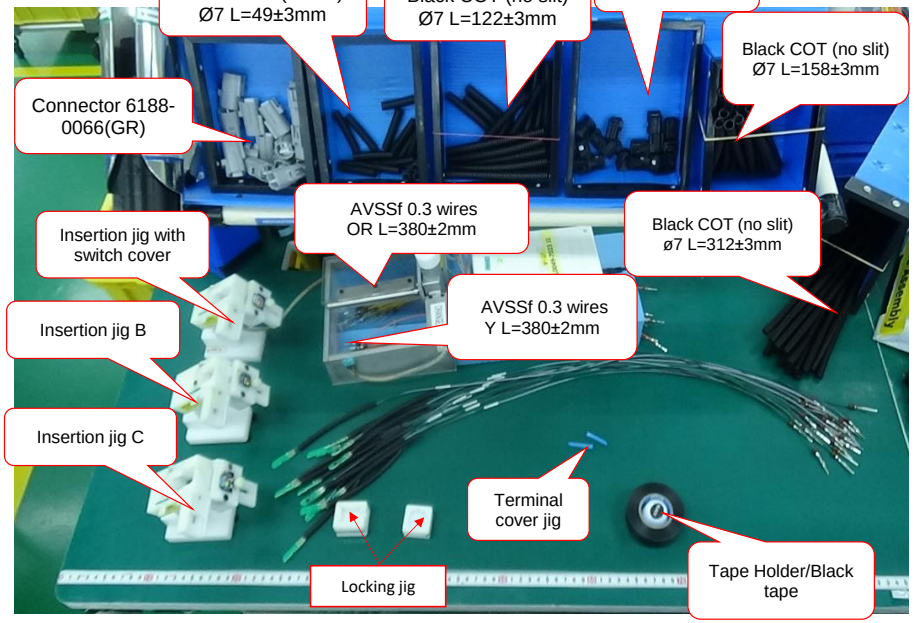
	WORK INSTRUCTION			Effectivity Date:	October 01, 2024	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 241B / 7L0049-7023A	Customer: TRQSS	Car Model: LEXUS ES	Document No.:	WI-ENG-PDE-1067A	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 1 of 12

PARTS:	1. Connector 6188-0066 GR; 6189-1161 (B); AVSSf 0.3 wires Y-OR L=380±2mm; MRSW CP (TVSSf 0.3 G-B/W L=679±3mm; Black VM tube (Sunprene) Ø5 L=106±3mm); Black Corrugated tube (no slit) Ø7 L=49±3mm; Corrugated tube (no slit) Ø7 L=122±3mm; Corrugated tube (no slit) Ø7 L=158±3mm; Corrugated tube (no slit) Ø7 L=312±3mm; Black tape	JIG:	1. Insertion jig with switch cover 2. Locking jig 3. Terminal cover 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 required 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.	***Document reference/s:*** ***1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance*** ***2. Refer to WI-PRO-KIT-006 for Wire Taping with Vinyl Tube*** 1. No missing parts/tools 2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
10/01/24	1	Change from Pre-launch to Masspro.	A. Hernandez	C. Villanueva	A. Arañes	n/a
09/24/24	0	Initial issue	A. Hernandez	C. Villanueva	A. Arañes	n/a

Prepared by	Reviewed by	Approved by	Noted by
A.Hernandez	C. Villanueva	A. Arañes	n/a
Est. Date:	September 24, 2024		

