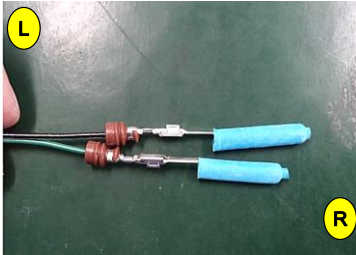


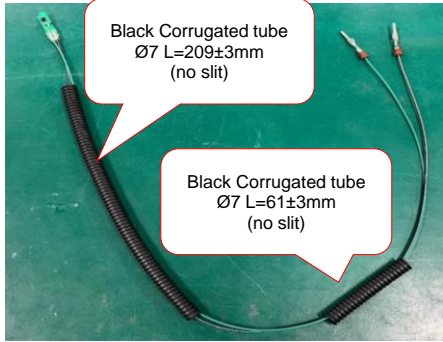




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	Model code/Part number: 410D/412D / 7N0235-7020		Customer: TRJ	Car Model: LEXUS-ES	Document No.:		WI-ENG-PDE-994	
	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO		Revision No.:		0	Page No.:	1 of 13	

PARTS:		1. MR SW CP (TVSSf 0.3 G-BW wires L=588±3mm 2. Black Corrugated tube (No slit) Ø7, L=297±4mm		JIG:		1. Terminal cover jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS			
1	P1 Wire insertion to Black Corrugated tube (No Slit) Ø7, L=209±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 G and B/W wires.</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div>		<div><p>2. Get the 1st Black Corrugated tube Ø7 L=209±3mm (no slit) using right hand and insert to G and B/W wires then get then 2nd Black Corrugated tube Ø7 L=61±3mm (no slit) and insert to G and B/W wires using right hand.</p></div> <div><p>Black Corrugated tube Ø7 L=209±3mm (no slit)</p><p>Black Corrugated tube Ø7 L=61±3mm (no slit)</p></div>		<div>Safety Instruction Be sure to wear required 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> <div>Terminal cover jig </div>		1. No wrong usage of parts 2. No deformed terminal	


Revision History							Prepared by	Reviewed by	Approved by	Noted by
09/04/24	0	Initial issue					 D. Castillo	 C. Villanueva	 A. Arañes	n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date: September 4, 2024

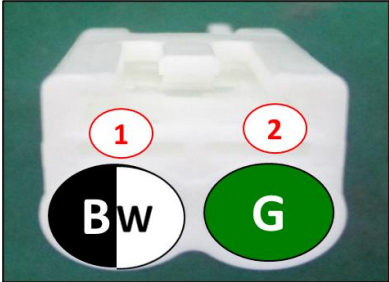
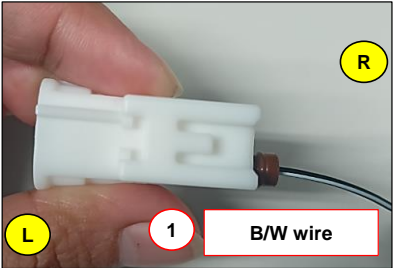
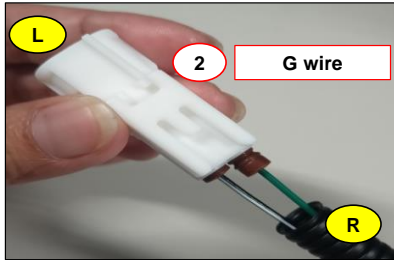
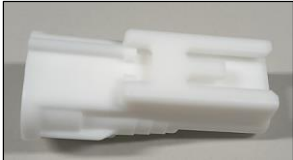

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	Model code/Part number: 410D/412D / 7N0235-7020		Customer: TRJ	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-994	
	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	2 of 13

PARTS:		1. Assy parts 2. Connector 6188-0407 (W)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1 Wire insertion to Connector 6188-0407 (W)	<div><div>12 BWG</div><div>VISUAL REFERENCE</div></div> <div><div>LR1B/W wire</div></div> <div><div>LR2G wire</div></div> <div><div>CONNECTOR ORIENTATION</div></div> <div><div>TERMINAL ORIENTATION</div></div> <div><p>1. Hold the connector using left hand. Get the Black/White wire then insert to terminal slot 1 using right hand.</p></div> <div><p>2. Get the Green wire and insert to terminal slot 2.</p></div>		n/a	<p>1. No wrong use of connector 2. No damaged connector 3. No wrong insertion 4. One by one insertion 5. No deformed terminal 6. No wrong wire facing</p> <p>Important reminder/Notes/:</p> <p>1. Please hold the wire near terminal during insertion. 2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</p> <p>Document reference/s:</p> <p>1. Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. 2. Please refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>

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	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	3 of 13

PARTS:	1. Assy parts			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1	Connector lock			

Coupler Cross Sectional View

NG

Double

Unlock Condition

NG

Double

Half Lock Condition

GOOD

Double

Full Lock Condition

L

R

1. Put the connector into locking jig using right hand then press **2x** to lock using both hands. Check the lock if properly locked.

