



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 20, 2024

Process Name/Title:

Model code/Part number:

800B/900B/
910B

/ 7N0101-7020B

Customer:

TRJ

Car Model:

LEXUS NX/RX

Validity Date:

n/a

Document No.:

WI-ENG-PDE-458A

Purpose:



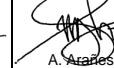
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Connector 6188-0175 (GR); AVSSf 0.3 wires Y-OR L=713±3mm; Black SV tube (Vinyl) ø7 L=178±3mm; Black COT (no slit) ø7 L=171±3mm; Black COT (no slit) ø5 L=316±3mm; Connector 6098-2220 (W); MRSW CP TVSSf 0.3 G-BW wires L=792±3mm; Black SV tube (Vinyl) ø5 L=69±3mm; AVSSf 0.3 B-B wires L=679±3mm; Connector 6098-3810 (W); Black tape						JIG:		1. Insertion jig with & w/o switch cover 2. Locking jig 3. Terminal cover jig															
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION						TOOLS/PPE		QUALITY POINTERS													
1		P1		Table Lay-out						<div><div><div>Safety Instruction</div><div>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div></div><div><div>Housekeeping</div><div>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div></div><div><div>Alert level</div><div>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div></div>		<div>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to WI-PRO-KIT-005 Wire Taping without Vinyl Tube</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>													
Revision History																									
06/20/24		5		Additional Work procedure/Illustration and notes on page 7-8 as countermeasure for the customer claim (Broken lock of connector 6098-2220 (W)).						D. Castillo		C. Villanueva		A.Arañes		n/a		Prepared by		Reviewed by		Approved by		Noted by	
08/15/24		4		Changed table lay-out illustration. Inclusion of Locking process- Connector 6098-2220 (W); Transfer process of Taping 1- Black SV tube (Vinyl) to wire near connector (6188-0175 GR); Taping 2 Black SV tube (Vinyl) to wire near connector 6098-3810 (W) from P1 to P2 due to new process distribution.						M. Ariola		J. Loterte		C. Villanueva		A. Arañes									
04/06/23		3		Work instruction improvement. Change MP from 4MP to 3MP. Transfer Taping 1 Black SV tube (Vinyl) to wire near connector (6188-0175 (GR)) and Taping 2 Black SV tube (Vinyl) to wire near connector (6098-3810 (W)) process from P2 to P1 (Page 11 and 14). Update table lay-out. Change term from vinyl tube to SV tube (Vinyl). Inclusion of Quality checkpoints (Page 15)						D. Castillo		J. Loterte		C. Villanueva		A. Arañes		 D Castillo		 C. Villanueva		 A. Arañes		n/a	
Eff. Date		Rev. No		Details of Change						Revised		Reviewed		Approved		Noted		Est. Date:		April 12, 2022					

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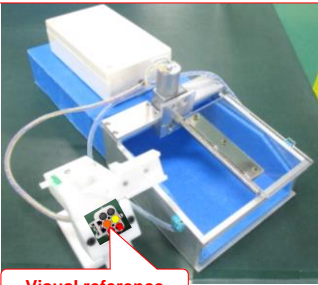
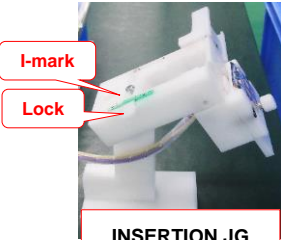

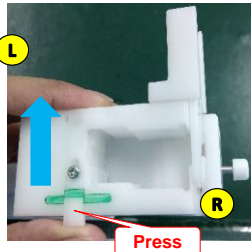
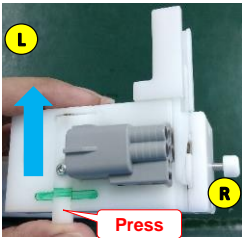
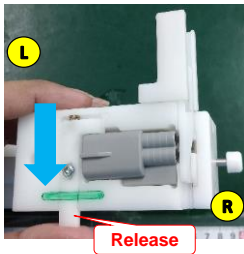

