	WORK INSTRUCTION				Effectivity Date:		May 24, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 100B / 7M0593-7021		Customer: TRJ	Car Model: LEXUS UX	Document No.:		WI-ENG-PDE-444A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		3	Page No.: 1 of 13

PARTS:	1. Connector 6098-3802 (W); Connector 6098-2220 (W); Connector 6188-0407 (W); AVSSf 0.3 Y/OR wires L=438±2mm; Black corrugated tube (no slit) Ø7 L=163±3mm; Black corrugated tube Ø5 L=201±3mm; Black corrugated tube (no slit) Ø7 L=96±3mm; MRSW CP TVSSf 0.3G-B/W L=685±3mm; Black tape [1pc]	JIG:	1. Insertion jig with switch cover 2. Terminal cover jig 3. Locking jig (6098-2220)
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	Table Lay-out	<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>	1. No missing parts/tools. 2. No excess parts/tools. <div> CONNECTOR ILLUSTRATION </div>

Revision History						Prepared by	Reviewed by	Approved by	Noted by
05/24/24	3	Update new template and inclusion of Car mode "LEXUS UX". Additional Work procedure/Illustration and notes on page 4 as countermeasure for the customer claim(Broken lock of Connector 6098-2220 (W)).	A.Hernandez	C. Villanueva	A. Arañes	n/a			
06/08/23	2	Removal of connector lock process (6189-0407), improvement due to QC claim (Unlock connector). Integrate the locking jig to Assembly jig. Inclusion of Locking process-Connector 6098-2220 (W). Change position of Y-OR wire in Switch cover to avoid crisscross.	D. Castillo	J. Loterte	C. Villanueva	A. Arañes			
02/15/23	1	Improve work procedure/ Illustration on process no 2, 5 and 6. Improve Quality checkpoints on pages 1,2,3,5,6,7,10 and 11; Inclusion of Quality checkpoints.	M.Ariola	J. Loterte	C. Villanueva	A. Arañes			
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	March 05, 2022	n/a

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 24, 2024

Process Name/Title:

Model code/Part number:

100B / 7M0593-7021

Customer: TRJ

Car Model:

LEXUS UX

Validity Date:

n/a

Document No.:

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:	1. Connector 6098-3802 (W)		JIG:	1. Insertion jig w/ switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Connector setting to insertion jig 6098-3802 (W)	<div><div><div>Insertion Jig with Switch</div><div><div>OR-wire</div><div>Y-wire</div><div>Visual reference</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><div>L</div><div>R</div><div>Press</div></div><div>1. Press the Lock of insertion jig using left hand.</div></div><div><div><div>L</div><div>R</div><div>Press</div></div><div><div><div>L</div><div>R</div><div>Release</div></div><div>2. Get the connector 6098-3802 (W) using right hand and insert to insertion jig. Release the lock after insertion.</div></div><div><div><div>L</div><div>R</div><div></div></div><div>3. Push the lower wire guide upward using right hand. Slot for Yellow wire will be open.</div></div></div></div><div>n/a</div><td><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><div>Connector Orientation Illustration</div><div><div><div>I-mark is align</div><div>2 Holes are open</div><div>GOOD</div></div><div><div>I-mark is not align</div><div>All holes are open</div><div>NG</div></div></div><div><div>CONNECTOR ILLUSTRATION</div><div><div><div>GOOD</div><div>6098-3802 (W)</div></div><div><div>NG</div><div>6098-5668 (W)</div></div></div></div></div></td></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><div>Connector Orientation Illustration</div><div><div><div>I-mark is align</div><div>2 Holes are open</div><div>GOOD</div></div><div><div>I-mark is not align</div><div>All holes are open</div><div>NG</div></div></div><div><div>CONNECTOR ILLUSTRATION</div><div><div><div>GOOD</div><div>6098-3802 (W)</div></div><div><div>NG</div><div>6098-5668 (W)</div></div></div></div></div>	

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Effectivity Date:

May 24, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

100B / 7M0593-7021Customer: **TRJ**

Car Model:

LEXUS UX

Document No.:

WI-ENG-PDE-444A

Purpose:

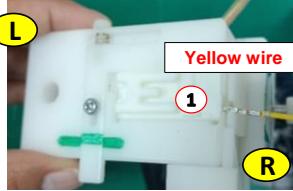
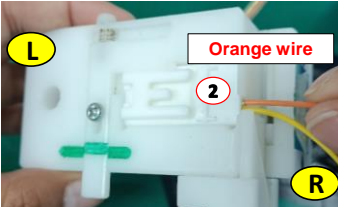


