

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 6, 2024

Model code/Part number:

800B / 7N0068-7020A

Customer:

TRJ

Car Model:

LEXUS NX

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

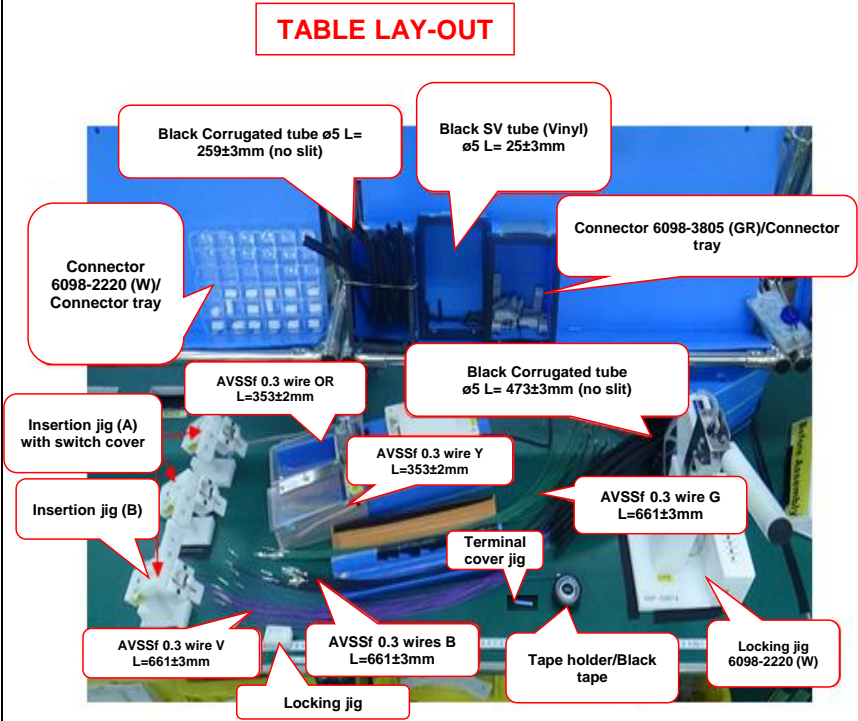
WI-ENG-PDE-187A

Revision No.:

3

Page No.:

1 of 14

PARTS:		1. Connector 6098-2220 (W); AVSSf 0.3 wires Y L=353±2mm, OR L=353±2mm; Black Corrugated tube ø5 L= 259±3mm (no slit); Connector 6098-3805 (GR); Black SV tube (Vinyl) ø5 L= 25±3mm; AVSSf 0.3 wires B L=661±3mm; G L=661±3mm; AVSSf 0.3 wire V L=661±3mm; Black tape; Black Corrugated tube ø5 L=473±4mm (no slit)		JIG:	1. Insertion jig with and w/o switch cover 2. Locking jig 3. Terminal cover jig 4. Locking jig with electrical			
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
1	P1	Table Lay-out	<div>TABLE LAY-OUT</div>  <p>Black Corrugated tube ø5 L= 259±3mm (no slit)</p> <p>Black SV tube (Vinyl) ø5 L= 25±3mm</p> <p>Connector 6098-2220 (W)/ Connector tray</p> <p>Connector 6098-3805 (GR)/Connector tray</p> <p>AVSSf 0.3 wire OR L=353±2mm</p> <p>AVSSf 0.3 wire Y L=353±2mm</p> <p>AVSSf 0.3 wire G L=661±3mm</p> <p>AVSSf 0.3 wire V L=661±3mm</p> <p>AVSSf 0.3 wires B L=661±3mm</p> <p>Terminal cover jig</p> <p>Tape holder/Black tape</p> <p>Locking jig</p>		<div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	1. No missing parts/tools 2. No excess parts/tools		
Revision History								
					Prepared by	Reviewed by	Approved by	Noted by
06/06/24	3	Improve Work procedure/illustration on process no.12 (Connector lock); Inclusion of locking process 6098-2220 (W) due to customer claim. Improve Quality pointers on pages no.1,3,4,5,6,8,10,11 and 12 as document process improvements; Update Table lay-out. Inclusion of Quality checkpoints. Transfer Wire insertion to Black Corrugated tube ø5 L=473±4mm (no slit) process from WI-ENG-PDE-187B to WI-ENG-PDE-187A due to Process improvement. Additional Work procedure/illustration and notes on page 4-5 as countermeasure for the customer claim(Broken lock of Connector 6098-2220 (W)).	D.Castillo	C. Villanueva	A. Arañes	n/a		
03/25/21	2	Change status from pre-launch to Masspro	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes		
11/27/20	1	Change part number from 7N0068-7020 to 7N0068-7020A due to changes in tape color (refer to WI-ENG-PDE-187C)	J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes		
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	November 6, 2020