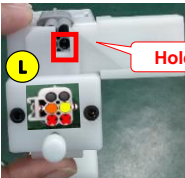
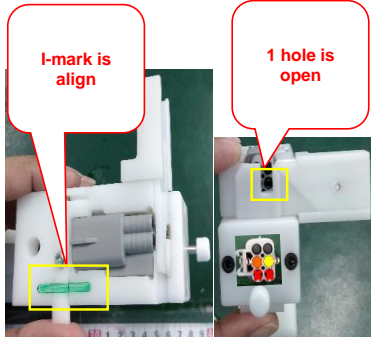
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PARTS:	1. Connector 6188-0175 (GR)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Connector setting to Insertion jig 6188-0175 (GR)	<div><div>Insertion jig with switch cover</div><div><div>Visual reference</div></div><div><div>I-mark</div><div>Lock</div><div>INSERTION JG ORIENTATION</div></div><div><div>CONNECTOR ORIENTATION</div></div><div><div>L</div><div>Press</div></div><div><div>L</div><div>Press</div></div><div><div>L</div><div>Release</div></div><div><div>2. Get the connector 6188-0175 (GR) using right hand and insert to insertion jig. Release the lock after insertion. Note: Follow the connector orientation.</div></div><div><div>L</div><div>Hole</div></div><div><div>L</div><div>Hole</div></div><div><div>3. Push the lower wire guide upward using left thumb. Slot for Yellow wire will be opened.</div></div></div>	N/A	<div>Connector Orientation Illustration</div> <div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</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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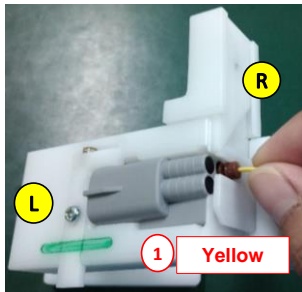
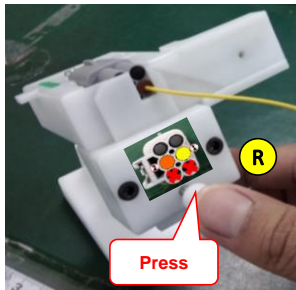
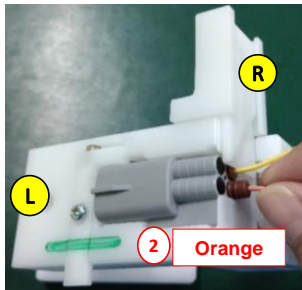
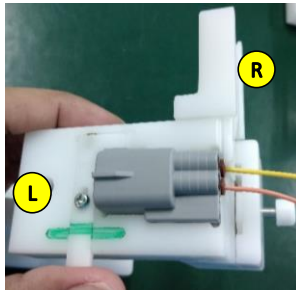
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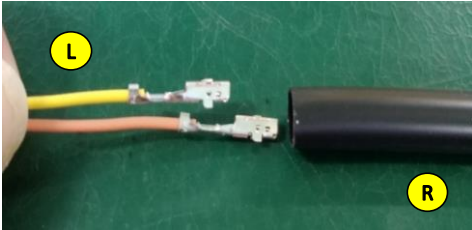

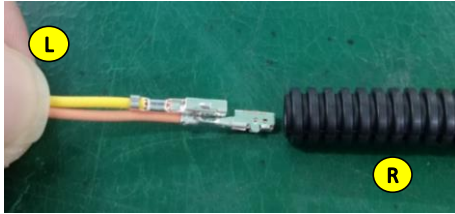

PARTS:		1. AVSSf 0.3 wires Y-OR L=713±3mm		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1	<div><div><p>Wire facing</p></div><div><p>1. Hold the insertion jig using left hand. Get Yellow wire then insert to terminal slot 1 using right hand.</p></div><div><p>2. Press the button using right thumb. The slot for Orange wire will be opened.</p></div><div><p>3. Get the Orange wire then insert to terminal slot 2 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> <div>N/A</div> <td><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>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></td>		<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>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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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	5	Page No.:	4 of 16

PARTS:	1. Assy parts 2. Black SV tube (Vinyl) $\phi 7$ L=178 \pm 3mm 3. Black COT (no slit) $\phi 7$ L=171 \pm 3mm 4. Black COT (no slit) $\phi 5$ L=316 \pm 3mm			JIG:	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Wire insertion to Black SV tube (Vinyl) $\phi 7$ L=178 \pm 3mm	 <div>1. Get the Black SV tube (Vinyl) $\phi 7$ L=178\pm3mm using right hand then insert the Y-OR wires.</div>		N/A	1. No wrong use of parts 2. No deformed terminal
5	Wire insertion to Black corrugated tube (no slit) $\phi 7$ L=171 \pm 3mm (1ST) $\phi 5$ L=316 \pm 3mm (2ND)	 <div>1. Get the Black COT (no slit) $\phi 7$ L=171\pm3mm using right hand then insert the Y-OR wires.</div>  <div>2. Get the Black COT (no slit) $\phi 5$ L=316\pm3mm using right hand then insert the Y-OR wires.</div> 			

