

	<b>WORK INSTRUCTION</b>				Effectivity Date:		October 09, 2024	
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: <b>220D / 7L0135-7021</b>		Customer: <b>TRQSS</b>		Car Model: <b>LEXUS-LM</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.: <b>WI-ENG-PDE-661A</b>		Revision No.: <b>2</b>		Page No.: <b>1 of 10</b>	

PARTS:	1. Assy parts; Connector 6098-3810 (W); Connector 6098-3802 (W); Black SV tube (Vinyl) ø5 L= 95±3mm; Black SV tube (Vinyl) ø5 L=181±3mm; AVSSf 0.3 G L=686±3mm; AVSSf 0.3 V L=796mm; AVSSf 0.3 B L=796±3mm; Black corrugated tube ø5 L=404±4mm (no slit); Black tape				JIG:	1. Insertion jig with switch cover 2. Locking jig 3. Terminal Cover Jig				
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS			
1	P1	<div style="text-align: center;"> <b>Table Lay-out</b> </div>				<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> <b>Safety Instruction</b>            Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> <b>Housekeeping</b>            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 solid red; padding: 5px;"> <b>Alert level</b>            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		

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
10/09/24	2	Transfer process of Offline assembly to Taping assembly process and some process to P2. Improved Table lay-out and Visual inspection/Quality checkpoints. Inclusion of car model "LEXUS-LM".						D.Castillo	C. Villanueva	A. Arañes	n/a				
04/04/23	1	Change purpose from Pre-Launch to Masspro.						M. ariola	J. Loterte	C. Villanueva	A. Arañes				
03/24/23	0	Initial issue. Removal of taping from Black VM tube (Sunprene) to wire near terminal and replaced by spot taping on VM tube (Sunprene)						M. ariola	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change						Revised	Reviewed	Approved	Noted	Est. Date:		March 24, 2023	

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220D / 7L0135-7021

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TRQSS

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LEXUS-LM

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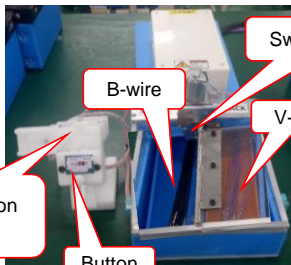
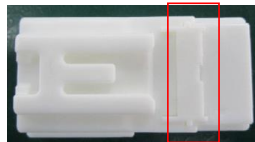
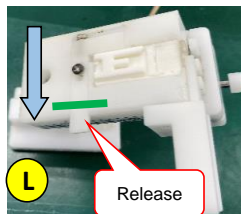
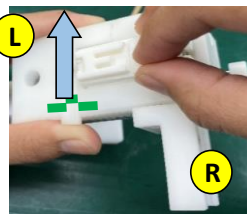
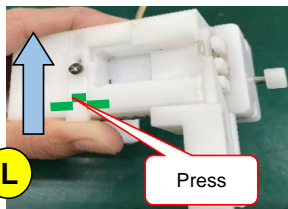
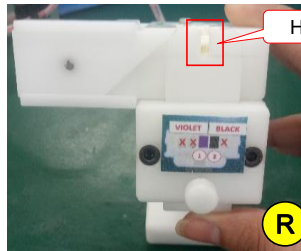
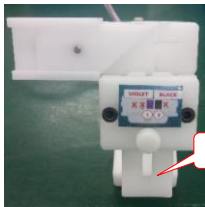
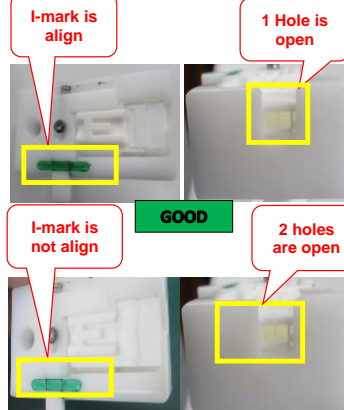
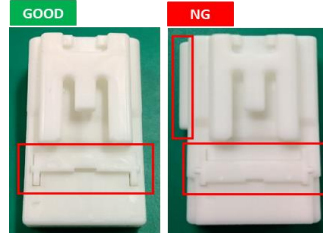
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PARTS:		1. Connector 6098-3802 (W)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<div><div>2</div><div>Connector setting to insertion jig 6098-3802 (W)</div></div> <div><div><div>INSERTION JIG WITH SWITCH COVER</div><div></div><div><div>CONNECTOR ORIENTATION</div><div></div></div></div><div><div></div><div><div></div></div><div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector <b>6098-3802</b> into jig using right hand and release the lock.</div><div>3. Push the guide using right hand. The slot for <b>Violet wire</b> will be opened.</div></div></div><div>n/a</div><div><div><div>Connector Orientation Illustration</div><div><div><div>I-mark is align</div><div>1 Hole is open</div><div>I-mark is not align</div><div>2 holes are open</div></div><div><div>GOOD</div><div>NG</div></div></div><div><div>CONNECTOR ILLUSTRATION</div><div><div><div>GOOD</div><div>NG</div></div><div><div>6098-3802 (W)</div><div>6098-5668 (W)</div></div></div><div><div>1. Use provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div></div></div></div></div></div>			

