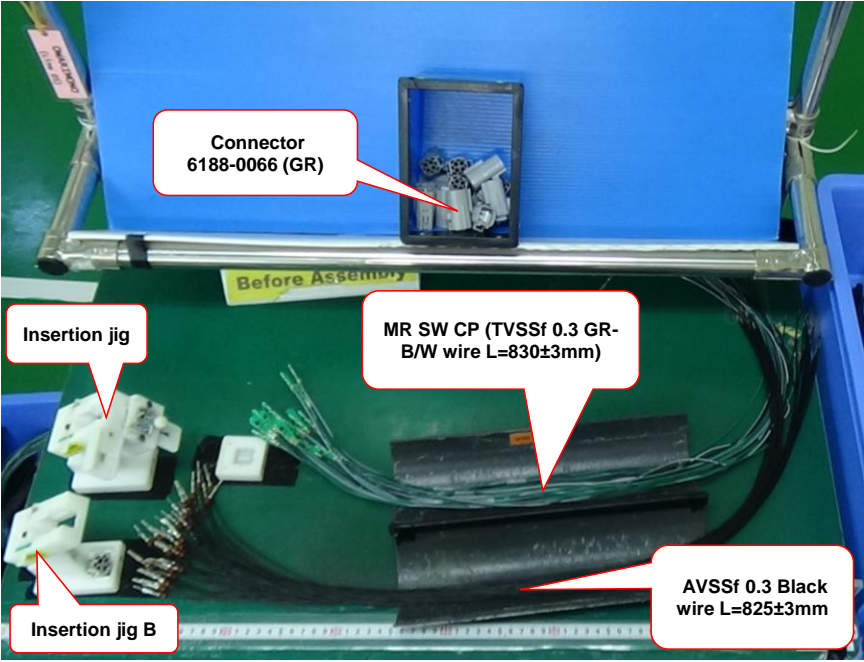

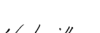

	WORK INSTRUCTION			Effectivity Date:	October 21, 2024			
	OFFLINE ASSEMBLY PROCESS			Validity Date:	n/a			
	Process Name/Title:			Model code/Part number:	240B / 7M0514-7021B	Customer:	TRJ	
			Car Model:	LEXUS-ES	Document No.:	WI-ENG-PDE-1124		
Purpose:				<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO	Revision No.:	1	Page No.:	1 of 8


PARTS:	1. Connector 6188-0066 (GR); MR SW CP (TVSSf 0.3 GR-B/W wire L=830±3mm); AVSSf 0.3 Black wire L=825±3mm			JIG:	1. Insertion jig 2. Locking 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> Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) <div>Housekeeping</div> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. <div>Alert level</div> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	<div>Document reference/s:</div> 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 1. No missing parts/tools 2. No excess parts/tools

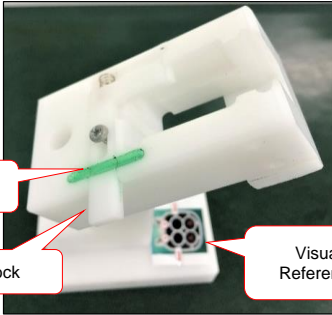
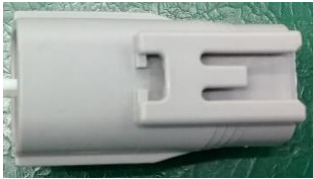
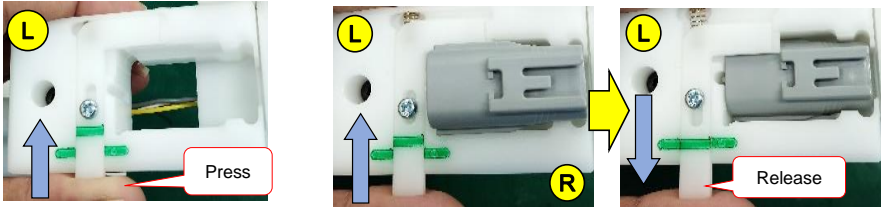
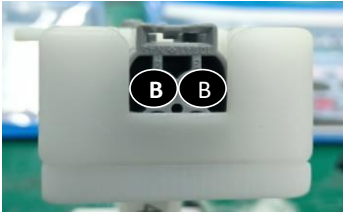
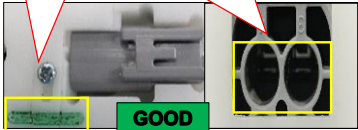

