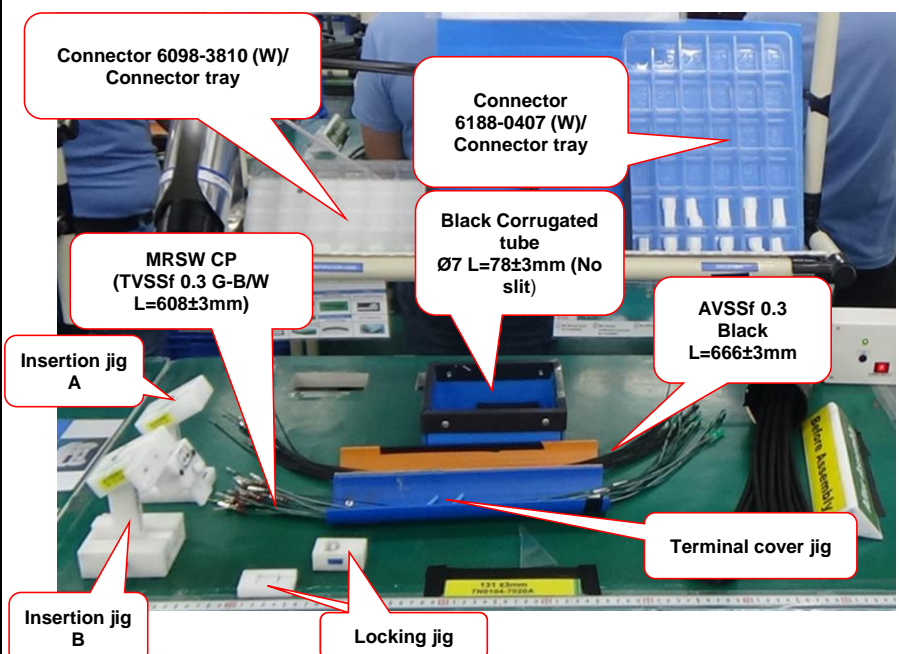




	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>October 21, 2024</b>			
	<b>OFFLINE ASSEMBLY PROCESS</b>				Validity Date:	n/a			
	Process Name/Title:		Model code/Part number: <b>900B.910B / 7N0104-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS-NX/RX</b>	Document No.:	<b>WI-ENG-PDE-1136</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	1	Page No.:	1 of 10	




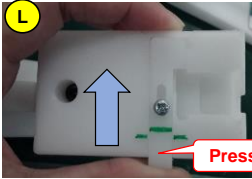
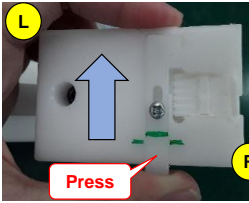
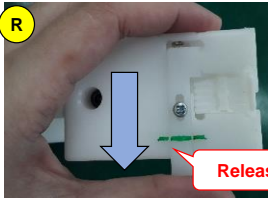

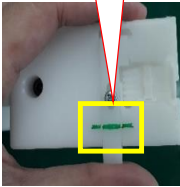
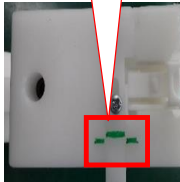
PARTS:		1. All parts (Connector 6098-3810 (W); Connector 6188-0407(W); MR SW CP(G,B/W L=608±3mm); Black Corrugated tube (no slit) Ø5 L=75±3mm and Ø7 L=78±3mm; AVSSf 0.3 B L=666±3mm;			JIG:	1. Insertion jig 2. Locking jig 3. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
1	OFFLINE	Table Lay-out	<div>TABLE LAY-OUT</div> 			<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>	<div>Document reference/s:</div> <p>1. Refer to WI-PRO-CNC-071 Wire and Strip Length Tolerance</p> <p>1. No missing parts/tools 2. No excess parts/tools 3. No wrong positions of parts/tools</p>