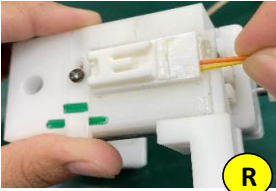


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PARTS:		1. AVSSf 0.3 Y/OR wires L=438±2mm 2. Black corrugated tube (no slit) Ø7 L=163±3mm; Ø5 L=201±3mm		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to connector 6098-3802 (W) P1	<div><div><p>1. Get the Yellow wire then insert to terminal slot ① using right hand.</p></div><div><p>3. Get the Orange wire then insert to terminal slot ② using right hand.</p></div><div><p>Wire facing</p></div><div><p>2. After insertion of Yellow wire press the button using right hand. The slot for Orange wire will be opened.</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></div>		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>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal during insertion.</p> <p>2. Insertion of wire must be from left to right.</p> <p>3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Length tolerance.</p> <p>2. Please refer to GL-PRO-ASSY-029 for Pull-Push procedure.</p>
4	Wire insertion to Black corrugated tube (no slit) Ø7 L=163±3mm Ø5 L=201±3mm	<div><div><p>1. Get the Black corrugated tube (no slit) Ø7 L=163±3mm using right hand and insert the wires using left hand.</p></div><div><p>2. Get the Black corrugated tube (no slit) Ø5 L=201±3mm using right hand and insert the wires using left hand.</p></div></div>			1. No wrong use of parts.

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TAPING ASSEMBLY PROCESS

Effectivity Date:

May 24, 2024

Process Name/Title:

Validity Date:

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Model code/Part number:

100B / 7M0593-7021

Customer: TRJ

Car Model:

LEXUS UX

Document No.:

WI-ENG-PDE-444A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Connector 6098-2220 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1 Connector setting to insertion jig 6098-2220 (W)	<div><div><div>Slider guide</div><div>Visual reference</div><div>Lower guide</div><div>Insertion Jig</div><div>Insertion Jig Orientation</div><div><div>I-mark</div><div>Lock</div><div>Connector Orientation</div></div><div><div><div><div>L</div><div>R</div></div><div><div>Press</div></div></div><div><div><div>L</div><div>R</div></div><div><div>Press</div></div></div><div><div><div>L</div><div>R</div></div><div><div>Release</div></div></div></div><div><div>1. Press the insertion jig lock using left hand.</div><div>2. Get the connector 6098-2220 (W) using right hand and insert to insertion jig. Release the lock after insertion.</div><div><div><div>L</div><div>R</div></div><div><div>3. Push the lower wire guide upward using right hand. Slot for yellow wire will be open.</div></div></div></div></div></div>	n/a	<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><div>Connector Orientation Illustration</div><div><div><div>I-mark was align</div><div>1 hole is open</div><div>GOOD</div></div><div><div><div>I-mark was not align</div><div>All holes were open</div><div>NG</div></div></div></div></div>

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100B / 7M0593-7021

Customer: TRJ

Car Model:

LEXUS UX

Validity Date:

n/a

Document No.:

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


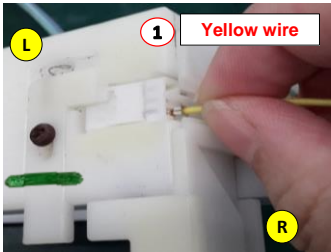
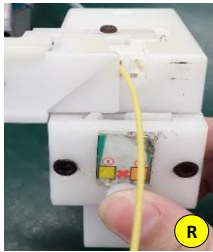
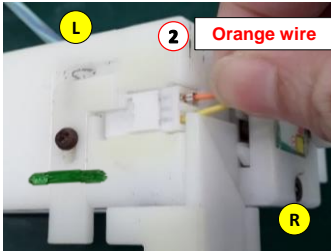
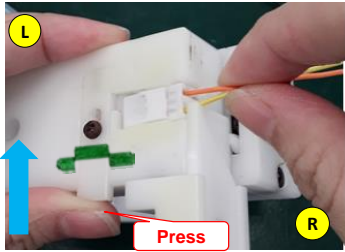
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PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1	<div><div><p>Wire facing</p></div><div><p>1. Hold the insertion jig using left hand. Get the Yellow wire and insert to connector using right hand.</p></div><div><p>2. Press the button using right thumb. slot for Orange wire will be open.</p></div><div><p>3. Get the Orange wire and insert to connector 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></div>		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>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal during insertion.</p> <p>2. Insertion of wire must be from left to right.</p> <p>3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Length tolerance.</p> <p>2. Please refer to GL-PRO-ASSY-029 for Pull-Push procedure.</p>