Before lock

After lock

LOCKING JIG

Important reminders/Notes

1. Manual locking may cause damaged connector lock


1. Use the provided jig per model
2. No unclocked/half-locked connector.



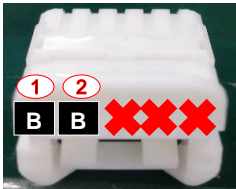

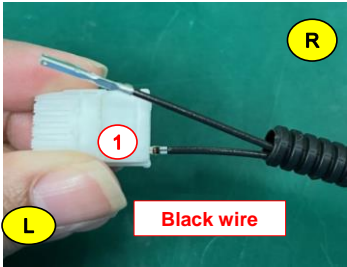
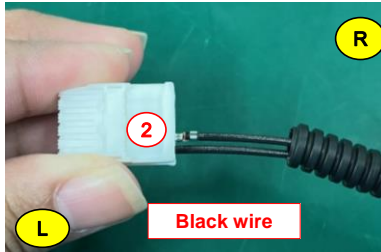
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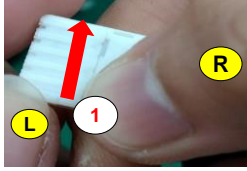
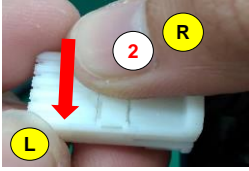
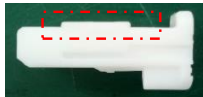





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	Process Name/Title:		Model code/Part number: 410D/412D / 7N0235-7020		Customer: TRJ	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-994	
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PARTS:		1. AVSSf 0.3 Black wire L=679±3mm 2. Black Corrugated tube ø5 L=159±3mm (no slit) 3. Connectro 6098-3810 (W)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Connector lock	 <p>1. Get the Black Corrugated tube ø5 L=159±3mm (no slit) using left hand and get two (2) AVSSf 0.3 Black wire L=679±3mm then insert using right hand.</p>		n/a	Document references: 1. Refer to WI-PRO-CNC-017 for Wire Strip lenght tolerance. 1. No wrong usage of parts. 2. No deformed terminal
5	Wire insertion to Connector 6098-3810 (W)	<div>  <p>CONNECTOR ORIENTATION</p> </div> <div>  <p>VISUAL REFERENCE</p> </div> <div>  <p>WIRE FACING</p> </div> <div>  <p>1. Get the connector 6098-3810 (W) then hold the 1st Balck wire and insert to terminal slot 1 of connector using right hand.</p> </div> <div>  <p>2. Hold the 2nd Balck wire and insert to terminal slot 2 of connector using right hand.</p> </div>		n/a	1. No wrong use of connector 2. No damaged connector 3. No wrong insertion 4. One by one insertion 5. No deformed terminal 6. No wrong wire facing Important reminder/Notes/: 1. Please hold the wire near terminal during insertion. 2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force. Document reference/s: 1. Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. 2. Please refer to GL-PRO-ASY-029 for Pull-Push procedure.


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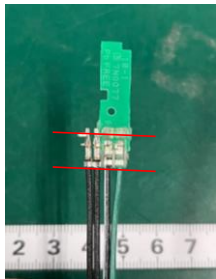
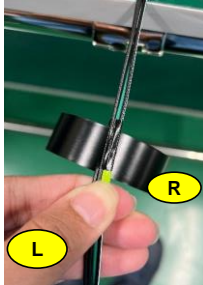
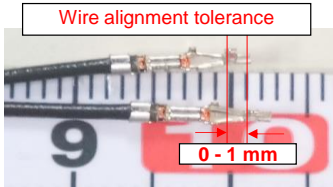
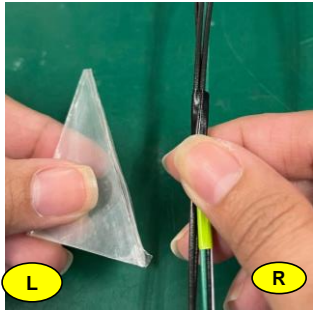
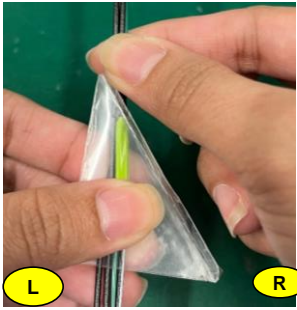
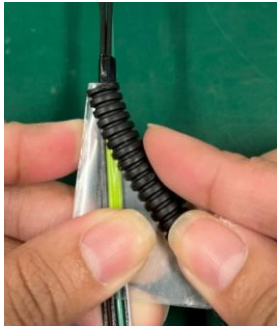

