
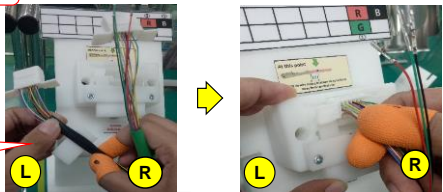
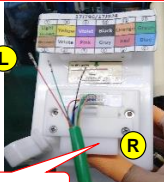
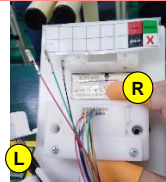
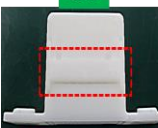

	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date: March 14, 2025	
	Process Name/Title:				Validity Date: n/a	
	Model code/Part number: 241B / 17J924-7051		Customer: TRP	Car Model: LEXUS-ES	Document No.: WI-ENG-PDE-092E	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: 17		Page No.: 1	of 11

PARTS: 1. Assy parts		JIG: 1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
1	P5 <div style="border: 1px solid black; padding: 5px; text-align: center;"> HIGH </div> Connector setting to insertion jig (Assy parts) 4F1640-000 (W)	<div style="display: flex; flex-direction: column; align-items: center;"> <div style="display: flex; justify-content: space-around; width: 100%;"> <div style="text-align: center;"> INSERTION JIG  Visual reference Guide Lock Lever Holder </div> <div style="text-align: center;"> CONNECTOR ORIENTATION  Note: Check the connector before insertion. </div> </div> <div style="display: flex; justify-content: space-around; width: 100%;"> <div style="text-align: center;"> BEFORE PRESSING  L R </div> <div style="text-align: center;"> AFTER PRESSING  L R </div> </div> <div style="text-align: center; margin-top: 10px;"> Guide Lock </div> </div> <div style="display: flex; justify-content: space-between; margin-top: 10px;"> <div style="width: 45%;"> 1. Set the connector 4F1640-000 (W) (Assy parts with Black VM tube (Sunprene)) to holder using both hands. </div> <div style="width: 45%;"> 2. Set the connector 4F1640-000 (W) (Assy parts with Green VM tube (Sunprene)) to insertion jig using right hand. </div> </div> <div style="margin-top: 10px;"> 3. Press the guide lock using right index finger </div> <div style="margin-top: 10px;"> 4. Hold the Group 3 wires (3pcs) using right hand for insertion. </div>	<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Safety Instruction 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;"> Housekeeping 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;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>
		QUALITY POINTERS	
		1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector Important reminders/Note/s: 1. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process. Do not attempt to repair. 2. Follow the connector orientation	
		<div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;"> <div style="background-color: green; color: white; padding: 2px 5px;">GOOD</div>  <div style="border: 1px solid red; padding: 2px;">UNLOCK</div> </div> <div style="text-align: center;"> <div style="background-color: red; color: white; padding: 2px 5px;">NG</div>  <div style="border: 1px solid red; padding: 2px;">HALF-LOCKED</div> </div> </div> <div style="border: 1px solid red; padding: 5px; text-align: center; margin-top: 5px;"> NO BEND TERMINAL/WIRES </div>	

Revision History				Prepared by	Checked by	Reviewed by	Approved by
03/14/25	17	Inclusion of Quality improvement measures (based on Mizen Boshi activity).	D.Castillo	J. Loterte	C. Villanueva	A. Arañes	
07/02/24	16	Include Good and No good picture for reference in proper arrangement of wire and additional reminders/quality pointers.	D.Castillo	n/a	C. Villanueva	A. Arañes	
08/02/23	15	Update template; Inclusion of CAR MODEL "LEXUS-ES". Transfer process of Connector lock (Assy parts with Black VM tube (Sunprene) from P3 to P5; Remove process of measurement from P5 to P6 due to TPS improvements. (Refer to	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	
03/02/23	14	Standardized Tube description: VM tube (Sunprene); Change WIP flow quantity from [1pc] flow to [3pcs] flow due to process improvement.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	
Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved	Est. Date: June 02, 2017