Revision History							Prepared by	Reviewed by	Approved by	Noted by
							 D. Castillo	 C. Villanueva	 A. Arañes	n/a
10/21/24	1	Change from Pre-launch to Masspro.	D.Castillo	C. Villanueva	A. Arañes	n/a				
10/17/24	0	Initial issue. Separate wire insertion to connector and connector lock from Taping assembly process.	D.Castillo	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted	Est. Date:	October 17, 2024	

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	WORK INSTRUCTION				Effectivity Date:	October 21, 2024		
	OFFLINE ASSEMBLY PROCESS				Validity Date:	n/a		
	Process Name/Title:		Model code/Part number: 240B / 7M0514-7021B		Customer: TRJ	Car Model: LEXUS-ES		Document No.: WI-ENG-PDE-1124
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		1	Page No.:

PARTS:	1. Connector 6188-0066 (GR)			JIG:	1. Insertion jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
2	OFFLINE	<div><div>INSERTION JIG ORIENTATION</div><div><div>I-Mark</div><div>Lock</div><div>Visual Reference</div></div><div>CONNECTOR ORIENTATION</div><div></div><div><div>Press</div><div>Release</div></div><div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6188-0066 (GR) into jig using right hand then release the lock. <i>Note: Follow the connector orientation.</i></div><div><div>3. Check the holes/terminal slot for B-B wires.</div></div></div></div>			n/a	<div>Connector Orientation Illustration</div> <div><div>I-mark is align</div><div>2 holes are open</div><div></div><div>GOOD</div></div> <div><div>I-mark is not align</div><div>2 holes are open</div><div></div><div>NG</div></div> <div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div>		

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**WORK INSTRUCTION**

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

October 21, 2024

Validity Date:

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Model code/Part number:

240B / 7M0514-7021B

Customer:

TRJ

Car Model:

LEXUS-ES

Document No.:

WI-ENG-PDE-1124

Purpose:



PROTOTYPE



PRE-LAUNCH




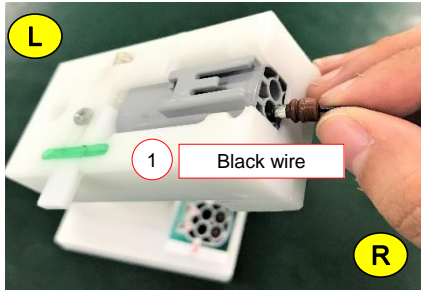
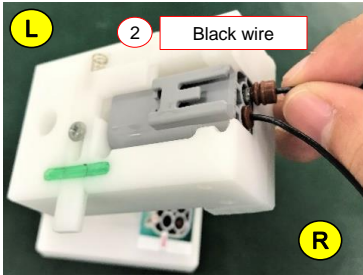

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PARTS:		1. AVSSf 0.3 Black wire L=825±3mm [2pcs]		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	OFFLINE	<div><div></div><div>TERMINAL FACING</div></div> <div><div></div><div>1. Get the first Black wire then insert to terminal slot 1 using right hand. <i>(Note: Insertion of wires must be from left to right.)</i></div></div> <div><div></div><div>2. Get the 2nd Black wire then insert to terminal slot 2 using right hand.</div></div> <div><div></div><div>3. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from the jig using right hand.</div></div>		n/a	<div>1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing</div> <div>Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Insertion of wires must be from left to right. 3. 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>