Revision History							Prepared by	Reviewed by	Approved by	Noted by		
							 D. Castillo	 C. Villanueva	 A. Arañes	n/a		
10/21/24	1	Change from Pre-launch to Masspro. Update Visual inspection/Quality checkpoints.			D. Castillo	C.Villanueva					A. Arañes	n/a
10/17/24	0	Initial issue.			D. Castillo	C.Villanueva					A. Arañes	n/a
Eff. Date	Rev. No	Details of Change			Revised	Reviewed	Approved	Noted	Est. Date:	October 17, 2024		

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)  
MASTER COPY

	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>October 21, 2024</b>		
	<b>OFFLINE ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Process Name/Title:		Model code/Part number: <b>900B.910B / 7N0104-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS-NX/RX</b>		Document No.: <b>WI-ENG-PDE-1136</b>
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	1	Page No.:	2 of 10


<b>PARTS:</b>	1. Connector 6098-3810 (W)			JIG:	1.Insertion jig			
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
2	OFFLINE	<div><div><p>INSERTION JIG</p><p>Holes</p><p>Lock</p></div><div><p>INSERTION JIG ORIENTATION</p><p>I-MARK</p></div><div><p>CONNECTOR ORIENTATION</p></div></div> <div><div><p>L</p><p>Press</p></div><div><p>L</p><p>Press</p></div><div><p>R</p><p>Release</p></div></div> <div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the connector <b>6098-3810 (W)</b> into jig using right hand and release the lock. <i>Note: Follow the connector orientation.</i></p><div><p>3. Check the holes/terminal slot for <b>B-B</b> wires.</p></div></div>			n/a	<div><div><p>I-mark was align</p><p>2 holes were only open</p><p>GOOD</p></div><div><p>I-mark is NOT align</p><p>All holes were open</p><p>NG</p></div></div> <p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p>		


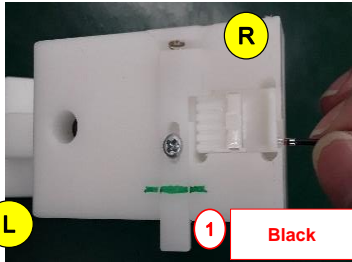
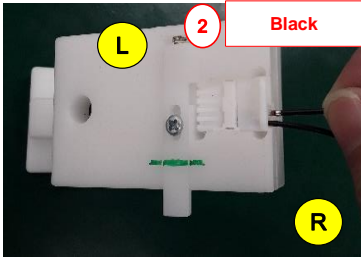
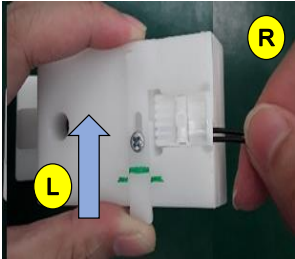
**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**

**MASTER COPY**

DCC Stamp

	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>October 21, 2024</b>		
	Process Name/Title: <b>OFFLINE ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>900B.910B / 7N0104-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS-NX/RX</b>	Document No.:	<b>WI-ENG-PDE-1136</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	3 of 10

<b>PARTS:</b>	1. AVSSf 0.3 B L=666±3mm [2pcs.]			JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
3	OFFLINE	<div><p><b>TERMINAL FACING</b></p></div> <div><p><b>1</b> Black</p></div> <div><p><b>2</b> Black</p></div> <div><p><b>3</b></p></div> <div>1. Get the <b>1st Black wire</b> then insert to connector slot <b>1</b> using right hand.</div> <div>2. Get the <b>2nd Black wire</b> then insert to connector slot <b>2</b> using right hand.</div> <div>3. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</div>		n/a	<p><b>Important reminders/Note/s:</b></p> <p>1. Please hold the wire near terminal during insertion. 2. Insertion of wire must be inserted. 3. Make sure wires are properly inserted. <u>Conduct Pull-Push-Pull-Push after insertion.</u> Do not exert extra force.</p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p><b>Document reference/s:</b></p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip lenght Tolerance 2. Please refer to GL-PRO-ASSY-029 for Pull-Push procedure.</p>

