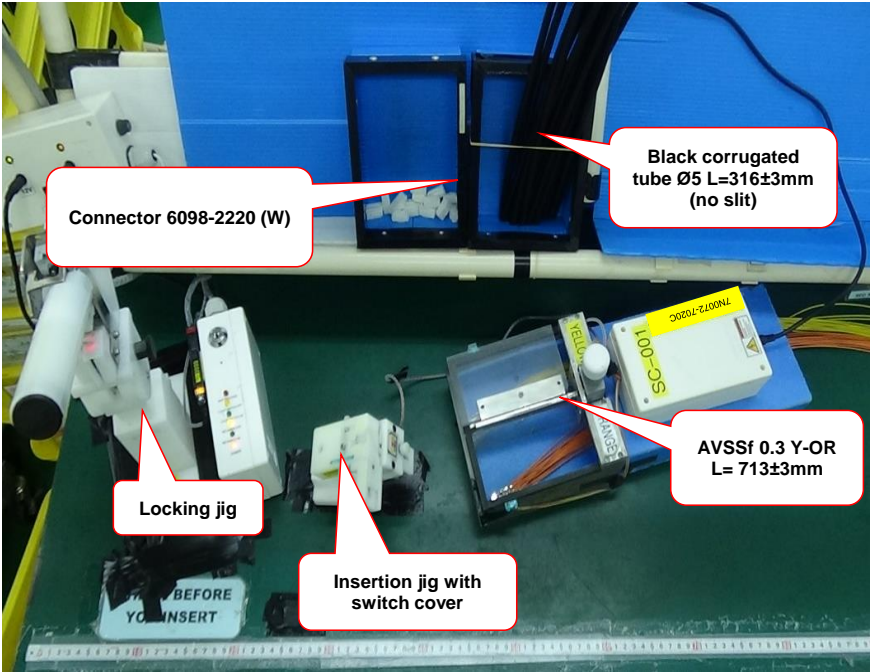


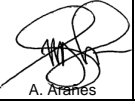
	WORK INSTRUCTION				Effectivity Date:		July 31, 2024	
	OFFLINE ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 900B/910B / 7N0072-7020C		Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.: WI-ENG-PDE-905	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		0	Page No.: 1 of 8

PARTS:		1. Connector 6098-2220 (W); Black corrugated tube Ø5 L=316±3mm (no slit); AVSSf 0.3 Y-OR L= 713±3mm				JIG:		1. Insertion jig with switch cover 2. Locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	Offline	<div>Table Lay-out</div> 				<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		<div>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div> <div>1. No missing parts/tools. 2. no excess parts/tools.</div>	


Revision History								Prepared by	Reviewed by	Approved by	Noted by		
07/31/24	0	Initial issue. Transfer Connector setting (6098-2220 (W)), Wire insertion to connector, Connector lock and Wire insertion to COT from P1 (WI-ENG-PDE-416A). Additional Work procedure/Illustration and notes on page 4-5 as countermeasure for the customer claim(Broken lock of Connector 6098-2220 (W)).				D.Castillo	C.Villanueva	A. Arañes	N/A				N/A
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	July 31, 2024		

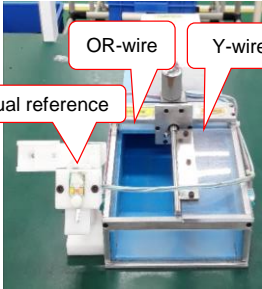
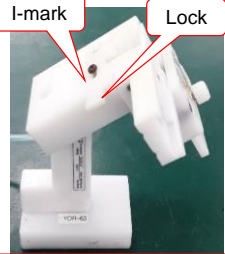

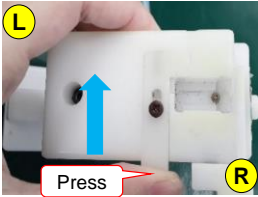
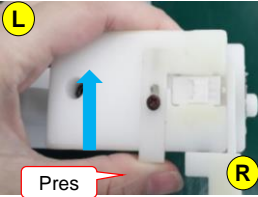
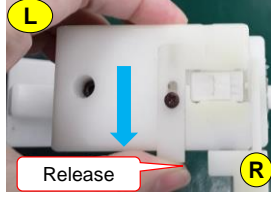
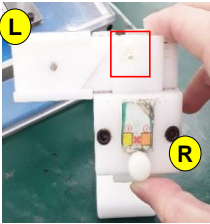
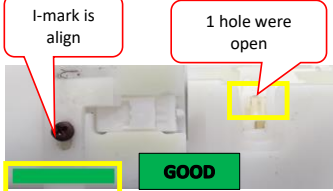
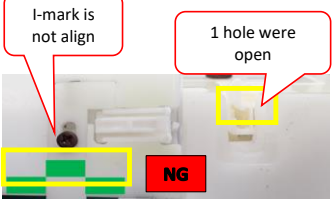
CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)

