PARTS: 1. All parts (Connector 6098-3810(W); Connector 6188-0407(W); MR SW CP(G,BW L=608±3mm); Black Corrugated tube(no slit) Ø5 I. Insertion jig 2. Locking jig 2. Locking jig 3. Taminal cover jig 3. Taminal cover jig 3. Taminal cover jig 3. Taminal cover jig 4. Locking jig 2. Locking jig 3. Taminal cover jig 3. Taminal cover jig 4. Locking jig 3. Taminal cover jig 4. Locking jig 4. Locking jig 3. Taminal cover jig 4. Locking jig 4. Locking jig 5. Taminal cover jig 5. Taminal cover jig 5. Taminal cover jig 5. Taminal cover jig 6. Table Lay-Out 6. Locking jig 6. Taminal cover jig 7. Table Lay-Out 7. Table Lay-Out 7. Safety instruction 8. Be sure to wear prescribed personal protective equipment during operation [gloves, finger cots, etc.] **Document reference/s:** I. Refer to Wi-PRO-CNC-071 Win and Strip Length Tolerance 9. No excess parts/tools 2. No excess parts/tools 3. No wrong positions of parts/tools 2. Alert level For any trouble, inform the Assembly Assistant to				WORK INST						Effect	ivity Date:		June 18, 202	24
Parts: 1. All parts (Connector 6098-3810/W); Connector 6188-0407(W); MR SW CP(G.B.W L=608±3mm); Black Corrugated tube(no silt) Ø5 JiG; 1. Insertion jig 2. Locking jig 3. Terminal cover jig 4. Locking jig 2. Locking jig 3. Terminal cover jig 3. Terminal cover jig 3. Terminal cover jig 4. Table Lay-Out			Process Name/Title:	OFFLIN	E ASSEMB	LY PRO	CESS			Validi	ty Date:		n/a	
PARTS: 1. All parts (Connector 698-3810(W); Connector 6188-0407(W); MR SW CP(G,BW L=608±3mm); Black Corrugated tube(no slit) Ø5 I. All parts (Connector 698-3810(W); Connector 6188-0407(W); MR SW CP(G,BW L=608±3mm); Black Corrugated tube(no slit) Ø5 I. Dig: 1. Insertion jig 2. Locking jig 3. Terminal cover jig 3. Terminal cover jig 4. Table Lay-Out Safety Instruction Be sure to wear prescribed personal protective equipment during poration (gloves, finger cots, etc.) Connector (6389-3810)/ Connector tray Connector (6389-3810)/ Connector tray Black Corrugated tube(no slit) Ø5 Safety Instruction Be sure to wear prescribed personal protective equipment during poration (gloves, finger cots, etc.) Document reference/s: 1. Refer to Wi-PRO-CNC-071 Win and Strip Length Tolerance 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 to the protection of the protection of the Assembly Assistant to the Assembly Assistant to the protection of the Assembly Assistant to the Assembly Assistant to the Assembly Assistant to the Assembly Assistant to the Assembly Assistan			Model code/Part number:	800B / 7N0104-7020A	Customer:	TRJ	Car Model:	LEXU	JS-NX/RX	Docu	ment No.:		WI-ENG-PDE-	808
PARTS: 1. Ap also to Mine to Bose-3s of My, Mr. SW CPG, BW Lesoses mill), place Collegated ube(n) sill) SJ (2. Locking) ig 3. Terminal cover jig 4. Table Lay-OUT Safety Instruction Be sure to wear prescribed personal protective equipment during operation (sloves, finger cots, etc.) Connector (6388-84071)/ Connector tray Table Lay-out Missy CP (TVSSf 0.3 G-B/W L=50883mm) Table Lay-out Missy CP (TVSSf 0.3 G-B/W L=50883mm) Table Lay-out Missy CP (TVSSf 0.3 G-B/W L=50883mm) AVSf 0.3 Black Locking igin 2. Locking jig 3. Terminal cover jig 3. Terminal cover jig 3. Terminal cover jig 4. No missing parts/tools 2. No wrong positions of parts/tools 2. No wrong positions of parts/tools 2. No wrong positions of parts/tools 4. No wro			Purpose:	PROTOTYPE	PRE-LAUNCH		MASSPF	RO		Revis	ion No.:	0	Page No.:	1 of 10