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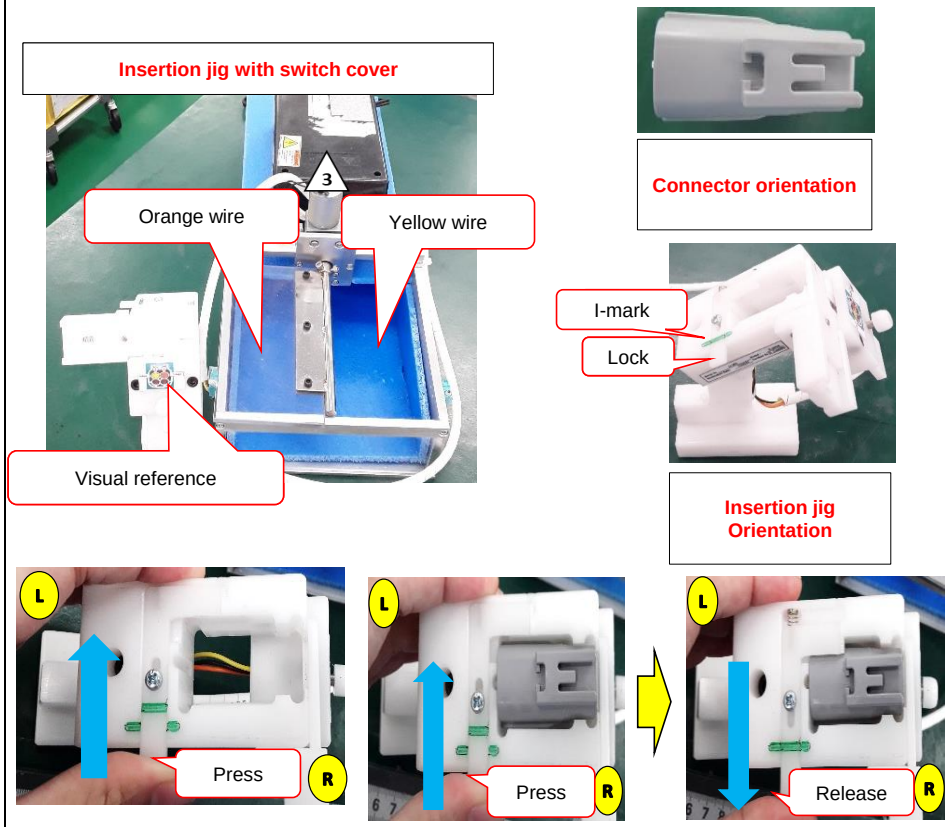
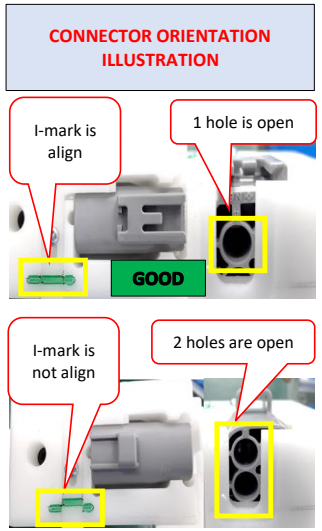
	Model code/Part number:	241B / 7L0049-7023A	Customer: TRQSS / Car Model: LEXUS ES	Document No.:	WI-ENG-PDE-1067A
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1 / Page No.: 2 of 12

PARTS:	1. Connector 6188-0066 (GR)	JIG:	1. Insertion jig with switch cover

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1	Connector setting to Insertion jig 6188-0066 (GR)	 1. Press the lock using left hand. 2. Get the connector 6188-0066 (GR) using right hand and insert to insertion jig. Release the lock after insertion. ***Note: Follow the connector orientation.***	**N/A**	 1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector

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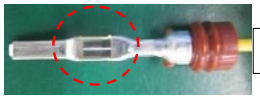
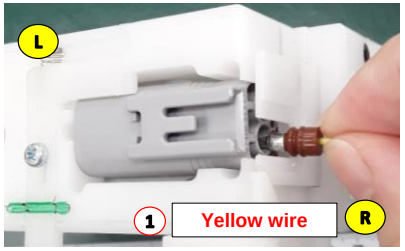
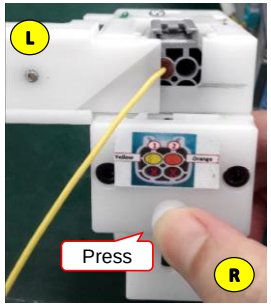
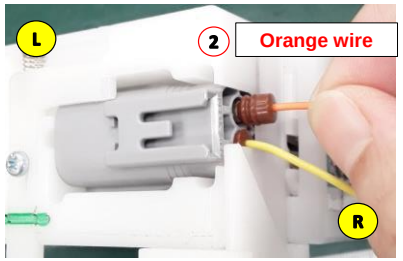
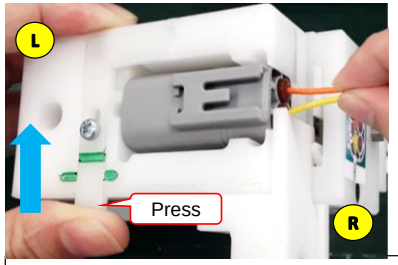
	Process Name/Title:	TAPING ASSEMBLY PROCESS			Validity Date:	n/a	
	Model code/Part number:	241B / 7L0049-7023A	Customer: TRQSS	Car Model: LEXUS ES	Document No.:	WI-ENG-PDE-1067A	
	Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	1	Page No.: 3 of 12

