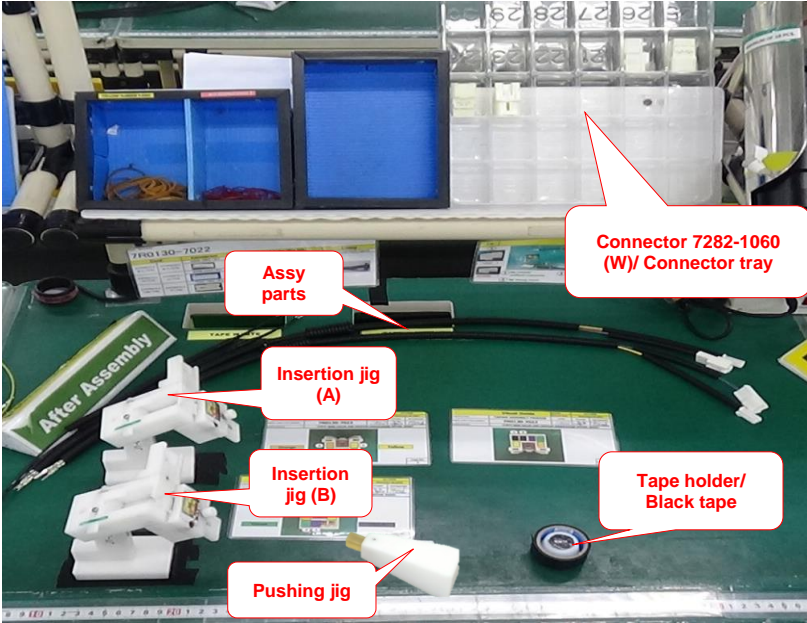



	WORK INSTRUCTION				Effectivity Date:		November 24, 2023	
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	Process Name/Title:		Model code/Part number: 220D / 7R0130-7022		Customer: TRMX	Car Model: LEXUS-LM		Document No.: WI-ENG-PDE-563B
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		5	Page No.:	1 of 10	

PARTS:		1. All parts: Assy parts; Black tape; Connector 7282-1060 (W)			JIG:		1. Insertion jig 2. Pushing jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	P2 <div>5</div>	<div>TABLE LAY-OUT</div> 				<div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>		1. No missing parts/ tools. 2. No excessive parts/tools.	

Revision History								Prepared by	Reviewed by	Approved by	Noted by		
11/24/23	5	Change locking method from locking jig to pushing jig due to countermeasure in DCS (DC-0623-114). Update table lay-out.				D. Castillo	C. Villanueva	A.Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
06/14/23	4	Changed MP from 3MP to 4MP; Removed and transferred process of Connector setting to insertion jig 7282-1060 (W) and Wire Insertion to connector 7282-1060 (W) from P1 to P2; Removed and transferred process of Taping 3; COT Ø13 L=45±3mm to COT Ø7 L=268±3mm wire near connector; and Y-Taping from P2 to P3 due to new process distribution; Changed table lay-out; Changed Quality Checkpoints.				M.Ariola	J. Loterte	C. Villanueva	A.Arañes				
12/02/22	3	Transfer process of Connector setting to insertion jig 7282-1060 (W) and Wire insertion to Connector from P1 to P2. Remove process of Y-taping 2 and transfer to P3 due to process Improvement. Change table lay-out.				M.Ariola	J. Loterte	C. Villanueva	A.Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	July 14, 2022		

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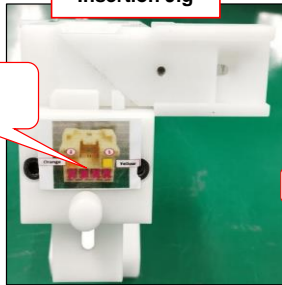
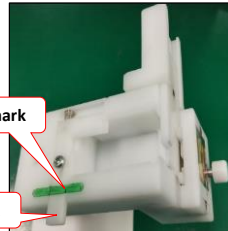

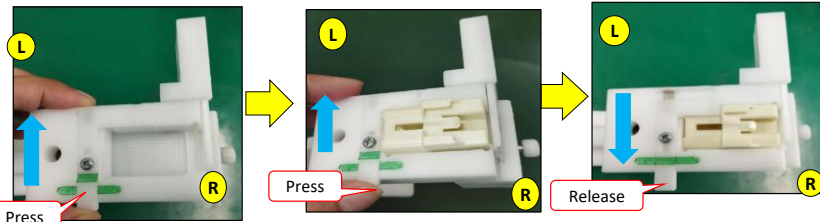
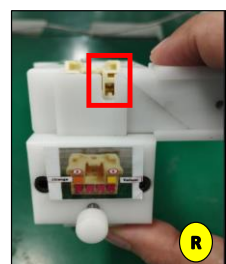
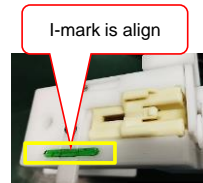