MASTER COPY

DCC Stamp

	WORK INSTRUCTION				Effectivity Date:	July 31, 2024		
	OFFLINE ASSEMBLY PROCESS				Validity Date:	n/a		
	Process Name/Title:		Model code/Part number: 900B/910B / 7N0072-7020C		Customer: TRJ	Car Model: LEXUS-NX/RX		Document No.: WI-ENG-PDE-905
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		0	Page No.: 2 of 8

PARTS:	1. Connector 6098-2220 (W)			JIG:	1. Insertion jig with switch cover			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
2	Offline Connector setting to insertion jig 6098-2220 (W)	<div><div><p>Visual reference</p></div><div><p>Insertion Jig Orientation</p></div><div><p>Connector Orientation</p></div></div> <div><div><p>Press</p></div><div><p>Pres</p></div><div><p>Release</p></div></div> <div><div><p>3. Push the lower wire guide upward using right hand. Slot for yellow wire will be open.</p></div></div>			n/a	<div>CONNECTOR ORIENTATION ILLUSTRATION</div> <div><p>I-mark is align 1 hole were open GOOD</p></div> <div><p>I-mark is not align 1 hole were open NG</p></div> <div>1. Use the provided jig per model 2. No wrong orientation of connector</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:

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-905

Purpose:


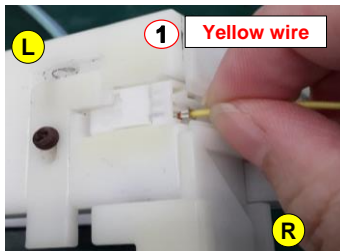
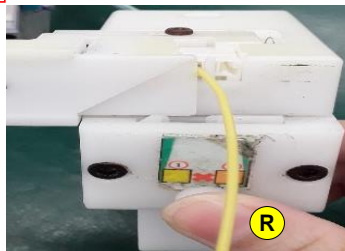
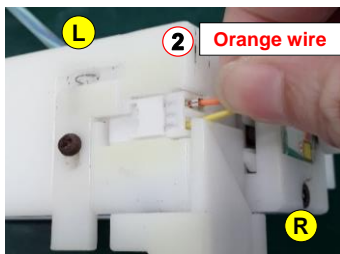
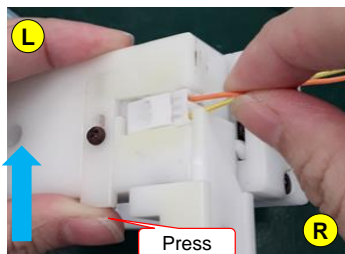
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

3 of 8

PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Offline	<div><div></div><div></div><div></div><div></div><div></div></div> <div><p>1. Hold the insertion jig using left hand. Get the Yellow wire and insert to connector using right hand. Note:Conduct Pull-Push-Pull-Push after insertion.</p><p>2. Press the button using right thumb. slot for Orange wire will be open.</p><p>3. Get the Orange wire and insert to connector using right hand. Note:Conduct Pull-Push-Pull-Push after insertion.</p><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><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. 3. Insertion mudt be from left to right.</div><div>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance. 2. Please refer to GL-PRO-ASY-029 for Pull-Push procedure</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:

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-905

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

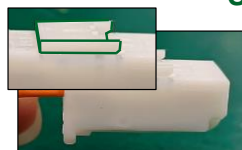
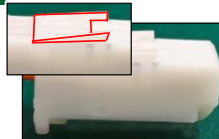
4 of 8

PARTS:

1. Assy parts

JIG:

1. Locking jig

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****CONNECTOR RETAINER ILLUSTRATION****SIDE VIEW****GOOD****NG**

1. Check the Retainer lock of connector before insertion to locking jig.

*Note: Must be **NO** half-locked condition prior connector locking.*

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.
2. Maintain 10mm proper holding of wire to connector
3. Connector must be fully inserted to connector slot.
4. Make sure no offset setting before locking process.
5. No wrong setting of connector.
6. No damaged connector lock
7. No unlocked/ half-locked connector.