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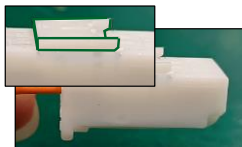
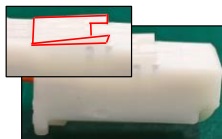
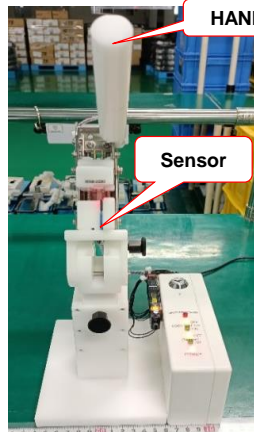
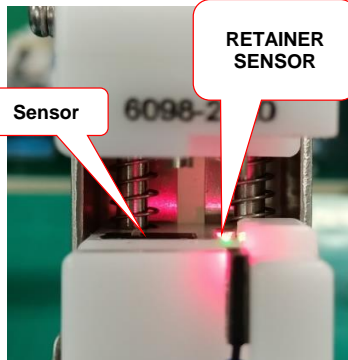
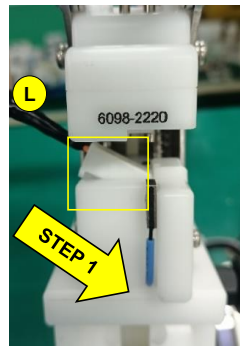
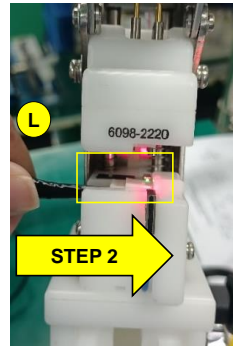
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WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	May 24, 2024		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-444A		
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Process Name/Title:	TAPING ASSEMBLY PROCESS		
Model code/Part number:	100B / 7M0593-7021	Customer:	TRJ
Car Model:	LEXUS UX		
Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO

PARTS:	1. Assy parts			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION 3		TOOLS/PPE	3 QUALITY POINTERS
7	P1	Connector lock	<div>3</div> <div>CONNECTOR RETAINER ILLUSTRATION SIDE VIEW</div> <div><div><p>GOOD</p></div><div><p>NG</p></div></div> <div>1. Check the Retainer lock of connector before insertion to locking jig. <i>Note: Must be NO half-locked condition prior connector locking.</i></div>		<div>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.</div>
			<div><p>HANDLE</p><p>Sensor</p></div> <div><p>RETAINER SENSOR</p><p>Sensor</p></div> <div><p>STEP 1</p></div> <div><p>STEP 2</p></div> <div>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. <i>NOTE: CONNECTOR LOCKING JIG WILL NOT FUNCTION IF CONNECTOR NOT REACH THE SENSOR.</i></div>	<div>3</div> <div>Important reminders/Note/s: <i>1. Incomplete locking process will alarm the jig.</i> <i>2. No retainer in connector cannot proceed.</i> <i>3. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</i></div>	

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Model code/Part number: 100B / 7M0593-7021

Customer: TRJ

Car Model: LEXUS UX

Document No.:

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Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH



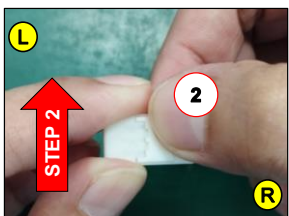
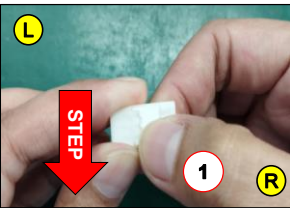
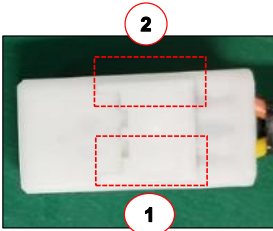
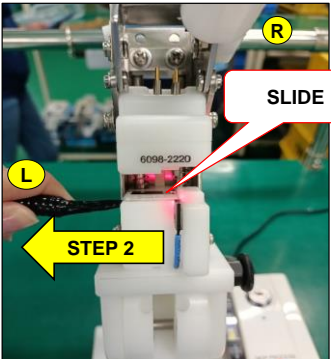
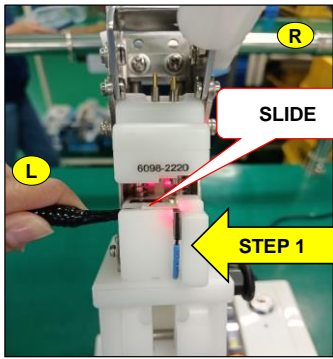
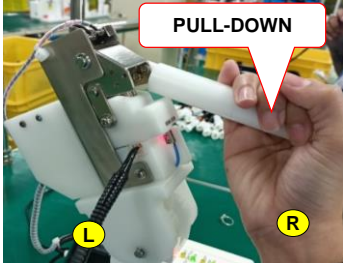
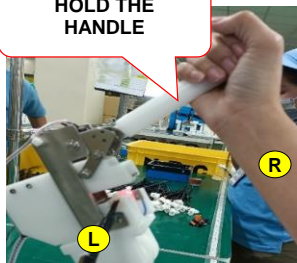

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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION 		TOOLS/PPE	 QUALITY POINTERS
7	P1 Connector lock (Continuation)	<div></div>		<p>3. Hold the handle of the connector locking jig using right hand then gently pull 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>	<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. <i>Incomplete locking process will alarm the jig.</i></p> <p>2. <i>No retainer in connector cannot proceed.</i></p> <p>3. <i>If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</i></p>

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Effectivity Date:

May 24, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

100B / 7M0593-7021

Customer: TRJ

Car Model:

LEXUS UX

Document No.:

WI-ENG-PDE-444A

Purpose:

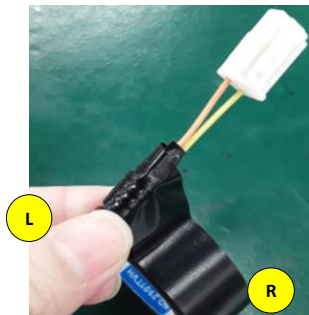
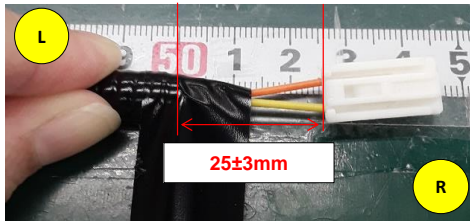
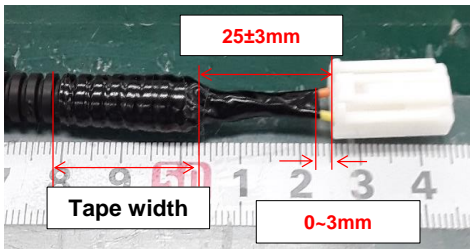

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1 Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1 Taping 1 Black corrugated tube to wire near connector	<div></div> <div>1. Hold the assy parts using left hand. Get Black tape using right hand and start pre-taping.</div> <div></div> <div>2. Measure from COT to Connector 25±3mm using both hands and continue the taping process.</div> <div></div> <div>3. After taping, check the measurement and taping condition.</div>		<div>Measuring tape</div> 	<div>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</div> <div>Important reminders/note/s: <i>1.Please use calibrated/verified measuring tape when getting the measurement.</i></div> <div>Document reference/s: <i>1. Refer to WI-PRO-ASY-001 for taping procedure.</i></div>

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Document No.:

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Purpose:

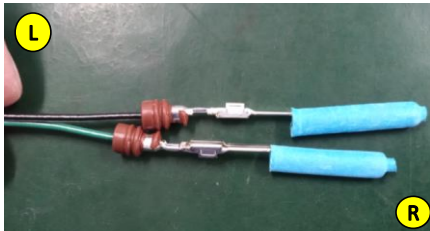



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PARTS:		1. Black corrugated tube (no slit) Ø7 L=96±3mm 2. TVSSf 0.3 MRSW CP G-B/W L=685±3mm		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1	<div><div></div><div><div></div><div><div></div></div><div>1. Get the cover jig using right hand then insert to both terminals (G-B/W wires) using right hand.</div><div>2. Get the corrugated tube Ø7, L=96±3mm using right hand then insert the G-B/W wires using left hand.</div><div>3. After insertion, remove the cover jig using right hand.</div></div></div>		<div>Terminal cover jig</div> 	1. No wrong usage of parts 2. No deformed terminal.

