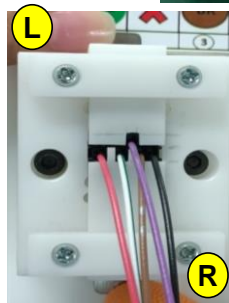
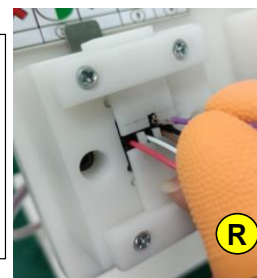
Wire insertion to connector
1746872-1 (B)
(Continuation)

INSERTION SEQUENCE FROM LEFT
TO RIGHT

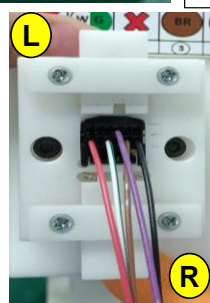
SECOND ROW (LEFT TO RIGHT)



2. Get the **V wire**
using right hand and
insert to terminal **slot**
5.
Note: Follow the
insertion sequence
based on the
illustration.



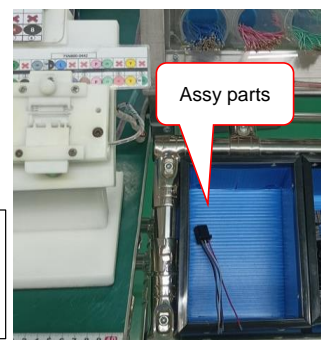
BEFORE PRESSING



AFTER PRESSING

3. Press the upper and lower guide lock with both
hands (**same timing**). Hold the wires using right
hand and gently pull out the connector from jig.
Note: Please see above illustration

4. After removal to insertion jig, put
the assy parts to empty box.
Note: Follow the illustration.



STEERING
NAVIGATION(2 layer)



CONTROLLER



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

Important reminders/Note/s:

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. Automatically dispose and replace the unit if once encountered bend terminal and difficulty of insertion and half locked connector.

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
3. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.

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TAPING ASSEMBLY PROCESS

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800B / 75N800-0442

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TRJ

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Purpose:



PROTOTYPE



PRE-LAUNCH



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PARTS:

1. AVSS 0.3 G L=291±2mm; GR L=291±2mm; GR/B L=291±2mm; L L=291±2mm; P L=291±2mm; LG L=291±2mm; Y L=291±2mm

JIG:

1. Insertion jig
2. Steering navigator

NO.

PROCESS NAME

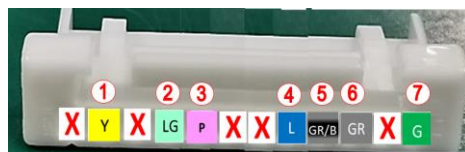
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

8

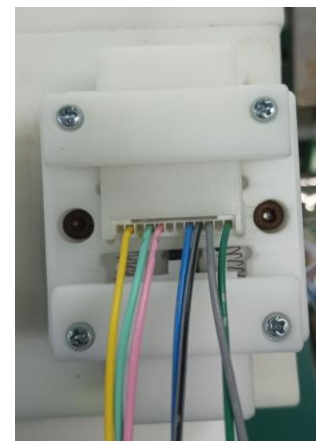
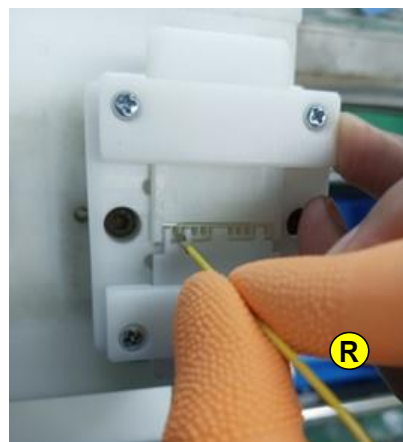
INSERTION SEQUENCE FROM LEFT TO RIGHT



TERMINAL FACING

WIRE INSERTION ILLUSTRATION

	1		2	3			4	5	6		7
X	Y	X	LG	P	X	X	L	GR/B	GR	X	G
	291		291	291			291	291	291		291



1. Get the **Y wire** using right hand and insert to connector. Repeat the process for **LG-P-L-GR/B-GR-G**.
Note: Follow the insertion sequence based on above illustration.

