

	<b>WORK INSTRUCTION</b>						Effectivity Date:		July 31, 2024				
	<b>TAPING ASSEMBLY PROCESS</b>						Validity Date:		n/a				
	Process Name/Title:			Model code/Part number: <b>900B/ 910B / 7N0072-7020C</b>			Customer: <b>TRJ</b>		Car Model: <b>LEXUS-NX/RX</b>		Document No.:	<b>WI-ENG-PDE-461A</b>	
	Purpose:			<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:		5		Page No.:	1 of 13	


<b>PARTS:</b>		1. Assy parts; Connector 6098-3810(W); Connector 6098-3802(W); Black SV tube(Vinyl) Ø5 L=69±3mm; Black Corrugated tube Ø5 L=171±3mm; Black SV tube(Vinyl) Ø5 L=182±3mm; Black Corrugated tube Ø5 L=275±3mm; AVSSf 0.3 B-G L=679±3mm						JIG:		1.Terminal cover jig 2.Insertion jig with switch cover 3.Locking jig													
<b>NO.</b>	<b>PROCESS NAME</b>	5 <b>WORK PROCEDURE/ ILLUSTRATION</b>						<b>TOOLS/PPE</b>		<b>QUALITY POINTERS</b>													
1	P1	<div style="text-align: center;"> <b>TABLE LAY-OUT</b> </div>						<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> <b>Housekeeping</b>            1. Maintain and always practice 5's.            2. Personal things on the workplace is prohibited. Keep it in your locker.         </div> <div style="border: 1px solid red; padding: 5px;"> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>		<div style="margin-bottom: 10px;"> <b>Document reference/s:</b>            1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance            2. Refer to WI-ENG-PDE-905 for Offline assembly process         </div> <div style="text-align: center;"> <b>CONNECTOR ILLUSTRATION</b> </div> <table style="width: 100%; text-align: center;"> <tr> <td style="width: 50%;">GOOD</td> <td style="width: 50%;">NG</td> </tr> <tr> <td></td> <td></td> </tr> <tr> <td>6098-3802 (W)</td> <td>6098-5668 (W)</td> </tr> </table> <div style="text-align: center;"> <b>CONNECTOR ILLUSTRATION</b> </div> <table style="width: 100%; text-align: center;"> <tr> <td style="width: 50%;">GOOD</td> <td style="width: 50%;">NG</td> </tr> <tr> <td></td> <td></td> </tr> <tr> <td>6098-3810 (W)</td> <td>6098-5677 (W)</td> </tr> </table>		GOOD	NG			6098-3802 (W)	6098-5668 (W)	GOOD	NG			6098-3810 (W)	6098-5677 (W)
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6098-3802 (W)	6098-5668 (W)																						
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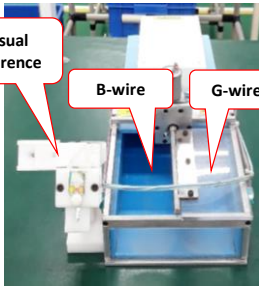

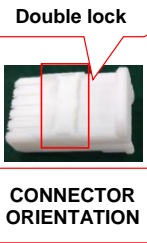
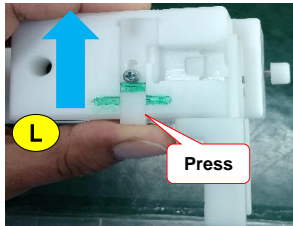
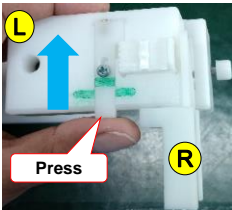
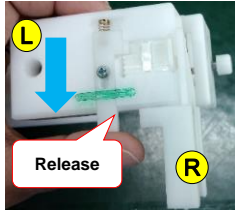
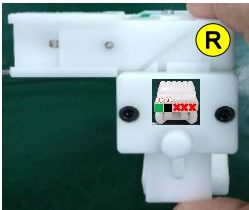
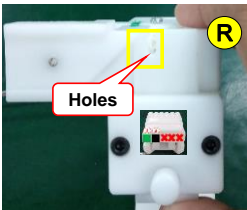
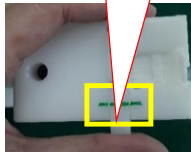
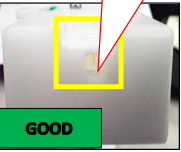
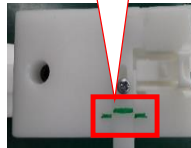
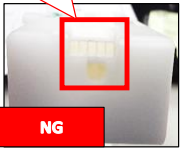