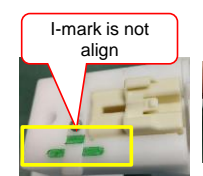
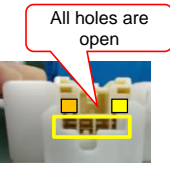
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PARTS:		1. Connector 7282-1060 (W)		JIG:	1.Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Connector setting to insertion jig 7282-1060 (W)	<div><div><p>Visual reference</p></div><div><p>I-mark</p><p>Lock</p><p>Insertion jig Orientation</p></div><div><p>CONNECTOR ORIENTATION</p></div><div><p>Press</p><p>Release</p></div><div><p>R</p></div><div><p>1. Press the lock of insertion jig using left hand.</p></div><div><p>2. Get the connector 7282-1060 (W) using right hand then insert to insertion jig. Release the lock after insertion. Note: Follow the connector orientation.</p></div><div><p>3. Push the lower wire guide upward using right hand. Slot for Yellow wire will be opened.</p></div></div>			<div><p>CONNECTOR ORIENTATION ILLUSTRATION</p></div> <div><p>I-mark is align</p></div> <div><p>1 hole is open</p></div> <div><p>GOOD</p></div> <div><p>I-mark is not align</p></div> <div><p>All holes are open</p></div> <div><p>NG</p></div> <div><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></div>

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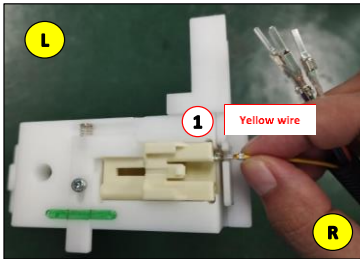
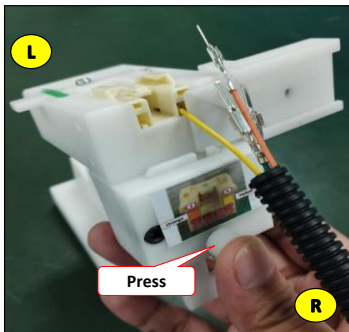
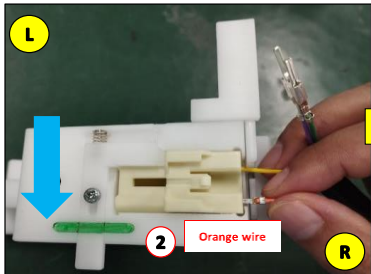
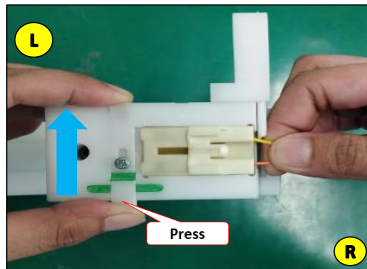
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PARTS:		1. Assy parts 2. Connector 7282-1060 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 Wire Insertion to connector 7282-1060 (W)	<div><div></div><div>Wire facing</div></div> <div><div></div><div><div>1</div><div>Yellow wire</div></div><div><div>1</div><div>Hold the insertion jig using left hand. Get the Yellow then insert to terminal slot 1 using right hand.</div></div></div> <div><div></div><div><div>Press</div></div><div><div>2</div><div>Press the button using right thumb. The slot for Orange wire will be opened.</div></div></div> <div><div></div><div><div>2</div><div>Orange wire</div></div><div><div>3</div><div>Get the Orange wire then insert to terminal slot 2 using right hand.</div></div></div> <div><div></div><div><div>Press</div></div><div><div>4</div><div>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></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 during insertion. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div><div>Document reference/s: 1. Refer to GL-PRO-ASY-029 for pull-push procedure.</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 during insertion. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>Document reference/s: 1. Refer to GL-PRO-ASY-029 for pull-push procedure.</div>	