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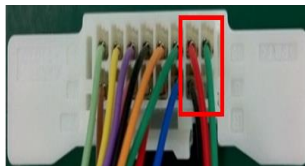





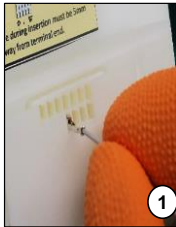

WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	March 14, 2025		
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Revision No.:	17	Page No.:	2 of 11

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

Model code/Part number: **241B / 17J924-7051** Customer: **TRP** Car Model: **LEXUS-ES**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Assy parts		JIG:	1. Insertion jig																																														
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS																																														
1	<div>17</div> <div>MEDIUM</div> <div>Wire insertion to connector (Group 3 wires) 4F1640-000 (W) (Assy parts)</div>	<div>WIRE INSERTION ILLUSTRATION</div> <div></div> <div>WIRE FACING</div> <div><table><tr><td></td><td colspan="8">GREEN SUNPRENE TUBE (GROUP 1&3 WIRES)</td><td></td></tr><tr><td>SECOND ROW TO INSERT</td><td>LG</td><td>Y</td><td>V</td><td>B</td><td>OR</td><td>G</td><td>R</td><td>G</td></tr><tr><td></td><td>176</td><td>180</td><td>177</td><td>181</td><td>181</td><td>188</td><td>189</td><td>190</td></tr><tr><td>FIRST ROW TO INSERT</td><td>BR</td><td>W</td><td>P</td><td>GR</td><td>R</td><td>L</td><td>B</td><td>EMPTY</td></tr><tr><td></td><td>179</td><td>185</td><td>178</td><td>181</td><td>184</td><td>184</td><td>190</td><td>EMPTY</td></tr></table></div> <div>Standard hold in wire</div> <div></div> <div>5mm</div> <div></div> <div><div>1. Get the wire and hold it 5mm away from terminal.</div><div>2. Half insert the wire.</div><div>3. Release wire to check the color.</div><div>4. Conduct point checking in visual</div><div>5. Hold again 5mm away from terminal</div><div>6. Fully inserted wires (avoid bending during insertion)</div></div>			GREEN SUNPRENE TUBE (GROUP 1&3 WIRES)									SECOND ROW TO INSERT	LG	Y	V	B	OR	G	R	G		176	180	177	181	181	188	189	190	FIRST ROW TO INSERT	BR	W	P	GR	R	L	B	EMPTY		179	185	178	181	184	184	190	EMPTY	<div>Finger COTS</div> <div></div>	<div>1. No wrong wire insertion</div> <div>2. No terminal backing out</div> <div>3. No deformed terminal</div> <div>4. Make sure wires are properly inserted.</div> <div>5. Must have slight MOVEMENT after insertion</div> <div>6. No bend terminal/wires</div> <div>Important reminders/Note/s:</div> <div>1. Automatically dispose and replace the unit if once encountered Bend terminal, Difficulty of insertion, Half-locked connector.</div> <div>2. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process. Do not attempt to repair.</div> <div>3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>4. Follow the insertion sequence based on the visual reference</div> <div>5. Hold on wire during insertion must be 5mm away from terminal end.</div> <div>Document references:</div> <div>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>
	GREEN SUNPRENE TUBE (GROUP 1&3 WIRES)																																																		
SECOND ROW TO INSERT	LG	Y	V	B	OR	G	R	G																																											
	176	180	177	181	181	188	189	190																																											
FIRST ROW TO INSERT	BR	W	P	GR	R	L	B	EMPTY																																											
	179	185	178	181	184	184	190	EMPTY																																											

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WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:

March 14, 2025

Process Name/Title:

Validity Date:

n/a

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

Customer: **TRP**

Car Model: **LEXUS-ES**

Document No.:

WI-ENG-PDE-092E

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

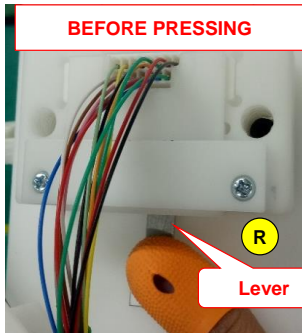
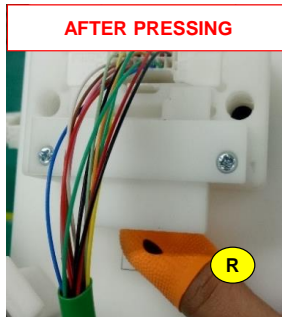
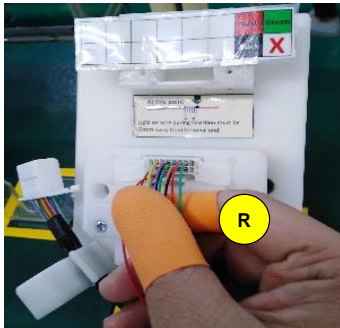

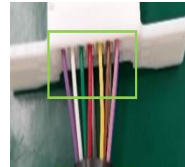
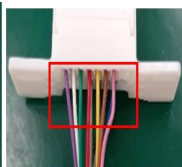
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PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	<div>17</div> <div>P5</div> <div>Wire insertion to connector (Group 3 wires) 4F1640-000 (W) (Assy parts) (Continuation)</div> <div>MEDIUM</div>	<div><div>BEFORE PRESSING</div><div>LEVER</div></div> <div><div>AFTER PRESSING</div></div> <div>7. Press the lever using right thumb.</div> <div></div> <div>8. Hold the wires using right hand then gently pull out the connector from jig. Check the insertion condition.</div>		<div>Finger COTS</div> 	<div>1. No wrong wire insertion 2. No terminal backing out 3. No deformed terminal 4. Make sure wires are properly inserted. 5. Must have slight MOVEMENT after insertion</div> <div><div>GOOD</div><div>NG</div><div>No bend terminal/wires</div></div>

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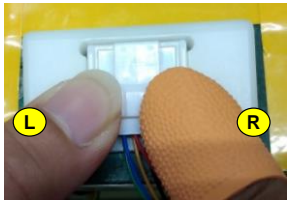
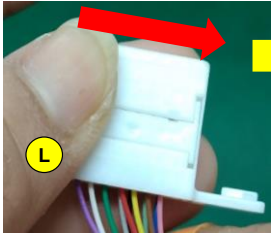
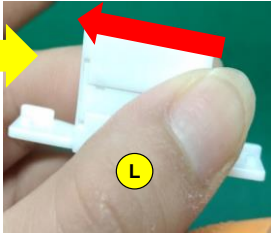
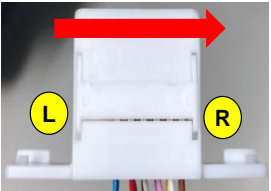

WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	March 14, 2025		
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Process Name/Title: **TAPING ASSEMBLY PROCESS**

Model code/Part number: **241B / 17J924-7051** Customer: **TRP** Car Model: **LEXUS-ES**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:	1. Assy parts			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	<div>17</div> <div>LOW</div> <div>Connector Lock 1 (Assy parts with Black VM tube)</div>	<div><p>Sequence of Pressing the Double Lock: ① - ① Method: Press same timing using both thumbs</p></div> <div><p>1. Get the assy parts using left hand then put the connector to locking jig using right hand. 2. Press down the connector to locking jig 2x using using left & right thumb (Same timing) 3. Touch the connector lock after locking (<i>See below sequence in checking of connector lock</i>)</p></div> <div><p>LEFT SIDE OF CONNECTOR LOCK</p><p>RIGHT SIDE OF CONNECTOR LOCK</p><div><p>2. Ensure that connector is in locked condition by slide touching the connector lock from LEFT to RIGHT using left thumb.</p><p>Checking point (LEFT to RIGHT)</p></div></div>		<div>LOCKING JIG</div> 	<p>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <p>1. No damaged double lock. 2. No half-locked connector</p>