STEERING
NAVIGATION(2 layer)

CONTROLLER



Important reminders/Note/s:

1. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** 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:

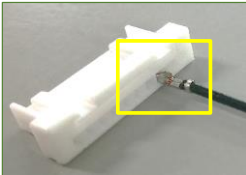

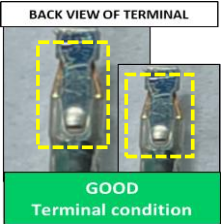
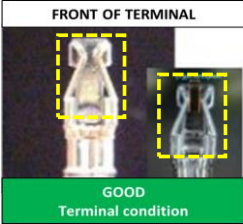
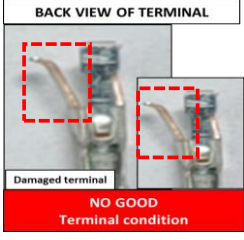
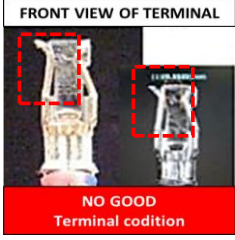
1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
4. . Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.

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	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 800B / 75N800-0442		Customer: TRJ	Car Model: LEXUS-NX	Document No.:	WI-ENG-PDE-131		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	8	Page No.:	6 of 17


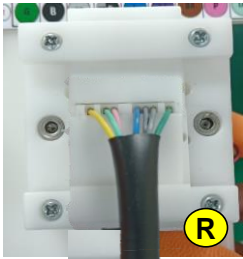


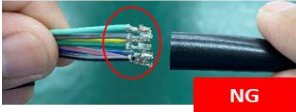

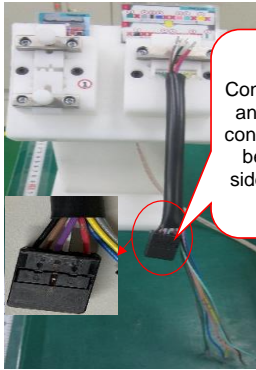

PARTS:	1. AVSS 0.3 G L=291±2mm; GR L=291±2mm; GR/B L=291±2mm; L L=291±2mm; P L=291±2mm; LG L=291±2mm; Y L=291±2mm		JIG:	1. Insertion jig 2. Steering navigator
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1 Wire insertion to connector PBVP-12V-S (W) (Continuation)	<div>Proper alignment of terminal to connector</div>  <div>Improper alignment of terminal to connector</div>  <div>BACK VIEW OF TERMINAL</div>  <div>GOOD Terminal condition</div> <div>FRONT OF TERMINAL</div>  <div>GOOD Terminal condition</div> <div>BACK VIEW OF TERMINAL</div>  <div>Damaged terminal NO GOOD Terminal condition</div> <div>FRONT VIEW OF TERMINAL</div>  <div>NO GOOD Terminal condition</div> <div>Note: *Make sure the terminal was in proper alignment before insert. *Avoid hitting the terminal into the connector during wire insertion, if encountered abnormality stop the process and call the attention of Immediate superior and Automatically disposed and replace the unit.</div>		<div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong insertion 4. No deformed terminal 5. No stuck of terminal tip 6. One by one insertion</div> <div>Important reminders/Note/s:</div> <div>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push 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.</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance. 2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.. 3. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</div>

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	Process Name/Title:		Model code/Part number: 800B / 75N800-0442	Customer: TRJ	Car Model: LEXUS-NX	Document No.:	WI-ENG-PDE-131	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	8	Page No.:

PARTS:	1. Assy parts 2. Black VM tube (Sunprene) Ø8.5 L=123±3mm			JIG:	1. Insertion jig 2. Steering navigator		
NO.	PROCESS NAME	<div>8</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
5	P1 Wire insertion to Black VM tube (Sunprene) Ø8.5 L=123±3mm	<div><div>1. Hold the wires using left hand, get the Black VM tube (Sunprene) Ø8.5 L=123±3mm using right hand then insert the wires using left hand.</div><div>2. Press the lower guide lock using right hand. Holes that need to be insert are only open.</div></div> <div></div>		<div>1. No wrong usage of parts 2. No deformed terminal</div> <div>Important reminders/Note/s: 1. Wires must be offset with each other.</div> <div></div>			
6	P1 Wire insertion to Black VM tube (Sunprene) Ø8.5 L=123±3mm (Assy Parts)	<div><div>1. Hold the Black VM tube (Sunprene) using left hand and get the assy part then insert the wires using right hand.</div><div>Connector facing and position of connector should be on the left side of harness.</div></div>	n/a	<div>1. No wrong usage of parts 2. No deformed terminal</div>			

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PROTOTYPE



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PARTS:

1. Assy parts

JIG:

1. Insertion jig
2. Steering navigator

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

8

INSERTION SEQUENCE FROM LEFT TO RIGHT



WIRE FACING



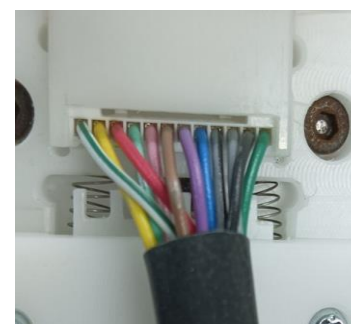
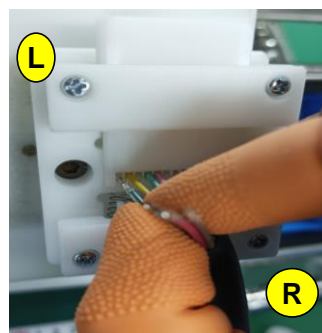
WIRE INSERTION ILLUSTRATION

1		2			3	4				5	
W/G	Y	R	LG	P	BR	V	L	GR/B	GR	B	G
160	291	160	291	291	160	160	291	291	291	160	291

7

P1

Wire insertion to connector PBVP-12V-S (W)



1. Hold the **W/G wire** using right hand and support the wire by the left index finger then insert to connector at slot **1** using right hand. Repeat the process for **R_BR-V-B wires**
Note: Follow the insertion sequence based on the illustration.

STEERING NAVIGATION(2 layer)



CONTROLLER



Important reminders/Note/s:

1. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** 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 WI-PRO-CNC-017 for Wire and Strip Length Tolerance.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
4. . Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.

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800B / 75N800-0442

Customer: TRJ

Car Model:

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Document No.:

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Purpose:



PROTOTYPE



PRE-LAUNCH



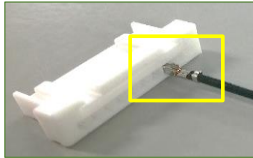
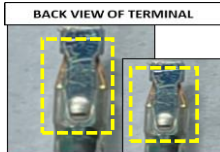
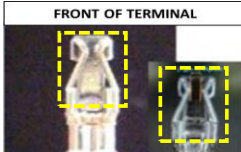

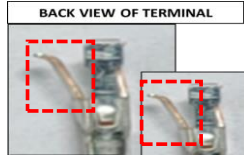
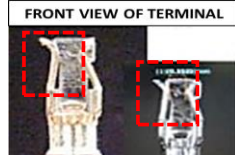