PARTS:	1. AVSSf 0.3 wires Y-OR L=380±2mm			JIG:	1. Insertion jig with switch cover
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
3	P1	Wire Insertion to connector 6188-0066 (GR)	 Terminal facing  1. Hold the insertion jig using left hand. Get the Yellow wire and insert to connector using right hand.  2. Press the button using right thumb. slot for Orange wire will be open.  3. Get the Orange wire and insert to connector using right hand.  4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.	N/A	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing ***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***

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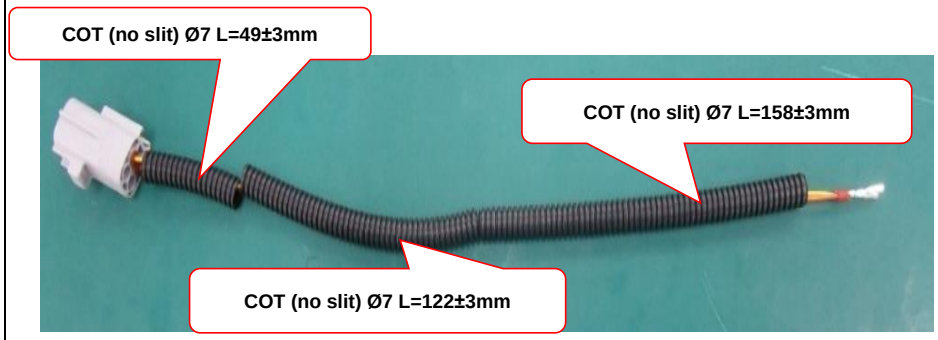
	Model code/Part number: 241B / 7L0049-7023A	Customer: TRQSS	Car Model: LEXUS ES	Document No.:	WI-ENG-PDE-1067A	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 4 of 12

PARTS:	1. Black Corrugated tube (no slit) ø7 L=49±3mm 2. Black Corrugated tube (no slit) ø7 L=122±3mm	3. Black Corrugated tube (no slit) ø7 L=158±3mm 4. Assy parts	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1	Wire insertion to COT (no slit) ø7 L= 49±3mm ø7 L= 122±3mm ø7 L= 158±3m	 1. Hold the wires using left hand. Get the Corrugated tube (no slit) ø7 L= 49±3mm using right hand and insert the wires. 2. Hold the wires using left hand. Get the Corrugated tube (no slit) ø7 L= 122±3mm using right hand and insert the wires. 3. Hold the wires using left hand. Get the Corrugated tube (no slit) ø7 L= 158±3mm using right hand and insert the wires. 	N/A	1. No wrong use of parts 2. No deformed terminal