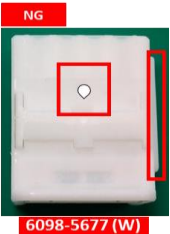
  

Revision History							Prepared by	Reviewed by	Approved by	Noted by
07/31/24	5	Separate Connector setting (6098-2220 (W)). Wire insertion to connector, Connector lock and Wire insertion to COT to Offline assembly process and Change process sequence due to process improvement. Inclusion of car model "LEXUS-NX/RX". Update table lay-out and Visual inspection/Quality checkpoints.	D.Castillo	C.Villanueva	A. Arañes	N/A	 D. Castillo	 C. Villanueva	 A. Arañes	N/A
08/15/23	4	Change MP from 2MP to 3MP; Exluded process no. 2,3, 4 and 5 from OFFLINE ASSEMBLY PROCESS transfer to P1: Inclusion of locking process of connector 6098-2220 (W); Inclusion of Quality checkpoints on page no.18; Transfer process of 1,15;16 and 17 to P2; process no. 18 to P3 due to Change process distribution. Change table lay-out. Standardized tube description: SV tube (Vinyl); VM tube (Sunprene).	M.Ariola	J. Loterte	C.Villanueva	A. Arañes				
12/09/22	3	Improvement Project: Change MP from 3MP to 2MP. Moved Taping 1 Black vinyl tube to wire near connector and Wire Insertion to Black Corrugated tube Ø5 L=171±3mm (No slit)(Assy parts) process to Page 2-3. Update connector lock process (Page 6). Transfer Wire insertion to Black sunprene tube, Taping 4 Black COT to Black sunprene tube near terminal and Taping 2 Black Corrugated tube to Wire near connector (Page 15-16). Include quality pointers (Page 16).	D.Castillo	J. Loterte	C.Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	April 12, 2022		

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Process Name/Title:		TAPING ASSEMBLY PROCESS			Validity Date:		n/a					
Model code/Part number: 900B/ 910B / 7N0072-7020C		Customer: TRJ		Car Model: LEXUS-NX/RX		Document No.:		WI-ENG-PDE-461A				
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PARTS:		1. Connector 6098-3810 (W) 2. AVSSf 0.3 G-B wires L=679±3mm					JIG:		1. Insertion jig with switch cover				
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION					TOOLS/PPE		QUALITY POINTERS		
2		P1		<div><div><div><div><div>Insertion Jig</div><div></div></div><div><div>Visual reference</div><div>B-wire</div><div>G-wire</div></div></div><div><div>Insertion Jig Orientation</div><div></div><div><div>I-mark</div><div>Lock</div></div></div><div><div>Double lock</div><div></div><div><div>CONNECTOR ORIENTATION</div></div></div></div><div><div><div><div><div></div><div><div>L</div><div>Press</div></div></div><div><div></div><div><div>L</div><div>Press</div><div>R</div></div></div><div><div></div><div><div>L</div><div>Release</div><div>R</div></div></div></div><div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6098-3810 (W) using right hand and release the lock using left hand. <i>Note: Follow the connector orientation.</i></div></div><div><div><div><div><div></div><div><div>R</div><div>Holes</div></div></div><div><div></div><div><div>R</div><div>Holes</div></div></div></div><div><div>3. Push the guide using right thumb, hole for G wires will be opened.</div></div></div></div></div></div></div>					n/a		<div><div><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></div><div><div><div><div><div>I-mark was align</div><div></div></div><div><div>1 hole were only open</div><div></div></div></div><div><div><div><div>I-mark is NOT align</div><div></div></div><div><div>1 hole were open</div><div></div></div></div><div><div>CONNECTOR ILLUSTRATION</div><div><div><div><div>GOOD</div><div></div></div><div><div>NG</div><div></div></div></div><div><div>6098-3810 (W)</div><div>6098-5677 (W)</div></div></div></div></div></div></div></div></div>		

