

	WORK INSTRUCTION				Effectivity Date:		June 11, 2024	
	OFFLINE ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 200D/220D / 7R0131-7021		Customer: TRMX		Car Model: LEXUS-LM	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.:		WI-ENG-PDE-591	
					Revision No.:		2 Page No.: 1 of 7	


PARTS:	1. All parts: Connector 6098-3810 (W); AVSSf 0.3 B L=266±2mm; Black Corrugated tube ø5 L=184±3mm (no slit)			JIG:	1. Insertion Jig 2. Locking Jig					
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS						
1	Offline	Table Lay-out	<div style="text-align: center; border: 1px solid red; padding: 5px; margin-bottom: 10px;"> TABLE LAY-OUT </div>				<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed 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: 1px dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>		1. No missing parts/tools 2. No excess parts/tools Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.	
			CONNECTOR ILLUSTRATION							
			<div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <div style="background-color: green; color: white; padding: 2px; font-weight: bold;">GOOD</div> <div style="background-color: green; color: white; padding: 2px; font-weight: bold;">6098-3810 (W)</div> </div> <div style="text-align: center;"> <div style="background-color: red; color: white; padding: 2px; font-weight: bold;">NG</div> <div style="background-color: red; color: white; padding: 2px; font-weight: bold;">6098-5677 (W)</div> </div> </div>							

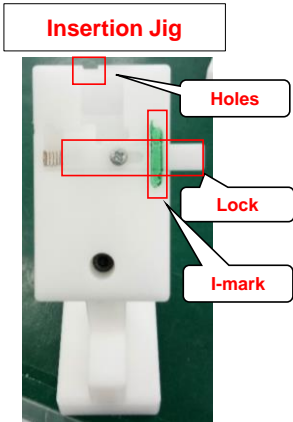


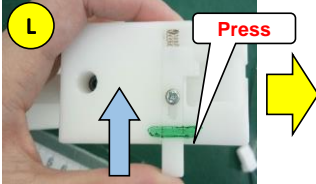
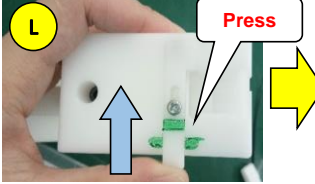
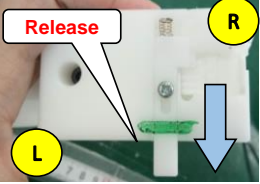




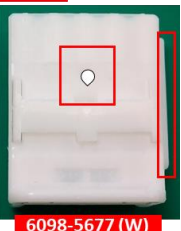



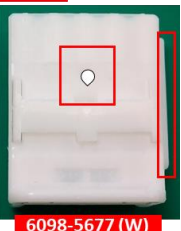
Revision History				Prepared by		Reviewed by		Approved by		Noted by		
06/11/24	2	Removal of terminal cover jig and update process sequence due to process improvement. Update table lay-out. Inclusion of Measurement, Visual inspection and Car model "Lexus-LM".	D. Castillo	C. Villanueva	A. Arañes	n/a						
10/21/22	1	Change from Pre-launch to Masspro.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes						
10/03/22	0	Initial issue. Wire length from L=281mm to L=266mm; COT length from ø5 L=199±3mm to ø5 L=184±3mm	M. Ariola	J. Loterte	C. Villanueva	A. Arañes						
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	June 10, 2022				

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:	June 11, 2024							
	OFFLINE ASSEMBLY PROCESS			Validity Date:	n/a							
	Process Name/Title:			Model code/Part number:	200D/220D / 7R0131-7021	Customer:	TRMX	Car Model:	LEXUS-LM	Document No.:	WI-ENG-PDE-591	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:		2	Page No.:	2 of 7		