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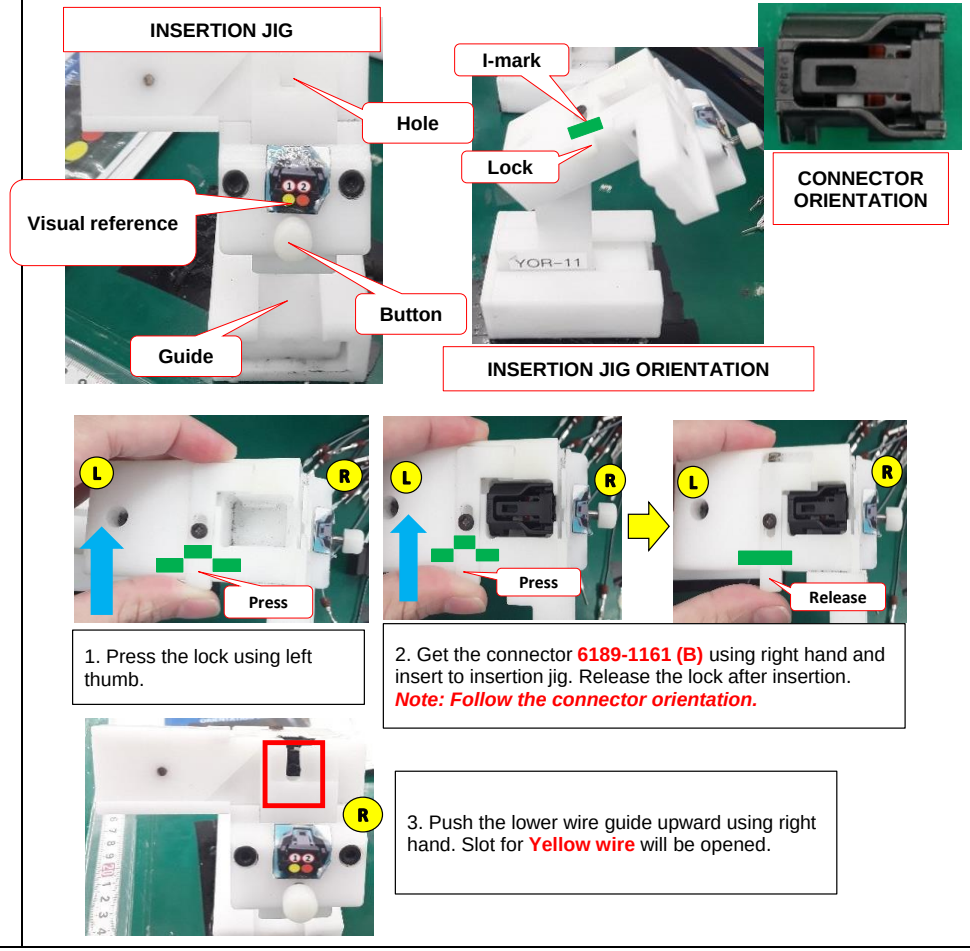
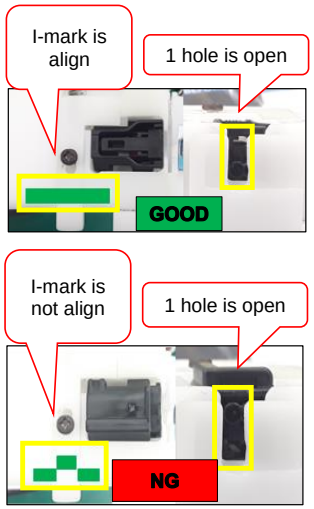
	Model code/Part number:	241B / 7L0049-7023A	Customer: TRQSS / Car Model: LEXUS ES	Document No.:	WI-ENG-PDE-1067A
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1 / Page No.: 5 of 12

PARTS:	1. Connector 6189-1161 (B)	JIG:	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1	Connector setting to insertion jig 6189-1161 (B)	 1. Press the lock using left thumb. 2. Get the connector **6189-1161 (B)** using right hand and insert to insertion jig. Release the lock after insertion. ***Note: Follow the connector orientation.*** 3. Push the lower wire guide upward using right hand. Slot for **Yellow wire** will be opened.	N/A	**CONNECTOR ORIENTATION ILLUSTRATION**  1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector

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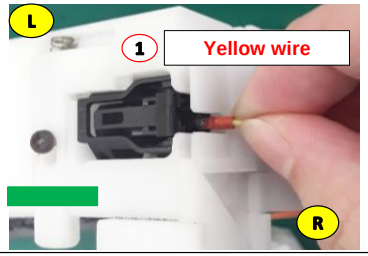
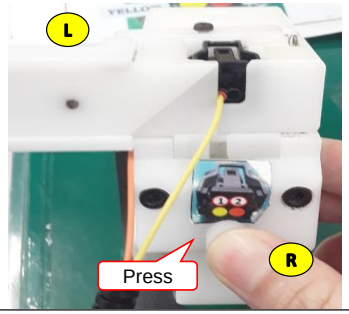
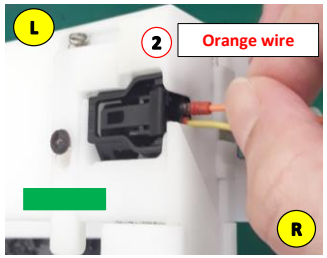
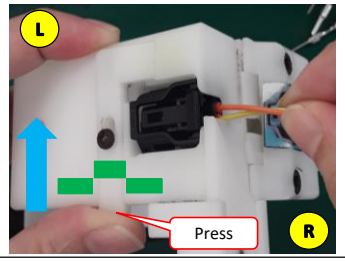
	Model code/Part number: 241B / 7L0049-7023A	Customer: TRQSS	Car Model: LEXUS ES	Document No.:	WI-ENG-PDE-1067A	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 6 of 12

