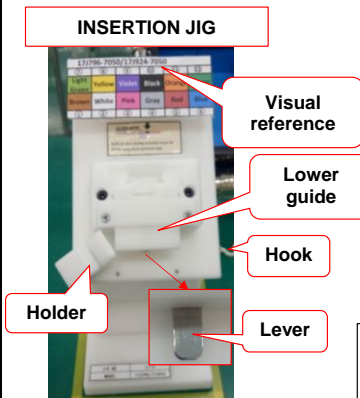
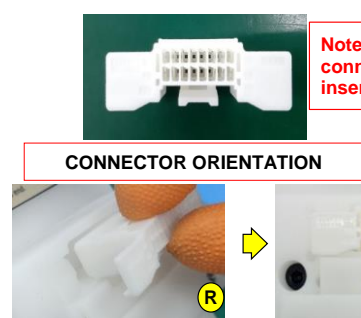
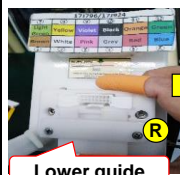
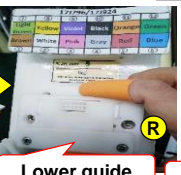
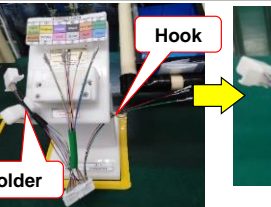




	WORK INSTRUCTION			Effectivity Date:	March 14, 2025		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number:	241B / 17J924-7051	Customer:	TRP	Car Model:	LEXUS-ES	
	Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Document No.:	WI-ENG-PDE-092D	
				Revision No.:	16	Page No.:	1 of 5

PARTS:	1. Connector 4F1640-000□ (W) 2. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P4 <div style="border: 1px solid black; padding: 5px; text-align: center; margin: 10px auto; width: 50px;">HIGH</div> Connector setting to insertion jig 4F1640-000□ (W)	<div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  <p>INSERTION JIG</p> </div> <div style="text-align: center;">  <p>CONNECTOR ORIENTATION</p> </div> </div> <p>1. Get the connector 4F1640-000 (W) using right hand and set to insertion jig.</p> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  <p>BEFORE PRESSING</p> </div> <div style="text-align: center;">  <p>AFTER PRESSING</p> </div> </div> <p>2. Press the guide lock using right</p> <div style="text-align: center;">  <p>Hook</p> </div> <p>3. Set the Group 2 wires (11pcs) to holder using both hands and set the Group 3 wires (3pcs) to hook using right hand.</p> <div style="text-align: center;">  <p>Hook</p> </div> <p>4. Hold the Group 1 wires (12pcs) using right hand for insertion.</p>		<div style="border: 2px solid red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 2px solid red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 2px solid red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> Finger COTS  </div>	<p>1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector 5. No half-locked connector</p> <p>Important reminders/Note/s: 1. Automatically dispose and replace the unit if once encountered Bend terminal, Difficulty of insertion, Half-locked connector. 2. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process. Do not attempt to repair. 3. Follow the connector orientation.</p> <div style="border: 1px solid black; padding: 5px; text-align: center; margin: 10px auto; width: 150px;"> Connector must be no damaged/half-locked/locked </div> <div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;"> <div style="background-color: green; color: white; padding: 2px 5px;">GOOD</div>  <div style="border: 1px solid red; padding: 2px; background-color: white;">UNLOCK</div> </div> <div style="text-align: center;"> <div style="background-color: red; color: white; padding: 2px 5px;">NG</div>  <div style="border: 1px solid red; padding: 2px; background-color: white;">HALF-LOCKED</div> </div> </div>
Revision History				Prepared by	Checked by
03/14/25	16	Inclusion of Quality improvement measures (based on Mizen Boshi activity). Update Work procedure of Connector lock process.		D.Castillo	J. Loterte
08/02/23	15	Update template: Inclusion of CAR MODEL "LEXUS-ES" . Transfer process of Connector lock from P2 to P4 due to TPS improvements. (Refer to ENGDRR-146 for Document Revision Request).		M. Ariola	J. Loterte
03/02/23	14	Standardized tube description: VM tube (Sunprene). Change WIP flow quantity from [1pc] flow to [3pcs] flow due to process improvement.		M. Ariola	J. Loterte
Eff. Date	Rev. No	Details of Change		Revised	Checked
				Reviewed	Approved
				Est. Date:	June 02, 2017

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WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number: 241B / 17J924-7051

Customer: TRP

Car Model: LEXUS-ES

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

March 14, 2025

Validity Date:

n/a

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PARTS:

1. Assy parts

JIG:

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

WIRE INSERTION ILLUSTRATION



SECOND
ROW TO
INSERT

7	8	9	10	11	12
LG	Y	V	B	OR	G
176	180	177	181	181	186
BR	W	P	GR	R	L
178	183	177	179	184	184
1	2	3	4	5	6

Standard hold in wire



TERMINAL FACING



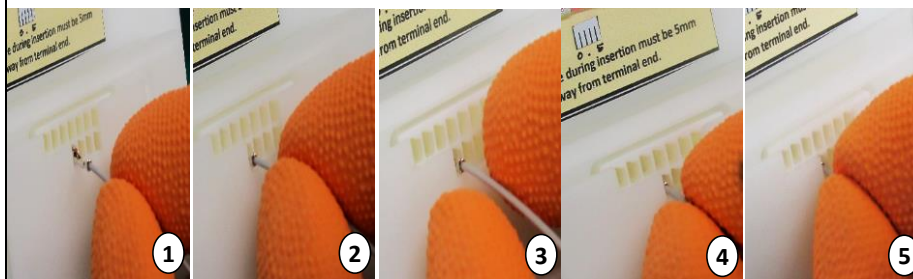
Finger COTS



16

MEDIUM

Wire insertion to connector
(Group 1 wires)
4F1640-000 (W)



1. Get the wire and hold it **5mm** away from terminal.
2. Half insert the wire.
3. Release wire to check the color.
4. Conduct point checking in visual
5. Hold again **5mm** away from terminal
6. Fully inserted wires (avoid bending during insertion)

1. No wrong wire insertion
2. No terminal backing out
3. No deformed terminal
4. Make sure wires are properly inserted.
5. Must have slight MOVEMENT after insertion
6. No bend terminal/wires

Important reminders/Note/s:

1. Automatically dispose and replace the unit if once encountered Bend terminal, Difficulty of insertion, Half-locked connector.
2. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process. Do not attempt to repair.
3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
4. Follow the insertion sequence based on the visual reference
5. Hold on wire during insertion must be **5mm** away from terminal end.

Document references:

1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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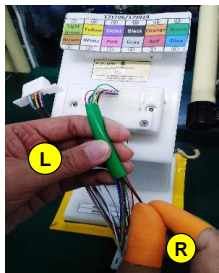
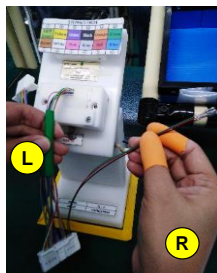

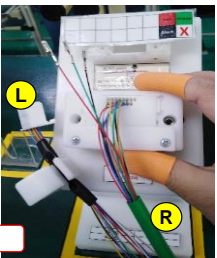
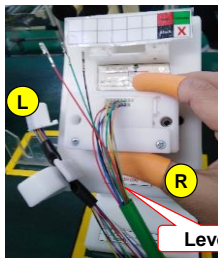
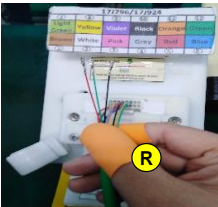
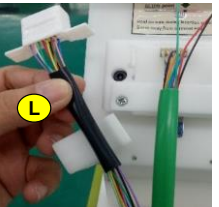

WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	March 14, 2025		
Validity Date:	n/a		
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Process Name/Title: **TAPING ASSEMBLY PROCESS**

Model code/Part number: **241B / 17J924-7051** Customer: **TRP** Car Model: **LEXUS-ES**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	<div>16</div> <div>MEDIUM</div> <div>P4</div> <div>Wire insertion to Green VM tube (Sunprene) (Group 3 wires)</div>	<div><div></div><div>1. Hold the Green VM tube (Sunprene) using left hand. Get the Group 3 wires (3pcs) in the hook and insert to Green VM tube (Sunprene) using right hand.</div><div><div></div><div>BEFORE PRESSINGAFTER PRESSING</div><div>Lever</div><div>2. Press the unlock lever using right thumb.</div><div><div></div><div>3. Release the Group 2 wires (11pcs) (Assy parts) using left hand.</div><div>4. Hold the wires right hand then gently pull the connector from jig. Check the insertion condition.</div></div></div><div><div>Finger COTS</div></div></div>		<div>1. No wrong wire insertion</div> <div>2. No terminal backing out</div> <div>3. No deformed terminal</div> <div>4. Make sure wires are properly inserted.</div> <div>5. Must have slight MOVEMENT after insertion</div> <div>6. No bend terminal/wires</div> <div>Important reminders/Note/s:</div> <div>1. Automatically dispose and replace the unit if once encountered Bend terminal, Difficulty of insertion, Half-locked connector.</div> <div>2. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process. Do not attempt to repair.</div> <div>3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>4. Follow the insertion sequence based on the visual reference</div> <div>5. Hold on wire during insertion must be 5mm away from terminal end.</div> <div>Document references:</div> <div>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div> <div>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div>	

