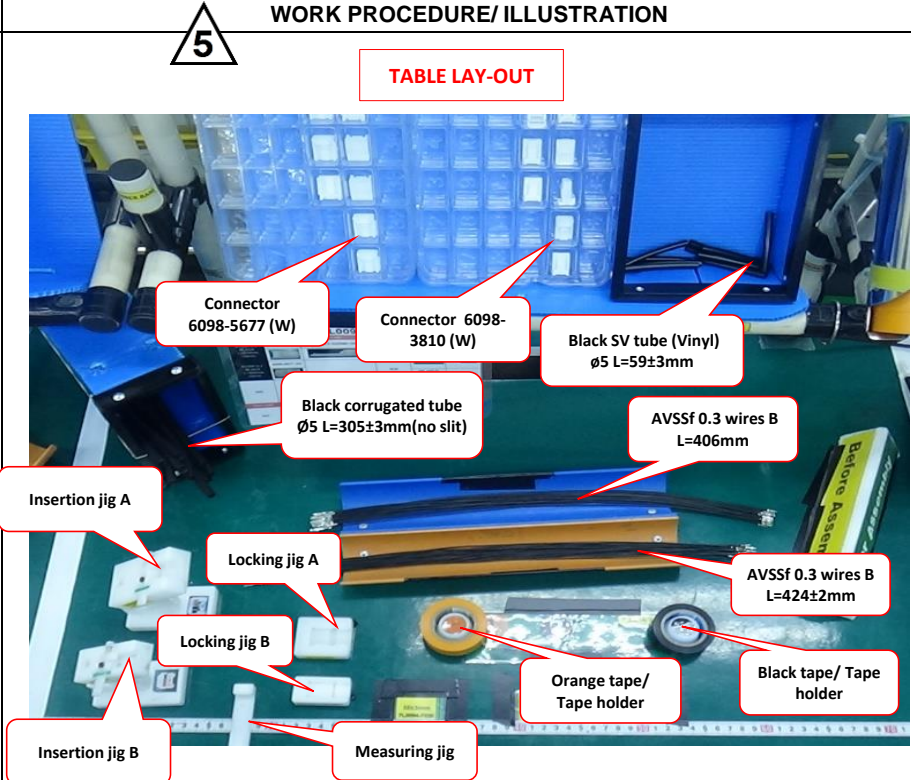
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	TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Process Name/Title:		Model code/Part number: 707B / 7L0094-7020		Customer: TRQSS	Car Model: LEXUS ES HIGHBRID		Document No.: WI-ENG-PDE-267A
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		5	Page No.:	1 of 12	

PARTS:		1. Connector 6098-5677 (W); Connector 6098-3810 (W); Black SV tube (Vinyl) ø5 L=59±3mm; Black corrugated tube Ø5 L=305±3mm(no slit); AVSSf 0.3 wires B L=406mm ; AVSSf 0.3 wires B L=424±2mm;Orange tape; Black tape				JIG:		1. Insertion jig 2.Locking jig 3. Measuring jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	P1	<div style="text-align: center;">  <p>5</p> <p>TABLE LAY-OUT</p> </div>				<div style="border: 1px dashed red; padding: 5px;"> <p>Safety Instruction</p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> <p>Housekeeping</p> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> <p>Alert level</p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>		<p>Document reference/s:</p> <p>1. Please refer to WI-PRO-CNC-017 for the Wire and Strip Length tolerance.</p> <p>1.No missing parts/ tools. 2. No excess parts/ tools.</p>	
Revision History						Prepared by	Reviewed by	Approved by	Noted by
09/12/24	5	Update Table lay-out due to split type process; tranfer insertion wire to COT and spot tape process in P2; Tranfer to clamp pocess to Clamp Assembly Process Remove terminal cover jig in insertion process.				A.Hernandez	C. Villanueva	A. Arañes	n/a
04/12/23	4	Work instruction improvement. Inclusion of batching. Update table lay-out. Inclusion of Quality Checkpoints (Page 20). Change term from vinyl tueb to SV tube (Vinyl).				M. Ariola	J. Loterte	C. Villanueva	A. Arañes
11/17/22	3	Improve Quality pointers; Reminders/Notes and reference on page no.1-19 due to documents improvement; Improve Work procedure/illustration on process no.5 and 8-Connector lock and process no.21-Visual/ By two's inspection due to process improvement.				M. Ariola	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted
						Est. Date:	June 11, 2021		