PARTS:	1. Black tape 2. Assy parts	JIG:	1. Insertion Jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1	Wire Insertion to Connector 6189-1161 (B)	 Terminal facing  1. Hold the insertion jig using left hand. Get the Yellow wire and insert to connector using right hand.  2. Press the button using right thumb. slot for Orange wire will be open.  3. Get the Orange wire and insert to connector using right hand.  4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.	N/A	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing ***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.***

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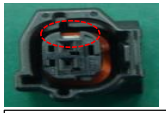
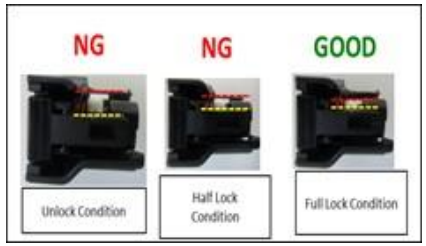
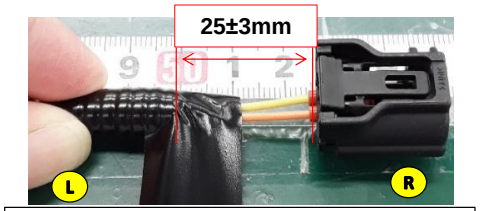
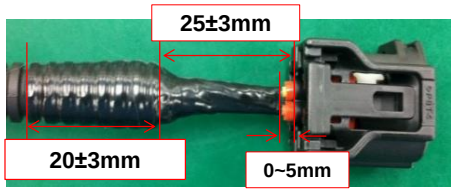
	Model code/Part number: 241B / 7L0049-7023A	Customer: TRQSS	Car Model: LEXUS ES	Document No.:	WI-ENG-PDE-1067A	
	Purpose: ☐PROTOTYPE ☐PRE-LAUNCH ■MASSPRO			Revision No.:	1	Page No.: 7 of 12

PARTS:	1. Black tape 2. Assy parts	JIG:	1. Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1	Connector lock	 1. Put the connector into locking jig and push down **2x** using both hands. Check the connector lock if properly locked. **Before pressing**  **After Pressing**  	**LOCKING JIG** 	***Important reminders/Note/s:*** ***1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR*** 1. No unlock/half-locked connector 2. No damaged lock
8		Taping 1 COT to wire near connector	 1. Hold the assy parts using left hand, get **Black tape** then conduct pre-taping using both hands.  2. Hold the assy parts using left hand and measure from COT to connector **25±3mm** using both hands. Continue taping process using both hands.  3. After taping, check the measurement and taping condition.	**MEASURING TAPE** 	***Important reminders and Note/s:*** ***1. Please use calibrated/verified measuring tape when getting the measurement.*** ***Document reference/s:*** ***1. Refer to WI-PRO-ASY-001 for taping procedure.*** 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape

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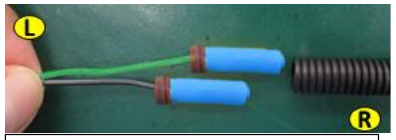
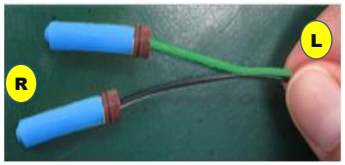
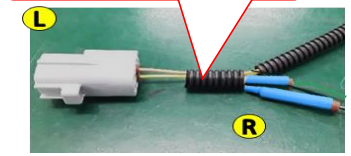
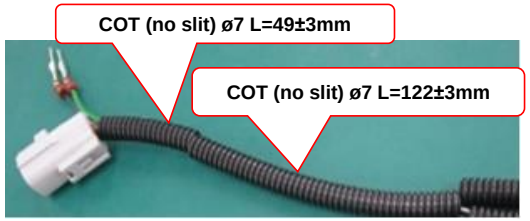
	Purpose: ☐PROTOTYPE ☐PRE-LAUNCH ■MASSPRO			Revision No.:	1	Page No.: 8 of 12