PARTS:		1. Connector 6098-3810 (W)		JIG:	1. Insertion Jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
2	Offline 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 Orientation</p></div><div><p>Press</p><p>1. Press the lock of insertion jig using left thumb.</p></div><div><p>Press</p><p>2. Insert the connector 6098-3810 into jig using right hand and release the lock.</p></div><div><p>Release</p><p>3. Check the holes/terminal slot for B-B wires.</p></div><div></div></div> <td>n/a</td> <td colspan="2"><div><p>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p></div><div><p>Connector Orientation Illustration</p><div><p>GOOD</p></div><div><p>NG</p></div></div><div><p>CONNECTOR ILLUSTRATION</p><div><p>GOOD 6098-3810 (W)</p></div><div><p>NG 6098-5677 (W)</p></div></div></td>		n/a	<div><p>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p></div> <div><p>Connector Orientation Illustration</p><div><p>GOOD</p></div><div><p>NG</p></div></div> <div><p>CONNECTOR ILLUSTRATION</p><div><p>GOOD 6098-3810 (W)</p></div><div><p>NG 6098-5677 (W)</p></div></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			Effectivity Date:	June 11, 2024		
	Process Name/Title: OFFLINE ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 200D/220D / 7R0131-7021		Customer: TRMX	Car Model: LEXUS-LM	Document No.:	WI-ENG-PDE-591	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	2	Page No.:	3 of 7

PARTS:		1. Black Corrugated tube ø5 L= 184±3mm (no slit) 2. AVSSf 0.3 B L=266±2mm [2pcs]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	Offline <div>2</div> Wire insertion to Black Corrugated tube ø5 L=184±3mm (no slit)	<div><div>L</div><div>R</div></div> <div>1. Get Black corrugated tube ø5 L=184±3mm (No slit) using left hand and get 2pcs of Black wire L=266±2mm then insert using right hand.</div>	n/a	1. No Wrong use of parts 2. No deformed terminal	

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:

June 11, 2024

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

200D/220D / 7R0131-7021

Customer:

TRMX

Car Model:

LEXUS-LM

Document No.:

WI-ENG-PDE-591

Purpose:


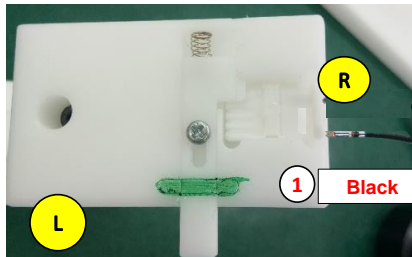
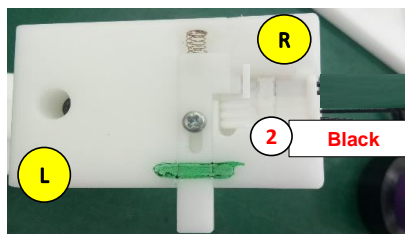
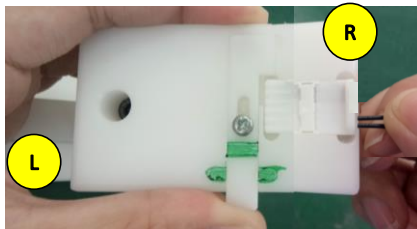
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

4 of 7

PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Offline Wire Insertion to Connector 6098-3810 (W)	<div><div>Wire facing</div></div> <div><div>1. Get the first Black wire and insert to Slot 1 of connector using right hand.</div></div> <div><div>2. Get the 2nd Black wire and insert to Slot 2 of 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	<div>1. No loose insertion 2. No wrong dimension 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>Important reminders/Note/s: 1. <i>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</i></div> <div>Document references: 1. <i>Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</i></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

DCC Stamp

**WORK INSTRUCTION**

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

June 11, 2024

Model code/Part number:

200D/220D / 7R0131-7021

Customer:

TRMX

Car Model:

LEXUS-LM

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:


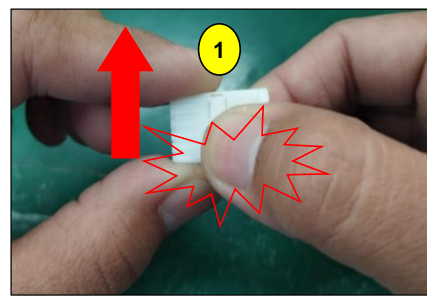
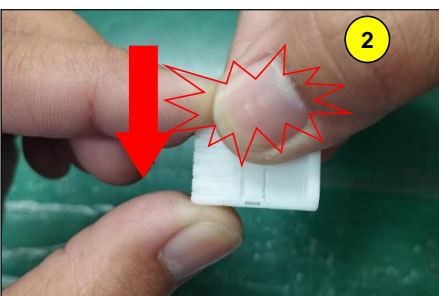
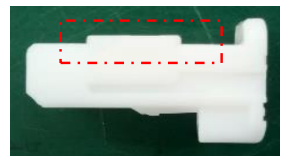
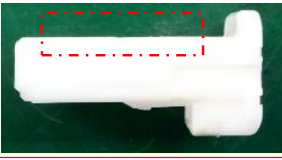

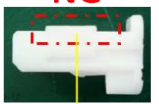

WI-ENG-PDE-591

Revision No.:

2

Page No.:

5 of 7

PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Offline Connector lock	<div></div> <div></div> <div></div> <div></div> <div></div>		<div></div>	<div>1. Use provided jig tool per model to avoid damaged lock. 2. No Unlock and half-locked connector 3. No damaged lock</div> <div>Important reminders/Note/s: <i>1. Manual locking may cause damaged connector lock.</i></div> <div>LOCK CONDITION</div> <div></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

DCC Stamp

**WORK INSTRUCTION**

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

June 11, 2024

Model code/Part number:

200D/220D / 7R0131-7021

Customer:

TRMX

Car Model:

LEXUS-LM

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

6 of 7

PARTS:

1. Assy parts

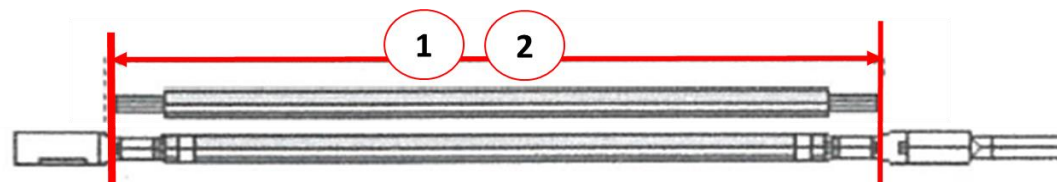
JIG:

n/a

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****MEASURING
TAPE**

Note:

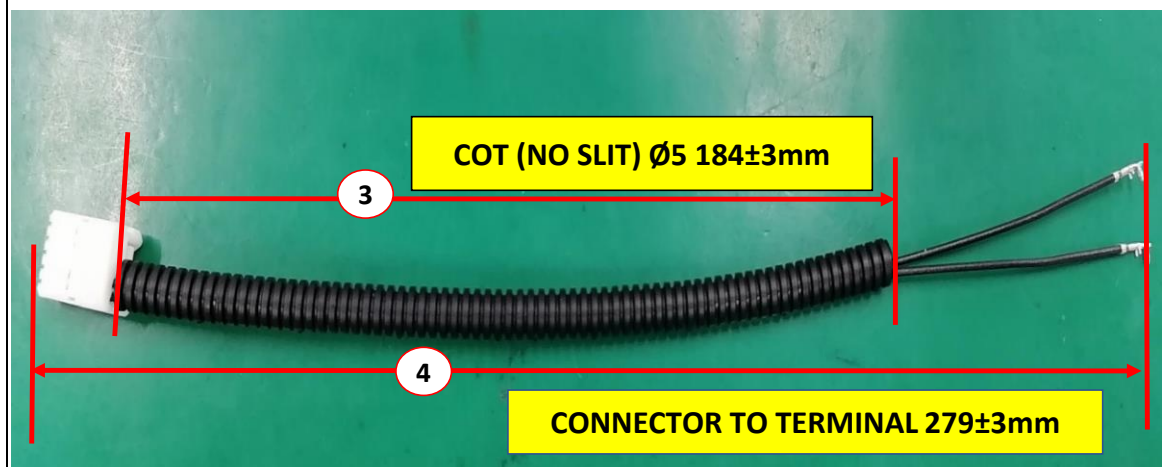
1. Measurement point: End of core wire to the end of core wire
2. Terminal is reference only.