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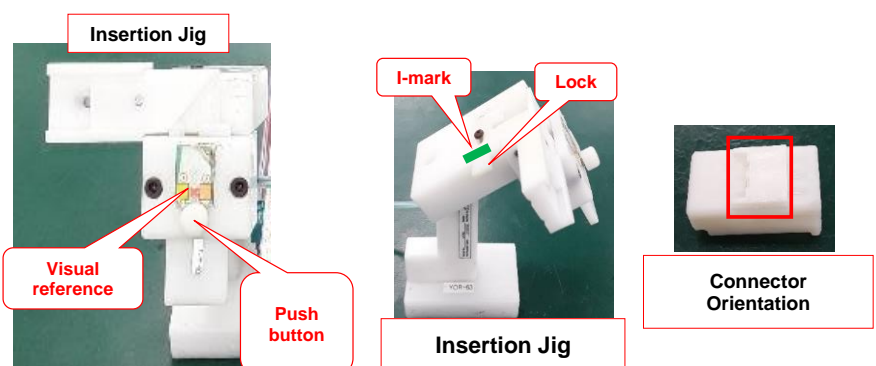
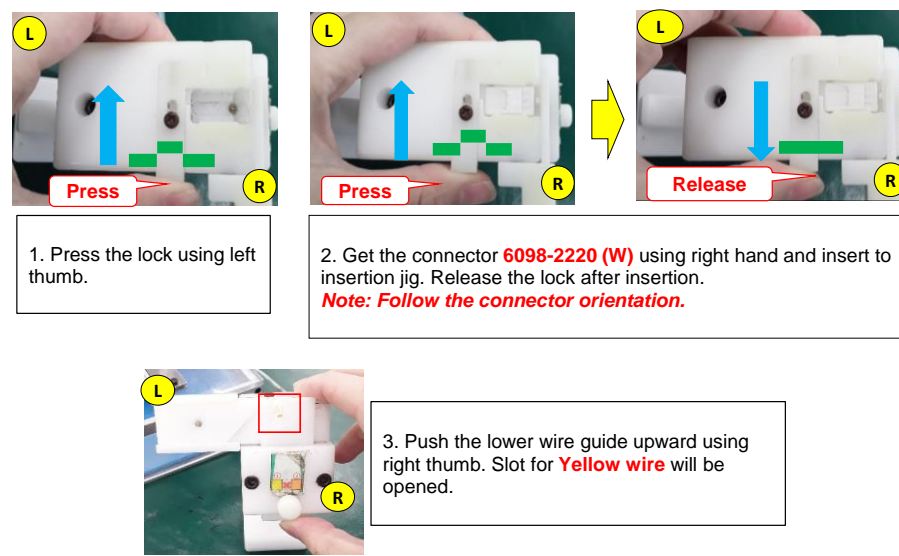
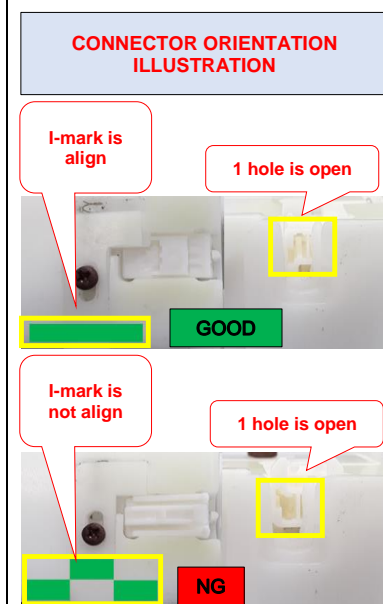
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PARTS:		1. Connector 6098-2220 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1	<p>Connector setting to Insertion jig 6098-2220 (W)</p>   <p>1. Press the lock using left thumb.</p> <p>2. Get the connector 6098-2220 (W) using right hand and insert to insertion jig. Release the lock after insertion. Note: Follow the connector orientation.</p> <p>3. Push the lower wire guide upward using right thumb. Slot for Yellow wire will be opened.</p>		N/A	<p>CONNECTOR ORIENTATION ILLUSTRATION</p>  <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>