PARTS:	1. Black Corrugated tube ø7 L=312±3mm (no slit) 2. MRSW CP (TVSSf 0.3 G-B/W L=679±3mm; Black VM tube (Sunprene) Ø5 L=106±3mm) 3. Assy parts	JIG:	1. Terminal cover jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P1	Wire insertion to COT ø7 L= 312±3mm (no slit)	 1. Get the terminal cover jig using right hand then insert to both terminals **G-B/W wires** using right hand.  2. Get the corrugated tube **ø7 L=312±3mm (no slit)** using right hand then insert the **G-B/W wires** using left hand.	**TERMINAL COVER JIG** 	1. No wrong use of parts 2. No deformed terminal
10		Wire insertion to Assy	 1. Hold the wires using right hand. COT (no slit) Ø7 L=122mm 2. Get the assy parts using left hand, insert the wires in COT **ø7 L=122mm** using right hand.  COT (no slit) ø7 L=49±3mm 3. Hold the corrugated tube ø7 L=49±3mm using left hand then insert the G-B/W wires using right hand. 4. After insertion, remove the cover jig using right hand.  COT (no slit) ø7 L=49±3mm COT (no slit) ø7 L=122±3mm	**TERMINAL COVER JIG** 	1. No wrong use of parts 2. No deformed terminal 3. No wrog insertion of parts

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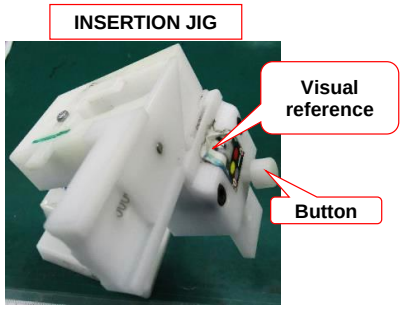
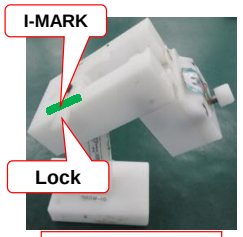
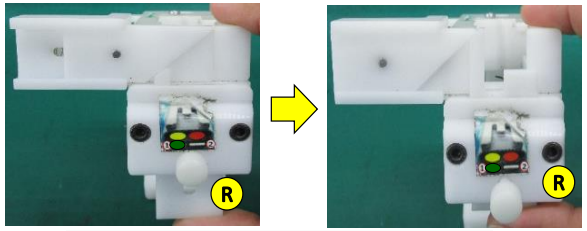
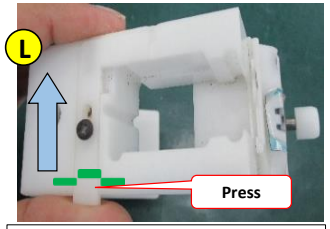
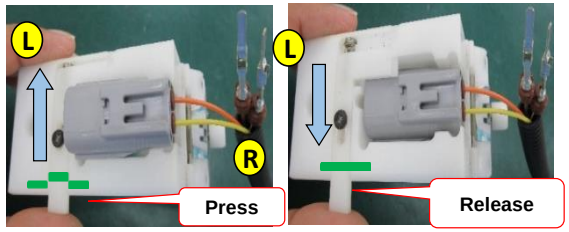
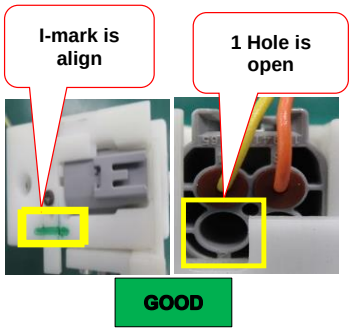
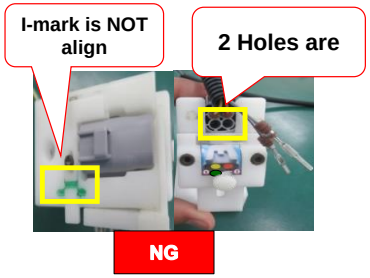
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1 / Page No.: 9 of 12