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TAPING ASSEMBLY PROCESS

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Process Name/Title: **241B / 17J924-7051**

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

Customer: **TRP**

Car Model: **LEXUS-ES**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	<div><div>17</div><div>LOW</div><div>Connector Lock 1 (Assy parts with Black VM tube) (Continuation)</div></div>	<div><div>Checking point (TOP to BOTTOM)</div><div></div><div><div>LEFT SIDE OF CONNECTOR LOCK</div><div></div><div></div><div>RIGHT SIDE OF CONNECTOR LOCK</div></div><div><div>Before pressing</div><div>After pressing</div><div></div></div><div><div>3. Ensure that connector is in locked condition by touching the LEFT SIDE of connector lock from TOP to BOTTOM using left thumb.</div><div>4. Ensure that connector is in locked condition by touching the RIGHT SIDE of connector lock from TOP to BOTTOM using left thumb.</div></div></div>		n/a	1. No damaged double lock. 2. No half-locked connector

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TAPING ASSEMBLY PROCESS

Effectivity Date:

March 14, 2025

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

241B / 17J924-7051

Customer: TRP

Car Model:

LEXUS-ES

Document No.:

WI-ENG-PDE-092E

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


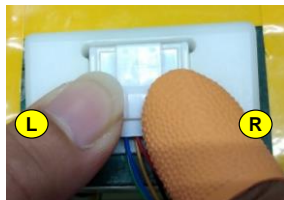
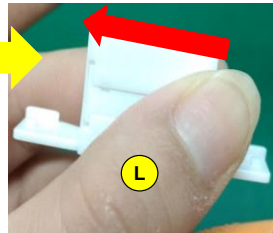
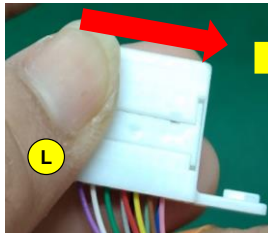
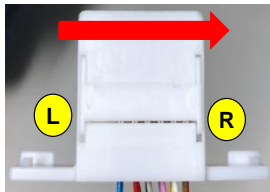

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PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	<div>17</div> <div>LOW</div> <div>Connector Lock 2 (Assy parts with Green VM tube)</div>	<div><div>Sequence of Pressing the Double Lock: ① - ① Method: Press same timing using both thumbs</div></div> <div><div>1. Get the assy parts using left hand then put the connector to locking jig using right hand. 2. Press down the connector to locking jig 2x using using left & right thumb (Same timing) 3. Touch the connector lock after locking (<i>See below sequence in checking of connector lock</i>)</div></div> <div><div>LEFT SIDE OF CONNECTOR LOCK</div><div>RIGHT SIDE OF CONNECTOR LOCK</div></div> <div><div>2. Ensure that connector is in locked condition by slide touching the connector lock from LEFT to RIGHT using left thumb.</div><div>Checking point (LEFT to RIGHT)</div></div>	<div>LOCKING JIG</div> 	<div>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</div> <div>1. No damaged double lock. 2. No half-locked connector</div>

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WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	March 14, 2025		
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Process Name/Title: **241B / 17J924-7051**

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

Customer: **TRP**

Car Model: **LEXUS-ES**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	<div>17</div> <div>LOW</div> <div>Connector Lock 2 (Assy parts with Green VM tube) (Continuation)</div>	<div>Checking point (TOP to BOTTOM)</div> <div></div> <div><div>LEFT SIDE OF CONNECTOR LOCK</div><div></div><div><div>RIGHT SIDE OF CONNECTOR LOCK</div><div></div></div><div><div>Before pressing</div><div></div><div><div>After pressing</div><div></div></div><div>3. Ensure that connector is in locked condition by touching the LEFT SIDE of connector lock from TOP to BOTTOM using <u>left thumb</u>.</div><div>4. Ensure that connector is in locked condition by touching the RIGHT SIDE of connector lock from TOP to BOTTOM using <u>left thumb</u>.</div></div></div>	n/a	1. No damaged double lock. 2. No half-locked connector