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Customer: **TRQSS**

Car Model: **LEXUS ES HIGHBRID**

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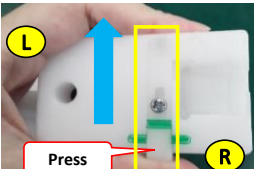
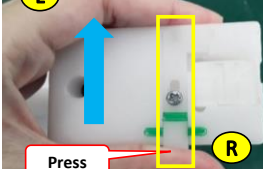
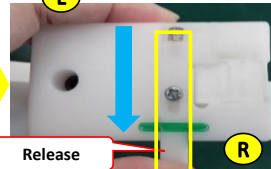
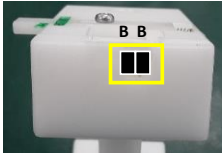










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PARTS:	1. Connector 6098-5677 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Connector setting to insertion jig 6098-5677 (W)	<div><div><div><p>Insertion Jig</p></div><div><p>I-mark</p></div><div><p>Lock</p></div><div><p>I-mark</p></div><div><p>Visual reference</p></div><div><p>Connector lock</p></div><div><p>Connector orientation</p></div></div><div><div><p>Press</p></div><div><p>Press</p></div><div><p>Release</p></div></div><div><div><p>1. Press the lock of insertion jig using left thumb.</p></div><div><p>2. Insert the connector 6098-5677 (W) into jig using right hand then release the lock.</p></div><div><p>B B</p></div><div><p>3. Check the holes/terminal slot for B-B wires</p></div></div></div>	n/a	<div><p>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p></div> <div><div><p>CONNECTOR ORIENTATION ILLUSTRATION</p><div><div><p>I-mark is align</p></div><div><p>2 holes are open</p></div><div><p>GOOD</p></div></div><div><div><p>I-mark is not align</p></div><div><p>2 holes are open</p></div><div><p>NG</p></div></div></div><div><div><p>CONNECTOR ILLUSTRATION</p><div><div><p>GOOD</p></div><div><p>NG</p></div></div><div><div><p>6098-5677 (W)</p></div><div><p>6098-3810 (W)</p></div></div></div></div></div>

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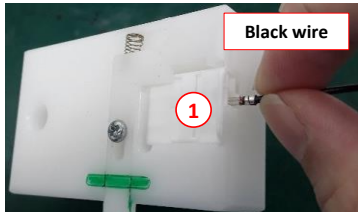
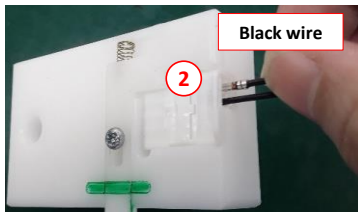
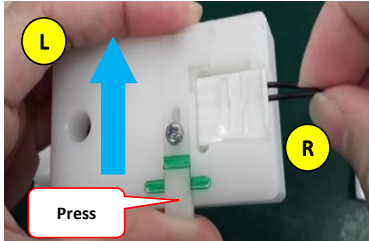
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PARTS:	1. AVSSf 0.3 wires B L=406±2mm [2pcs] 2. Connector 6098-5677 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to connector 6098-5677 (W)	<div><div>Wire Facing</div></div> <div><div><div>Black wire</div><div>1</div></div><div><div>Black wire</div><div>2</div></div></div> <div><div>1. Get the first Black wire and insert to Slot 1 of connector using right hand.</div><div>2. Get the second Black wire and insert to Slot 2 of connector using right hand.</div><div><div>L</div><div>R</div><div>Press</div><div>3. 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>	n/a	<div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</div> <div>Important reminders/Note/s:</div> <div>1. Please hold the wire near terminal during insertion. 2. Insertion must be from left to right. 3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-CNC for Wire and Strip length tolerance. 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>