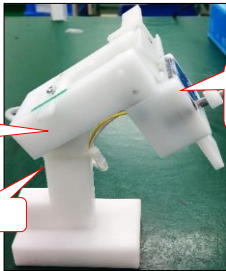

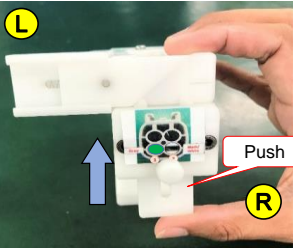
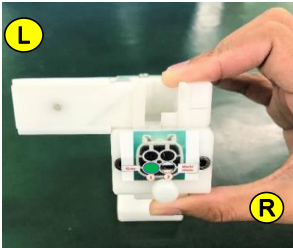
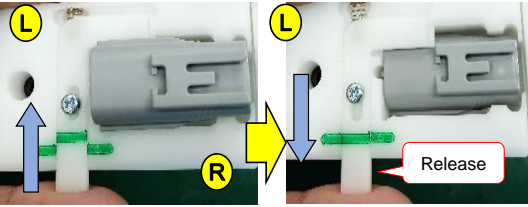
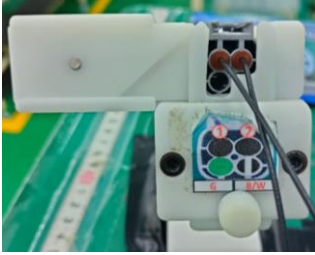
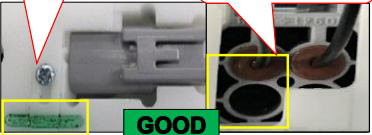

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	WORK INSTRUCTION				Effectivity Date:	October 21, 2024			
	OFFLINE ASSEMBLY PROCESS				Validity Date:	n/a			
	Process Name/Title:		Model code/Part number: 240B / 7M0514-7021B		Customer: TRJ	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-1124	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	1	Page No.:	4 of 8	


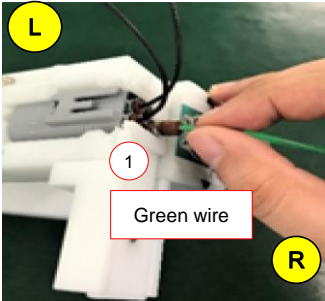
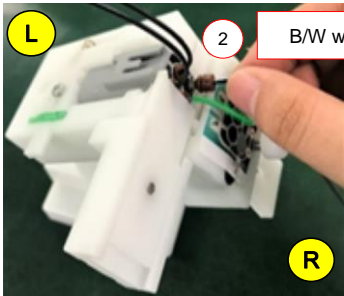
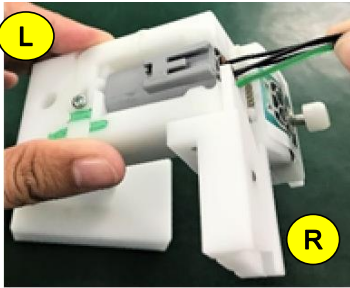
PARTS:		1. Assy parts		JIG:	1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
4	OFFLINE	<div><div>INSERTION JIG ORIENTATION</div><div><p>I-Mark</p><p>Lock</p><p>Visual Reference</p></div><div>CONNECTOR ORIENTATION</div><div><p>Push</p></div><div><p>Release</p></div><div><p>Release</p></div><div>2. Insert the connector 6188-0066 (GR) with assy parts into jig using right hand then release the lock. <i>Note: Follow the connector orientation.</i></div><div><p>3. Check the holes/terminal slot for G wire is open.</p></div></div>		n/a	<div>Connector Orientation Illustration</div> <div><p>I-mark is align</p><p>1 hole is open</p><p>GOOD</p></div> <div><p>I-mark is not align</p><p>2 hole is open</p><p>NG</p><p>1. No wrong wire facing</p></div>	

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	Model code/Part number: 240B / 7M0514-7021B		Customer: TRJ	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-1124	
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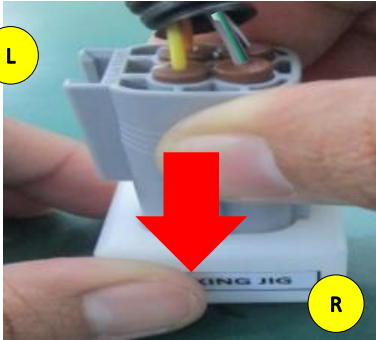


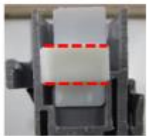
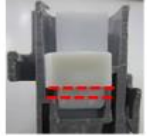
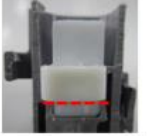

PARTS:	1. Assy parts			JIG:	1. Locking jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
5	OFFLINE	Wire insertion to Connector 6188-0066 (GR) (Assy parts)	<div><p>TERMINAL FACING</p></div> <div><p>1. Get the MR SW CP wires then hold. Insert the G wire to terminal slot 1 using right hand. After insertion, press the button using right thumb and slot for B/W will be opened.</p></div> <div><p>2. Get the MR SW CP Black/white wire then insert to terminal slot 2 using right hand.</p></div> <div><p>3. 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 wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing</p> <p>Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Insertion of wires must be form left to right. 3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>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</p>		