TABLE LAY-OUT Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) Connector (6388-0407)/ Connector tray Connector (6388-0407)/ Connector tray Black Corrugated tube (97 L-7833mm (No sit)) AVSST 0.3 Black L-66823mm AVSST 0.3 Black L-66823mm Alert level For any trouble, inform the Avsembly Assistant the Avsembly Assistant to the Avssit can be a sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) Document reference/s: 1. Refer to WI-PRO-CNC-071 Win and Strip Length Tolerance 2. No missing parts/tools 3. No wrong positions of parts/tools 4. No wrong positions of parts/tools 5. No wrong positions of parts/tools 6. No wrong positions of parts/tools 6. Table Lay-out Alert level For any trouble, inform the Avsembly Assistant the Avsembly Assista	PARTS:	L=75±3	mm and Ø7 L=78±3mm; A	VSSf 0.3 B L=666±3mm;				d tube(no	slit) Ø5			 Locking Termina 	jig I cover jig	ITEDS
Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) Connector (698-3810)/ Connector tray Connector (6188-0407)/ Connector tray Black Corrugated tube (97 L=78±3mm (No sit)) AVSST 0.3 G-8/W L=608±3mm) AVSST 0.3 Black L=666±3mm Alert level For any trouble, inform the Assembly Assistant the Assembly Assistant to the protective and the protective equipment during operation (gloves, finger cots, etc.) Document reference/s: 1. Refer to Wi-PRO-CNC-071 Wire and Strip Length Tolerance Alert level For any trouble, inform the Assembly Assistant to the protective equipment during operation (gloves, finger cots, etc.) Alert level For any trouble, inform the Assembly Assistant to the protective equipment during operation (gloves, finger cots, etc.) Alert level For any trouble, inform the Assembly Assistant to the protective equipment during operation (gloves, finger cots, etc.) Alert level For any trouble, inform the Assembly Assistant to the protective equipment during operation (gloves, finger cots, etc.) Alert level For any trouble, inform the Assembly Assistant to the protective equipment during operation (gloves, finger cots, etc.) Alert level For any trouble, inform the Assembly Assistant to the protective equipment during operation (gloves, finger cots, etc.) Alert level For any trouble, inform the Assembly Assistant to the protective equipment during operation (gloves, finger cots, etc.) Alert level For any trouble, inform the Assembly Assistant to the protective equipment during operation (gloves, finger cots, etc.) Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) Alert level For any trouble, inform the protective equipment during operation (gloves, finger cots, etc.) Alert level For any trouble, inform the protective equipment during operation (gloves, etc.) Alert level For any trouble, inform the protective equipment during operation (gloves, etc.) Alert level For any trouble information equip	NO.		ROCESS NAME	WORKF	ROCLDORL	ILLUSTR	ATION				TOOLS/FFL		QUALITI FOIL	IILKS
Insertion Jig A	1	n/a	Table Lay-out	MRSW CP (TVSSf 0.3 G-B/W L=608±3mm) Insertion Jig A	Connecto	or (6188-0407) nector tray	ck Corrugated tub. L=78±3mm (No sli	AVSSF L=66	6±3mm	f pr dur	Be sure to wear prescribed persona otective equipmer ing operation (glow finger cots, etc.) Housekeeping Maintain and alwa practice 5's. Personal things on introlled in your locked and the properties of the pr	Docur 1. Referand Stri 1. No miss 2. No exceed. 3. No wroner. mn nt der	to WI-PRO-CNC- p Length Tolerar ing parts/tools ss parts/tools	071 Wire ace
Revision History Prenared by Reviewed by Approved by Note				Povision History									T	T
Revision History Prepared by Reviewed by Approved by Note				revision i listory							Prepared by	Reviewed by	Approved by	Noted by
06/1824 0 Initial issue. D. Castillo C.Villanueva A. Arañes n/a D. Castillo C. Villanueva A. Arañes n/a D. Castillo C. Villanueva A. Arañes n	06/1824 0	Initial iss	Je.				D. Castillo C	C.Villanueva	A. Arañes	n/a	Latillo D. Castillo	Jour House	A Associates	n/a
Eff. Date Rev. No Details of Change Revised Reviewed Approved Noted Est. Date: June 18, 2024	Eff. Date Rev. N	No		Details of Change			Revised	Reviewed	Approved	Noted 4			1	1 39 Mars