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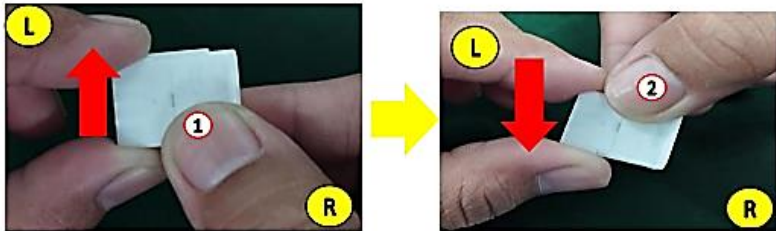



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PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1 Connector lock	<div><p>1. Put the connector into locking jig using both thumb then press to lock 2x.</p><p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div>	<div>LOCKING JIG</div> 	<div>1. No Unlock and half-locked connector 2. No damaged lock 3. Use provided jig tool to lock the connector.</div> <div>Important reminders/Note/s:</div> <div>1. Manual locking may cause damaged connector lock.</div> <div></div>

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PARTS:

1. Black corrugated tube Ø5 L=305±3mm
2. AVSSf 0.3 wires B L=424±2mm

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

5

P1

Wire insertion to
Corrugated tube
Ø5 L=305±3mm
(no slit)



1. Get **black corrugated tube Ø5 L=305±3mm** using left hand and insert **Black wires L=424±2mm** using right hand.

n/a

1. No wrong use of parts
2. No deformed terminal

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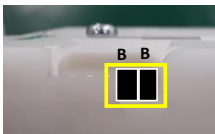
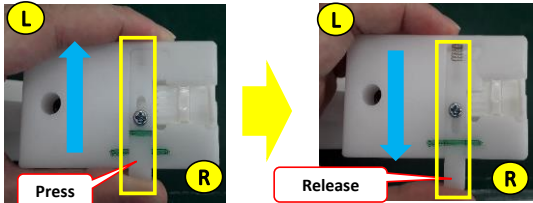
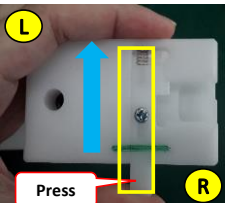
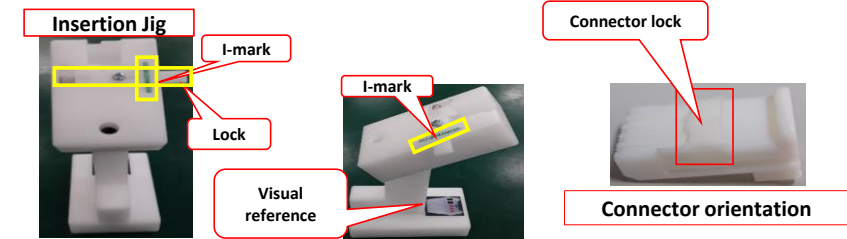
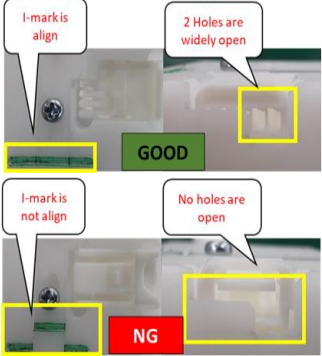
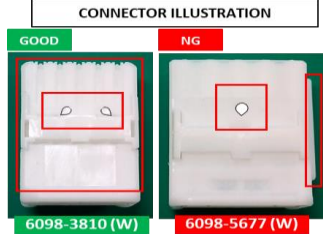
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PARTS:		1. Connector 6098-3810 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1 Connector setting to insertion jig 6098-3810 (W)	<div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the connector 6098-3810 (W) into jig using right hand then release the lock.</p><p>3. Check the holes/terminal slot for B-B wires.</p></div>		n/a	<p>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p> <div><p>Connector Orientation Illustration</p><p>CONNECTOR ILLUSTRATION</p></div>