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	Process Name/Title: OFFLINE ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 240B / 7M0514-7021B		Customer: TRJ	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-1124	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	6 of 8

PARTS:	1. Assy parts			JIG:	1. Locking jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
6	OFFLINE	Connector lock	<div><div><div><div><div>L</div></div><div><div>1. Put the connector into locking jig using both hands and then conduct 2x pressing. Check the connector if properly locked.</div></div></div></div><div><div><div>Before pressing</div><div>After pressing</div></div><div><div>Connector Cross Sectional View</div><div><div><div>NG</div><div>Unlock</div></div><div><div>NG</div><div>Half Lock Condition</div></div><div><div>GOOD</div><div>Full Lock Condition</div></div></div></div></div><div><div>LOCKING JIG</div></div><div><div>Document references:</div><div>1. Manual locking may cause damaged connector lock</div><div>1. Use the provided locking jig per model</div><div>2. No unlock/half-locked connector</div><div>3. No damaged lock</div></div></div>				

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**WORK INSTRUCTION**

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Model code/Part number:

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:

1. Assy parts

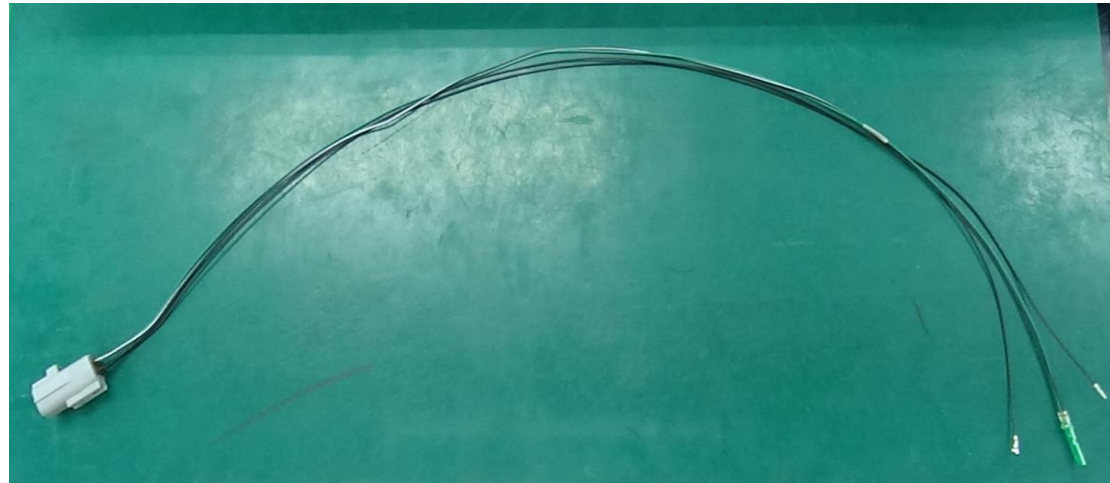
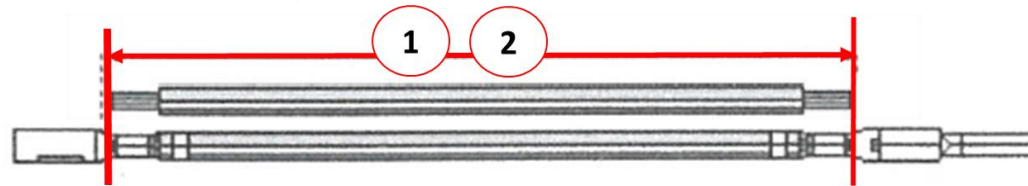
JIG:

n/a

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

Note:

1. Measurement point: End of core wire to the end of core wire
2. Terminal is reference only.



1. No wrong dimension.

Important reminders and note/s:

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

Document reference/s:

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

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Model code/Part number:

240B / 7M0514-7021B

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PROTOTYPE



PRE-LAUNCH



MASSPRO

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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**OFFLINE INSERTION****7M0514-7021B**

- ① **No Unlocked/Half-locked connector**
- ② **No Wrong Insert**
- ③ **No Terminal Backing Out**
- ④ **No Deformed Terminal**

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