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**

**MASTER COPY**

DCC Stamp

**WORK INSTRUCTION**

Process Name/Title:

**OFFLINE ASSEMBLY PROCESS**

Effectivity Date:

**October 21, 2024**

Model code/Part number:

**900B.910B / 7N0104-7020C**

Customer:

**TRJ**

Car Model:

**LEXUS-NX/RX**

Document No.:

**WI-ENG-PDE-1136**

Purpose:


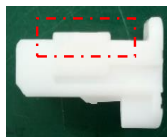

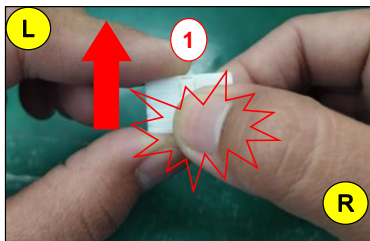
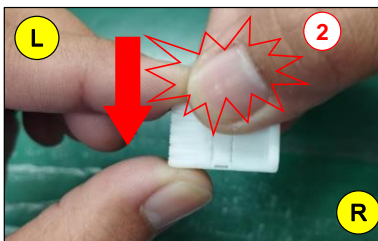

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

**1**

Page No.:


**4 of 10**

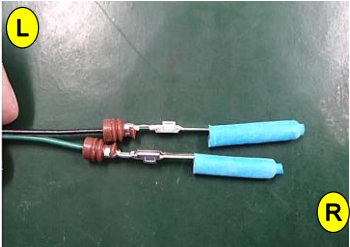



<b>PARTS:</b>		1. Assy parts		JIG:	1. Locking jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
4	OFFLINE	<div></div> <div></div> <div></div> <div><b>Before Pressing</b></div> <div><b>After Pressing</b></div> <div>1. Put the connector into locking jig using right hand then press to lock <b>2x</b>.</div> <div></div> <div></div> <div>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</div>		<div><b>LOCKING JIG</b></div> 	<b>Important reminders/Note/s:</b>  <b>1. Manual locking may cause damaged connector lock</b>  1. Use provided jig tools per model 2. No unlock/ half-locked connector.

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**

DCC Stamp


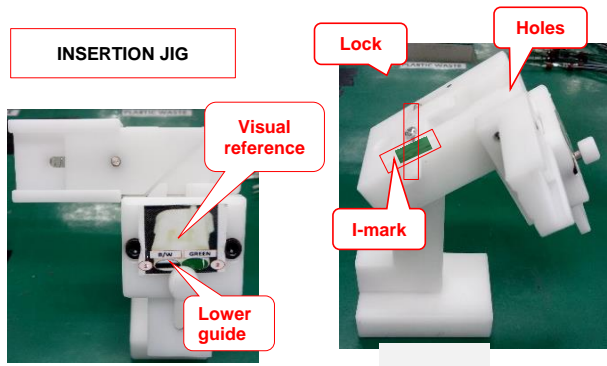
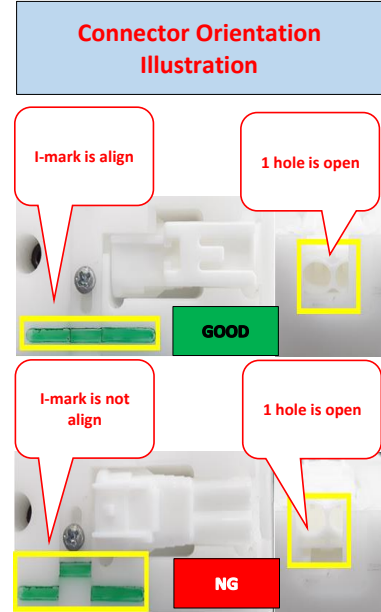
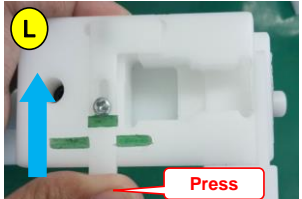
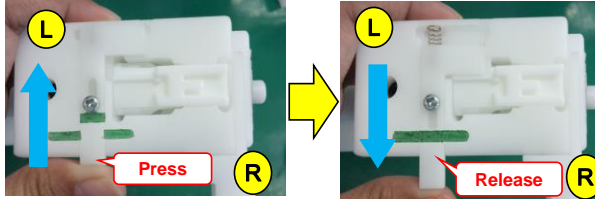
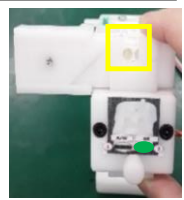
	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>October 21, 2024</b>				
	<b>OFFLINE ASSEMBLY PROCESS</b>				Validity Date:	n/a				
	Process Name/Title:		Model code/Part number: <b>900B.910B / 7N0104-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS-NX/RX</b>		Document No.:	<b>WI-ENG-PDE-1136</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:		1	Page No.:

<b>PARTS:</b>		1. MRSW CP TVSSf 0.3 G-B/W L=608±3mm 2. Black Corrugated tube Ø7 L=78±3mm (no slit)			JIG:	1. Terminal cover jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
5	OFFLINE	<div>Wire insertion to Black Corrugated tube Ø7 L=78±3mm (no slit)</div> <div><p>1. Get the terminal cover jig using right hand then insert the <b>G</b> and <b>B/W</b> wires.</p></div> <div><p>2. Get the Corrugated <b>Ø7 L=78±3mm (no slit)</b> using right hand and insert the <b>G</b> and <b>B/W</b> wires</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div>			<div>TERMINAL COVER JIG</div> 	<p><b>Important reminders/Note/s:</b></p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance</p> <p>1. No wrong use of parts 2. No deformed terminal</p>	

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)  
MASTER COPY

DCC Stamp

		WORK INSTRUCTION				Effectivity Date:		October 21, 2024		
		OFFLINE ASSEMBLY PROCESS				Validity Date:		n/a		
		Model code/Part number: 900B.910B / 7N0104-7020C		Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:		WI-ENG-PDE-1136		
		Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		1	Page No.:	6 of 10
PARTS:		1. Connector 6188-0407 (W)				JIG:		1. Insertion jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS		
6	OFFLINE	<div><div>Connector setting to Insertion jig 6188-0407 (W)</div><div><div></div><div></div><div><div></div><div></div><div></div></div><div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6188-0407 (W) into jig using right hand and release the lock. <i>Note: Refer to above illustration for correct setting.</i></div><div>3. Press the lower wire guide using right thumb. Terminal slot for B/W wire will be open.</div></div></div></div> <td colspan="2">n/a</td> <td colspan="2"><div>Connector Orientation Illustration</div><div>I-mark is align, 1 hole is open (GOOD)</div><div>I-mark is not align, 1 hole is open (NG)</div><div>1. Use the provided jig per model</div><div>2. No wrong orientation of connector</div><div>3. No wrong use of connector</div><div>4. No damaged connector</div></td>				n/a		<div>Connector Orientation Illustration</div> <div>I-mark is align, 1 hole is open (GOOD)</div> <div>I-mark is not align, 1 hole is open (NG)</div> <div>1. Use the provided jig per model</div> <div>2. No wrong orientation of connector</div> <div>3. No wrong use of connector</div> <div>4. No damaged connector</div>		

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**





## WORK INSTRUCTION

Process Name/Title:

## OFFLINE ASSEMBLY PROCESS

Effectivity Date:

October 21, 2024

Model code/Part number: 900B.910B / 7N0104-7020C

Customer: TRJ

Car Model: LEXUS-NX/RX

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

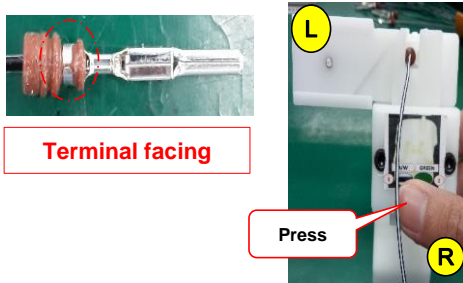
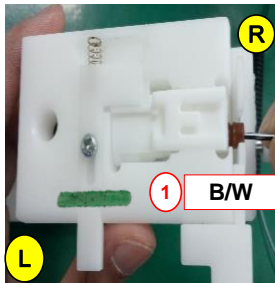
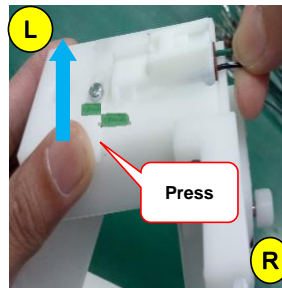
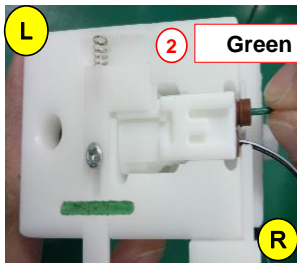
WI-ENG-PDE-1136

Revision No.:

1

Page No.:


7 of 10


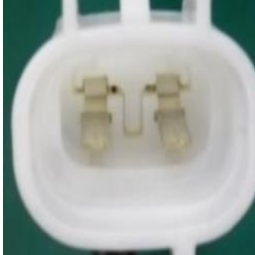

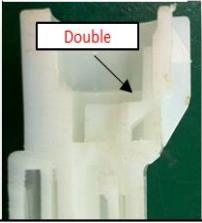
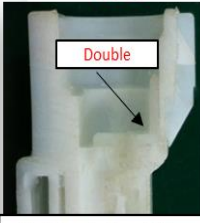
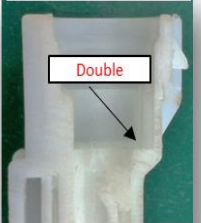

PARTS:	1. MRSW CP (TVSSf 0.3 G-B/W L=608±3mm)			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	OFFLINE	Wire Insetion to Connector 6188-0407 (W)	<div><p>1. Hold the Insertion jig using left hand. Get <b>Black/White wire</b> then insert to terminal <b>slot 1</b> using right hand.</p><p>2. Push the button using right hand. The slot for <b>Green wire</b> will be opened.</p></div> <div><p>3. Get <b>Green wire</b> then insert to terminal <b>slot 2</b> 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><b>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"><li>1. Please hold the wire near terminal during insertion.</li><li>2. Insertion of wire must be inserted.</li><li>3. Make sure wires are properly inserted.</li></ol> <p><b>Conduct Pull-Push-Pull-Push after insertion.</b></p> <p><b>Do not exert extra force.</b></p> <ol style="list-style-type: none"><li>1. No loose insertion</li><li>2. No wrong insertion</li><li>3. One by one insertion</li><li>4. No deformed terminal</li><li>5. No wrong wire facing</li></ol> <p><b>Document reference/s:</b></p> <ol style="list-style-type: none"><li>1. Refer to WI-PRO-CNC-017 for Wire and Strip lenght Tolerance</li><li>2. Please refer to GL-PRO-ASSY-029 for Pull-Push procedure.</li></ol>

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)  
MASTER COPY

DCC Stamp

	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>October 21, 2024</b>		
	Process Name/Title: <b>OFFLINE ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>900B.910B / 7N0104-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS-NX/RX</b>	Document No.:	<b>WI-ENG-PDE-1136</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	8 of 10