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
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	TAPING ASSEMBLY PROCESS				Validity Date:	n/a			
	Process Name/Title:		Model code/Part number: 410D/412D / 7N0235-7020	Customer: TRJ	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-994		
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input checked="" type="checkbox"/> PRE-LAUNCH	<input type="checkbox"/> MASSPRO	Revision No.:	0	Page No.:	5 of 13


PARTS:		1. Assy parts		JIG:	1. Locking jig 2. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	Wire insertion to Black Corrugated tube (with slit) Ø5 L=164±3mm	   <p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p>  <p>Before Pressing</p>  <p>After Pressing</p>		n/a	Important reminders/Notes 1. Manual locking may cause damaged connector lock 1. Use the provided jig per model 2. No unlocked/half-locked connector.
7	Wire insetion to assy parts	 <p>1. Get the terminal cover jig using right hand then insert to B wires.</p>  <p>2. Get the assy parts and insert to Black Corrugated tube Ø7 L=209±3mm (no slit) using right hand.</p>  <p>3. After insertion, remove the terminal cover jig using right hand.</p>		 <p>Terminal cover jig</p>	1. No wrong usage of parts. 2. No deformed terminal

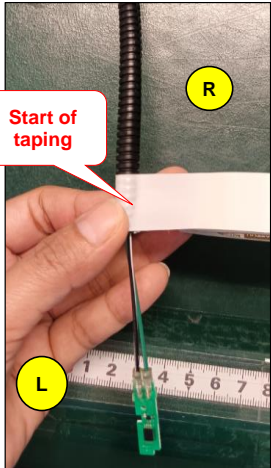

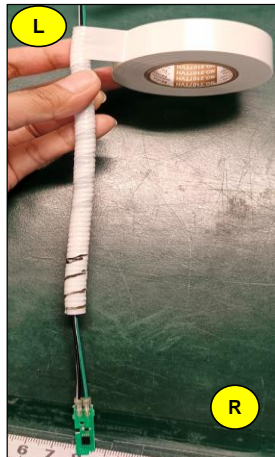

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	Model code/Part number: 410D/412D / 7N0235-7020		Customer: TRJ	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-994	
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PARTS:		1. Assy parts 2. Black Corrugated tube (with slit) Ø5 L=164±3mm 3. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	Spot taping	<div>  <div> 1. Fix the hotmelted wire and terminal pointed tip using both hands. </div>  <div> 2. Hold the wires using left hand and get the Black tape then conduct spot taping near Light Green tape using both hands. Make 2 windings of tape. Check the alignment and taping condition. </div> </div>		n/a	1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No missing tape <div>  <p>Wire alignment tolerance 0 - 1 mm</p> </div>
9	P1 Wire insertion to Black Corrugated tube (with slit) Ø5 L=164±3mm	<div>   <div> 1. Hold the COT Adaptor using left hand. Insert the wires using right hand. </div>  <div> 2. Hold the COT Adaptor with wires using left hand, get the Black Corrugated tube (w/ slit) Ø5 L=164±3mm using right hand then insert to COT adaptor. Hold the COT adaptor and push the COT (same timing) using both hands. Make sure all wires are inserted. </div> </div>		<div>  <p>COT Adaptor</p> </div>	1. No wrong use of parts 2. No wires left between the COT slit

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	P1 Half-wrap Taping	<div><p>Start of taping</p></div> <div><p>1/2 shifting</p></div> <div><p>1/2 shifting</p></div> <div><p>1. Hold the corrugated tube (w/slit) using left hand. Get the black tape using right hand. Conduct 2 windings of tape before shifting using both hands.</p><p>2. Make 1/2 shifting. Repeat the process until the end of corrugated tube. Make 3 windings of tape then cut the tape.</p><p>3. Check the taping condition.</p></div> <div><p>MEASURING TAPE</p></div>		<p>Important reminders/Notes</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. Used WHITE TAPE to easily visualize the tape shifting, but actual should be BLACK TAPE.</p> <p>3. Internal tolerance for halfwrap taping shifting should be 0~14mm only.</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape</p>	