5

Offline

Measurement

**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

1. No wrong dimension

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:

June 11, 2024

Validity Date:

n/a

Model code/Part number: 200D/220D / 7R0131-7021

Customer: TRMX

Car Model: LEXUS-LM

Document No.:

WI-ENG-PDE-591

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

2

Page No.:

7 of 7

PARTS:

n/a

JIG:

n/a



QUALITY CHECKPOINTS

OFFLINE INSERTION

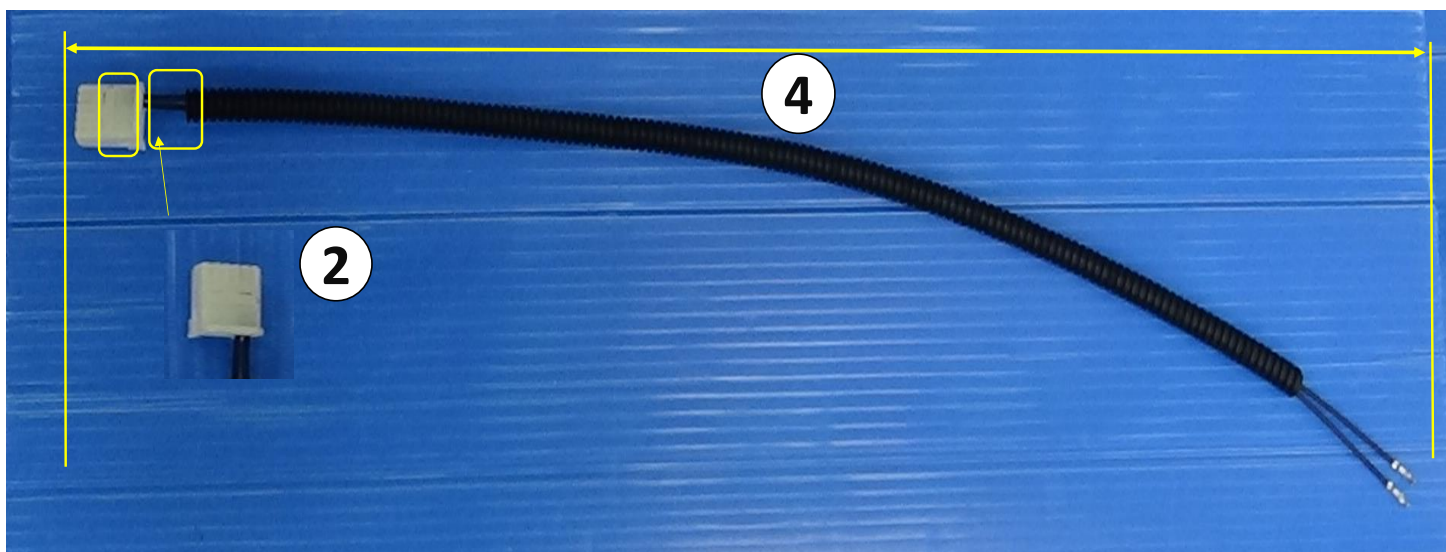
7R0131-7021



GOOD



NO GOOD



GOOD



NO GOOD

1

No Unlocked/Half-locked connector

3

No Terminal Backing Out

2

No Wrong insert

4

Check the Alignment

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