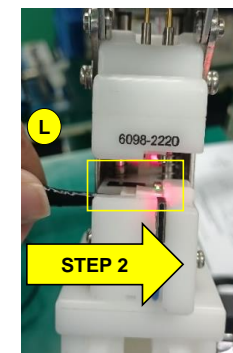
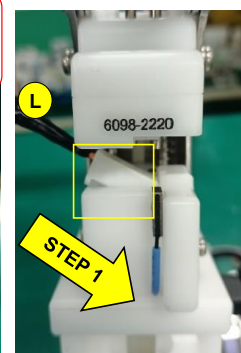
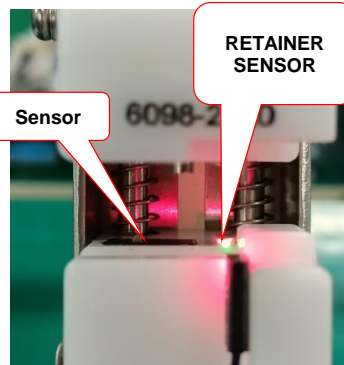
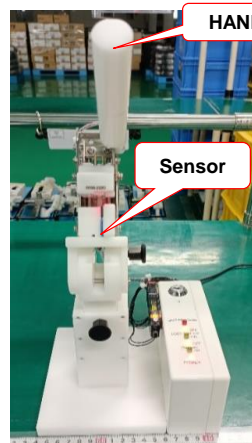
Important reminders/Note/s:

1. **Incomplete locking process will alarm the jig.**
2. **No retainer in connector cannot proceed.**
3. **If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.**

4

Offline

Connector lock



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.

NOTE: CONNECTOR LOCKING JIG WILL NOT FUNCTION IF CONNECTOR NOT REACH THE SENSOR.

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:

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-905

Purpose:

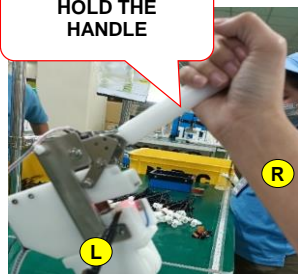
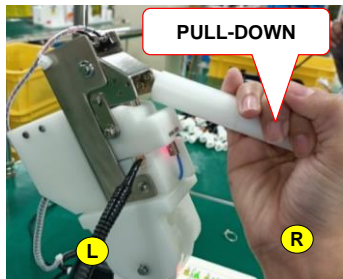
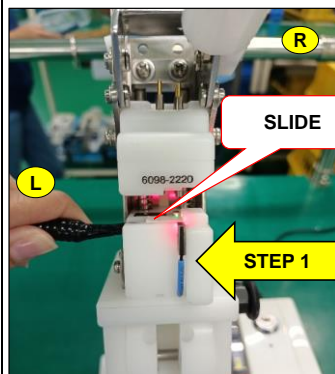
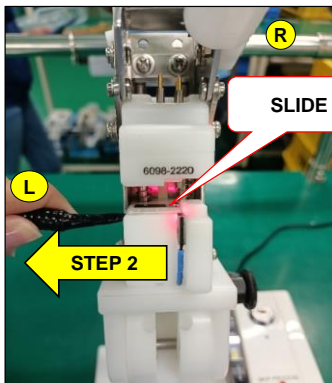
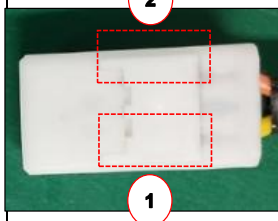
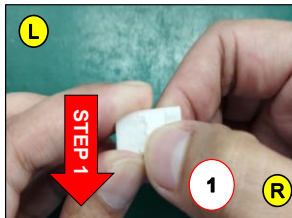
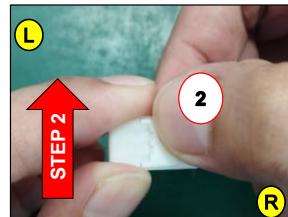
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:


5 of 8


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

DCC Stamp

	WORK INSTRUCTION			Effectivity Date:	July 31, 2024		
	Process Name/Title: OFFLINE 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-905	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	6 of 8

PARTS:		1. Assy parts 2. Black Corrugated tube Ø5 L=316±3mm (No slit)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Offline	<div></div> <div>1. Get the Black COT Ø5 L=316±3mm (No slit) using right hand and insert Y-OR wires using left 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**