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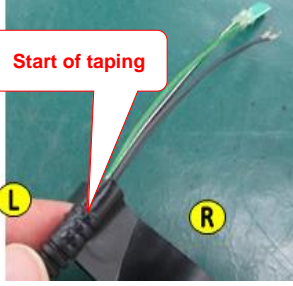
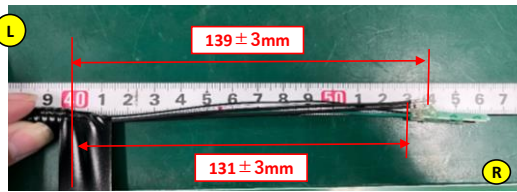
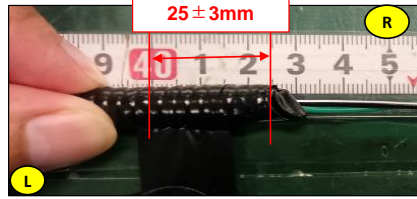
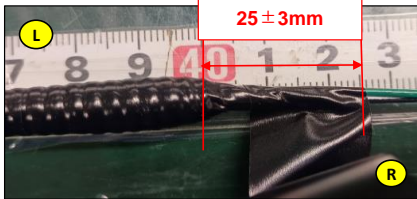
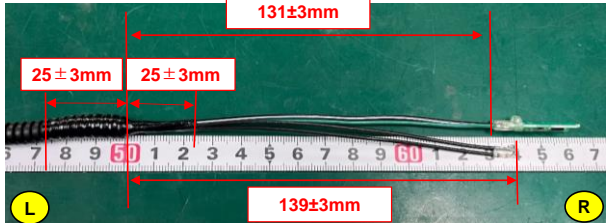

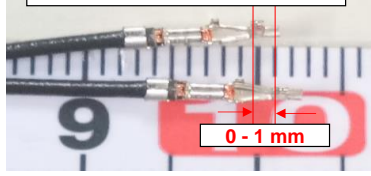
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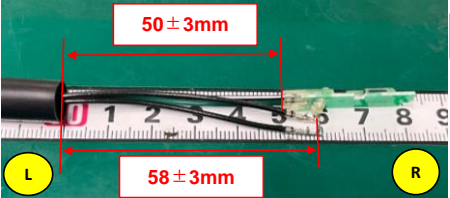


PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1 Taping 1 Black Corrugated tube to Wire near PCB	<div><p>Start of taping</p></div> <div><p>139 ± 3mm 131 ± 3mm</p></div> <div><p>2. Measure from end of COT up to Hotmelted wires L=131±3mm and COT to terminal pointed tip L=139±3mm then continue the taping process using both hands.</p></div> <div><p>25 ± 3mm</p></div> <div><p>25 ± 3mm</p></div> <div><p>3. Confirm measurement from end of tape up to end of COT 25±3mm then continue the taping process using both hands.</p></div> <div><p>4. Confirm measurement from end of COT up to end of tape 25±3mm then continue the taping process using both hands.</p></div> <div><p>131 ± 3mm 25 ± 3mm 25 ± 3mm 139 ± 3mm</p></div> <div><p>5. After taping, check the measurement, wire alignment and taping condition.</p></div>		<div><p>MEASURING TAPE</p></div>	<div><p>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p><p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p><p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape</p><div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div></div>

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PARTS:	1. Assy parts 2. Black VM tube (Sunprene) ø9, L=101±3mm			JIG:	1. Terminal cover jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
12	Wire insertion to Black VM tube (Sunprene) ø9, L=101±3mm	<div><p>2. Get the Black VM tube (Sunprene) ø9, L=101±3mm using left hand then insert the hotmelted wires (B/W-G) and Black wires using right hand.</p><p>1. Get the terminal cover jig using right hand then insert to B wires.</p></div>			<div></div> <p>Terminal cover jig</p>	1. No wrong usage of parts 2. No deformed terminal		
13	P1 Taping 2 Black Corrugated tube to VM tube (Sunprene)	<div><p>1. Measure the end of VM tube (Sunprene) up to hotmelted wires 50±3mm and end of VM tube (Sunprene) up to terminal pointed tip 58±3mm using both hands.</p><p>2. Hold the VM tube (Sunprene) using left hand, get the Black tape then start taping using right hand.</p><p>3. After taping, check the measurement and taping condition.</p></div>			<div></div> <p>MEASURING TAPE</p>	1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.		