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3

Page No.:

2 of 14

PARTS:		1. Connector 6098-2220 (W)		JIG:	1. Insertion jig with Switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<div><div>Insertion Jig with Switch Cover</div><div><div>Visual reference</div><div>OR-wire</div><div>Y-wire</div></div><div><div>I-mark</div><div>Lock</div></div><div>Connector Orientation</div><div>Insertion Jig Orientation</div><div><div>2. Insert the connector 6098-2220 (W) into jig using right hand and release the lock. Note: Follow the connector orientation.</div></div><div><div>1. Press the lock of insertion jig using left thumb.</div></div><div><div>Guide</div></div><div><div>Hole</div></div><div><div>3. Push the guide using left hand. The slot for Y wire will be opened.</div></div></div>		n/a	<div><div>CONNECTOR ORIENTATION ILLUSTRATION</div><div><div>I-mark is align</div><div>1 hole is open</div></div><div><div>I-mark is not align</div><div>1 hole is open</div></div><div>1. Use the provided jig per model 2. No wrong orientation of connector</div></div>

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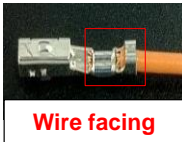
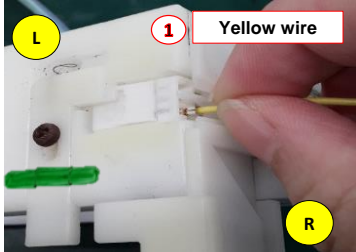
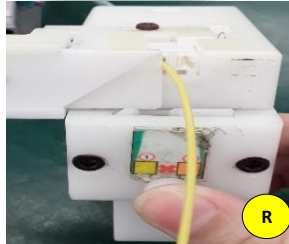
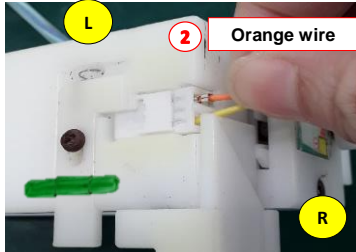
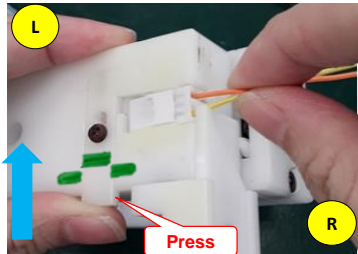
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Revision No.:

3

Page No.:

3 of 14

PARTS:		1. AVSSf 0.3 wires Y L=353±2mm, OR L=353±2mm		JIG:	1. Insertion Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1	<div><div></div><div><p>1. Hold the insertion jig using left hand. Get the Y wire and insert to connector using right hand.</p></div><div><p>2. Press the button using right thumb the slot for OR wire will be opened.</p></div><div><p>3. Get the OR wire and insert to connector using right hand.</p></div><div><p>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.</p></div></div>		n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</div> <div>Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>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</div>

