
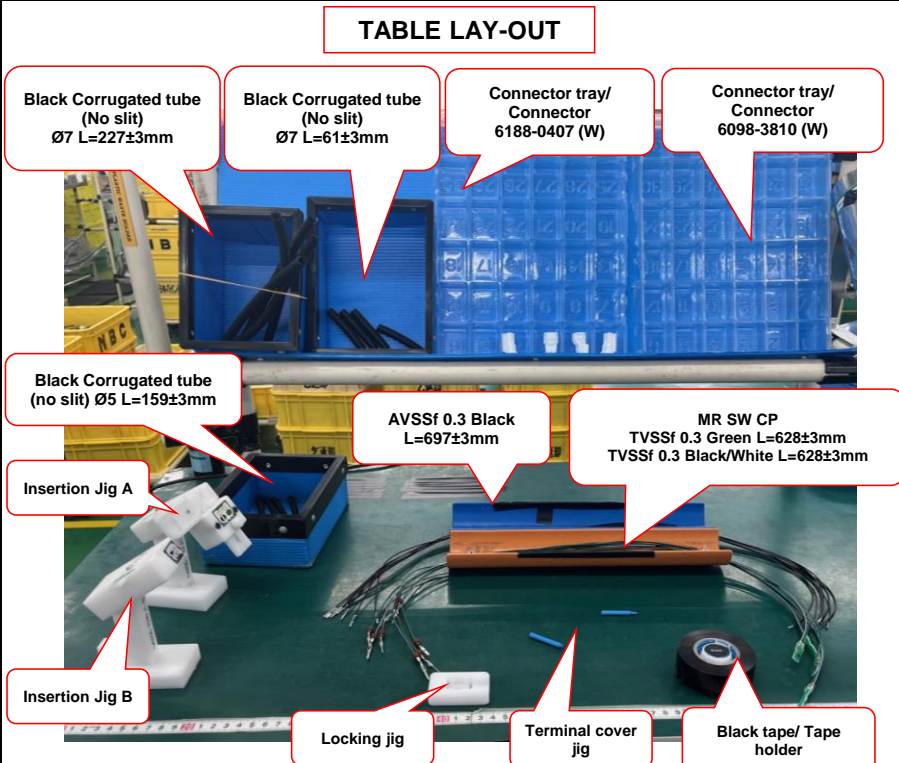


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|  | <b>WORK INSTRUCTION</b>   |                      |                            | Effectivity Date: | <b>December 03, 2024</b> |           |         |
|   | Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>  |                      |                            | Validity Date:    | n/a                      |           |         |
|   | Model code/Part number: <b>410D/412D / 7N0235-7020A</b>   | Customer: <b>TRJ</b> | Car Model: <b>LEXUS-ES</b> | Document No.:     | <b>WI-ENG-PDE-1121A</b>  |           |         |
|   | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO |                      |                            | Revision No.:     | 1                        | Page No.: | 1 of 10 |


| PARTS: |              | 1. MR SW CP (TVSSf 0.3 G wire L=628±3mm; B/W wire L=628±3mm); Connector 6188-0407 (W); Connector 6098-3810 (W); AVSSf 0.3 Black wire L=697±3mm [2pcs]; Black Corrugated tube ø5 L=159±3mm (no slit); Black Corrugated tube (No slit) ø7, L=227±3mm; Black Corrugated tube (No Slit) ø7, L=61±3mm; Black tape |  | JIG:  | 1. Insertion jig<br>2. Locking jig<br>3. Terminal cover jig  |  |
|--------|--------------|--|--|---|--|--|
| NO.    | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION   |  | TOOLS/PPE   | QUALITY POINTERS   |  |
| 1      | P1           | <div>TABLE LAY-OUT</div>    |  | <div>Safety Instruction</div> <p>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's.<br/>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> | <div>Document references:</div> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No missing parts/tools<br/>2. No excess parts/tools<br/>3. No wrong positions of parts/tools</p> |  |