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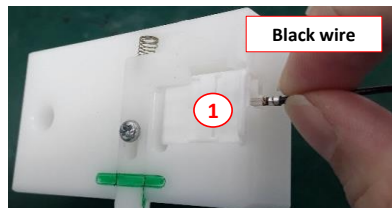
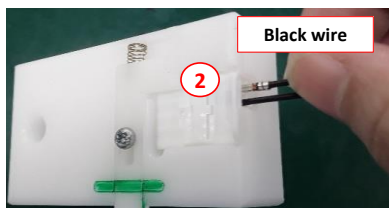
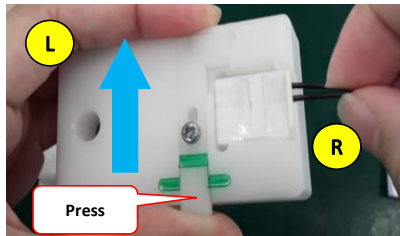
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PARTS:		1. AVSSf 0.3 wires B L=424±2mm[2pcs] 2. Connector 6098-3810 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1 Wire insertion to connector 6098-3810 (W)	<div><div><p>Wire Facing</p></div><div><p>Black wire</p><p>1</p></div><div><p>Black wire</p><p>2</p></div><div><p>L</p><p>Press</p><p>R</p></div><div><p>1. Get the first Black wire and insert to Slot 1 of connector using right hand.</p><p>2. Get the second Black wire and insert to Slot 2 of connector using right hand.</p><p>3. 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>		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><i>1. Please hold the wire near terminal during insertion. 2. Insertion must be from left to right. 3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</i></p> <p>Document reference/s:</p> <p><i>1. Refer to WI-PRO-CNC for Wire and Strip length tolerance. 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i></p>

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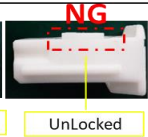
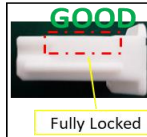
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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1	Connector lock	<div><p>1. Put the connector into locking jig using both thumb then press to lock 2x.</p><p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div>	<div><p>LOCKING JIG</p></div>	<p>1. No Unlock and half-locked connector 2. No damaged lock 3. Use provided jig tool to lock the connector.</p> <p>Important reminders/Note/s:</p> <p>1. Manual locking may cause damaged connector lock.</p> <div></div>

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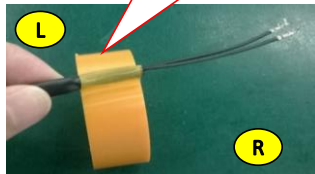
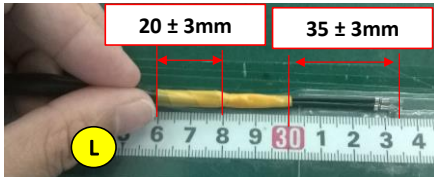

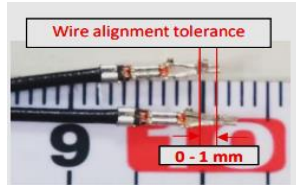
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PARTS:		1. Assy parts 2. Orange tape		3. Black SV tube (Vinyl) ø5 L= 59±3mm		JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
9	Wire insertion to SV tube (Vinyl) Ø5 L=59±3mm		<div></div> <div>Hold the assy part using left hand then get the SV tube (Vinyl) ø5 L= 59±3mm using right hand and insert the Black wires.</div>			n/a	1. No wrong use of parts 2. No deformed terminal
10	P1	Taping 1 SV tube (Vinyl) to wire near terminal	<div><div></div><div>1. Measure the end of the SV tube (Vinyl) up to the end of the terminal pointed tip <u>55 ± 3mm</u> using both hands.</div></div> <div><div></div><div>2. Get <u>Orange tape</u> using right hand, hold the SV tube (Vinyl) (ø5 L=59±3mm) using left hand then fold the vinyl tube and start taping using right hand.</div></div> <div><div></div><div>3. After taping, check the measurement, terminal appearance and taping condition.</div></div>			<div>MEASURING TAPE</div> 	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 Important reminders/Note/s: <i>1. Please use calibrated/verified measuring tape when getting the measurement.</i> <i>2. Use Orange tape only</i> 