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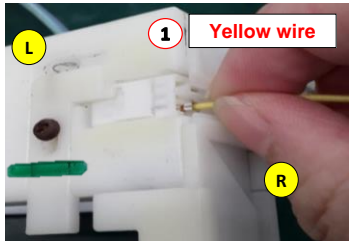
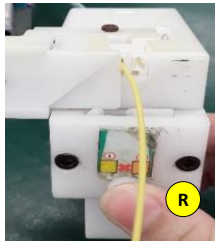
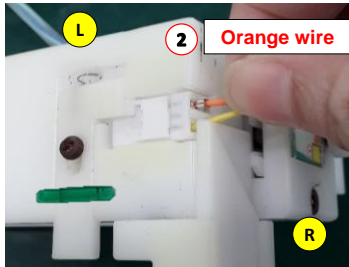
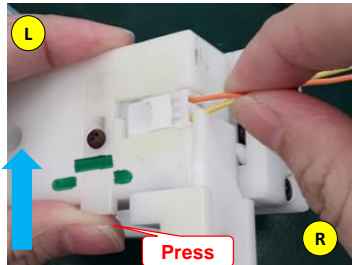
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PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1 Wire Insertion to Connector 6098-2220 (W)	<div><div>Wire facing</div></div> <div><div>1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot 1 using right hand.</div></div> <div><div>2. Press the button using right thumb. The slot for Orange wire will be opened.</div></div> <div><div>3. Get the Orange wire then insert to terminal slot 2 using right hand.</div></div> <div><div>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.</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>Important reminders/Note/s: <i>1. Please hold the wire near terminal.</i> <i>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</i></div> <div>Document references: <i>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i></div>

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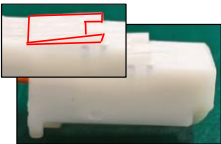
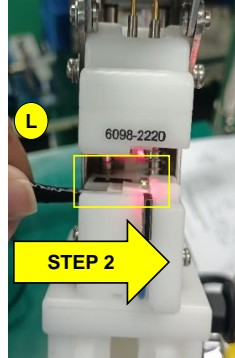
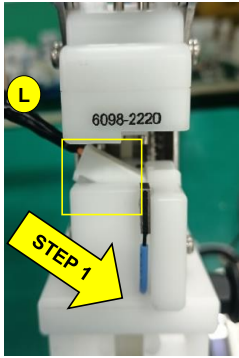
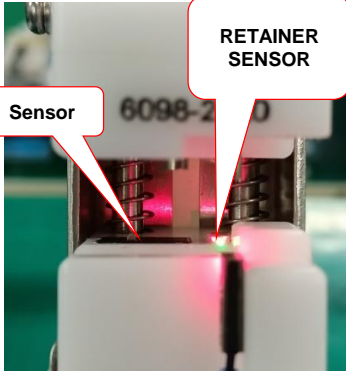
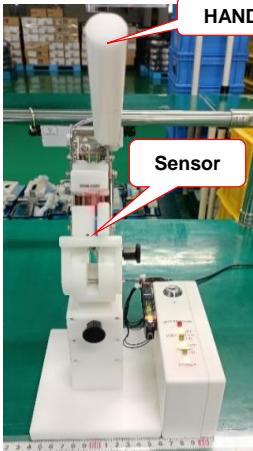
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PARTS:	1. Assy parts			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P2 Connector lock	<div><h3>CONNECTOR RETAINER ILLUSTRATION</h3><h4>SIDE VIEW</h4><div><p>GOOD</p></div><div><p>NG</p></div></div> <div></div> <div><p>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.</p><p>NOTE: CONNECTOR LOCKING JIG WILL NOT FUNCTION IF CONNECTOR NOT REACH THE SENSOR.</p></div>		<p>1. Check the Retainer lock of connector before insertion to locking jig.</p> <p><i>Note: Must be NO half-locked condition prior connector locking.</i></p>	<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. <i>Incomplete locking process will alarm the jig.</i></p> <p>2. <i>No retainer in connector cannot proceed.</i></p> <p>3. <i>If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</i></p>