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WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:

March 14, 2025

Process Name/Title:

Validity Date:

n/a

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

Customer: TRP

Car Model: LEXUS-ES

Document No.:

WI-ENG-PDE-092E

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

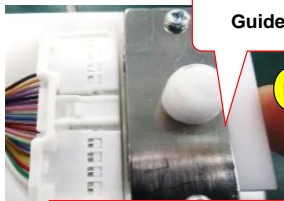
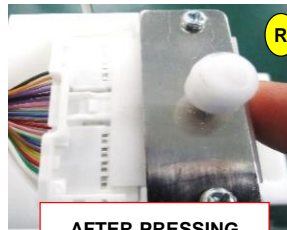


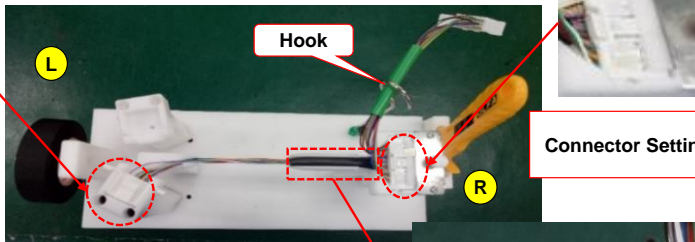
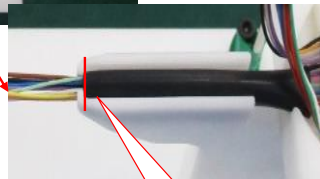
☒ MASSPRO

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PARTS:		1. Assy parts 2. Black Tesa tape (Tesa no. 51036)		JIG:	1. Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P5	<div><div><p>Guide</p><p>R</p><p>BEFORE PRESSING</p></div><div><p>R</p><p>AFTER PRESSING</p></div></div> <div>1. Set the connector 1827842-1 (W) then push the guide lock using right index finger</div>		<div><div><p>OLFA Cutter</p></div></div>	<div>1. No wrong setting of harness 2. No wrong orientation of connector 3. Wires must align properly to avoid bend wire .</div> <div>Important reminders/Note/s: 1. Make sure that both BLACK and GREEN VM tube (Sunprene) must reach the TUBE guide before taping process. 2. Long wires must be exposed near connector 4F1640-000 (W) during setting of harness on jig to avoid the loose wire move along (1827842-1 (W) connector .</div>
		<div><div><p>Connector Setting</p></div><div><p>Hook</p><p>R</p><p>Connector Setting</p></div><div>2. Set the connector 4F1640-000 (W) with Black VM tube (Sunprene) on the jig, hook the harness with Green VM tube (Sunprene) using both hands.</div><div><p>Tube guide</p></div></div>			

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

March 14, 2025

Process Name/Title:

Validity Date:

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Model code/Part number:

241B / 17J924-7051

Customer:

TRP

Car Model:

LEXUS-ES

Document No.:

WI-ENG-PDE-092E

Purpose:



PROTOTYPE



PRE-LAUNCH





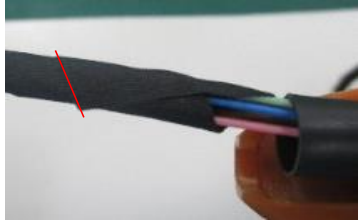
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PARTS:		1. Assy parts 2. Black Tesa tape (Tesa no. 51036)		JIG:	1. Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P5 Taping 1 & 2 Wire taping (Tesa) (Continuation)	<div>17</div> <div>HIGH</div> <div>Start of taping</div> <div>1/2 shifting</div> <div>3. Using the guide, make 1 winding of tape before shifting.</div> <div>4. Wind the 1/2 shifting or 3-4 winds going to the right side near VM tube (Sunprene) using both hands.</div> <div>5. Use the provided cutter to cut the tesa tape using both hands.</div> <div>6. Remove the harness in jig using left hand then press the tape using right hand.</div>		<div>OLFA Cutter</div> 	<div>Important reminders/Note/s: 1. No holding/fixing of wire during taping.</div>  <div>Important reminders/Note/s: 1. The end tape must be half wrap</div> 