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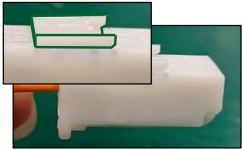
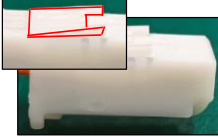
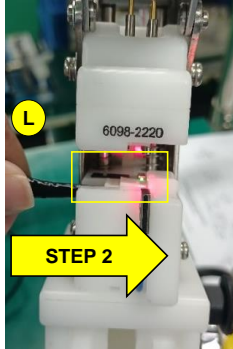
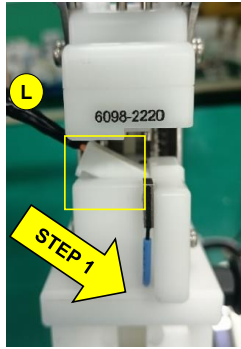
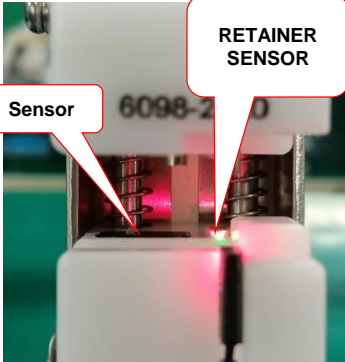
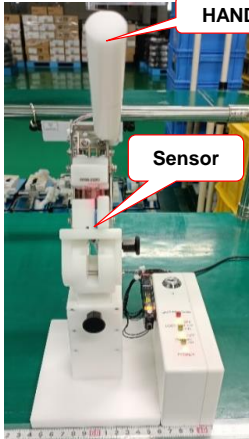
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Revision No.:

3

Page No.:

4 of 14

PARTS:		1. Assy parts		JIG:	1. Locking jig with electrical
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	<div><div><h3>CONNECTOR RETAINER ILLUSTRATION</h3><div><div><p>GOOD</p></div><div><p>NG</p></div></div><div></div></div><div>1. Check the Retainer lock of connector before insertion to locking jig. <i>Note: Must be NO half-locked condition prior connector locking.</i></div><div>2. Hold the assy parts using left hand and insert into connector locking jig based on the direction of arrow. Make sure the connector touch the sensor. Sound will be heard if properly lock. NOTE: CONNECTOR LOCKING JIG WILL NOT FUNCTION IF CONNECTOR NOT REACH THE SENSOR.</div></div>			<div>1. Please ensure that Connector lock/retainer will not touch or hit by any object prior insertion into locking jig to avoid half-lock connector.</div> <div>2. Maintain 10mm proper holding of wire to connector</div> <div>3. Connector must be fully inserted to connector slot.</div> <div>4. Make sure no offset setting before locking process.</div> <div>5. No wrong setting of connector.</div> <div>6. No damaged connector lock</div> <div>7. No unlocked/ half-locked connector.</div> <div>Important reminders/Note/s:</div> <div>1. Incomplete locking process will alarm the jig.</div> <div>2. No retainer in connector cannot proceed.</div> <div>3. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</div>

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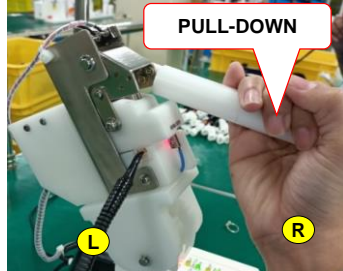
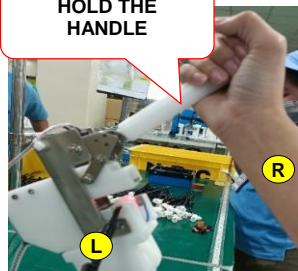
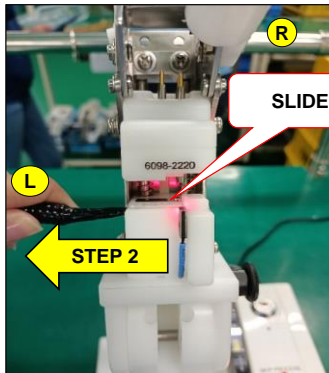
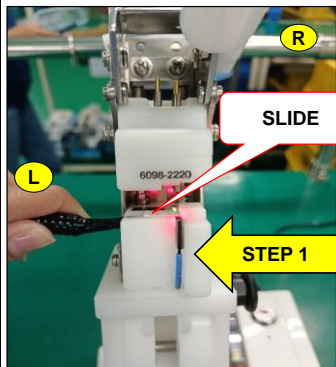
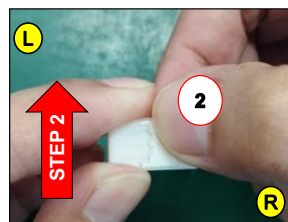
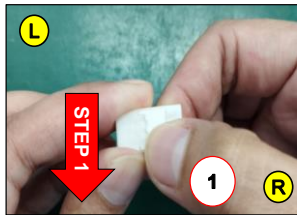
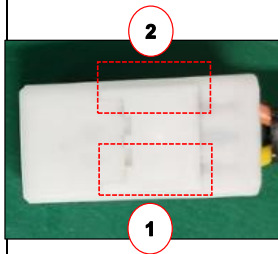