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**TAPING ASSEMBLY PROCESS**

Effectivity Date:

July 31, 2024

Validity Date:

n/a

Model code/Part number: **900B/ 910B / 7N0072-7020C**Customer: **TRJ**Car Model: **LEXUS-NX/RX**

Document No.:

**WI-ENG-PDE-461A**

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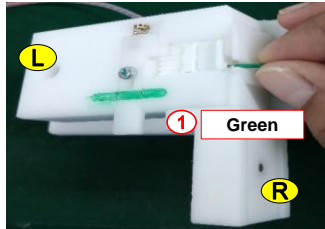
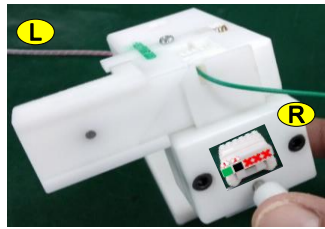
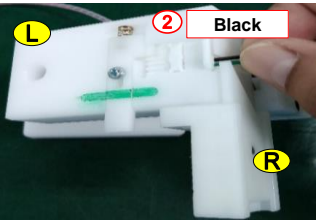
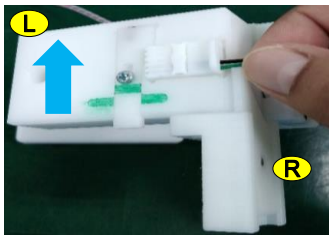
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PARTS:	1. Assy parts			JIG:	1. Insertion jig with switch cover	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	P1	<div><div></div><div>Wire facing</div><div></div><div>1. Get the <b>Green wire</b> then insert to terminal slot <b>1</b> using right hand.</div><div></div><div>2. Press the button using right thumb. The slot for <b>Black wires</b> will be opened.</div><div></div><div>2. Get the <b>Black wire</b> then insert to terminal slot <b>2</b> using right hand.</div><div></div><div>4. After insertion, push the lock using left thumb 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><b>Important reminders/Note/s:</b>  <b>1. Please hold the wire near terminal during insertion.</b>  <b>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</b>  <b>3. Insertion must be from left to right.</b></div> <div><b>Document reference/s:</b>  <b>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</b>  <b>2. Please refer to GL-PRO-ASY-029 for Pull-Push procedure</b></div>


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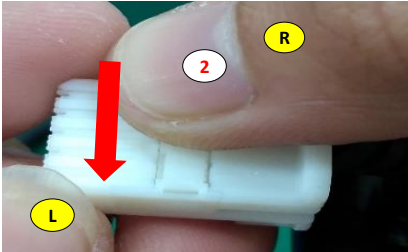
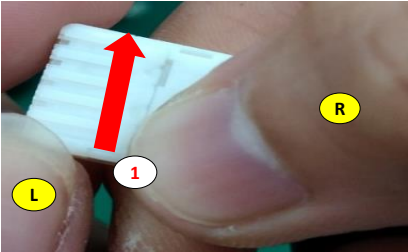
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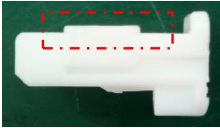
<b>PARTS:</b>	1. Assy parts			JIG:	1. Locking jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
4	P1	Connector lock		<div><div>LOCKING JIG</div></div>	<div>1. Use the provided locking jig per model 2. No unlocked/half-locked connector 3. No damaged lock</div> <div><b>Important reminders/Note/s:</b>  <b>1. Manual locking may cause damaged connector lock.</b></div>



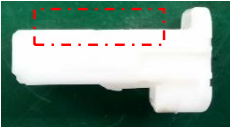
1. Put the connector into locking jig using right hand then press **2x** using both hands. Touch the connector lock to confirm if properly locked.