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PARTS:		1. Assy parts		JIG:	1. Inserton jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	<div><div><div><div><div>Insertion Jig</div><div>Visual reference</div><div>Button</div><div>Lower Guide lock</div></div><div><div>I-mark</div><div>Lock</div><div>Insertion jig Orientation</div></div><div><div>CONNECTOR ORIENTATION</div></div></div><div><div><div>L</div><div>R</div><div>Press</div></div><div><div>L</div><div>R</div><div>Press</div></div><div><div>L</div><div>R</div><div>Release</div></div></div><div><div><div>L</div><div>R</div><div>Press</div></div></div></div><div><div>1. Push the lower wire guide upward using right hand.</div><div>2. Get the connector 7282-1060 (W) using right hand then insert to insertion jig. Release the lock after insertion. Note: Follow the connector orientation.</div><div>3. Press the button using left hand. Slot for Violet wire will be opened.</div></div></div>		N/A	<div><div><div>CONNECTOR ORIENTATION ILLUSTRATION</div><div><div>I-mark is align</div><div>1 hole is open</div></div><div><div>GOOD</div></div><div><div>I-mark is not align</div><div>All holes are open</div></div><div><div>NG</div></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>

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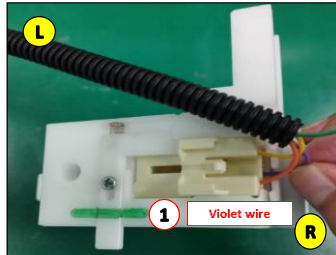
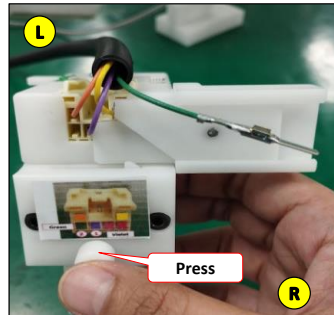
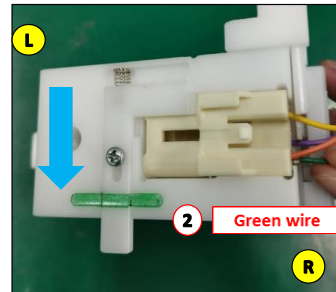
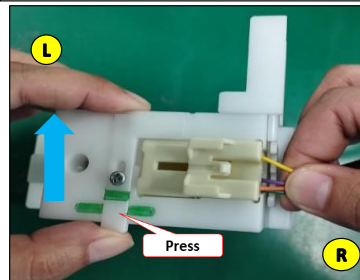
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PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2 Wire Insertion to connector 7282-1060 (W)	<div><p>Wire facing</p></div> <div><p>1. Hold the insertion jig using left hand. Get the Violet then insert to terminal slot 1 using right hand.</p></div> <div><p>2. Press the button using right thumb. The slot for Green wire will be opened.</p></div> <div><p>3. Get the Green 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>	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: 1. Please hold the wire near terminal during insertion. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>Document reference/s: 1. Refer to GL-PRO-ASY-029 for pull-push procedure.</div>

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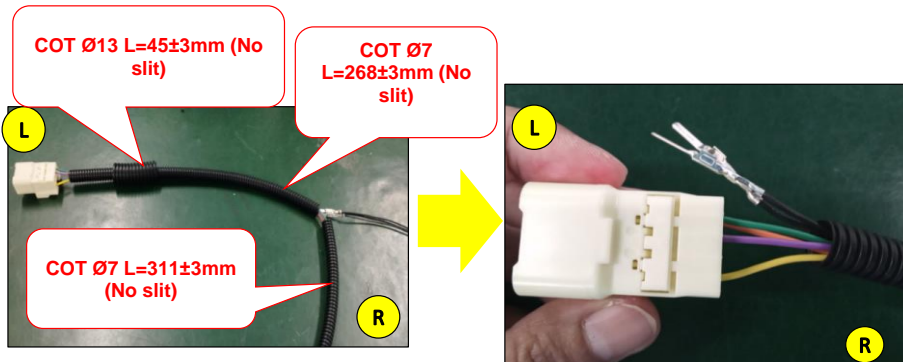
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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P2	<p>Wire Insertion to COT Ø7 L=268±3mm (No slit) (Assy parts)</p>  <p>1. Get the B-B wires and insert to COT Ø7 L=268±3mm (No slit) (assy parts) using right hand.</p>		N/A	1. No wrong use of parts. 2. No deformed terminal.

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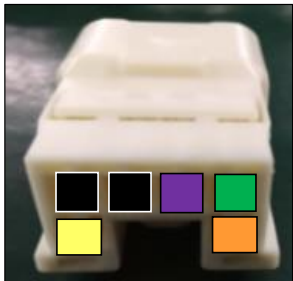