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Effectivity Date:

May 24, 2024

Process Name/Title:

Model code/Part number:

100B / 7M0593-7021

Customer: TRJ

Car Model:

LEXUS UX

Validity Date:

n/a

Document No.:

WI-ENG-PDE-444A

Purpose:

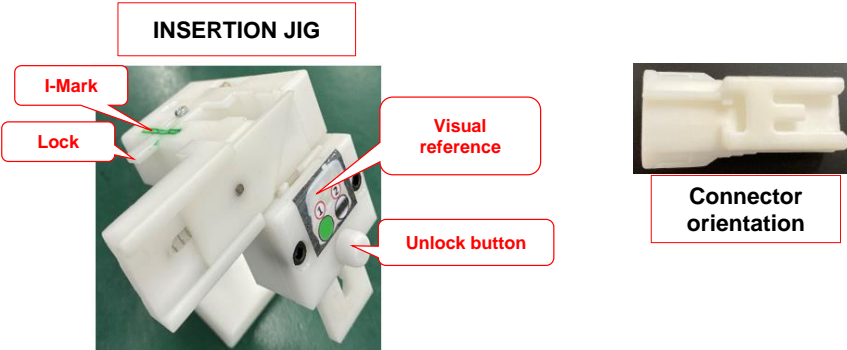
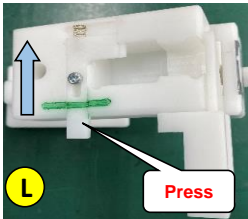
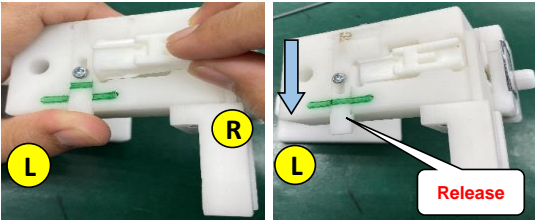
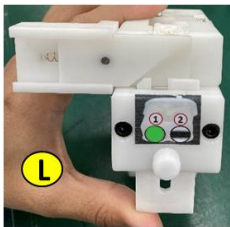
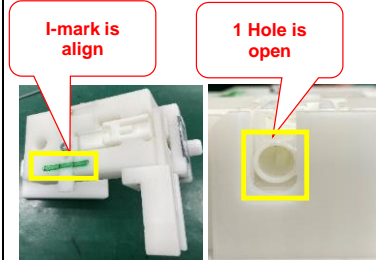
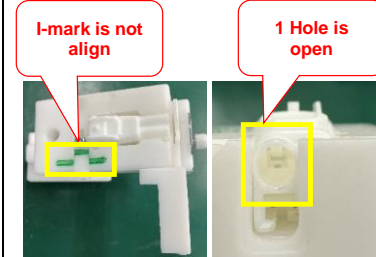
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Connector 6188-0407 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	P1	<div><p>INSERTION JIG</p><p>Connector orientation</p></div> <div><p>Press</p><p>1. Press the lock of insertion jig using left thumb.</p></div> <div><p>Release</p><p>2. Insert the connector 6188-0407 (W) into jig using right hand and release the lock.</p></div> <div><p>Push</p><p>3. Push the guide using left hand. The slot for G wire will be opened.</p></div>		n/a	<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><p>Connector Orientation Illustration</p><div><p>I-mark is align 1 Hole is open</p><p>GOOD</p></div><div><p>I-mark is not align 1 Hole is open</p><p>NG</p></div></div>

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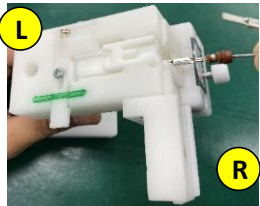
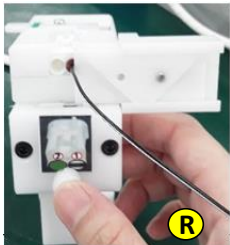

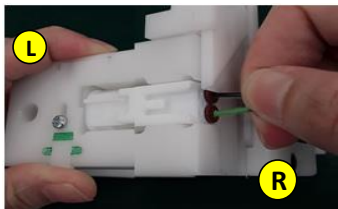
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Revision No.:

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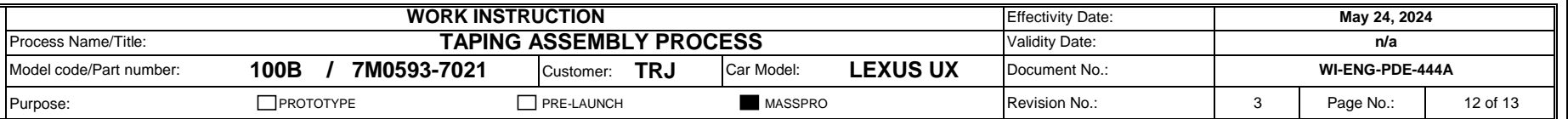
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PARTS:		1.TVSSf 0.3 MRSW CP G-B/W L=685±3mm		JIG:	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1	<div>Wire insertion to connector 6188-0407 (W)</div> <div> Wire facing</div> <div> 1. Get the G wire then insert to terminal slot ① using right hand.</div> <div> 2. After insertion of G wire press the button using right hand. The slot for B/W wire will be opened.</div> <div> 3. Get the B/W wire then insert to terminal slot ② using right hand.</div> <div> 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.</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 WI-PRO-CNC-017 for Wire and Length tolerance. 2. Please refer to GL-PRO-ASSY-029 for Pull-Push procedure.</div>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS

P1

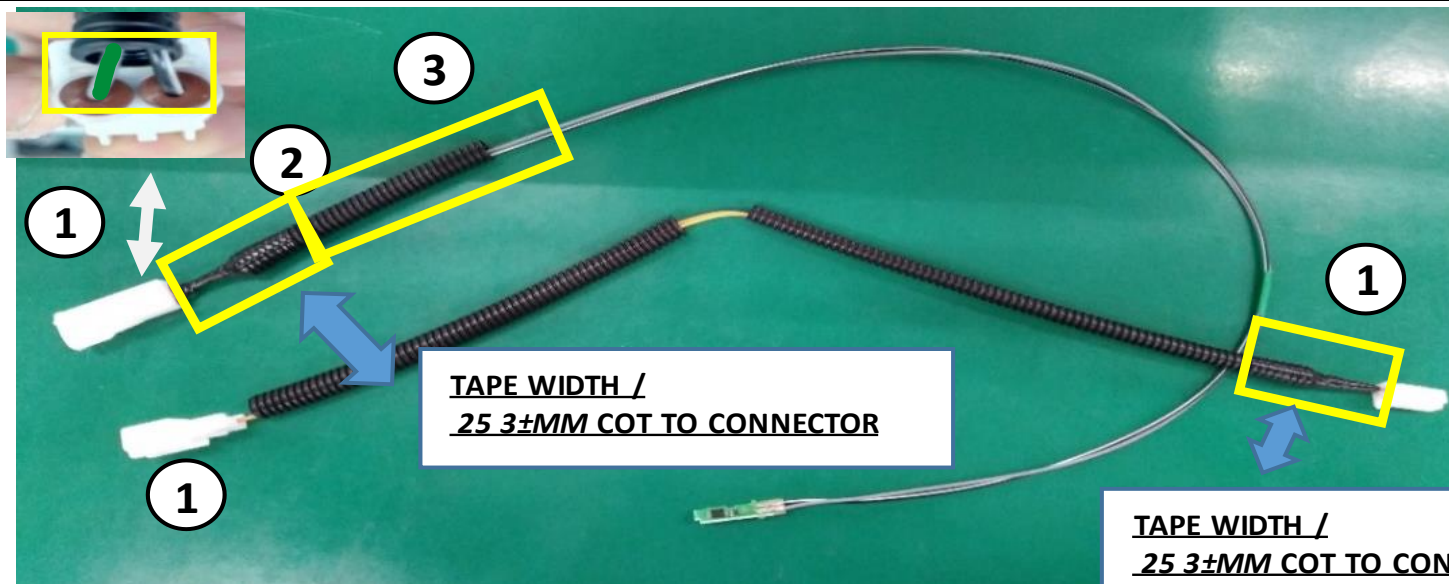
7M0593-7021



GOOD



NO GOOD



①

No **WRONG INSERT**
No **UNLOCKED/HALFLOCKED**
No **TBO**

②

No **MISSING TAPE**

③

No **MISSING COT**

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