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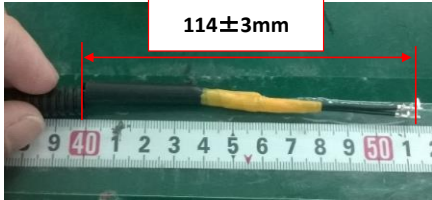
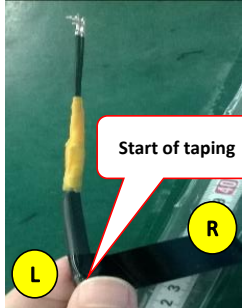
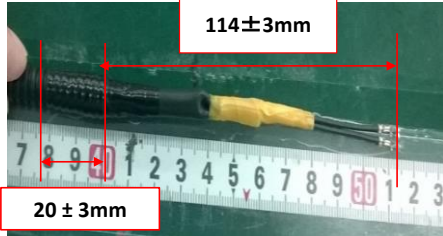

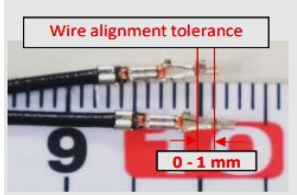
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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1 Taping 2 Corrugated tube to Vinyl tube	 <p>1. Hold the COT using left hand and measure from COT to terminal pointed tip 114±3mm.</p>  <p>2. Get Black tape using right hand, hold the cot using left hand and start taping using right hand.</p>  <p>3. After taping, check the measurement and taping condition.</p>			<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> 

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**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

September 12, 2024

Validity Date:

n/a

Model code/Part number: **707B / 7L0094-7020**Customer: **TRQSS**Car Model: **LEXUS ES HIGHBRID**

Document No.:

WI-ENG-PDE-267A

Purpose:

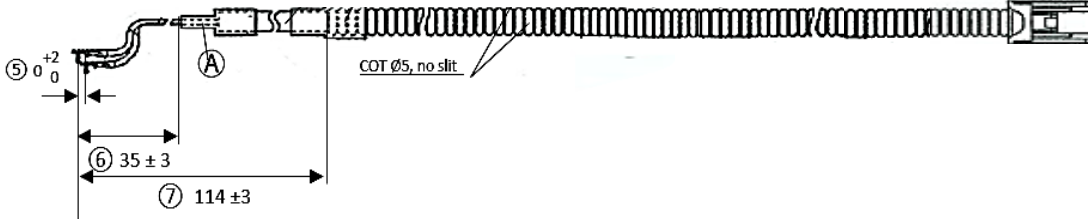
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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PARTS:	1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
12	P1 Measurement			<p>Important reminders and note/s:</p> <p>1.Please use calibrated /verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono,Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection.</p> <p>1.No wrong dimension</p>

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PARTS:

1. Assy parts

JIG:

n/a

5

VISUAL INSPECTION/QUALITY CHECKPOINTS

P1

7L0094-7020

1



GOOD



NO GOOD

3



2



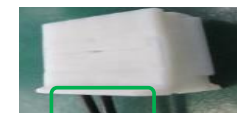
4



5



6



GOOD



NO GOOD

1 No Unlock/ Halflock Connector

2 3 No Wrong Insert

4 5 No Missing Tape(Black tape)/ Wrong Use of Tape(Orange Tape)

6 No Terminal Backing Out

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