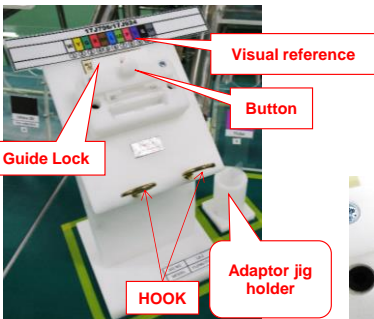
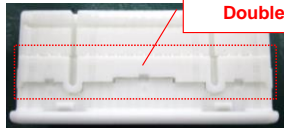
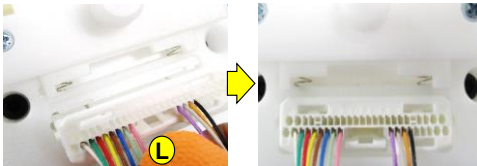
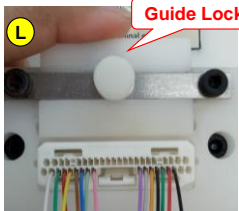
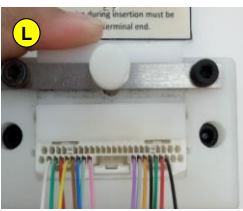


	WORK INSTRUCTION				Effectivity Date:		March 14, 2025	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 241B / 17J924-7051		Customer: TRP		Car Model: LEXUS-ES	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked=""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

PARTS:	1. Assy parts			JIG:	1. Insertion jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
1	P2 <div>17</div> <div>HIGH</div> <div>Connector setting to insertion jig (Assy parts) 1827842-1 (W)</div>	<div><div>INSERTION JIG</div><div>DOUBLE LOCK</div><div>CONNECTOR ORIENTATION</div><div>1. Get the connector 1827842-1 (W) (Assy parts) using left hand then set to insertion jig.</div><div><div>BEFORE PRESSING</div><div>AFTER PRESSING</div><div>2. Press the guide lock using left index finger.</div></div></div>		<div><div>Safety Instruction</div><div>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div></div> <div><div>Housekeeping</div><div>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div></div> <div><div>Alert level</div><div>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>	<div><div>Important reminders/Note/s:</div><div>1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector (gloves, finger cots, etc.) 5. No half-locked connector</div><div>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. 3. Do not attempt to repair. 3. Follow the connector orientation.</div><div>Connector must be no damaged/half-locked/locked</div><div><div>GOOD</div><div>UNLOCK</div><div>NG</div><div>HALF-LOCKED</div></div></div>		

Revision History				Prepared by		Checked by		Reviewed by		Approved by	
03/14/25	17	Inclusion of Quality improvement measures (based on Mizen Boshi activity).			D. Castillo	J. Loterte	C. Villanueva	A. Arañes			
08/02/23	16	Update Template; Inclusion of CAR MODEL "LEXUS-ES"; Transfer process of Connector lock from P2 to P4 due to TPS improvement.			M. Ariola	J. Loterte	C. Villanueva	A. Arañes			
03/02/23	15	Standardized tube description: VM tube (Sunprene); Change WIP flow quantity from [1pc] to [3pcs] flow; Update Work procedure/Illustration on process no.4 (Connector lock) as process improvement.			M. Ariola	J. Loterte	C. Villanueva	A. Arañes			
Eff. Date	Rev. No	Details of Change			Revised	Checked by	Reviewed	Approved	Est. Date:	June 02, 2017	

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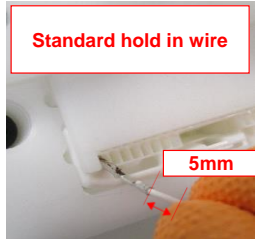



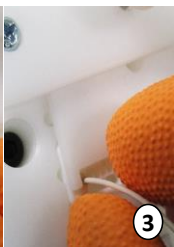
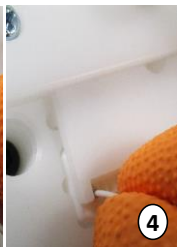

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WORK INSTRUCTION  
TAPING ASSEMBLY PROCESS

Effectivity Date:	March 14, 2025		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-092B		
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Process Name/Title:	TAPING ASSEMBLY PROCESS		
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		

PARTS:		1. Assy parts 2. CIVUS 0.13 W L=183±2mm; Y L=178±2mm; G L=181±2mm; R L=178±2mm; BR L=176±2mm; L L=175±2mm; LG L=176±2mm; P L=175±2mm; V L=185±2mm; B L=179±2mm; GR L=179±2mm;		JIG:	1. Insertion jig																																																																																				
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS																																																																																				
2	P2  Wire insertion to connector (Group 2 wires) 1827842-1 (W)	<div>17</div> <div>WIRE INSERTION ILLUSTRATION</div> <div></div> <div><table border="1"><tr><td colspan="18">17796-7051</td></tr><tr><td>X</td><td>X</td><td>X</td><td>X</td><td>-</td><td>X</td><td>W</td><td>Y</td><td>G</td><td>R</td><td>BR</td><td>L</td><td>LG</td><td>P</td><td>V</td><td>B</td><td>GR</td><td>X</td><td>X</td><td>X</td><td>X</td><td>X</td></tr><tr><td>-</td><td>-</td><td>-</td><td>-</td><td>-</td><td>-</td><td>183</td><td>178</td><td>181</td><td>178</td><td>176</td><td>175</td><td>176</td><td>175</td><td>185</td><td>179</td><td>179</td><td>-</td><td>-</td><td>-</td><td>-</td><td>-</td></tr><tr><td colspan="22">X</td></tr></table></div> <div><div>GOOD SHORT terminal</div><div></div><div>NG LONG terminal</div><div></div><div>Terminal facing</div><div></div><div>5mm</div><div></div><div>Finger COTS</div><div></div><div></div><div></div><div></div><div></div><div><div>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)</div></div></div>		17796-7051																		X	X	X	X	-	X	W	Y	G	R	BR	L	LG	P	V	B	GR	X	X	X	X	X	-	-	-	-	-	-	183	178	181	178	176	175	176	175	185	179	179	-	-	-	-	-	X																							<div>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</div> <div><b>Important reminders/Note/s:</b> 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.</div> <div><b>Document references:</b> 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div>
17796-7051																																																																																									
X	X	X	X	-	X	W	Y	G	R	BR	L	LG	P	V	B	GR	X	X	X	X	X																																																																				
-	-	-	-	-	-	183	178	181	178	176	175	176	175	185	179	179	-	-	-	-	-																																																																				
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WORK INSTRUCTION  
TAPING ASSEMBLY PROCESS