				STRUCTION			Effectivity Date:		June 18, 202	4
		Process Name/Title:		INE ASSEMBLY PRO	CESS		Validity Date:		n/a	
		Model code/Part number:	800B / 7N0104-7020A	Customer: TRJ	Car Model:	LEXUS-NX/RX	Document No.:		WI-ENG-PDE-8	808
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPR	RO	Revision No.:	0	Page No.:	2 of 10
PARTS:	1. Conn	ector 6098-3810 (W)					JIG:	1.Insertion	jig	
NO.	F	PROCESS NAME	WORK	PROCEDURE/ ILLUSTE	RATION		TOOLS/PPE	(QUALITY POIN	TERS
2	n/a	Connector setting to insertion jig 6098-3810 (W)	INSERTION JIG Lock Lock 1. Press the lock of insertion jig using left thumb.	INSERTION JIG ORIENTS R Press Insert the connector 6098-3810 (page the lock, the: Follow the connector orient)	R R W) into jig using		n/a	I-mark al 1. Use the 2. No wror 3. No wror	rk was lign 2 h	oles were only open



			WORK INSTRUCTIO	N			Effectivity Date:	T	June 18, 2024	4
		Process Name/Title:	OFFLINE ASSE	MBLY PF	ROCESS		Validity Date:		n/a	
Process Name/Title: OFFLINE ASSEMBLY PROCESS Validity Date: Model code/Part number: 800B / 7N0104-7020A Customer: TRJ Car Model: LEXUS-NX/RX Document No.: WI-ENG-PDE-808	08									
		Purpose:	PROTOTYPE PRE-LAI	JNCH	MASSPR	o	Revision No.:	0	Page No.:	3 of 10
PARTS:	1. AVS	Sf 0.3 B L=666±3mm [2pc	s.]				JIG:	1. Insertior 2. Locking	n jig jig	
NO.	F	ROCESS NAME	WORK PROCEDU	RE/ ILLUS	STRATION		TOOLS/PPE	(QUALITY POIN	TERS
3	n/a	connector	1. Get the 1st Black wire then insert to connector slot 1 using right hand. 3. After it hold the	2. Ge conne	et the 2nd Black wir nector slot 2 using rig	e then insert to not hand.	n/a	1. Pleas during i 2. Insert 3. Make inserted Conductinsertion Do not 6. 1. No loose 2. No wron 3. One by 6. No defor 5. No wron Docum 1. Refer and Strip 2. Please	se hold the wire name insertion. tion of wire must be sure wires are pod. tt Pull-Push-Pull-In. exert extra force. e insertion one insertion red terminal on wire facing ment references to WI-PRO-CNC-Coolength Tolerance or erfer to GL-PRO	ear terminal be inserted. properly Push after /s:



1			WORK INS	STRUCTION			Effectivity Date:	T	June 18, 2024	1
		Process Name/Title:		NE ASSEMBLY PRO	CESS		Validity Date:		n/a	-
		Model code/Part number:	800B / 7N0104-7020A	Customer: TRJ	Car Model:	LEXUS-NX/RX	Document No.:	 	WI-ENG-PDE-8	08
		Purpose:	PROTOTYPE	☐ PRE-LAUNCH	MASSPRO		Revision No.:	0	Page No.:	4 of 10
PARTS:	1. Assy	parts					JIG:	1. Locking ji	ig	
NO.	F	ROCESS NAME	WORK F	PROCEDURE/ ILLUSTF	RATION		TOOLS/PPE	(QUALITY POIN	TERS
4	n/a	Connector lock	1. Put the connector into locking jig u hand then press to lock 2x. 2. Ensure that connector is connector lock based on the connector lock ba	R is in locked condition by slide		After Pressing	LOCKING JIG	1. Manua damaged	ant reminders/N al locking may ca d connector lock vided jig tools per ock/ half-locked co	use model