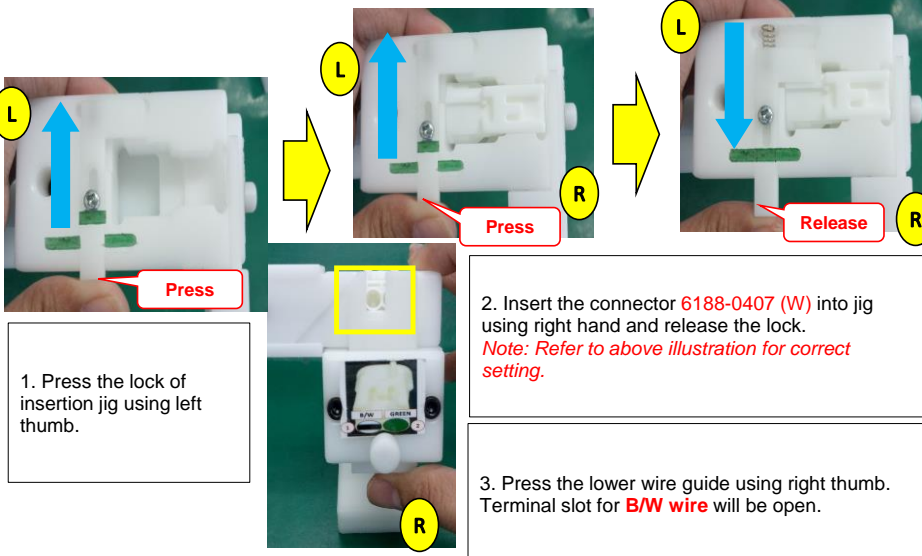
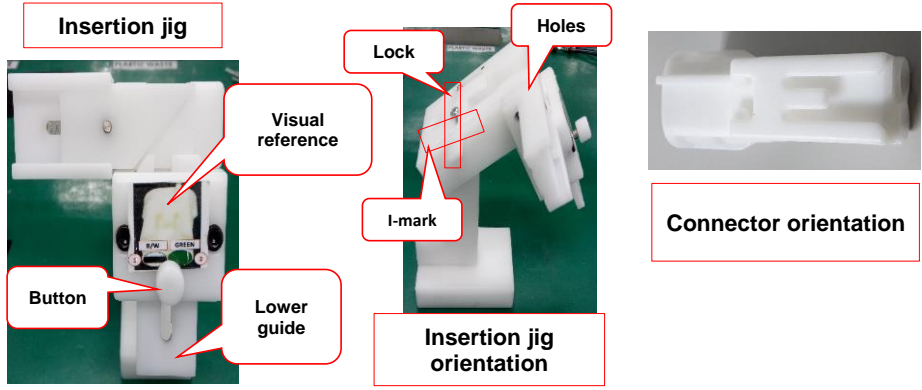
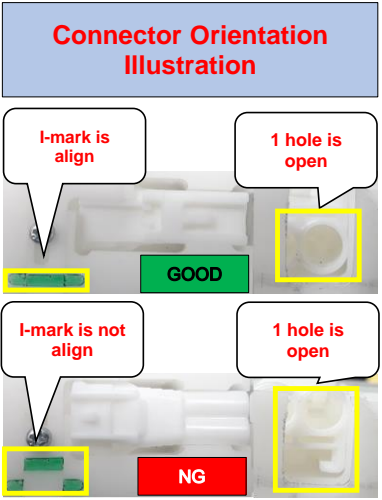
| Revision History |         |   |         | Prepared by | Reviewed by  | Approved by | Noted by         |
|------------------|---------|---|---------|-------------|--------------|-------------|------------------|
|                  |         |   |         |             |              |             |                  |
| 12/03/24         | 1       | Change from Pre-launch to masspro. Separate other process to P2 and P3. |         | D.Castillo  | C.Villanueva | A. Arañes   | n/a              |
| 10/22/24         | 0       | Initial issue.  |         | D.Castillo  | C.Villanueva | A. Arañes   | n/a              |
| Eff. Date        | Rev. No | Details of Change   | Revised | Reviewed    | Approved     | Noted       | Est. Date:       |
|                  |         |   |         |             |              |             | October 22, 2024 |