2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.



Before Pressing




After Pressing





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<b>PARTS:</b>	1. Assy parts 2. Black SV tube (Vinyl) $\phi 5$ L=69 $\pm$ 3mm 3. Black Corrugated tube $\phi 5$ L=171 $\pm$ 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	Wire insertion to Black SV tube (Vinyl) $\phi 5$ L=69 $\pm$ 3mm	 <div>         1. Get the Black SV tube (Vinyl) <math>\phi 5</math> L=69<math>\pm</math>3mm using right hand then insert the <b>G-B wires</b>.       </div>		n/a	1. No wrong use of parts 2. No deformed terminals.
6	<div> <div>5</div> <div>P1</div> </div> Wire Insertion to Black Corrugated tube $\phi 5$ L=171 $\pm$ 3mm (No Slit)	<div>  <div>         1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the <b>B-G-V wires</b> using left hand.       </div> </div> <div>  <div>         2. Get the corrugated tube (<b>no slit</b>) <math>\phi 5</math> L=171<math>\pm</math>3mm (<b>no slit</b>) using right hand then insert the <b>B-G-V wires</b> using left hand.       </div> </div> <div>  <div>         3. After insertion, remove the terminal cover jig using right hand.       </div> </div>			


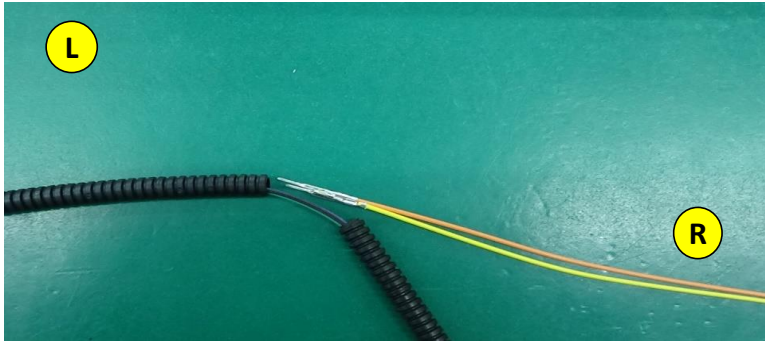




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<b>PARTS:</b> 1. Assy parts 2. Black SV tube (Vinyl) Ø5 L=182±3mm	JIG: n/a	
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	<div style="text-align: center;">  </div> Wire insertion to corrugated tube Ø5 L=171+3mm (no slit) (Assy Part)	<div style="text-align: center;">  </div> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;">           1. Hold the assy part using left hand then insert <b>Y-OR wires</b> to corrugated tube Ø5 L=171 ±3mm ( Assy part ) using right hand.(Combine)         </div>	n/a	1. No wrong use of parts 2. No deformed terminal
8	<div style="text-align: center;">  </div> Wire insertion to Black SV tube (Vinyl) Ø5 L=182±3mm	<div style="text-align: center;">  </div> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;">           1. Hold the Black SV tube (Vinyl) <b>Ø5 L=182±3mm</b> using right hand then insert <b>(Y-OR and V wire)</b> using left hand.         </div>		1. No wrong use of parts 2. No deformed terminal

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## TAPING ASSEMBLY PROCESS

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### PARTS:

1. Connector 6098-3802 (W)

JIG:

1. Insertion jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE

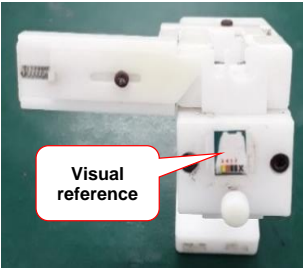
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9

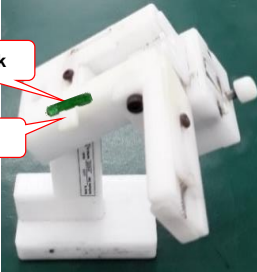
P1

Connector setting to  
insertion jig  
6098-3802 (W)