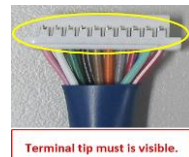
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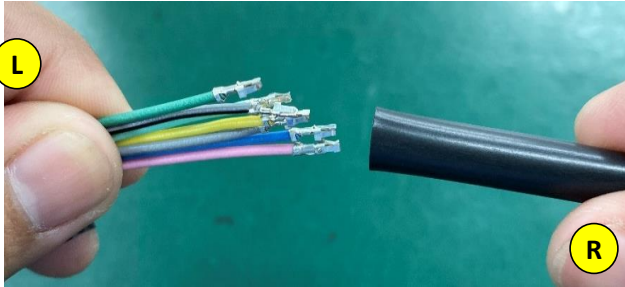


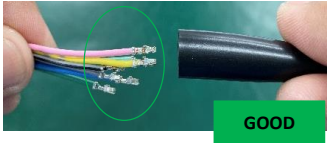
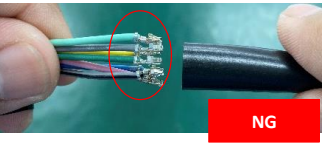
PARTS:	1. Assy parts		JIG:	1. Insertion jig 2. Steering navigator	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1 Wire insertion to connector PBVP-12V-S (W) (Continuation)	<div><div>Proper alignment of terminal to connector</div><div>BACK VIEW OF TERMINAL</div><div>GOOD Terminal condition</div><div>FRONT OF TERMINAL</div><div>GOOD Terminal condition</div></div> <div><div>Improper alignment of terminal to connector</div><div>BACK VIEW OF TERMINAL</div><div>Damaged terminal NO GOOD Terminal condition</div><div>FRONT VIEW OF TERMINAL</div><div>NO GOOD Terminal condition</div></div> <div>Note: *Make sure the terminal was in proper alignment before insert. *Avoid hitting the terminal into the connector during wire insertion, if encountered abnormality stop the process and call the attention of Immediate superior and Automatically disposed and replace the unit.</div> <div><div><div>2. Hold the wires using right hand and then press the unlock button using left thumb.</div></div><div><div>3. Gently pull out the connector from jig then check the terminal tip condition.</div></div></div>			<div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong insertion 4. No deformed terminal 5. No stuck of terminal tip 6. One by one insertion</div> <div>Important reminders/Note/s:</div> <div><div>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div><div>2. Please hold the wires near terminal during insertion.</div><div>3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</div><div>4. Insertion of wires must be from left to right.</div></div> <div>Document reference/s:</div> <div><div>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</div><div>2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..</div><div>3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div><div>4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</div></div> <div><div>Terminal tip must be visible.</div></div>

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	WORK INSTRUCTION			Effectivity Date:	February 04, 2025		
	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Process Name/Title:			Document No.:	WI-ENG-PDE-131		
	Model code/Part number: 800B / 75N800-0442		Customer: TRJ	Car Model: LEXUS-NX	Revision No.: 8 Page No.: 10 of 17		
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO							


PARTS:		1. Black VM tube (Sunprene) Ø6 L=120±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
8	P1 Wire insertion to Black VM tube (Sunprene) Ø6 L=120±3mm	<div><div></div><div><p>1. Get the Black VM tube (Sunprene) Ø6 L=120±3mm using right hand then insert the wires using left hand.</p></div><div></div><div><p>2. After insertion, check the terminal appearance and then set aside the assy parts.</p></div></div> <div></div>	n/a	<p>Important reminders/Note/s:</p> <p>1. Wires must be offset with each other.</p> <div>GOOD</div> <div>NG</div> <p>1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires</p>	