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

July 31, 2024

Model code/Part number:

900B/910B / 7N0072-7020CCustomer: **TRJ**

Car Model:

LEXUS-NX/RX

Document No.:

WI-ENG-PDE-905

Purpose:

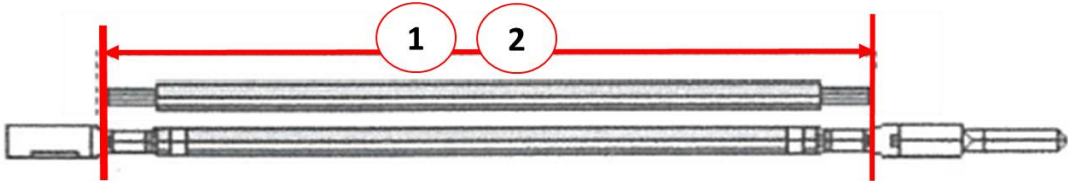


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

7 of 8

PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	Offline	Measurement	<div>Note: 1. Measurement point: End of core wire to the end of core wire 2. Terminal is reference only.</div> <div></div> <div></div> <div>MEASURING TAPE</div>	<div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div>
			<div></div> <div>1. No wrong dimension</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:

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-905

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

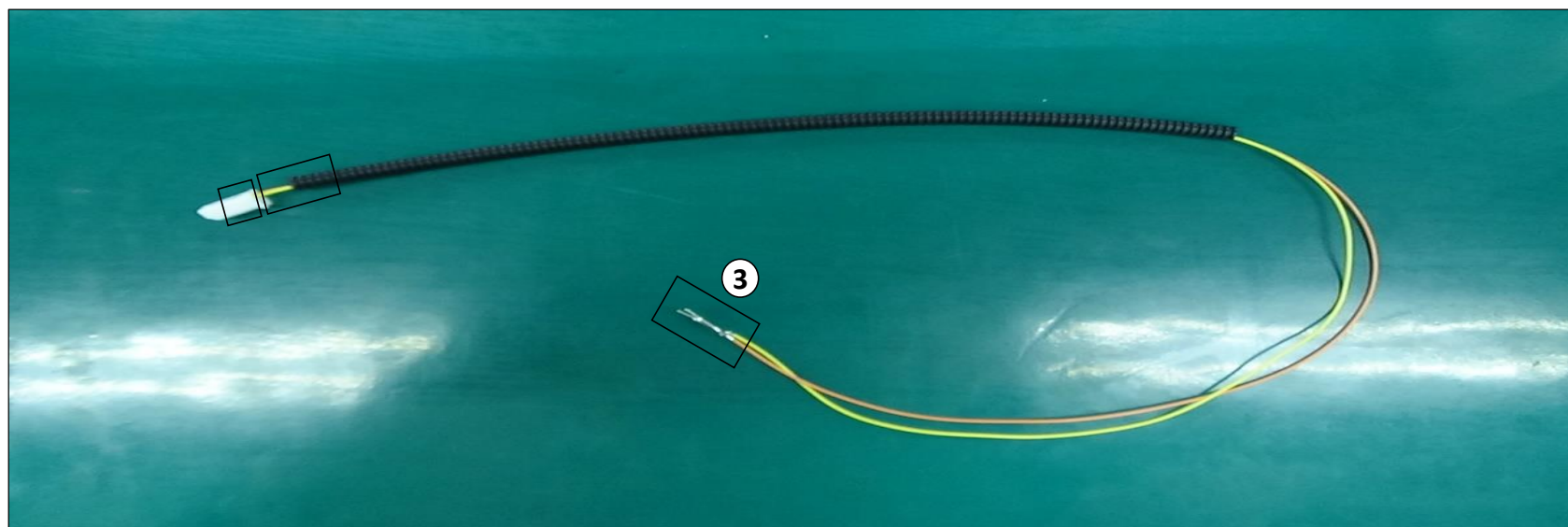
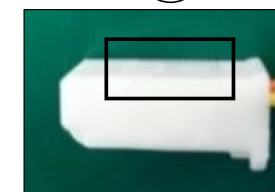
8 of 8

PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**OFFLINE INSERTION****7N0072-7020C****1****GOOD****NO GOOD****1****No Unlock/ Halflock Connector****2****No Wrong Insert****3****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