			WORK INS	TRUCTION			Effectivity Date:		June 18, 2024	1
		Process Name/Title:		NE ASSEMBLY F	PROCESS		Validity Date:		n/a	•
		Model code/Part number:	800B / 7N0104-7020A	Customer: TR		LEXUS-NX/RX	Document No.:		WI-ENG-PDE-8	08
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPE		Revision No.:	0	Page No.:	5 of 10
PARTS:		N CP TVSSf 0.3 G-B/W L=6 Corrugated tube Ø7 L=78±3					JIG:	1. Termina	al cover jig	
NO.	F	ROCESS NAME	WORK F	ROCEDURE/ ILLU	JSTRATION		TOOLS/PPE	(QUALITY POIN	TERS
5	n/a	Wire insertion to Black Corrugated tube Ø7 L=78±3mm (no slit)	1. Get the terminal cover jig using right hand then insert the G and B/W wires.	2. Get the using right right using right r	the Corrugated Ø7 Lands the corrugated of the co	the G and B/W wires	TERMINAL COVER JIG	1. Refer Wire and	tant reminders, to WI-PRO-CNC- d Strip length tole g use of parts med terminal	017 for

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			WORK INS	STRUCTION			Effectivity Date:	T	June 18, 2024	1
		Process Name/Title:		INE ASSEMBLY PRO	CESS		Validity Date:	+	n/a	•
		Model code/Part number:	800B / 7N0104-7020A		Car Model:	LEXUS-NX/RX	Document No.:	-	WI-ENG-PDE-8	08
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	MASSPR		Revision No.:	0	Page No.:	6 of 10
PARTS:	1. Conn	ector 6188-0407 (W)					JIG:	1. Insertion	jig	
NO.	F	ROCESS NAME	WORK	PROCEDURE/ ILLUSTR	RATION		TOOLS/PPE	(QUALITY POIN	TERS
6	n/a	Connector setting to Insertion jig 6188-0407 (W)		Lock	0407 (W) into jig u		n/a	I-mark is I-mark is I-mark is alig 1. Use the 2. No wron 3. No wron	GOOD	1 hole is open 1 hole is open odel nnector