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Revision No.:

3

Page No.:


5 of 14



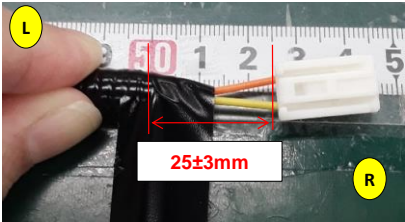
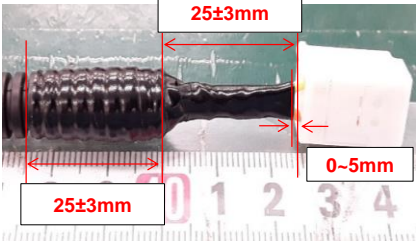

PARTS:		1. Assy parts		JIG:	1. Locking jig with electrical
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 Connector lock. (Continuation)	<div><div><div></div><div></div><div></div></div><div><p>3. Hold the handle of the connector locking jig using right hand then gently pull down and bring back to original position after locking. Note: Pull down one time only.</p><p>4. Remove the locked connector using left hand based on the illustration, follow the direction of arrow.</p><p>5. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div></div>			<p>1. Please ensure that Connector lock/retainer will not touch or hit by any object prior insertion into locking jig to avoid half-lock connector.</p> <p>2. Maintain 10mm proper holding of wire to connector</p> <p>3.Connector must be fully inserted to connector slot.</p> <p>4. Make sure no offset setting before locking process.</p> <p>5.No wrong setting of connector.</p> <p>6. No damaged connector lock</p> <p>7. No unlocked/ half-locked connector</p> <p>Important reminders/Note/s: </p> <p>1. Incomplete locking process will alarm the jig.</p> <p>2. No retainer in connector cannot proceed.</p> <p>3. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</p>

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	Process Name/Title:		Model code/Part number: 800B / 7N0068-7020A		Customer: TRJ	Car Model: LEXUS NX		Document No.: WI-ENG-PDE-187A
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		3	Page No.: 6 of 14

PARTS:		1. Assy parts 2. Black Corrugated tube $\varnothing 5$ L= 259 \pm 3mm (no slit)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5		<div><div><div><div>L</div><div>R</div></div><div>1. Get the corrugated tube $\varnothing 5$ L=259\pm3mm (no slit) using right hand then insert the yellow wire and orange wire by using left hand.</div></div></div>		n/a	1. No wrong use of parts 2. No deformed terminal
6	P1 Taping 1 Black corrugated tube to Wire near Connector	<div><div><div><div>L</div><div>R</div></div><div>1. Hold the assy parts using left hand. Get Black tape using right hand and start pre-taping.</div></div><div><div><div>L</div><div>R</div></div><div>2. Measure from COT to Connector 25\pm3mm using both hands and continue the taping process.</div></div><div><div><div><div><div>25\pm3mm</div><div>0~5mm</div><div>25\pm3mm</div></div><div>3. After taping, Check the measurement, terminal appearance and taping condition.</div></div></div></div></div>		<div>Measuring tape</div> 	<div><div>3</div>Important reminders/note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. Document references: 1. Refer to WI-PRO-ASY-001 for Taping process</div> <div>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.</div>

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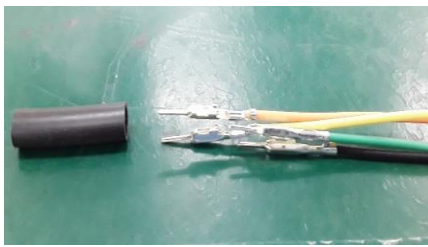
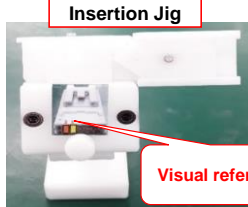
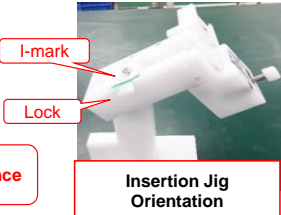