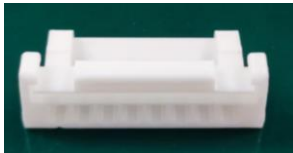
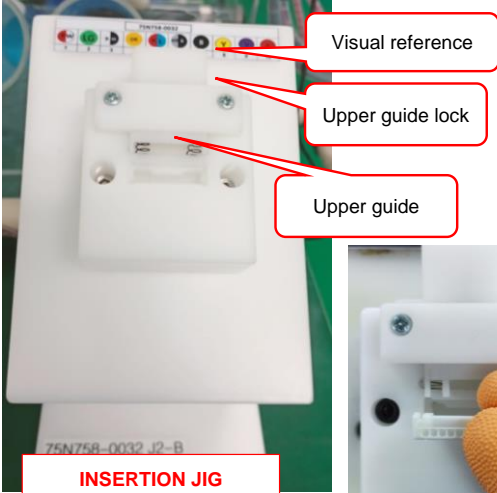
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	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 800B / 75N800-0442		Customer: TRJ	Car Model: LEXUS-NX	Document No.:	WI-ENG-PDE-131	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	8	Page No.:	11 of 17

PARTS:	1. Connector PVBVP-08V-S (W)			JIG:	1. Insertion jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
9	P1 <div>8</div> Connector setting to insertion jig PVBVP-08V-S (W)	<div><div>1. Get the connector PBVP-08V-S (W) and insert to insertion jig using right hand. Note: Follow the connector orientation.</div><div>2. Press the upper guide using left hand. You will notice the holes that needs to be inserted are only open.</div></div> <div>N/A</div>			<div>1. Use provided jig per model</div> <div>2. No wrong usage of parts</div> <div>3. No wrong insertion</div> <div>4. No deformed terminal</div> <div>5. No stuck of terminal tip</div> <div>6. One by one insertion</div>			

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TAPING ASSEMBLY PROCESS

Effectivity Date:

February 04, 2025

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Customer:

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Car Model:

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Purpose:



PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Assy parts

JIG:

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

10

P1

Wire insertion to
connector
PBVP-08V-S (W)

INSERTION SEQUENCE FROM LEFT TO RIGHT

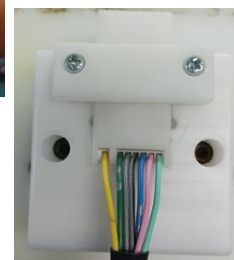
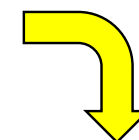
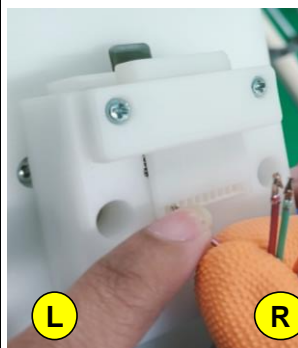


WIRE FACING



WIRE INSERTION ILLUSTRATION

1	2	3	4	5	6	7	10
Y	X	G	GR	GR/B	L	P	LG
291		291	291	291	291	291	291



1. Hold the **Y** wire using right hand and support the wire by the left index finger then insert to connector at slot **1** using right hand. Repeat the process for **G-GR-GR/B-L-P-LG** wires
Note: Follow the insertion sequence based on the illustration.

N/A

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

Important reminders/Note/s:

1. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** 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 WI-PRO-CNC-017 for Wire and Strip Length Tolerance.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
4. . Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.

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Purpose:



PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Assy parts

JIG:

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

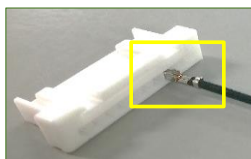
QUALITY POINTERS

10

P1

Wire insertion to connector
PBVP-08V-S (W)
(Continuation)

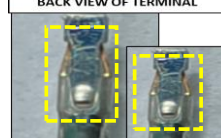
Proper alignment of terminal to connector



Improper alignment of terminal to connector

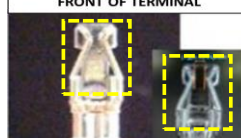


BACK VIEW OF TERMINAL



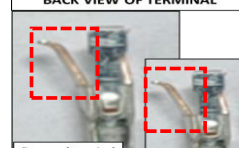
GOOD
Terminal condition

FRONT OF TERMINAL



GOOD
Terminal condition

BACK VIEW OF TERMINAL



Damaged terminal
NO GOOD
Terminal condition

FRONT VIEW OF TERMINAL

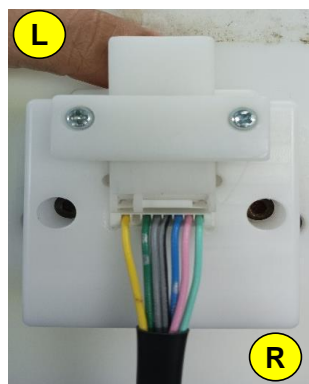


NO GOOD
Terminal condition

Note:

***Make sure the terminal was in proper alignment before insert.**

***Avoid hitting the terminal into the connector during wire insertion, if encountered abnormality stop the process and call the attention of Immediate superior and Automatically disposed and replace the unit.**



2. Hold the wires using right hand and then press the unlock button using left thumb.



3. Gently pull out the connector from jig then check the terminal tip condition.

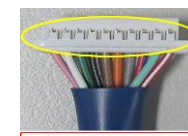
1. Use provided jig per model
2. No wrong usage of parts
3. No wrong insertion
4. No deformed terminal
5. No stuck of terminal tip
6. One by one insertion

Important reminders/Note/s:

1. **Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push 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 WI-PRO-CNC-017 for Wire and Strip Length Tolerance.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.



Terminal tip must be visible.

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PARTS:

1. Assy parts

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

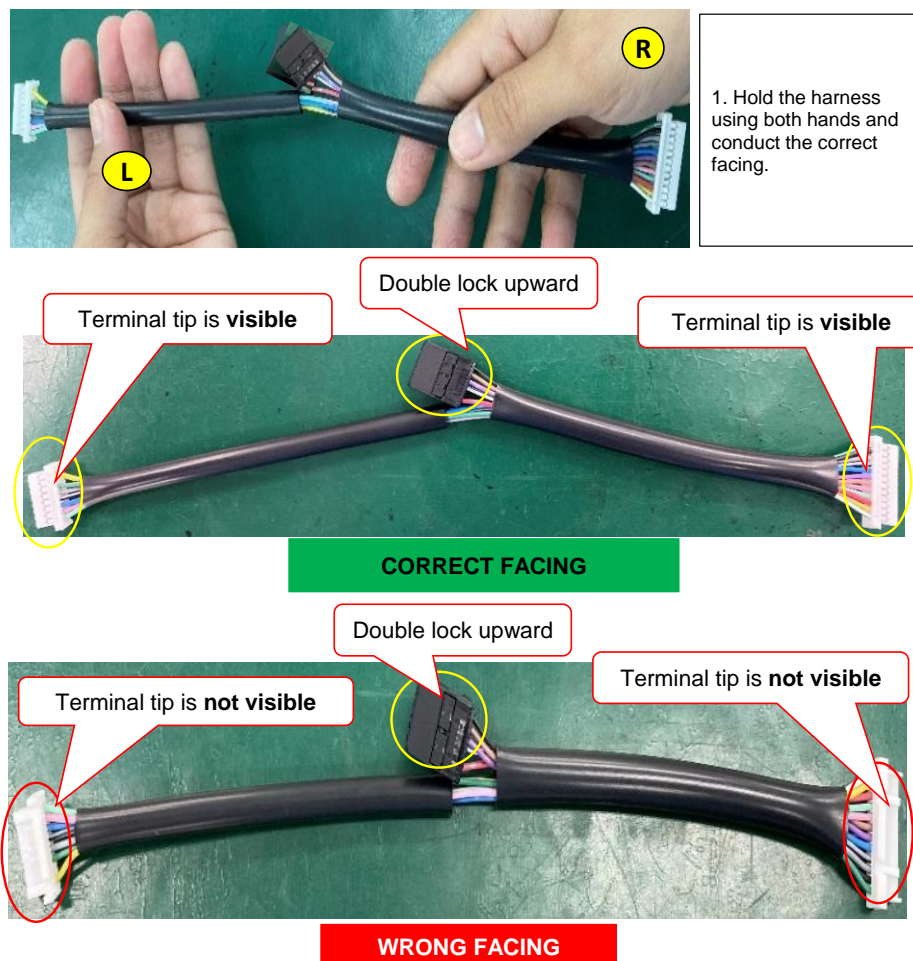
TOOLS/PPE

QUALITY POINTERS

11

P1

Wire arrangement



1. Hold the harness using both hands and conduct the correct facing.

Important reminders/Note/s:

1. Harness must be straight and not folded.

1. No wrong facing
2. No tangled wires

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Purpose:



PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Assy parst

JIG:

n/a

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

12

P1

Visual/By Two's
Inspection

1. Check the connector lock, locking of connector is included in Steering electrical test.

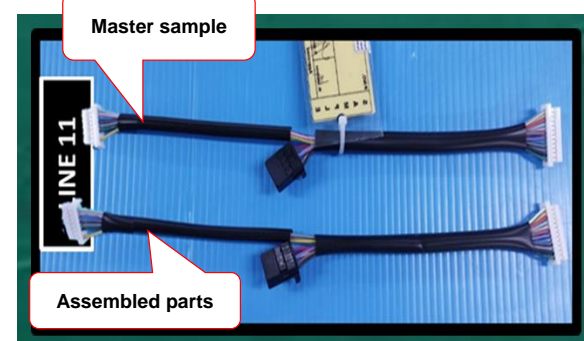
2. Check the wire alignment. Make sure no tangled wires.

3. Check the terminal if with backing out (not fully inserted) or deformed terminal.



4. Check the orientation of harness.

5. Compare to Master sample by tapping..

**MASTER SAMPLE****Document reference/s:**

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

1. No wrong facing of harness
2. No Tangled wires
3. No missing parts

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Purpose:



PROTOTYPE



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PARTS:

1. Assy parts

JIG:

n/a

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

8

MEASURING TAPE**Important reminders and note/s:**

1. Please use calibrated/verified measuring tape when getting the measurement.
2. For Hatsumono, Nakamono and Owarimono.

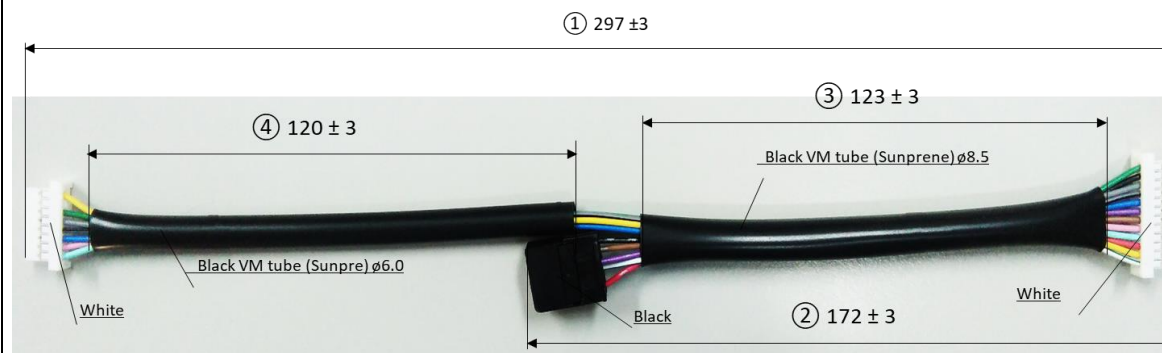
Document reference/s:

1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection

13

P1

Measurement

**NOTE:** *Unit of dimension is in millimeter (mm)

1. No wrong dimension.

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LEXUS-NX

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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

75N800-0442

1. Check the connector lock, should be unlock.

Black VM tube (Sunprene)

GOOD FACING

GOOD FACING

Black VM tube (Sunprene)

2. Check the wire alignment. Make sure no tangled wires.

3. Check the orientation of harness.

4. Check if no missing parts.

5. Check the terminal if with backing out (not fully inserted) or deformed terminal.

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