INSERTION JIG



INSERTION JIG ORIENTATION



CONNECTOR ORIENTATION





Press



Press



Release



1. Press the Lock of  
insertion jig using left hand.

2. Get the connector **6098-3802 (W)** using right hand and insert  
to insertion jig. Release the lock after insertion.

3. Push the lower wire guide upward using right  
hand. Slot for **yellow wire** will be open.

CONNECTOR ILLUSTRATION

GOOD



6098-3802 (W)

NG



6098-5668 (W)

1. Use provided jig per model  
2. No wrong orientation of connector

n/a

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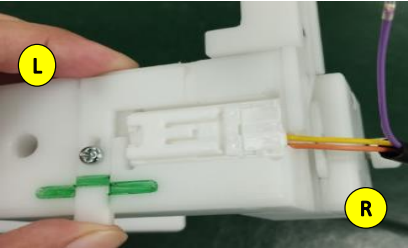
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<b>PARTS:</b>	1. Assy parts			JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
10	P1  Wire insertion to Connector 6098-3802 (W)	<div><div>Wire facing</div></div> <div><div>1. Hold the insertion jig using left hand. Insert the <b>Yellow wire</b> to connector using right hand. Press the button using right hand. Slot for <b>Orange wire</b> will be open.</div></div> <div><div>2. Hold the <b>Orange wire</b> and insert to connector 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	<b>Important reminders/Note/s:</b>  <b>1. Please hold the wire near terminal during insertion.</b> <b>2. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b>  <b>Document reference/s:</b>  <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b>  1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

July 31, 2024

Validity Date:

n/a

Model code/Part number: **900B/ 910B / 7N0072-7020C**Customer: **TRJ**Car Model: **LEXUS-NX/RX**

Document No.:

**WI-ENG-PDE-461A**

Purpose:

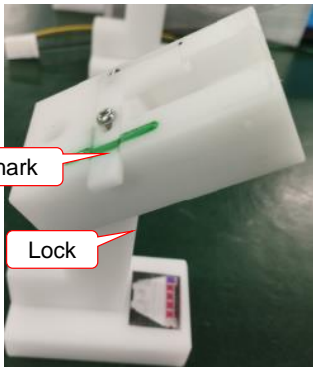



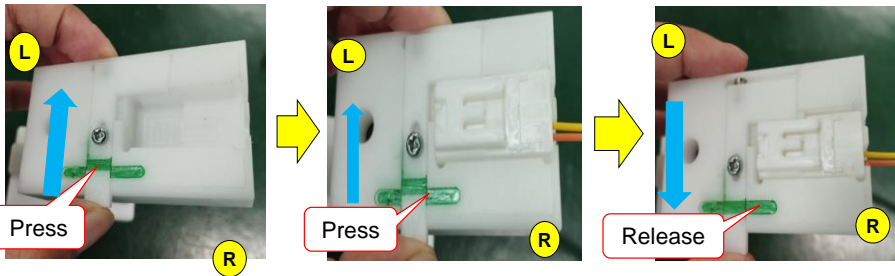
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PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1	<div><div><p>I-mark</p><p>Lock</p></div><div><p>CONNECTOR ORIENTATION</p></div><div><p>WIRE FACING</p></div><div><p>INSERTION JIG ORIENTATION</p></div><div><p>Press</p><p>Press</p><p>Release</p></div><div><div>1. Press the Lock of insertion jig using left hand.</div><div>2. Get the connector 6098-3802 (W) using right hand and insert to insertion jig. Release the lock after insertion.</div></div></div>		n/a	1. Use provided jig per model 2. No wrong orientation of connector