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|  | <b>WORK INSTRUCTION</b>   |  |                      | Effectivity Date:          | <b>December 03, 2024</b>              |           |         |
|   | <b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>  |  |                      | Validity Date:             | n/a                                   |           |         |
|   | Model code/Part number: <b>410D/412D / 7N0235-7020A</b>   |  | Customer: <b>TRJ</b> | Car Model: <b>LEXUS-ES</b> | Document No.: <b>WI-ENG-PDE-1121A</b> |           |         |
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|               |  |  |  |                  |   |  |
|---------------|--|--|--|------------------|---|--|
| <b>PARTS:</b> |  | 1. Connector 6188-0407 (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>   |  |
| 3             | P1<br>Connector setting to insertion jig 6188-0407 (W) | <div></div> |  | n/a              | <div><p>1. Use the provided jig per model<br/>2. No wrong orientation of connector</p></div> |  |

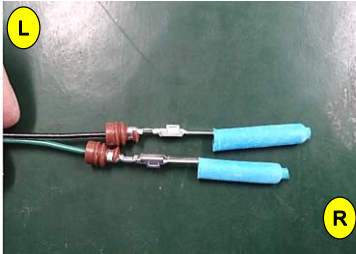


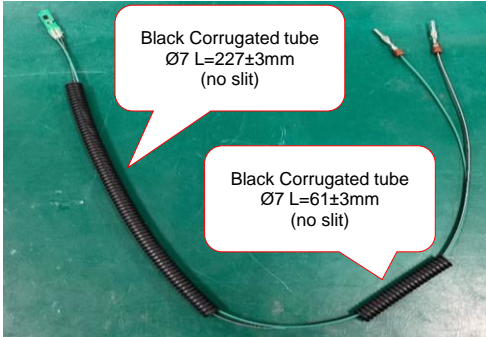

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|   | <b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>  |  |                      |                            | Validity Date:    | n/a                      |           |         |
|   | Model code/Part number: <b>410D/412D / 7N0235-7020A</b>   |  | Customer: <b>TRJ</b> | Car Model: <b>LEXUS-ES</b> | Document No.:     | <b>WI-ENG-PDE-1121A</b>  |           |         |
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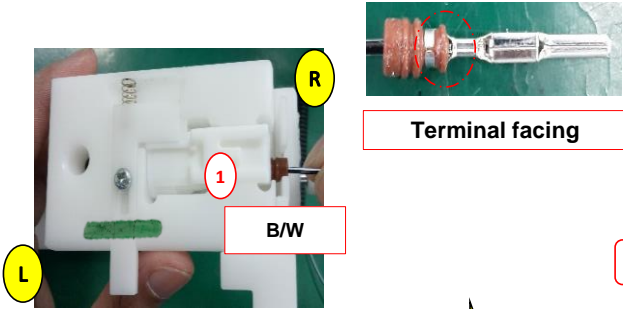
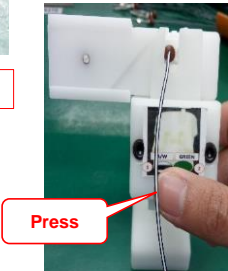
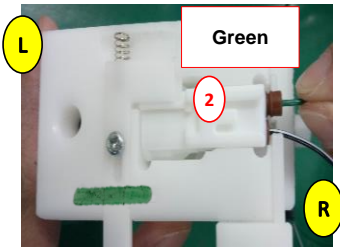
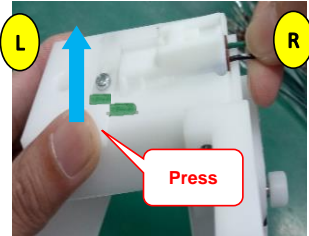
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| <b>PARTS:</b> | 1. MR SW CP (TVSSf 0.3 G-BW wires L=628±3mm)<br>2. Black Corrugated tube (No slit) Ø7, L=227±3mm<br>3. Black Corrugated tube (No Slit) Ø7, L=61±3mm |  |  | JIG:   | 1.Terminal cover jig                                  |
| <b>NO.</b>    | <b>PROCESS NAME</b>   | <b>WORK PROCEDURE/ ILLUSTRATION</b>  |  | <b>TOOLS/PPE</b>   | <b>QUALITY POINTERS</b>                               |
| 2             | P1<br><br>Wire insertion to Black Corrugated tube (No Slit) Ø7, L=227±3mm and Black Corrugated tube (No Slit) Ø7, L=61±3mm                          | <div><p>1. Get the terminal cover jig using right hand then insert to <b>G</b> and <b>B/W wires</b>.</p></div> <div><p>2. Get the 1st Black Corrugated tube <b>Ø7 L=227±3mm (no slit)</b> using right hand and insert to <b>G</b> and <b>B/W wires</b> then get then <b>2nd</b> Black Corrugated tube <b>Ø7 L=61±3mm (no slit)</b> and insert to <b>G</b> and <b>B/W wires</b> using right hand.</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div> <div><p>Black Corrugated tube Ø7 L=227±3mm (no slit)</p><p>Black Corrugated tube Ø7 L=61±3mm (no slit)</p></div> |  | <div><b>TERMINAL COVER JIG</b></div>  | 1. No wrong usage of parts<br>2. No deformed terminal |