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220D / 7L0135-7021

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Car Model:

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Purpose:



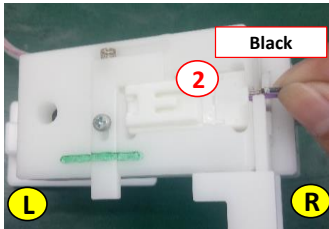
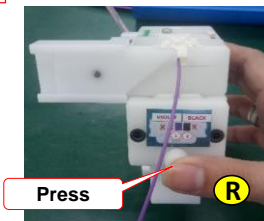
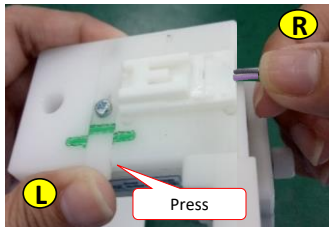
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PARTS:		1. AVSSf 0.3 B L=796±3mm 2. AVSSf 0.3 V L=796±3mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to connector 6098-3802 (W)	<div><div><p>Wire facing</p></div><div><p>Violet</p><p>1. Get the <b>Violet wire</b> then insert to terminal slot <b>1</b> using right hand.</p></div><div><p>Black</p><p>3. Get the <b>Black wire</b> then insert to terminal slot <b>2</b> using right hand.</p></div><div><p>Press</p><p>2. After insertion of Violet wire press the button using right hand. The slot for <b>Black wire</b> will be opened.</p></div><div><p>Press</p><p>4. After insertion, press the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div></div> <td>n/a</td> <td><p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p><p><b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal.</b> <b>2. Make sure wires are properly inserted.</b> <b>Conduct <u>Pull-Push-Pull-Push</u> after insertion.</b> <b>Do not exert extra force.</b></p><p><b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b> <b>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b></p></td>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p><b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal.</b> <b>2. Make sure wires are properly inserted.</b> <b>Conduct <u>Pull-Push-Pull-Push</u> after insertion.</b> <b>Do not exert extra force.</b></p> <p><b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b> <b>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b></p>

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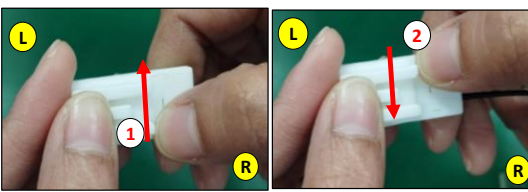