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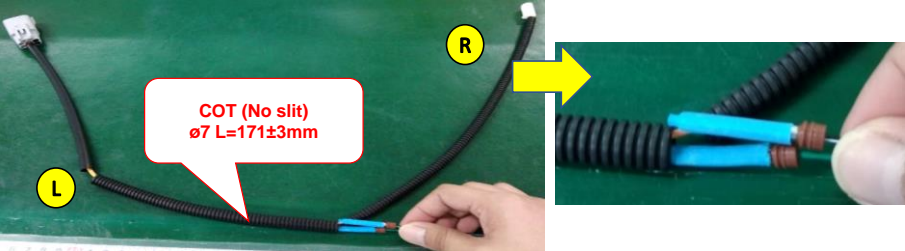
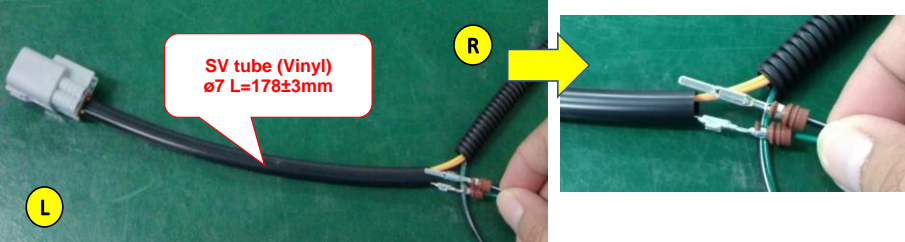

PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P2 Connector lock (Continuation)	<div><div><div></div><div></div><div></div><div></div><div></div><div></div><div></div></div><div><p>3. Hold the handle of the connector locking jig 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. <i>Incomplete locking process will alarm the jig.</i></p> <p>2. <i>No retainer in connector cannot proceed.</i></p> <p>3. <i>If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</i></p>

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PARTS:	1. Assy parts 2. MRSW CP TVSSf 0.3 G-BW wires L=792±3mm			JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1 Wire insertion to assy parts	<div><p>1. Get the cover jig then insert to G-B/W wires using right hand.</p></div> <div><p>2. Hold the corrugated tube (no slit) ø7 L=171±3mm using left hand then insert G-B/W wires using right hand.</p></div> <div><p>3. Hold the SV tube (Vinyl) ø7 L=178±3mm using left hand then insert G-B/W wires using right hand.</p></div>		<div>TERMINAL COVER JIG</div> 	1. No wrong use of parts 2. No deformed terminal

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WORK INSTRUCTION

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June 20, 2024

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

800B/900B/
910B

/ 7N0101-7020B

Customer: TRJ

Car Model:

LEXUS NX/RX

Document No.:

WI-ENG-PDE-458A

Purpose:


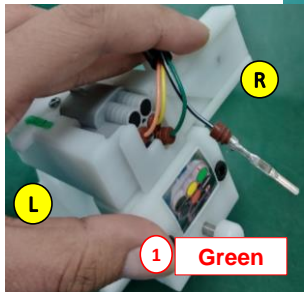
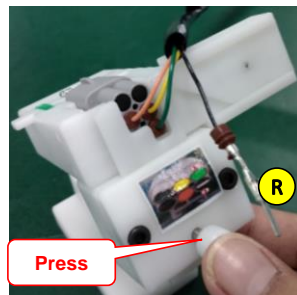
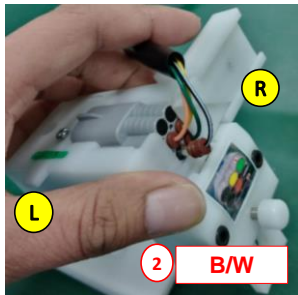
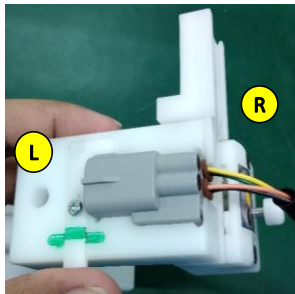
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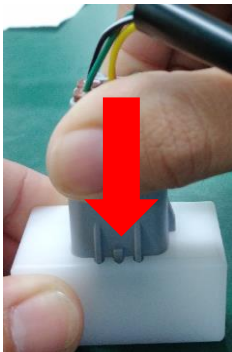




PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
11	P1 Wire insertion to Connector 6188-0175 (GR) (Assy parts)	<div> Wire facing</div> <div> 1. Hold the insertion jig using left hand. Get Green wire then insert to terminal slot 1 using right hand.</div> <div> 2. Press the button using right hand. The slot for Black/white wire will be opened.</div> <div> 3. Get the Black/white wire then insert to terminal slot 2 using right hand.</div> <div> 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.</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>Important reminders/Note/s: <i>1. Please hold the wire near terminal.</i> <i>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</i></div> <div>Document references: <i>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i> <i>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</i></div>

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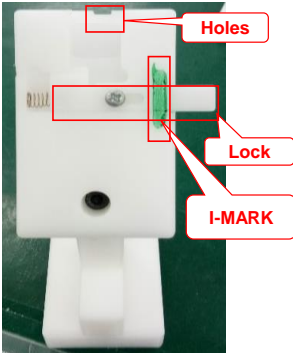
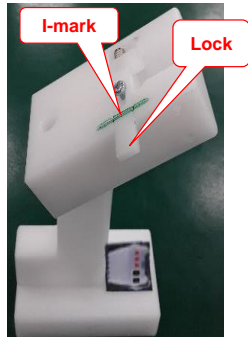
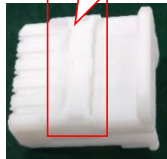
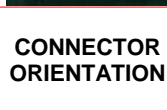
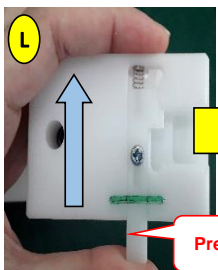
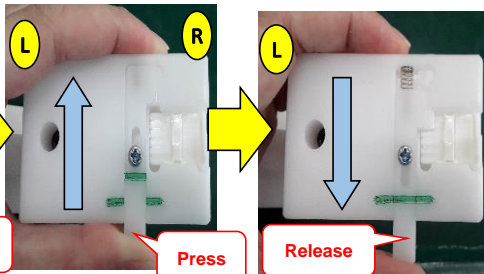

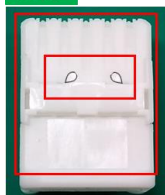
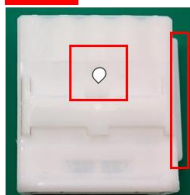

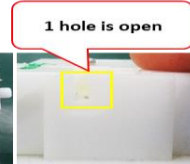
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	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 800B/900B/910B / 7N0101-7020B		Customer: TRJ	Car Model: LEXUS NX/RX	Document No.:	WI-ENG-PDE-458A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	5	Page No.:	12 of 16

PARTS:	1. Assy parts 2. Black SV tube (Vinyl) ø5 L=69±3mm 3. AVSSf 0.3 B-B wires L=679±3mm			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
12	Connector lock	 <div> <p>1. Hold the connector using left hand then press 2x to lock using right hand. Touch the connector lock to confirm if properly locked.</p> </div> <div>   </div> <div> <p>NOTE: SET ASIDE THE ASSY PARTS</p> </div>		<div> <p>LOCKING JIG</p>  </div>	<p>Important reminders/Note/s:</p> <p>1. Manual locking may cause damaged connector lock.</p> <p>1. Use the provided jig per connector 2. No unlock/half-locked connector</p>
13	Wire insertion to Black SV tube (Vinyl) ø5 L=69±3mm	 <div> <p>1. Get the Black SV tube (Vinyl) ø5 L=69±3mm using right hand then insert the B-B wires.</p> </div>		N/A	<p>Document reference/s:</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>

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		TAPING ASSEMBLY PROCESS				Validity Date:		n/a		
		Model code/Part number: 800B/900B/910B / 7N0101-7020B		Customer: TRJ	Car Model: LEXUS NX/RX		Document No.:		WI-ENG-PDE-458A	
		Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		5	Page No.:	13 of 16
PARTS:		1. Assy parts 2. Connector 6098-3810 (W)				JIG:		1. Insertion jig		
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS		
14		P1 Connector setting to Insertion jig 6098-3810 (W)		<div><div><p>INSERTION JIG</p></div><div><p>Insertion Jig Orientation</p></div><div><p>Connector lock</p></div><div><p>CONNECTOR ORIENTATION</p></div></div> <div><div><p>Press</p><p>1. Press the lock of insertion jig using left thumb.</p></div><div><div><p>Press</p><p>2. Get the connector 6098-3810 (W) using right hand then insert to jig using right hand and release the lock using left thumb. <i>Note: Follow the connector orientation.</i></p></div><div><div><p>Release</p><p>3. Check the holes/terminal slot for B-B wires.</p></div></div></div><div>N/A</div><div><div><p>1. Use the provided jig per model</p><p>2. No wrong orientation of connector</p><p>3. No wrong use of connector</p><p>4. No damaged connector</p></div><div><div><p>CONNECTOR ILLUSTRATION</p><div><div><p>GOOD</p><p>6098-3810 (W)</p></div><div><p>NG</p><p>6098-5677 (W)</p></div></div><div><p>Connector Orientation Illustration</p><div><div><p>I-mark was align</p><p>GOOD</p></div><div><p>1 hole is open</p><p>NG</p></div></div></div></div></div></div></div>						