Effectivity Date:

March 14, 2025

Process Name/Title:

Validity Date:

n/a

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

Customer: TRP

Car Model: LEXUS-ES

Document No.:

WI-ENG-PDE-092B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH



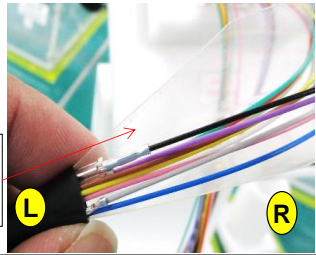
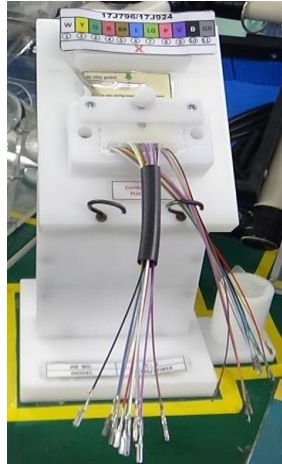



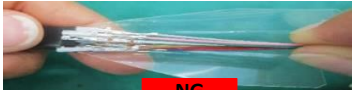


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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) $\phi 7$ L=55 $\pm$ 5mm		JIG:	1. Insertion jig 2. Adaptor jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 Wire insertion to Black VM tube (Sunprene) $\phi 7$ L=55 $\pm$ 5mm	<div><div><p>1. Get the <b>Black VM tube (Sunprene) <math>\phi 7</math> L=55<math>\pm</math>5mm</b> using left hand then insert the adaptor jig using right hand.</p></div><div><p>2. Hold the <b>Group 2 wires [11pcs.]</b> using right hand.</p></div></div> <div><div><p>Use the adaptor jig to easily insert wires.</p></div><div><p>3. Insert the wires to <b>Black VM tube (Sunprene)</b> using right hand.</p></div></div>		<div><div><p>Adaptor jig</p></div><div><p>Finger COTS</p></div></div>	<div><div><p>GOOD</p></div><div><p>NG</p></div><p><b>Wires must not be inserted at the same time</b></p></div> <div><p>1. No wrong use of parts. 2. No remaining wires outside black sunprene tube 3. No cut tube 4. Wires must not be inserted at the same time</p></div> <div><div><p>GOOD</p></div><div><p>NG</p></div><p><b>MUST BE NO CUT/DAMAGED TUBE</b></p></div> <div><p><b>STANDARD TUBE APPEARANCE</b></p></div>

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WORK INSTRUCTION  
TAPING ASSEMBLY PROCESS

Effectivity Date:

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Process Name/Title:

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

Customer: TRP

Car Model: LEXUS-ES

Document No.:

WI-ENG-PDE-092B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) $\phi 7$ L=55 $\pm$ 5mm		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	<div>17</div> <div>P2</div> <div>MEDIUM</div> <div>Wire insertion to Black VM tube (Sunprene) <math>\phi 7</math> L=55<math>\pm</math>5mm (Continuation)</div>	<div><div><div>Button</div><div>L</div><div>R</div><div>BEFORE PRESSING</div></div><div><div>L</div><div>R</div><div>AFTER PRESSING</div></div><div>4. Press the button using left thumb.</div></div> <div><div>R</div><div>5. Hold the wires using right hand then gently pull out the connector from jig. Check the insertion condition.</div></div>		<div>Finger COTS</div> <div></div>	<div>1. No wrong use of parts 2. No remaining wires outside black sunprene tube 3. No cut tube</div> <div>STANDARD TUBE APPEARANCE</div> <div><div><div>GOOD</div><div>NG</div></div><div>MUST BE NO CUT/DAMAGED TUBE</div><div>No bend terminal/wires</div><div><div>GOOD</div><div>NG</div></div><div>No damaged/whitens</div></div>

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**March 14, 2025**

Validity Date:

**n/a**

Model code/Part number:

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

Car Model:

**LEXUS-ES**

Document No.:

**WI-ENG-PDE-092B**

Purpose:



☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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<b>PARTS:</b>	1. Assy parts			JIG:	1. WIP Holder
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
4	P2 Pass WIP to P3	<div>3 PIECES FLOW</div>  <div>1. Pass WIP to WIP Holder. <b>Note: Three pieces flow.</b></div>		<div>WIP HOLDER</div> 	1. No WIP overflow

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