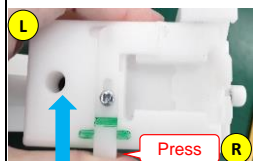


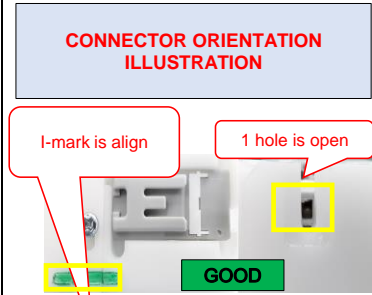
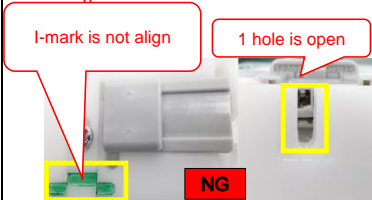
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Revision No.:

3

Page No.:

7 of 14

PARTS:		1. Assy parts 2. Connector 6098-3805 (GR)		3. Black SV tube (Vinyl) $\phi 5$ L= 25 \pm 3mm 4. AVSSf 0.3 wires B L=661 \pm 3mm; G L=661 \pm 3mm		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
7	Wire insertion to SV tube (Vinyl) $\phi 5$ L= 25 \pm 3mm	 <div>1. Get the Black SV tube (Vinyl) $\phi 5$ L= 25\pm3mm using left hand. Combine the Assy parts (Connector with inserted Y and OR wires and COT), B and G wires and insert to SV tube using right hand.</div>				1. No wrong use of parts 2. No deformed terminal	
8	Connector setting to insertion jig 6098-3805 (GR)	<div><div><div>Visual reference</div></div><div><div>I-mark Lock</div></div><div><div>Connector Orientation</div></div></div> <div><div><div>1. Press the lock of insertion jig using left</div></div><div><div>2. Get the connector 6098-3805 (GR) using right hand and insert to insertion jig. Release the lock after insertion.</div></div><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><div>CONNECTOR ORIENTATION ILLUSTRATION</div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div></div><div><div>I-mark is not align</div><div>1 hole is open</div><div>NG</div></div></div> <div>1. Use the provided jig per model 2. No wrong orientation of connector</div>	

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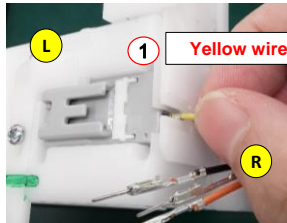
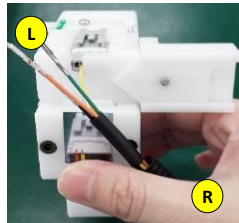
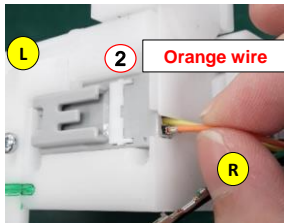
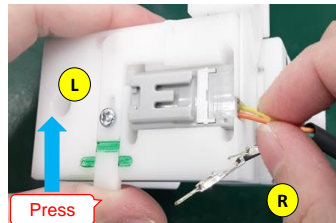

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3

Page No.:

8 of 14

PARTS:	1. Assy parts		JIG:	1. Insertion jig for Y/OR wire
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P1 Wire Insertion to Connector 6098-3805 (GR)	<div><div>Wire facing</div></div> <div><div>1. Hold the insertion jig using left hand. Insert the Yellow wire using right hand.</div></div> <div><div>2. After insertion, press the button using right hand. Slot for Orange wire will be open.</div></div> <div><div>3. Hold the insertion jig using left hand. Insert the Orange wire using right hand.</div></div> <div><div>4. After insertion, push the lock button 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></div> <div>Important reminders/note/s:</div> <div>1. Please hold the wire near terminal during insertion.</div> <div>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>Document reference/s:</div> <div>1. Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</div> <div>2. Please refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>

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**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 6, 2024

Model code/Part number:

800B / 7N0068-7020A

Customer:

TRJ

Car Model:

LEXUS NX

Document No.:

WI-ENG-PDE-187A

Purpose:

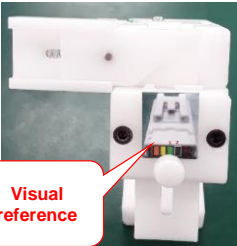
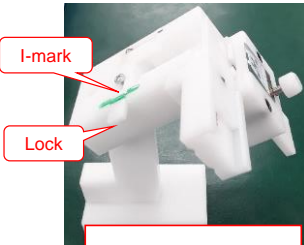