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/ 7N0101-7020B

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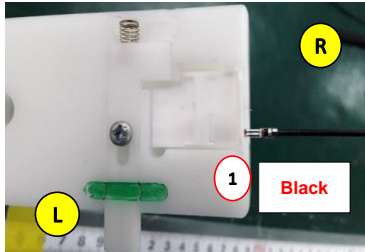
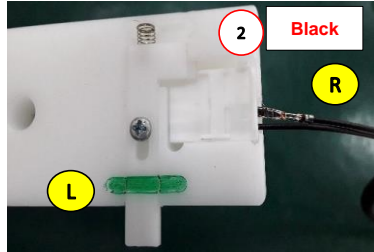
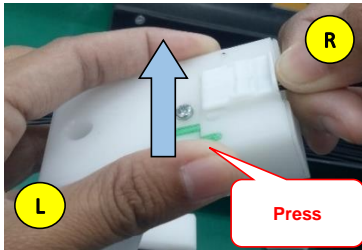
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PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
15	P1 Wire insertion to connector 6098-3810 (W)	<div><div>WIRE FACING</div></div> <div><div>1. Get 1st black wire then insert to terminal slot 1 using right hand. Note : Insertion should be from left to right.</div></div> <div><div>2. Get 2nd Black wire then insert to terminal slot 2 using right hand.</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 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>Important reminders/Note/s: <i>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.</i></div> <div>Document references: <i>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></div>

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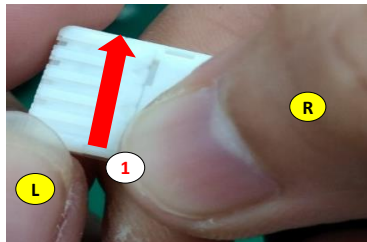
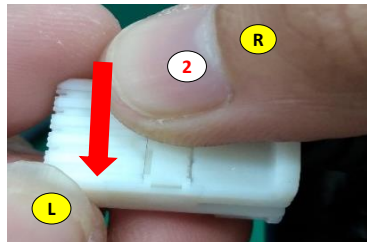
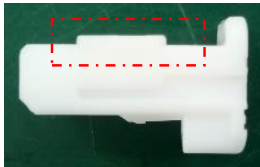
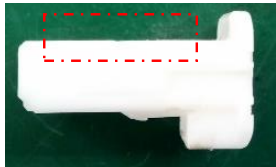

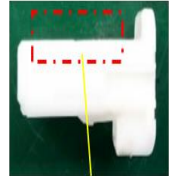
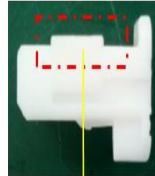
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PARTS:		1. Assy parts 2. Black tape		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
16	P1 Connector Lock	<div><div></div><div><p>1. Put the connector into locking jig using right hand then press 2x using both hands. Touch the connector lock to confirm if properly locked.</p></div><div><div></div><div></div><div><p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div><div><div></div><div></div><div>Before Pressing</div><div>After Pressing</div></div></div></div>		<div>LOCKING JIG</div> 	<p>1. Use the provided jig per connector 2. No unlock/half-locked connector</p> <p>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR.</p> <div>CONNECTOR LOCK CONDITION</div> <div><div><p>GOOD</p><p>Fully Locked</p></div><div><p>NG</p><p>UnLocked</p></div></div> <p>Document reference/s: 1. Please refer to GL-PRO-ASY-017 for the verification of connector lock.</p>

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PARTS:

1. Assy parts

JIG:

N/A

VISUAL INSPECTION/ QUALITY CHECKPOINTS

P1

7N0101-7020B



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