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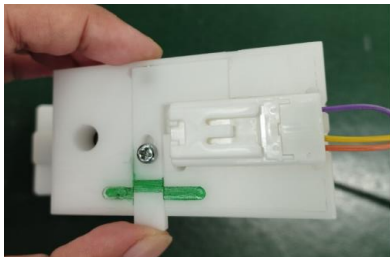
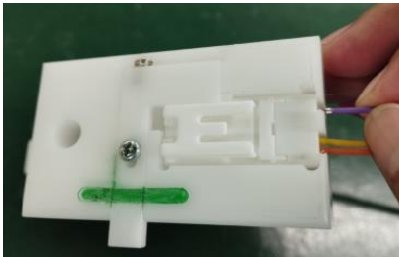
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<b>PARTS:</b>		1. Assy parts		JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
12	P1	<div>Wire insertion to Connector 6098-3802 (W)</div> <div></div> <div>1. Get the assy part and hold the <b>Violet wire</b> then insert to terminal connector using right hand.</div> <div>2. 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><b>Important reminders/Note/s:</b>  <b>1. Please hold the wire near terminal during insertion.</b> <b>2. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b></div> <div><b>Document reference/s:</b>  <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b></div>

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

July 31, 2024

Validity Date:

n/a

Model code/Part number: 900B/ 910B / 7N0072-7020C

Customer: TRJ

Car Model: LEXUS-NX/RX

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### PARTS:

1. Assy parts

JIG:

1.Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

13

P1

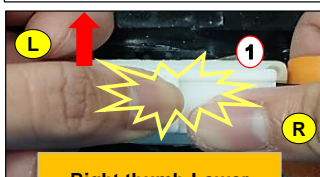
Connector lock



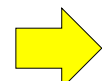
1. Load the connector into the jig holding both side of the connector, tip first.



2. Press the lower part of connector to fully insert into the locking jig.



Right thumb-Lower  
Left thumb-middle



Right thumb-upper  
Left thumb-middle

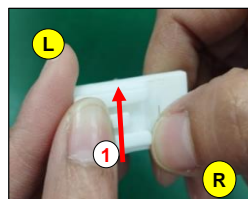
3. Press the lower parts of connector using right hand while left hand holding the middle.

4. Press the upper part of connector using right hand while left hand holding the middle.



Right thumb-middle  
Left thumb-middle

5. Lift then press the connector in the middle using left and right hand.



6. Ensure that connector is in a locked condition by slide touching the connector lock based on the sequence illustrated.

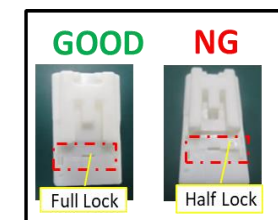
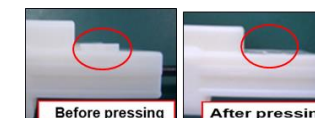
LOCKING JIG



**Important reminders/Note/s:**

**1. Manual locking may cause damaged connector lock.**


1. Use the provided locking jig per model
2. No unlock/half-lock connector






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	<b>WORK INSTRUCTION</b>				Effectivity Date:		July 31, 2024	
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Model code/Part number: <b>900B/ 910B / 7N0072-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS-NX/RX</b>	Document No.:		<b>WI-ENG-PDE-461A</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		5	Page No.: 12 of 13

<b>PARTS:</b>		1. Assy parts 2. Black corrugated tube ø5 L=275±3mm (no slit)		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
14	P1	<div><div><div>1. Get the corrugated tube <b>ø5 L=275±3mm (no slit)</b> using right hand then insert the <b>B-G-V wires</b> using left hand.</div></div><div><div>2. After insertion, remove the terminal cover jig using right hand.</div></div></div> <div><div><b>TERMINAL COVER JIG</b></div></div> <div>1. No wrong use of parts 2. No Deformed terminal</div>			

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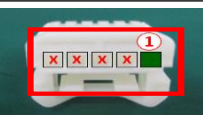
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P1****7N0072-7020C****GOOD****GOOD****NO GOOD****NO GOOD****GOOD****NO GOOD****1****No Unlock/  
Halflocked Connector****2****No Wrong Insert****3****No Deformed  
Terminal**

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