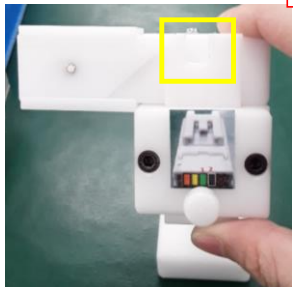
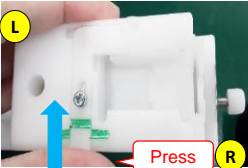
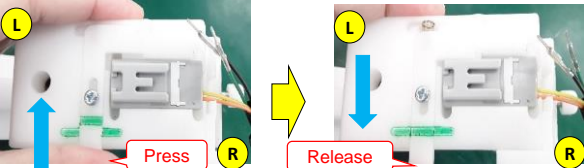
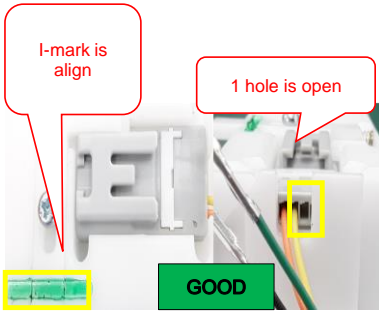
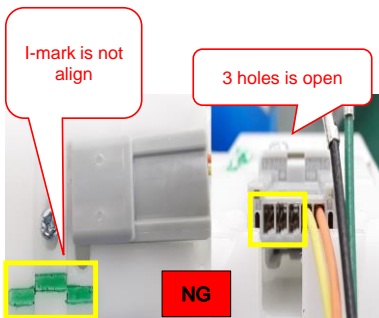
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Revision No.:

3

Page No.:

9 of 14

PARTS:		1. Assy parts		JIG:	1. Insertion jig for B/G wire
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	P1	<div><div>Insertion Jig</div><div><div>Visual reference</div></div><div><div>I-mark</div><div>Lock</div><div>Insertion Jig Orientation</div></div><div><div>Connector Orientation</div></div><div><div>1. Push the lower wire guide upward using right hand. Slot for assy parts wires (Y and OR) and G wire will be open.</div></div><div><div>2. Press the insertion jig lock using left hand.</div></div><div><div>3. Get the connector 6098-3805 (GR) (with inserted wires) using right hand and insert to insertion jig. Release the lock after insertion.</div></div></div>		n/a	<div><div>CONNECTOR ORIENTATION ILLUSTRATION</div><div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div></div><div><div>I-mark is not align</div><div>3 holes is open</div><div>NG</div></div><div>1. Use the provided jig per model 2. No wrong orientation of connector</div></div>

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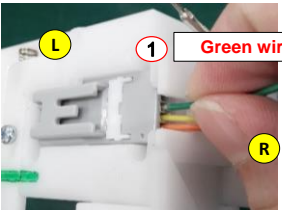
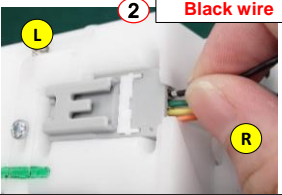


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Revision No.:

3

Page No.:


10 of 14

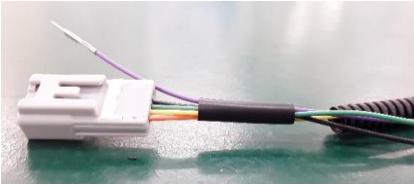

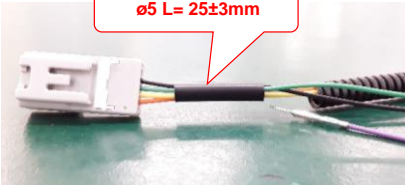


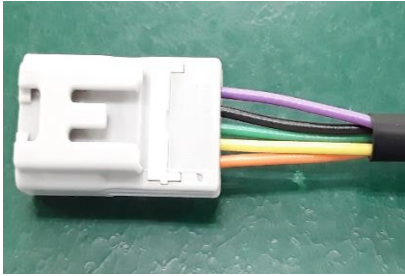
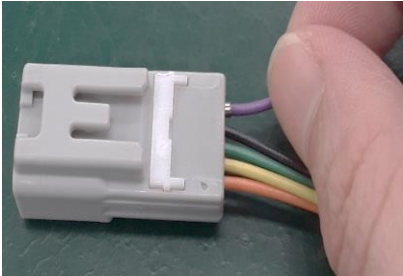

PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1	<div><div><p>Wire facing</p></div><div><p>1 Green wire</p></div><div><p>2 Black wire</p></div><div><p>Press</p></div><div></div></div> <div><p>1. Hold the insertion jig using left hand. Insert the Green wire using right hand.</p><p>2. After insertion, press the button using right hand. Slot for Black wire will be open.</p><p>3. Hold the insertion jig using left hand. Insert the Black wire using right hand.</p><p>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.</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>3</p> <p>Important reminders/note/s:</p> <p>1. Please hold the wire near terminal during insertion.</p> <p>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. Please refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>

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	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 800B / 7N0068-7020A		Customer: TRJ	Car Model: LEXUS NX	Document No.:	WI-ENG-PDE-187A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	3	Page No.:	11 of 14

PARTS:	1. AVSSf 0.3 wires V L=661±3mm			JIG:	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
12	P1	Wire insertion to SV tube (Vinyl) ø5 L= 25±3mm (assy parts)	<div></div> <div>1. Hold the assy parts using left hand. Get the V wire L=661mm and insert to SV tube (Vinyl) ø5 L= 25±3mm (assy parts) using right hand.</div>	n/a	<div>1. No wrong use of parts 2. No deformed terminal</div> <div>Document references: </div> <div>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div>
13		Wire insertion to connector 6098-3805 (GR) (with assy parts)	<div><div>Wire facing</div></div> <div>1. Hold the assy parts using left hand and manually insert the V wire to empty slot of connector using right hand.</div>		<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></div> <div>Important reminders/note/s:</div> <div>1. Please hold the wire near terminal during insertion.</div> <div>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>Document reference/s:</div> <div>1. Please refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>

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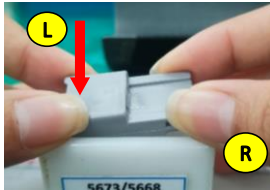
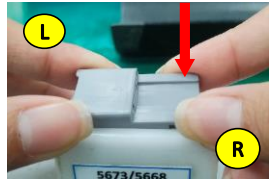



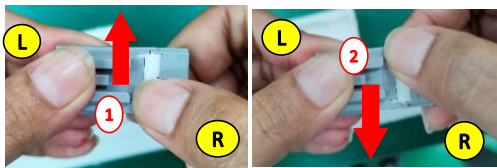

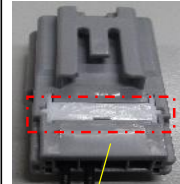
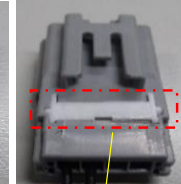


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Revision No.:

3

Page No.:

12 of 14

PARTS:	1. Assy parts		JIG:	1. Locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
14	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>	<div><div>LOCKING JIG</div></div> <div><div><div>GOOD</div><div>Full Lock</div></div><div><div>NG</div><div>Half Lock</div></div></div> <div><div>Before pressing</div></div> <div><div>After pressing</div></div>	<div><div>3 Important reminders/note/s:</div><div>1. Manual locking may caused damaged connector lock.</div><div>Document reference/s:</div><div>1. Refer to GL-PRO-ASY-017 for verification of connector lock.</div></div>

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800B / 7N0068-7020A

Customer:

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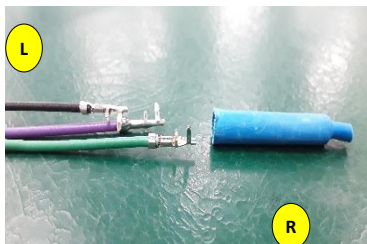



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Revision No.:

3

Page No.:

13 of 14

PARTS:		1. Black Corrugated tube $\varnothing 5$ L=473 \pm 4mm (no slit) 2. Assy parts		JIG:	1. Terminalcover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
15	P1	<div><div></div><div></div><div>1. Hold the assy parts wires using left hand. Get the terminal cover jig using right hand and insert the wires.</div><div></div><div>2. Hold the wires using left hand and insert to Corrugated tube $\varnothing 5$ L=473\pm4mm (no slit) using right hand.</div><div>3. Remove the terminal cover jig using both hands after insertion.</div></div>		<div>Terminal cover jig</div> <div></div>	1. No wrong use of parts 2. No deformed terminal