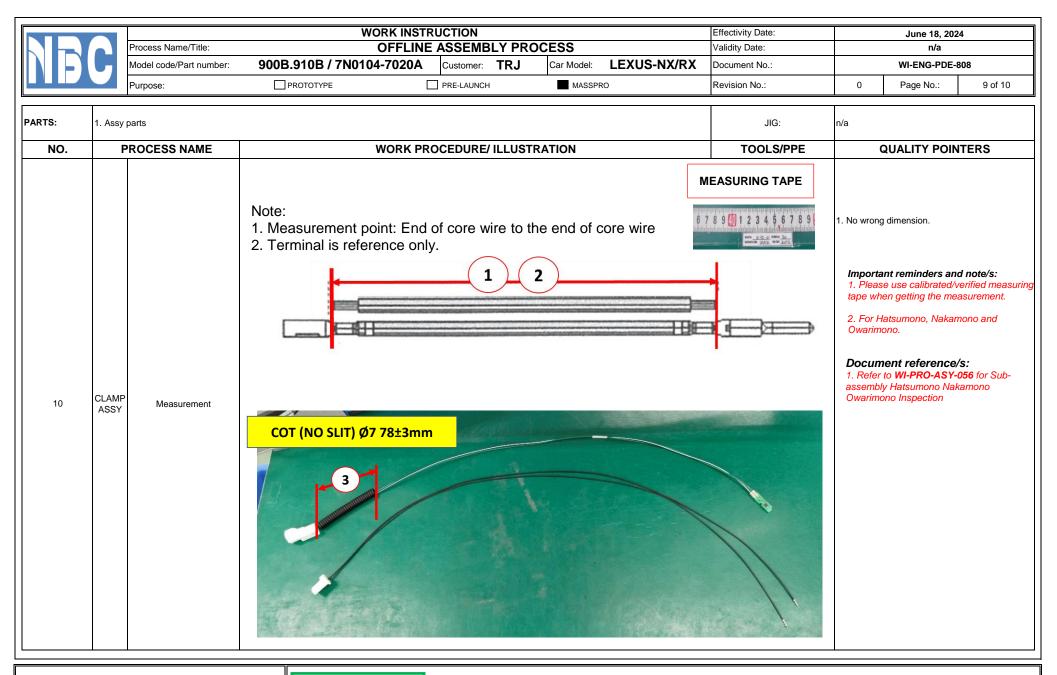
			WORK INST					Effectivity Date:		June 18, 202	1
		Process Name/Title:		E ASSEMBL				Validity Date:		n/a	
		Model code/Part number:	800B / 7N0104-7020A	Customer:	TRJ	Car Model:	LEXUS-NX/RX	Document No.:		WI-ENG-PDE-8	08
		Purpose:	PROTOTYPE	PRE-LAUNCH		MASSPR	0	Revision No.:	0	Page No.:	7 of 10
PARTS:	1. MRS\	W CP (TVSSf 0.3 G-B/W L=6	508±3mm)					JIG:	1. Insertion	jig	
NO.	F	ROCESS NAME	WORK PI	ROCEDURE/ I	ILLUSTRA	TION		TOOLS/PPE	(QUALITY POIN	TERS
7	n/a	Wire Insetion to Connector 6188-0407 (W)	1. Hold the Insertion jig using left hand. Get Black/White wire then insert to terminal sld 1 using right hand. 2 Green 3. Get Green wire then insert to terminal s 2 using right hand.		2. Push the for Green w	Piertion, push the then hold the	right hand. The slot ened. R Le lock using left wires and gently pull g using right hand.	n/a	1. Please during in 2. Insertion 3. Make inserted. Conduct insertion Do not e. 1. No loose 2. No wron 3. One by 4. No defo 5. No wron Docum 1. Refer and Strip 2. Please	ion of wire must k sure wires are property in the property in	ar terminal be inserted. coperly ush after 117 for Wire e

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			WORK INS	TRUCTION			Effectivity Date:		June 18, 2024	1
		Process Name/Title:	OFFLIN	NE ASSEMBLY PRO	CESS		Validity Date:		n/a	
		Model code/Part number:	800B / 7N0104-7020A	Customer: TRJ	Car Model:	LEXUS-NX/RX	Document No.:		WI-ENG-PDE-8	08
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPR	0	Revision No.:	0	Page No.:	8 of 10
PARTS:	1.Assy	parts					JIG:	1.Locking jig	g	
NO.	F	PROCESS NAME	WORK F	PROCEDURE/ ILLUSTR	ATION		TOOLS/PPE	(QUALITY POIN	ΓERS
8	n/a	Connector Lock	Before lock After locked 1. Put the to lock 2x the condit	CONNECTOR CING NG Double Unlock Condition Connector into locking jig us. Check the connector lock it	NG Double Half Lock Condition	GOOD Double Full Lock Condition	LOCKING JIG	1. Manua connecto	ant reminders/N al locking may cat or lock provided locking p ck/half-locked conf	use damaged







NA		Process Name/Title:	WORK INS OFFLIN	TRUCTION NE ASSEMBLY PRO	CESS		Effectivity Date: Validity Date:		June 18, 202 n/a	4
		Model code/Part number:	800B / 7N0104-7020A	Customer: TRJ	Car Model:	LEXUS-NX/RX	Document No.:		WI-ENG-PDE-8	308
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPR	0	Revision No.:	0	Page No.:	10 of 10
PARTS:	1. Ass	y parts					JIG:	n/a		
			VIS	UAL INSPECTION/ QU	ALITY CHEC	KPOINTS				
	<mark>OF</mark>	FLINE		7N01	04-	<mark>7020</mark>	A			
		1							3	
			2 × × × × × × × × × × × × × × × × × × ×				5	J.		
	GOOD NO GOOD	GOOD NO GOOD	2	4					GOOD NO GOOD	
	\sim	No Unlocked/ F	Half Locked Connector	\sim	minal Bassing Co	acking Out OT	5 No Defo	orm Te	rminal	

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