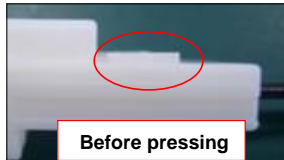



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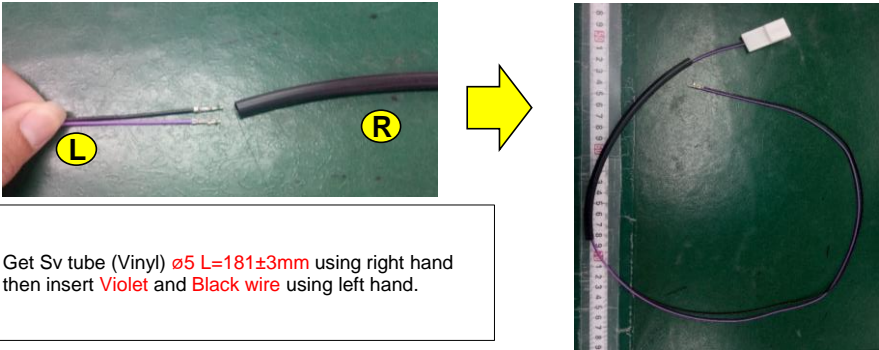
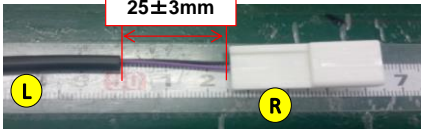
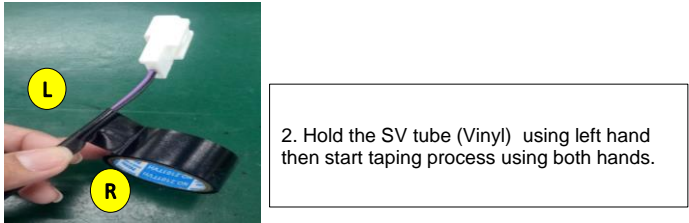
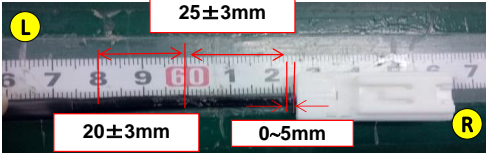

PARTS:	1. Assy parts			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 Connector Lock	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div> <div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div> <div><p>Right thumb-Lower Left thumb-middle</p><p>3. Press the lower parts of connector using right hand while left hand holding the middle.</p></div> <div><p>Right thumb-upper Left thumb-middle</p><p>4. Press the upper part of connector using right hand while left hand holding the middle.</p></div> <div><p>Right thumb-middle Left thumb-middle</p><p>5. Lift then press the connector in the middle using left and right hand.</p></div> <div><p>6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div>		<p>LOCKING JIG</p> 	<div><p>Before pressing</p><p>After pressing</p></div> <div><p>GOOD NG</p><p>Full Lock</p><p>Half Lock</p></div> <p><b>Important reminders/Note/s:</b> <b>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b></p> <p>1. Use the provided jig tool to lock the connector. 2. No unlock/half-locked connector</p>

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<b>PARTS:</b>	1. Black SV tube (Vinyl) ø5 L=181±3mm 2. Assy parts 3. Black tape			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
5	<div>2</div> Wire insertion to Black SV tube (Vinyl) ø5 L=181±3mm	<div><p>Get Sv tube (Vinyl) ø5 L=181±3mm using right hand then insert Violet and Black wire using left hand.</p></div>		n/a	1. No wrong use of parts 2. No deformed terminal
6	P1  Taping 1 Black SV tube (Vinyl) to wire near connector	<div><p>1. Get the assy parts, measure the end of the SV tube (Vinyl) up to the connector 25±3mm using both hands.</p></div> <div><p>2. Hold the SV tube (Vinyl) using left hand then start taping process using both hands.</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>		<div>MEASURING TAPE</div> 	<b>Important reminders and Note/s:</b> 1. Please use calibrated/verified measuring tape when getting the measurement.  <b>Document reference/s:</b> 1. Refer to WI-PRO-ASY-001 for taping procedure.  1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape


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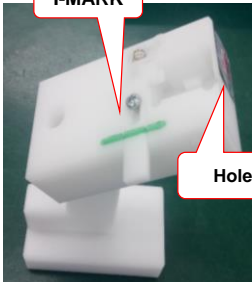