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|   | <b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>  |  |                      |                            | Validity Date:    | n/a                      |           |         |
|   | Model code/Part number: <b>410D/412D / 7N0235-7020A</b>   |  | Customer: <b>TRJ</b> | Car Model: <b>LEXUS-ES</b> | Document No.:     | <b>WI-ENG-PDE-1121A</b>  |           |         |
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|               |   |  |                  |  |                  |
|---------------|---|--|------------------|--|------------------|
| <b>PARTS:</b> | 1. Assy parts                                       |  |                  | JIG:   | 1. Insertion jig |
| <b>NO.</b>    | <b>PROCESS NAME</b>                                 | <b>WORK PROCEDURE/ ILLUSTRATION</b>  | <b>TOOLS/PPE</b> | <b>QUALITY POINTERS</b>  |                  |
| 4             | P1<br><br>Wire Insertion to connector 6188-0407 (W) | <div><p>1. Get <b>Black/White wire</b> then insert to terminal <b>slot 1</b> using right hand.</p></div> <div><p>2. Push the button after insertion. Hole for Green wire will be open.</p></div> <div><p>3. Get <b>Green wire</b> then insert to terminal <b>slot 2</b> 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              | <p>1. No loose insertion<br/>2. No wrong insertion<br/>3. One by one insertion<br/>4. No deformed terminal<br/>5. No wrong wire facing</p> <p><b>Important reminders/Note/s:</b></p> <p>1. Please hold the wire near terminal during insertion.</p> <p>2. Insertion of wire must be inserted.</p> <p>3. Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip lenght Tolerance.</p> <p>2. Please refer to <b>GL-PRO-ASSY-029</b> for Pull-Push procedure.</p> |                  |


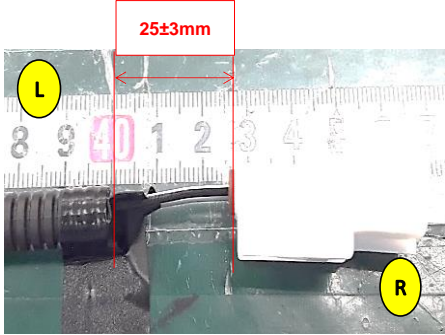
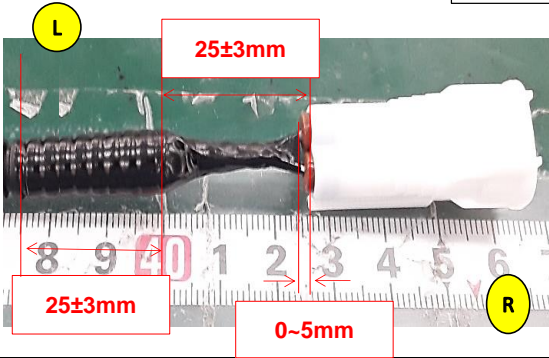