PARTS:	1. Assy parts	JIG:	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
11	P1	Connector setting to insertion jig 6188-0066 (GR) (Assy parts)	   1. Press the guide using right thumb. The slot for **G wire** will be opened.  2. Press the lock of insertion jig using left thumb.  3. Insert the connector **6188-0066 (GR)** with inserted **Y-OR wire** using right hand. ***Note: Follow the connector orientation.***	N/A	  1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector

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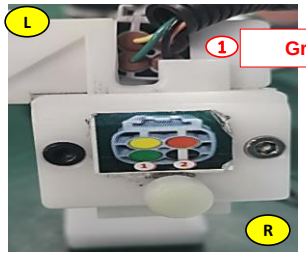
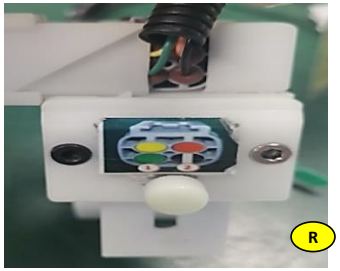
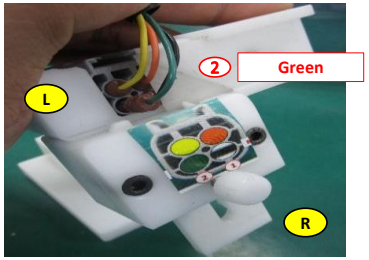
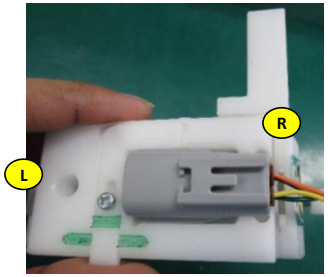
	WORK INSTRUCTION				Effectivity Date:	October 01, 2024	
	Process Name/Title:	TAPING ASSEMBLY PROCESS			Validity Date:	n/a	
	Model code/Part number:	241B / 7L0049-7023A	Customer: TRQSS	Car Model: LEXUS ES	Document No.:	WI-ENG-PDE-1067A	
	Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	1	Page No.: 10 of 12

PARTS:	1. Assy parts	JIG:	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
12	P1	Wire insertion to connector 6188-0066 (GR) (Assy parts)	 Terminal Facing  1. Hold the insertion jig using left hand, get **Green wire** then insert to connector slot **1** using right hand.  2. Press the button using right hand, slot for **Black/White wire** will be opened.  3. Hold the insertion jig using left hand, get **Black/White wire** then insert to connector slot **2** using right hand.  4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.	N/A	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing ***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.***

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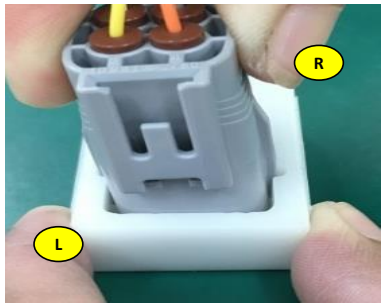
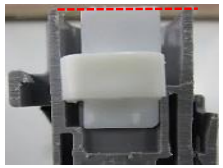
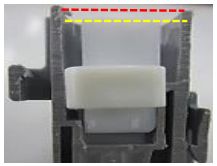
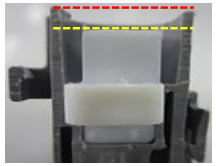
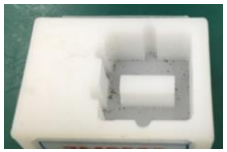
NBC	WORK INSTRUCTION			Effectivity Date:	October 01, 2024
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number:	241B / 7L0049-7023A	Customer: TRQSS / Car Model: LEXUS ES	Document No.:	WI-ENG-PDE-1067A
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1 / Page No.: 11 of 12