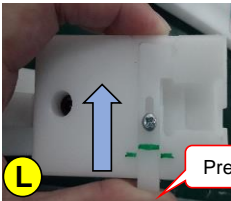
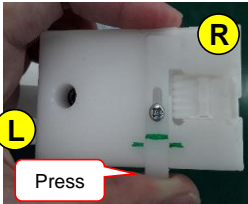
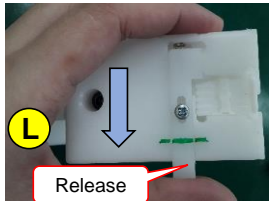



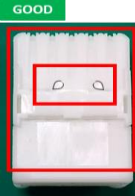
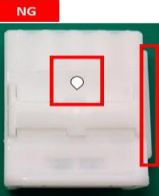


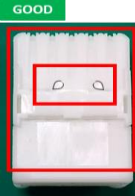
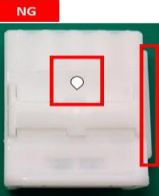
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<b>PARTS:</b>	1. Connector 6098-3810 (W)			JIG:	1. Insertion jig			
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
7	P1	<div>Connector setting to insertion jig 6098-3810 (W)</div> <div><div><p><b>INSERTION JIG</b></p></div><div><p><b>I-MARK</b></p><p><b>Insertion jig orientation</b></p></div><div><p><b>Connector orientation</b></p></div><div><p><b>Press</b></p></div><div><p><b>Press</b></p></div><div><p><b>Release</b></p></div><div><p><b>Hole</b></p></div><div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the connector <b>6098-3810 (W)</b> into jig using right hand and release the lock.</p><p>3. Check the hole/terminal slot for <b>Green wire</b>.</p></div></div> <td>n/a</td> <td colspan="3"><div><p><b>Connector Orientation Illustration</b></p><p><b>I-mark is align</b></p><p><b>1 hole is open</b></p><p><b>GOOD</b></p><p><b>I-mark is not align</b></p><p><b>Half of hole is open</b></p><p><b>NG</b></p><p><b>CONNECTOR ILLUSTRATION</b></p><p><b>GOOD</b></p><p><b>6098-3810 (W)</b></p><p><b>NG</b></p><p><b>6098-5677 (W)</b></p></div><div><p>1. Use the provided jig per model</p><p>2. No wrong orientation of connector</p><p>3. No wrong use of connector</p><p>4. No damaged connector</p></div></td>			n/a	<div><p><b>Connector Orientation Illustration</b></p><p><b>I-mark is align</b></p><p><b>1 hole is open</b></p><p><b>GOOD</b></p><p><b>I-mark is not align</b></p><p><b>Half of hole is open</b></p><p><b>NG</b></p><p><b>CONNECTOR ILLUSTRATION</b></p><p><b>GOOD</b></p><p><b>6098-3810 (W)</b></p><p><b>NG</b></p><p><b>6098-5677 (W)</b></p></div> <div><p>1. Use the provided jig per model</p><p>2. No wrong orientation of connector</p><p>3. No wrong use of connector</p><p>4. No damaged connector</p></div>		


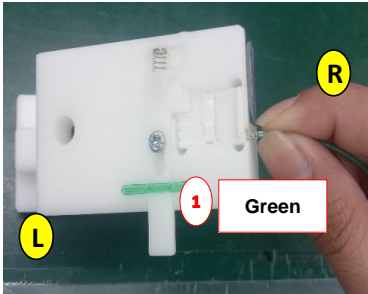
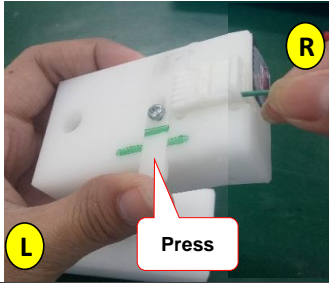
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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.:	7 of 10