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|   | Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>  |  |                      | Validity Date:             | n/a                      |                         |         |
|   | Model code/Part number: <b>410D/412D / 7N0235-7020A</b>   |  | Customer: <b>TRJ</b> | Car Model: <b>LEXUS-ES</b> | Document No.:            | <b>WI-ENG-PDE-1121A</b> |         |
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|               |  |  |   |                         |     |
|---------------|--|--|---|-------------------------|-----|
| <b>PARTS:</b> |  | 1. Assy part<br>2. 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             | P1<br>Taping 1<br>Corrugated tube to wire near Connector | <div><div><p>Start of taping</p></div><div><p>1. Hold the COT using left hand. Get <b>Black tape</b> using right hand and conduct pre taping.</p></div><div><p>25±3mm</p><p>2. Measure the end of COT to connector <b>25±3mm</b> and continue taping process.</p></div><div><p>25±3mm</p><p>0~5mm</p><p>3. After taping, check the dimension and taping condition.</p></div></div> <div><p><b>MEASURING TAPE</b></p></div> | <div><p>1. No flip-out tape<br/>2.No peel-off tape<br/>3. No loose tape<br/>4. No wrong dimension<br/>5. No wrong use of tape<br/>6. No missing tape<br/>7. No insufficient tape</p><p><b>Important reminders/Note/s:</b><br/>1. <b>Please use calibrated/verified measuring tape when getting the measurement.</b></p><p><b>Document references:</b><br/>1. <b>Refer to WI-PRO-ASY-001A for Taping process</b></p></div> |                         |     |



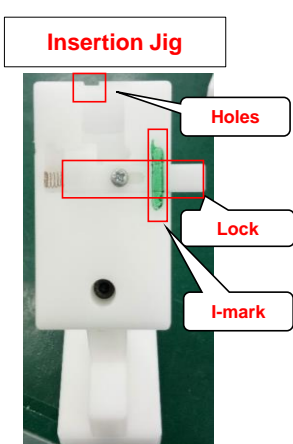

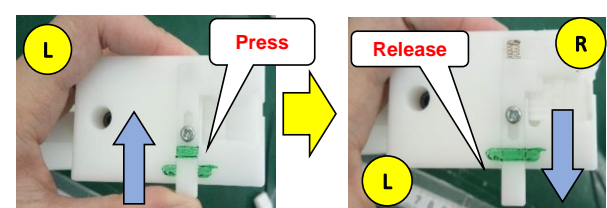
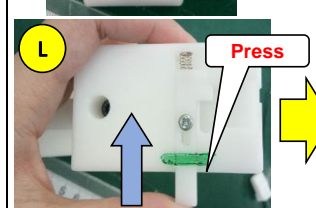