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WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	March 14, 2025		
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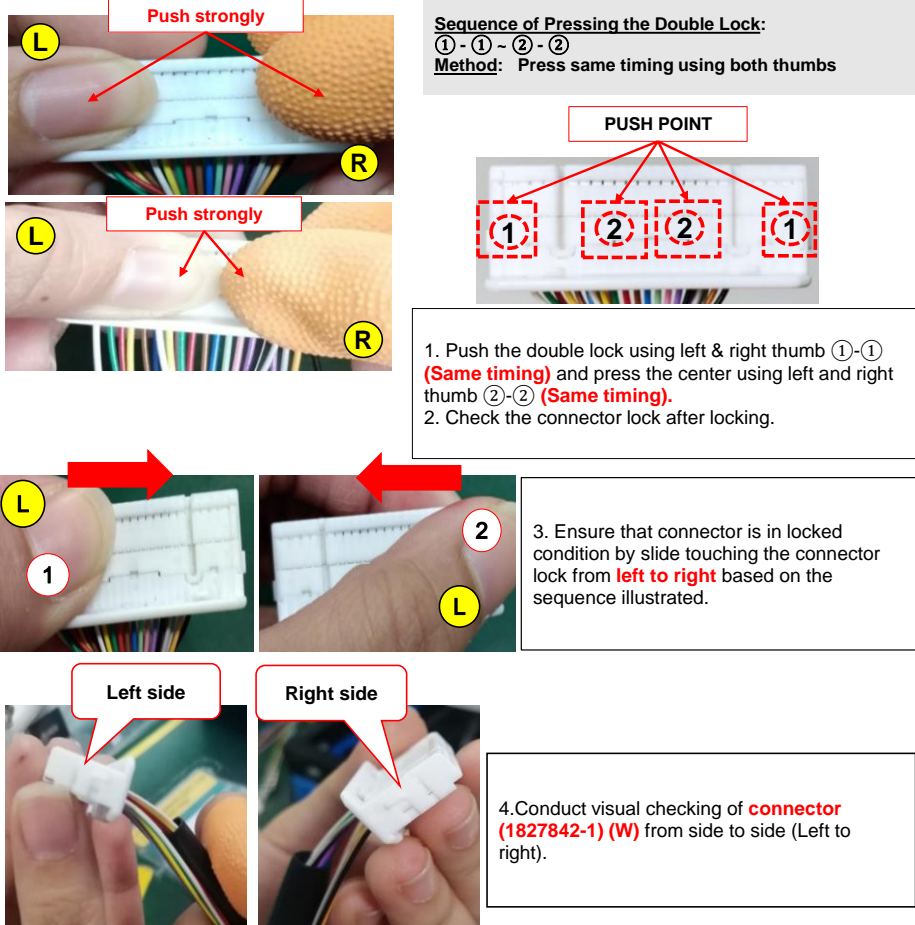
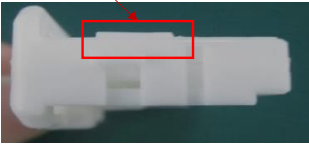
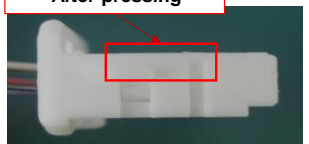
Process Name/Title: **241B / 17J924-7051**

Model code/Part number: **241B / 17J924-7051**

Customer: **TRP**

Car Model: **LEXUS-ES**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	16 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	P4 LOW Connector lock	<div></div>	n/a	<div><p>1. No damaged double lock.</p><p>2. No half-locked connector</p></div> <div><p>Before pressing</p><p>After pressing</p></div>	

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**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

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241B / 17J924-7051Customer: **TRP**

Car Model:

LEXUS-ES

Document No.:

WI-ENG-PDE-092D

Purpose:



☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts			JIG:	1. WIP Holder
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P4 Pass WIP to P5	<div>3 PIECES FLOW</div>  <div>1. Pass WIP to WIP Holder. Note: Three pieces flow.</div>		<div>WIP HOLDER</div> 	1. No WIP overflow

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