PARTS:	1. Assy parts	JIG:	1. Locking Jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
13	P1	Connector lock	 1. Put the connector into locking jig using right hand then press **2x.** Touch the connector lock if properly locked. Before pressing After pressing **Connector Cross Sectional View** NG  Unlock Condition NG  Half Lock Condition GOOD  Full Lock Condition	**LOCKING JIG** 	***Important reminders/Note/s:*** ***1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR*** 1. Use the provided locking jig per model 2. No unlock/half-lock connector

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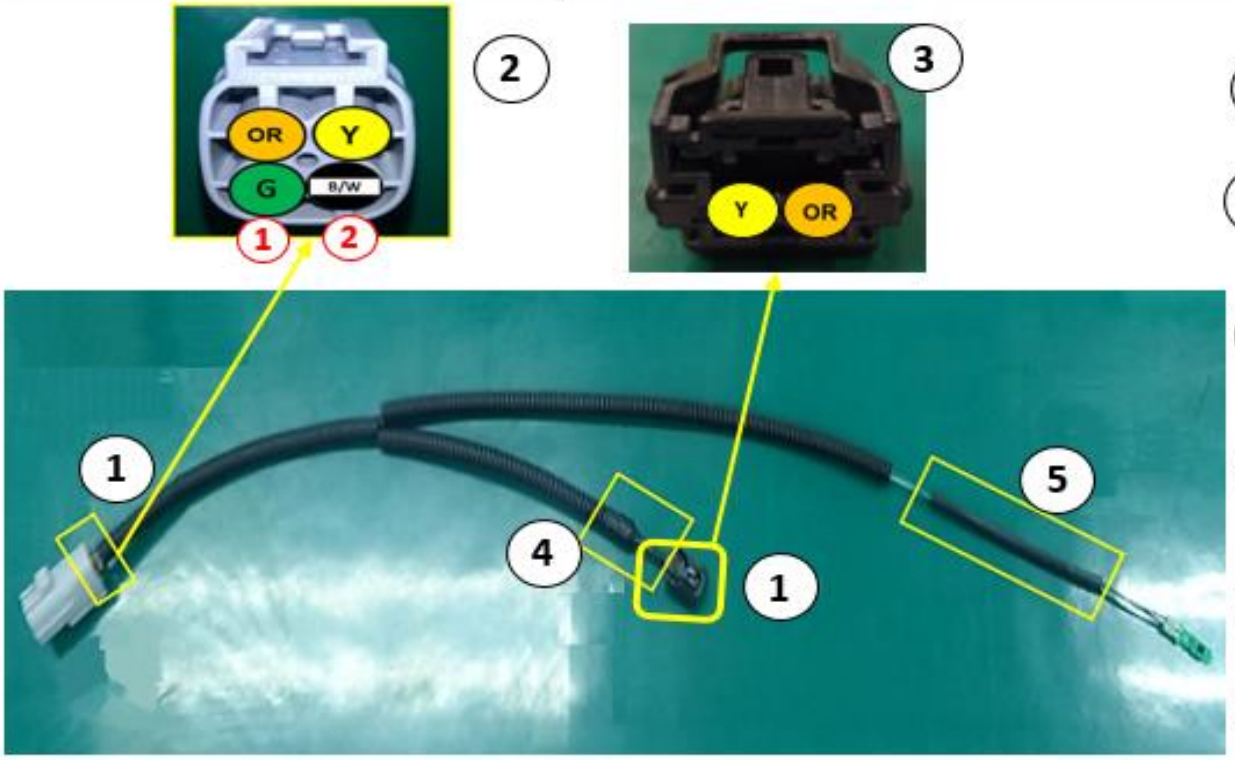
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number: 241B / 7L0049-7023A	Customer: TRQSS	Car Model: LEXUS ES	Document No.:	WI-ENG-PDE-1067A
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 1	Page No.: 12 of 12

PARTS:	1. Assy parts	JIG:	n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING - P1	7L0049-7023A



1. No Unlocked /Half-locked Connector
2. 3 No Wrong Insert
4. No Missing Tape (Black)
5. No Missing Black Sunprene tube
6. No Terminal Backing out
7. No Deformed Terminal

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