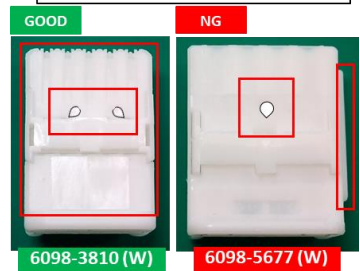
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|   | Model code/Part number: <b>410D/412D / 7N0235-7020A</b>   |  | Customer: <b>TRJ</b> | Car Model: <b>LEXUS-ES</b> | Document No.: <b>WI-ENG-PDE-1121A</b> |           |         |
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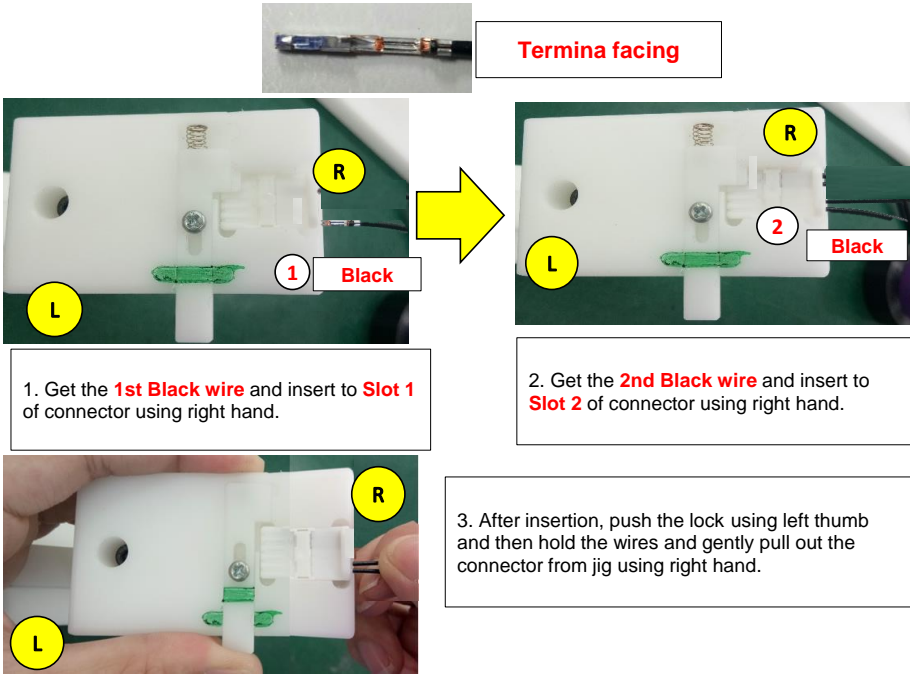
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| <b>PARTS:</b> |  | 1. Connector 6098-3810 (W)   |                  | JIG:  | 1. Insertion Jig |
| <b>NO.</b>    | <b>PROCESS NAME</b>                                    | <b>WORK PROCEDURE/ ILLUSTRATION</b>  | <b>TOOLS/PPE</b> | <b>QUALITY POINTERS</b>   |                  |
| 6             | P1<br>Connector Setting to Insertion jig 6098-3810 (W) | <div></div> <div></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 holes/terminal slot for <b>B-B wires</b>.</p></div> | n/a              | <div><p>1. Use provided jig per model<br/>2. No wrong usage of parts<br/>3. No wrong orientation of connector<br/>4. No damaged connector</p></div> <div></div> <div></div> |                  |

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|   | Process Name/Title: TAPING ASSEMBLY PROCESS   |  |               | Validity Date:      | n/a               |                  |         |
|   | Model code/Part number: 410D/412D / 7N0235-7020A  |  | Customer: TRJ | Car Model: LEXUS-ES | Document No.:     | WI-ENG-PDE-1121A |         |
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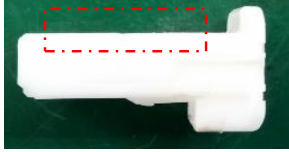
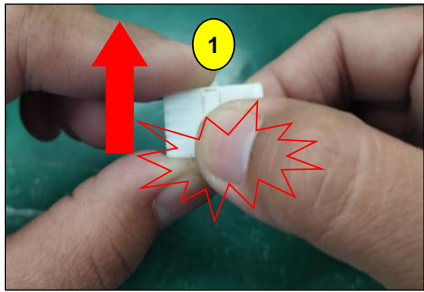
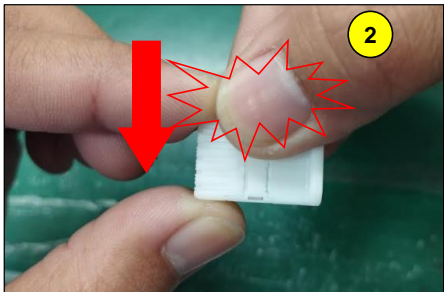