<b>PARTS:</b>	1. Black SV tube (Vinyl) ø5 L=95±3mm 2. AVSSf 0.3 G L=686±3mm			JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
8	Wire insertion to Black SV tube (Vinyl) ø5 L= 95±3mm	<div><div>1. Get the Black SV tube (Vinyl) <b>ø5 L=95±3mm</b> using right hand and insert the <b>G wire</b> using left hand.</div></div>		n/a	1. No wrong usage of parts 2. No deformed terminal
9	P1 Wire insertion to connector 6098-3810 (W)	<div><div><div>1. Get the <b>Green wire</b> and insert to terminal slot <b>1</b> using right hand.</div></div><div><div>2. After insertion, press the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</div></div><div>Terminal facing</div></div>		n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing  <b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal.</b> <b>2. Make sure wires are properly inserted.</b> <b>Conduct <u>Pull-Push-Pull-Push</u> after insertion.</b> <b>Do not exert extra force.</b>  <b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b> <b>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b>

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Document No.:

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


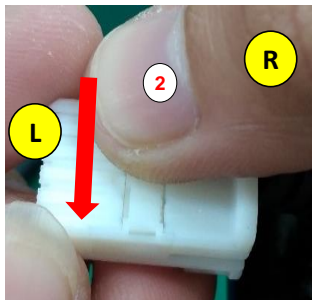
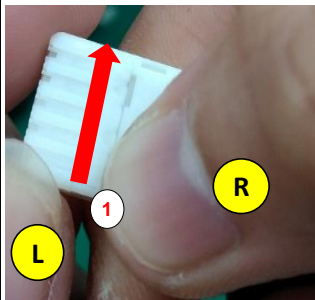
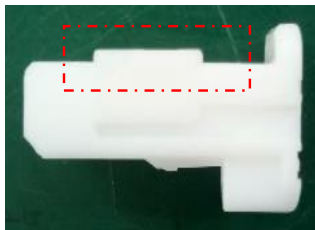
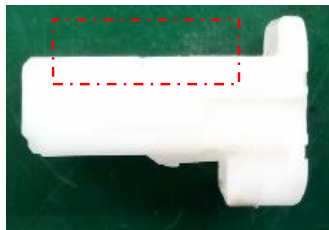

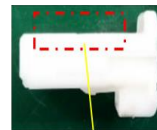
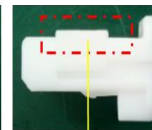
☒ MASSPRO

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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	P1	<div><div></div><div><p>1. Put the connector into locking jig using right hand then press <b>2x</b> using both hands. Touch the connector lock to confirm if properly locked.</p></div></div> <div><div></div><div><p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div></div> <div><div></div><div><p>Before Pressing</p></div><div></div><div><p>After Pressing</p></div></div>		<div><p><b>LOCKING JIG</b></p></div>	<p><b>Important reminders/Note/s:</b> <b>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b></p> <p>1. Use the provided locking jig per model 2. No unlock/half-locked connector</p> <div><p><b>CONNECTOR LOCK CONDITION</b></p><div><div><p><b>GOOD</b></p></div><div><p>Fully Locked</p></div><div><p><b>NG</b></p></div><div><p>UnLocked</p></div></div></div>

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**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**

Effectivity Date:

**October 09, 2024**Model code/Part number: **220D / 7L0135-7021**Customer: **TRQSS**Car Model: **LEXUS-LM**

Validity Date:

**n/a**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

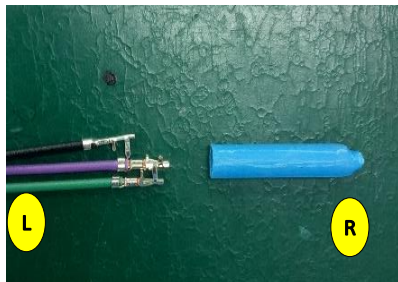

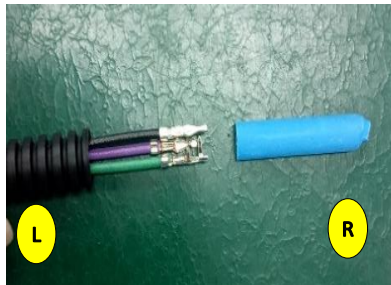

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PARTS:		1. Assy parts		2. Black corrugated tube (no slit) ø5 L=404±4mm		JIG:	1. Terminal cover jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
11	P1	Wire insertion to Black corrugated tube (no slit) ø5 L=404±4mm	<div></div> <div>1. Combined the assy parts (G, V and B wire with SV tube (Vinyl)), get the terminal cover jig using right hand and insert wires using left hand.</div> <div></div> <div>2. Get the Black corrugated tube (no slit) ø5 L=404±4mm using right hand and insert the wires using left hand.</div> <div></div> <div>3. After insertion, remove the terminal cover jig using right hand.</div>	<div>MEASURING JIG</div> <div></div>	1. No wrong use of parts 2. No deformed terminal		

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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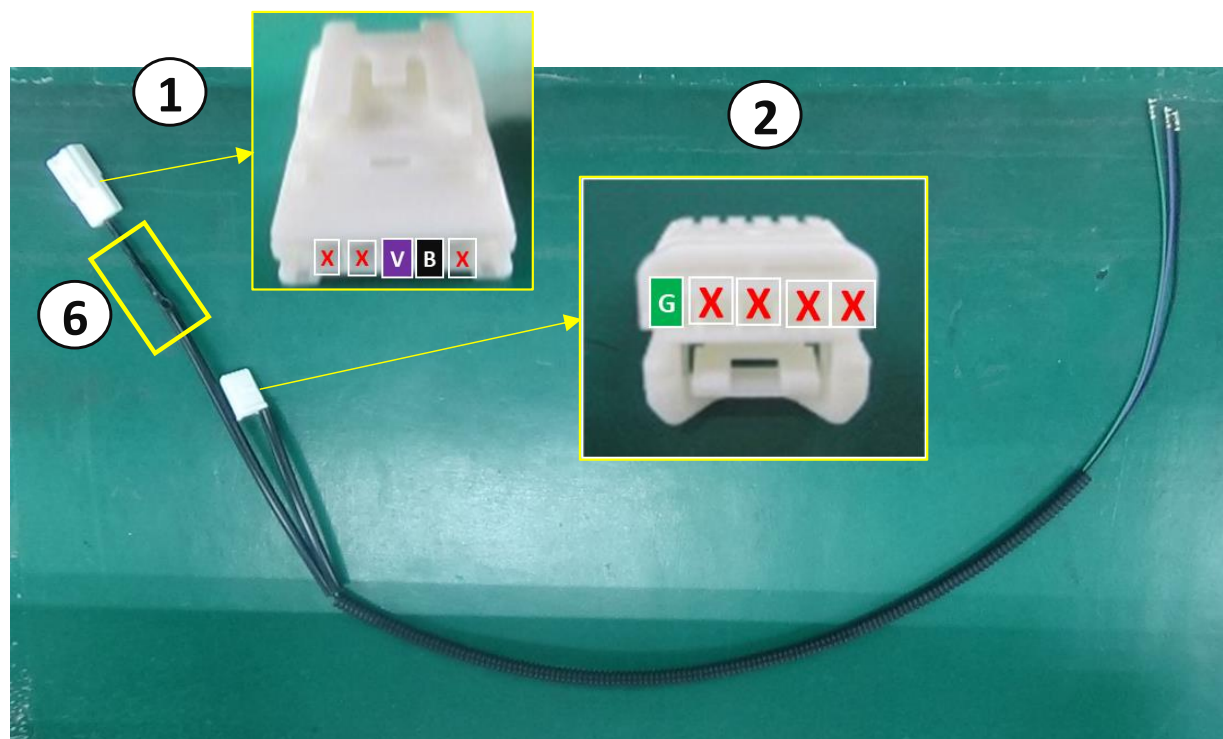
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P1****7L0135-7021**

- ① ② No Wrong Insert
- ③ No Unlocked/  
Half-locked Connector
- ④ No Terminal Backing  
Out
- ⑤ No Deformed Terminal
- ⑥ No Missing tape

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