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WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:

March 14, 2025

Process Name/Title:

Validity Date:

n/a

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

Customer: TRP

Car Model: LEXUS-ES

Document No.:

WI-ENG-PDE-092E

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

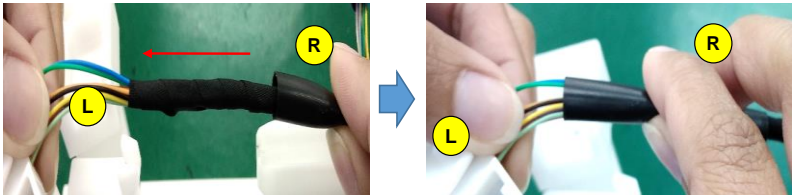
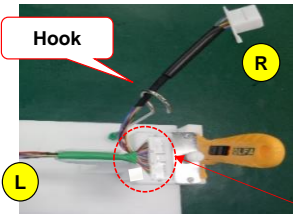
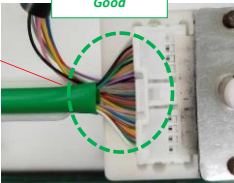
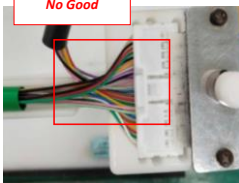
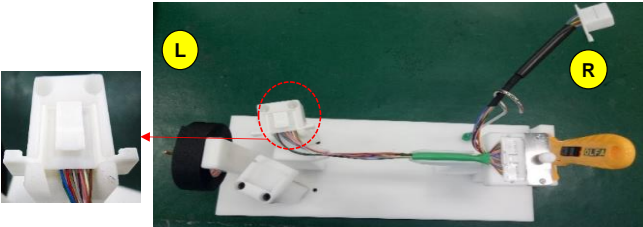

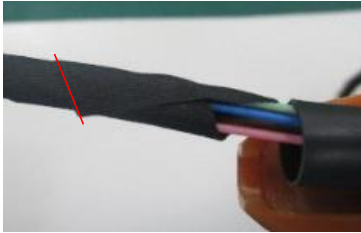
☒ MASSPRO

Revision No.:

17

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PARTS:	1. Assy parts 2. Black Tesa tape (Tesa no. 51036)		JIG:	1. Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P5 <div>HIGH</div> Taping 1 & 2 Wire taping (Tesa) (Continuation)	<div>17</div>  <div>7. After taping, move the vinyl tube to left side using right hand.</div>  <div>Hook</div> <div>8. Place the assy parts with Black VM Tube (Sunprene) to Hook. .</div>  <div>Good</div>  <div>No Good</div>  <div>9. Set the assy with Green VM tube (Sunprene) then repeat the process from step 3 to 7..</div>	<div>OLFA Cutter</div> 	<p>Important reminders/Note/s:</p> <p>1. Pink & Light green wires must be on bottom of other wires, not expose.</p> <p>2. No holding/fixing of wire during taping.</p>  <ol style="list-style-type: none">1. No loose tape2. No excessive tape winding3. No damage on parts4. No peel off tape5. No bend wire6. No NG of end tape

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**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

March 14, 2025

Validity Date:

n/a

Model code/Part number:

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

Car Model:

LEXUS-ES

Document No.:

WI-ENG-PDE-092E

Purpose:



☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts			JIG:	1. WIP Holder
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P5 Pass WIP to P6	<div>3 PIECES FLOW</div>  <div>1. Pass WIP to WIP Holder. Note: Three pieces flow.</div>		<div>WIP HOLDER</div> 	1. No WIP overflow

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