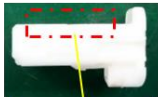
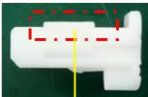
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| PARTS: | 1. AVSSf 0.3 Black wire L=697±3mm [2pcs]<br>2. Black Corrugated tube ø5 L=159±3mm (no slit) |  |  | JIG:      | n/a   |
| NO.    | PROCESS NAME  | WORK PROCEDURE/ ILLUSTRATION   |  | TOOLS/PPE | QUALITY POINTERS  |
| 7      | Wire insertion to Black Corrugated tube (no slit) Ø5 L=159±3mm                              |  <p>1. Get Black corrugated tube Ø5 L=159±3mm (No slit) using left hand and get 2pcs of Black wire L=697±3mm then insert using right hand.</p>   |  | n/a       | <b>Document references:</b><br>1. Refer to WI-PRO-CNC-017 for Wire Strip lenght tolerance.<br><br>1. No Wrong use of parts<br>2. No deformed terminal   |
| 8      | P1<br><br>Wire insertion to Connector 6098-3810 (W)   |  <p>Termina facing</p> <p>1. Get the 1st Black wire and insert to Slot 1 of connector using right hand.</p> <p>2. Get the 2nd Black wire and insert to Slot 2 of connector using right hand.</p> <p>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.</p> |  | n/a       | 1. No wrong use of connector<br>2. No damaged connector<br>3. No wrong insertion<br>4. One by one insertion<br>5. No deformed terminal<br>6. No wrong wire facing<br><br><b>Important reminder/Notes/:</b><br>1. Please hold the wire near terminal during insertion.<br>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.<br><br><b>Document reference/s:</b><br>1. Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.<br>2. Please refer to GL-PRO-ASY-029 for Pull-Push procedure. |

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|   | Process Name/Title:                              |  |               | Document No.:       | WI-ENG-PDE-1121A  |  |  |
|   | Model code/Part number: 410D/412D / 7N0235-7020A |  | Customer: TRJ | Car Model: LEXUS-ES | Revision No.: 1   |  |  |
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|        |              |  |  |  |  |  |
|--------|--------------|--|--|--|--|--|
| PARTS: |              | 1. Assy part   |  | JIG:   | 1. Locking jig   |  |
| NO.    | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION   |  | TOOLS/PPE  | QUALITY POINTERS   |  |
| 9      | P1           | Connector lock   |  |  | 1. Use provided jig tool per model to avoid damaged lock.<br>2. No Unlock and half-locked connector<br>3. No damaged lock<br><br><b>Important reminders/Note/s:</b><br>1. Manual locking may cause damaged connector lock. |  |
|        |              | <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><p>Before Pressing</p><p>After Pressing</p></div><div><p>1</p><p>2</p></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><p>LOCKING JIG</p></div> <div><p>LOCK CONDITION</p><div><div><p>GOOD Fully Locked</p></div><div><p>NG UnLocked</p></div></div></div> |  |  |






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|   |                                |  |   |                                     |   |                          |                         |           |
|---|--------------------------------|--|---|-------------------------------------|---|--------------------------|-------------------------|-----------|
|  | <b>WORK INSTRUCTION</b>        |  |   |                                     | Effectivity Date:                           | <b>December 03, 2024</b> |                         |           |
|   | <b>TAPING ASSEMBLY PROCESS</b> |  |   |                                     | Validity Date:                              | n/a                      |                         |           |
|   | Process Name/Title:            |  | Model code/Part number: <b>410D/412D / 7N0235-7020A</b> | Customer: <b>TRJ</b>                | Car Model: <b>LEXUS-ES</b>                  | Document No.:            | <b>WI-ENG-PDE-1121A</b> |           |
|   | Purpose:                       |  | <input type="checkbox"/> PROTOTYPE                      | <input type="checkbox"/> PRE-LAUNCH | <input checked="" type="checkbox"/> MASSPRO | Revision No.:            | 1                       | Page No.: |

|               |                                    |  |  |   |  |
|---------------|------------------------------------|--|--|---|--|
| <b>PARTS:</b> | 1. Assy part                       |  |  | JIG:  | 1. Terminal cover jig                                  |
| <b>NO.</b>    | <b>PROCESS NAME</b>                | <b>WORK PROCEDURE/ ILLUSTRATION</b>  |  | <b>TOOLS/PPE</b>  | <b>QUALITY POINTERS</b>                                |
| 10            | P1<br>Wire insertion to assy parts | <div><p>1. Get the terminal cover jig using right hand then insert to <b>B wires</b>.</p></div> <div><p>Black Corrugated tube<br/>Ø7 L=227±3mm<br/>(no slit)</p><p>2. Get the assy parts and insert to Black Corrugated tube <b>Ø7 L=227±3mm (no slit)</b> using right hand.</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div> <div></div> |  | <div><p>Terminal cover jig</p></div> | 1. No wrong usage of parts.<br>2. No deformed terminal |