<b>PARTS:</b>	1.Assy parts			JIG:	1. Locking jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
8	OFFLINE	Connector Lock	<div><p>1. Put the connector into locking jig using right hand then press to lock <b>2x.</b> Check the connector lock if properly locked.Touch the condition of lock after pressing.</p><div></div><div><b>Before lock</b><b>After lock</b></div><div><b>CONNECTOR CROSS SECTIONAL VIEW</b><div><div><b>NG</b><p>Double</p><p>Unlock Condition</p></div><div><b>NG</b><p>Double</p><p>Half Lock Condition</p></div><div><b>GOOD</b><p>Double</p><p>Full Lock Condition</p></div></div></div></div>	<div><b>LOCKING JIG</b></div> 	<p><b>Important reminders/Note/s:</b></p> <p><b>1. Manual locking may cause damaged connector lock</b></p> <p>1. Use the provided locking per model 2. No unlock/half-locked connector</p>

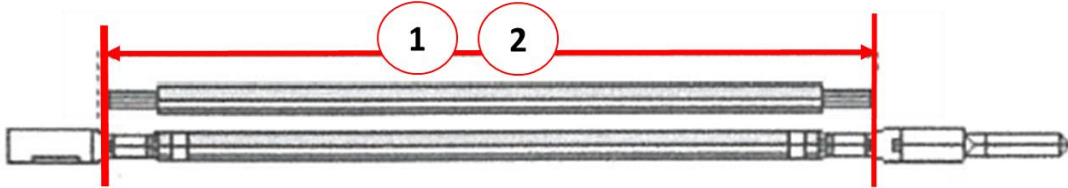

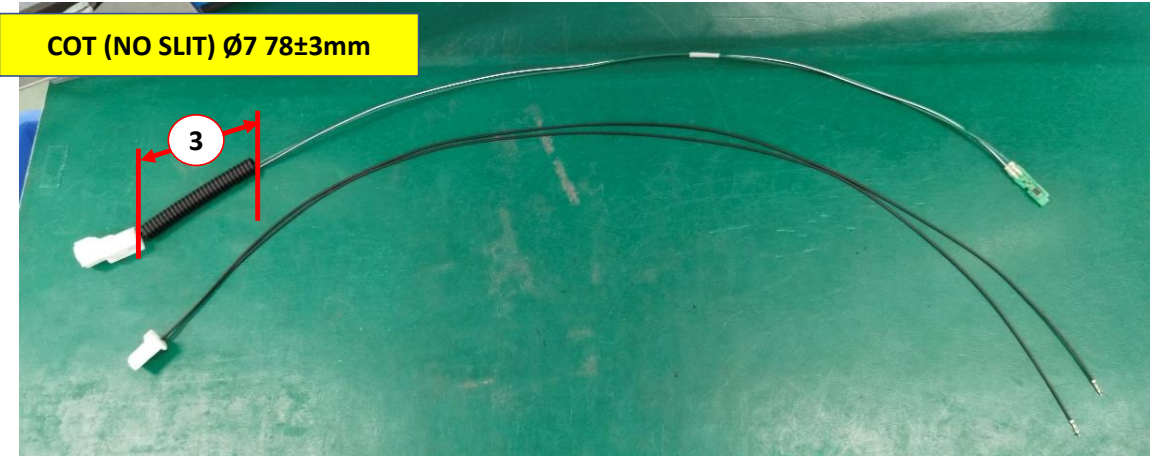
**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**

DCC Stamp



	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>October 21, 2024</b>		
	<b>OFFLINE ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Process Name/Title:		Model code/Part number: <b>900B.910B / 7N0104-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS-NX/RX</b>		Document No.: <b>WI-ENG-PDE-1136</b>
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	1	Page No.:	9 of 10

<b>PARTS:</b>	1. Assy parts			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
10	OFFLINE	Measurement	<div>MEASURING TAPE</div>    <div>COT (NO SLIT) <math>\varnothing 7.78 \pm 3\text{mm}</math></div>	<p>1. No wrong dimension.</p> <p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p>	

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**

**MASTER COPY**

DCC Stamp



# WORK INSTRUCTION

Process Name/Title:

## OFFLINE ASSEMBLY PROCESS

Effectivity Date:

October 21, 2024

Validity Date:

n/a

Model code/Part number: 900B.910B / 7N0104-7020C

Customer: TRJ

Car Model: LEXUS-NX/RX

Document No.:

WI-ENG-PDE-1136

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

10 of 10

PARTS:

1. Assy parts

JIG:

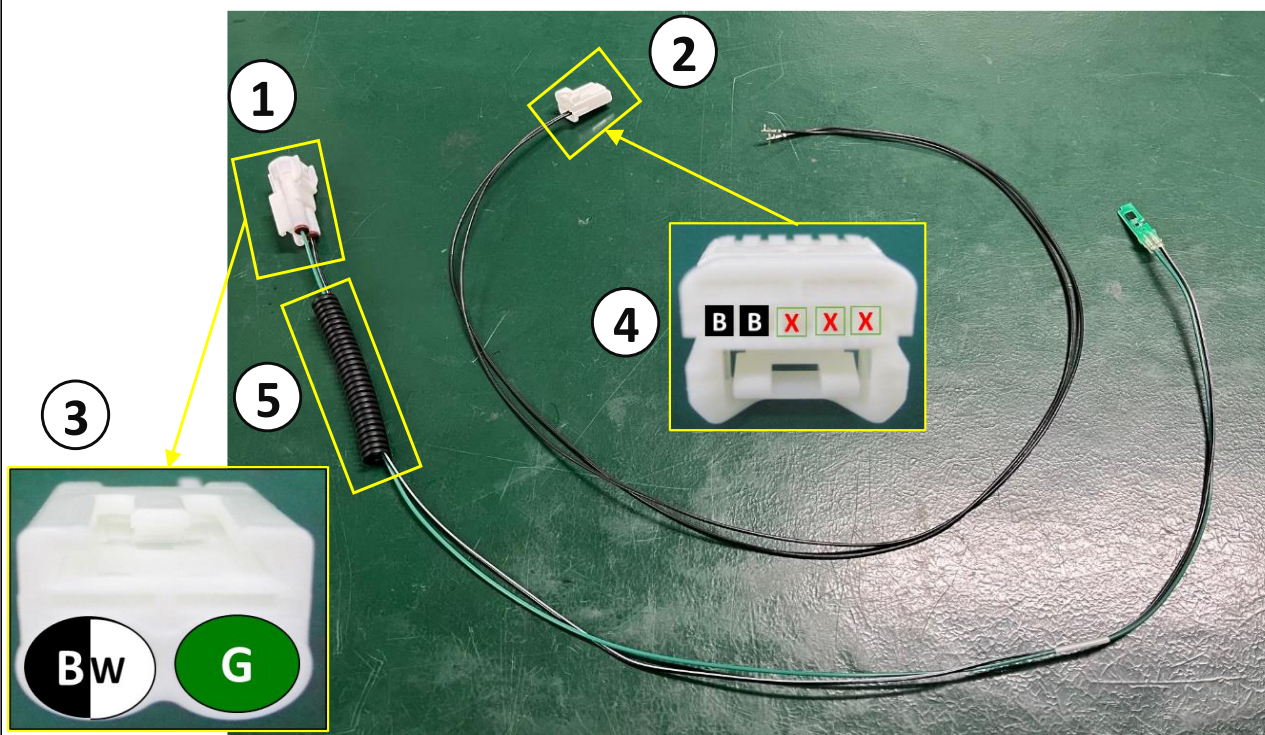
n/a



### VISUAL INSPECTION/ QUALITY CHECKPOINTS

## OFFLINE INSERTION

# 7N0104-7020C



- 1 2 No Unlocked/  
Half-locked connector
- 3 4 No Wrong Insert
- 5 No Missing COT
- 6 No Deformed terminal
- 7 No Terminal backing out

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)  
MASTER COPY

DCC Stamp