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TAPING ASSEMBLY PROCESS

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Model code/Part number:

800B / 7N0068-7020ACustomer: **TRJ**

Car Model:

LEXUS NX

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3

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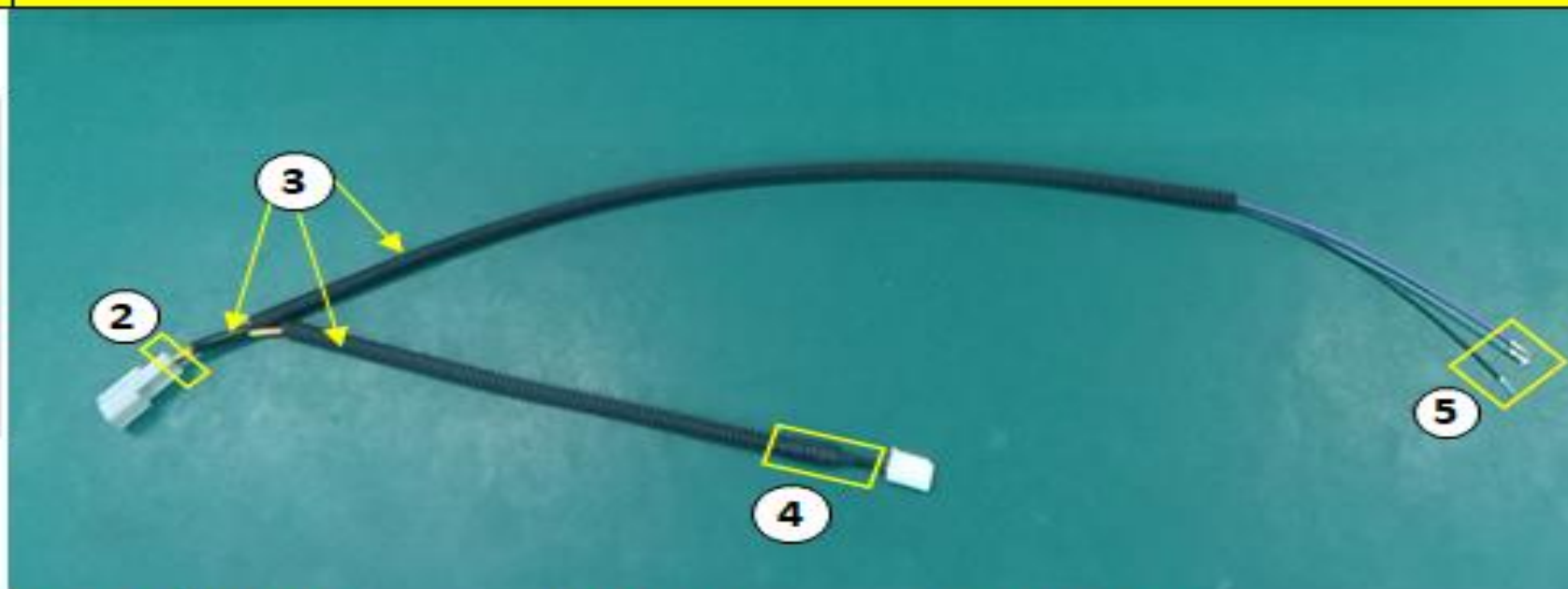
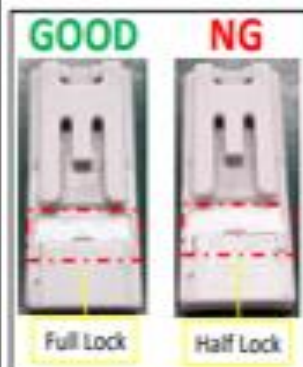
14 of 14

PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P1****7N0068-7020A****1**

- 1** No Unlock/Halflock connector
- 2** No Terminal Backing out

- 3** No Missing Vinyl L=25mm
COT L=259mm
COT L= 473mm

- 4** No Missing tape (COT to wire near connector)
- 5** No Deformed Terminal

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