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

December 03, 2024

Validity Date:

n/a

Model code/Part number:

410D/412D / 7N0235-7020A

Customer:

TRJ

Car Model:

LEXUS-ES

Document No.:

WI-ENG-PDE-1121A

Purpose:



PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Assy parts

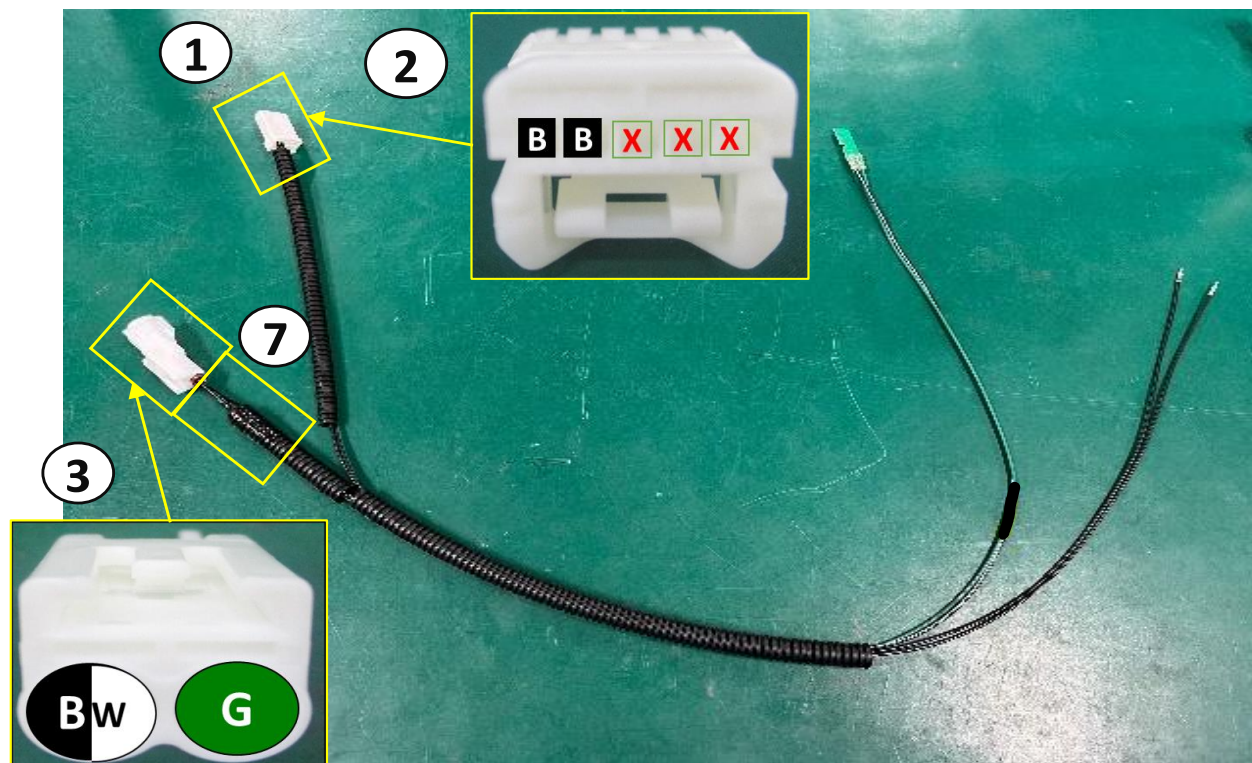
JIG:

n/a

### VISUAL INSPECTION/ QUALITY CHECKPOINTS

## TAPING - P1

## 7N0235-7020A



- ① No **Unlock/Halflock Connector**
- ② ③ No **Wrong Insert**
- ④ No **Terminal Backing Out**
- ⑤ No **Deformed Terminal**
- ⑥ No **Missing parts**
- ⑦ No **Missing tape**

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