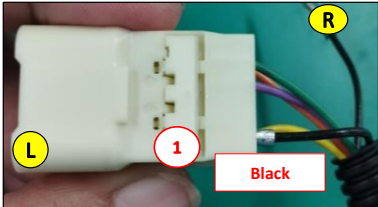
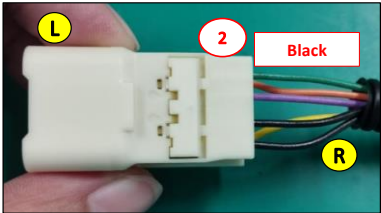
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PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P2 Wire insertion to Connector 7282-1060 (W)	<div><div>Visual Reference</div><div>Connector Setting</div><div>Wire facing</div></div> <div><div>1. Hold the connector using left hand. Get the 1st wire and insert to connector using right hand.</div></div> <div><div>2. Get the 2nd Black wire using left hand and insert to connector 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 during insertion. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</i></div> <div>Document reference/s: <i>1. Refer to GL-PRO-ASY-029 for pull-push procedure.</i></div>

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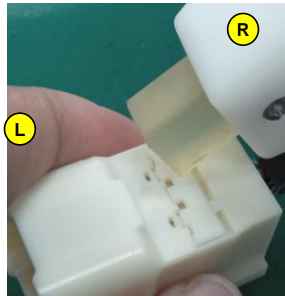
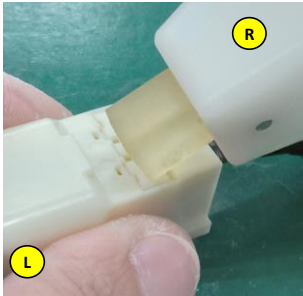
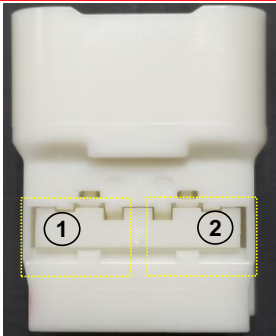


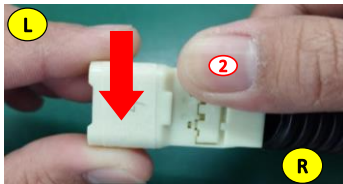
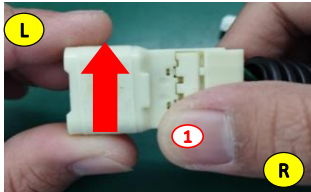


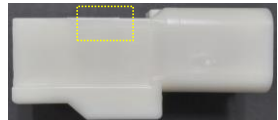
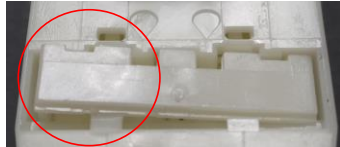

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PARTS:	1. Assy parts		JIG:	1. Locking Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P2	<div>Connector Lock</div> <div>5</div>	<div><div>LOCKING SEQUENCE</div><div></div><div></div><div><div>1. Hold the connector using left hand and place on the table.</div><div>2. Get the pushing jig using right hand and start the sequential locking based on above illustration.</div><div>3. Push the left side part of the connector (1) then push the right side part (2).</div><div>(Position of pushing jig during locking must be slant)</div><div></div><div>4. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</div></div></div> <div><div>PUSHING JIG</div></div>	<div>1. Use the provided locking jig per model 2. No unlock</div> <div>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR LOCK 2. Use provided jig tool per model to avoid damaged lock</div> <div><div>BEFORE PRESSING</div><div>AFTER PRESSING</div></div> <div><div>HALF LOCKED VISUAL</div></div>

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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
9	P2 Taping 2 COT to wire near connector	<p>1. Hold the assy parts using left hand. Get Black tape using right hand and start pre-taping.</p> <p>2. Measure from end of vinyl tube up to end of connector 30±3mm using both hands.</p> <p>3. After taping, check the measurement and taping condition.</p>		MEASURING TAPE 	1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension Important reminders/Note/s: <i>1. Please use calibrated/ verified measuring tape when getting the measurement.</i>

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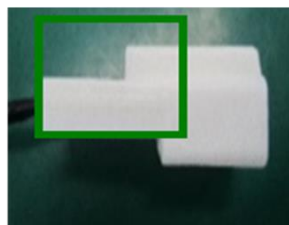
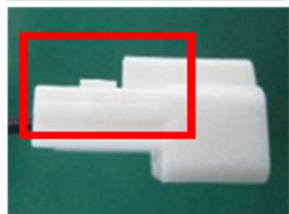
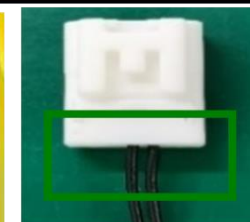
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PARTS:

JIG:

QUALITY CHECKPOINTS**P2****7R0130-7022****GOOD****NO GOOD****GOOD****NO GOOD**

1 No Unlock/
Halflocked Connector

2 **3** No wrong insert

4 No Missing tape

5 No Terminal backing out

6 No Deformed terminal

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DCC Stamp