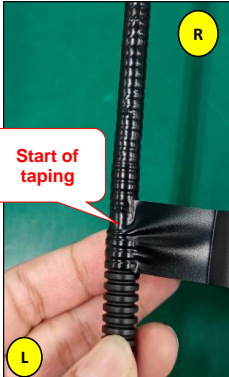
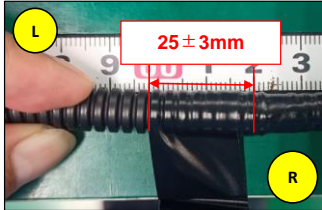
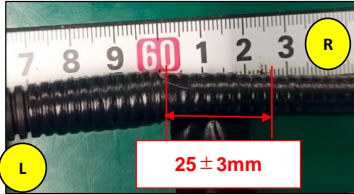
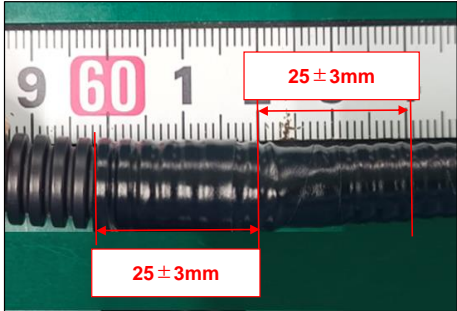

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	WORK INSTRUCTION			Effectivity Date:	September 4, 2024			
	TAPING ASSEMBLY PROCESS			Validity Date:	n/a			
	Process Name/Title:		Model code/Part number: 410D/412D / 7N0235-7020	Customer: TRJ	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-994	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input checked="" type="checkbox"/> PRE-LAUNCH	<input type="checkbox"/> MASSPRO	Revision No.:	0	Page No.:

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
14	P1 Taping 3 Black Corrugated tube (No slit) to Corrugated tube (w/ slit)	<div><p>1. Fix the Corrugated tube (No slit) and the Corrugated tube (w/slit) using both hands.</p></div> <div><p>2. Get the black tape and start taping process using both hands.</p></div> <div><p>3. Measure from end of tape up to end of Corrugated tube (No slit) 25±3mm.</p></div> <div><p>4. Measure from end of Corrugated tube (No slit) to end of tape 25±3mm.</p></div> <div><p>65 After taping, check the measurement and taping condition.</p></div>		<div>MEASURING TAPE</div> 	<p>Important reminders/Notes</p> <p>1. Please use calibrated/verified measuring tape when fetting the measurement.</p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape</p>	

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model code/Part number:

410D/412D / 7N0235-7020

Customer:

TRJ

Car Model:

LEXUS-ES

Purpose:

☐ PROTOTYPE

☒ PRE-LAUNCH

☐ MASSPRO

Effectivity Date:

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Validity Date:

n/a

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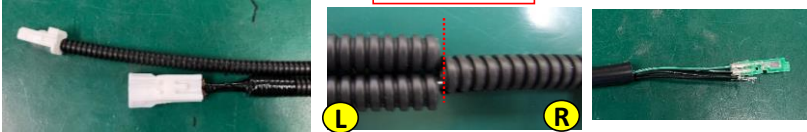

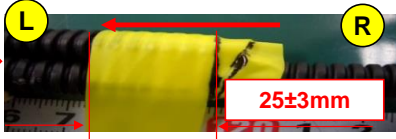
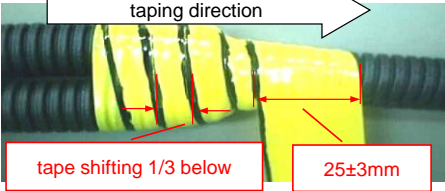
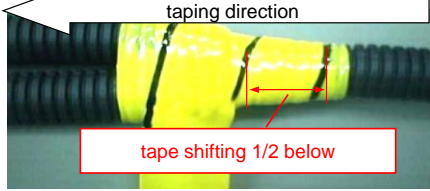
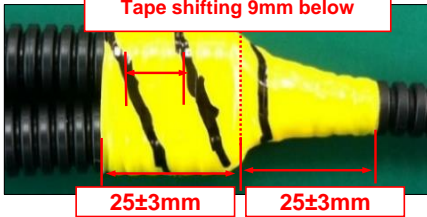
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PARTS:		1. Clamp 82711-48210 (B) 2. Clamp 82711-33650 (B)		3. Clamp 82711-3A540 (W) 3. Black tape [4pcs]		JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
15	P1	Y-Taping	<div><div><div></div><div><div>1. Fix the 3 corrugated tube .</div></div></div><div><div><div></div><div></div></div><div><div>2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side , width must be same with tape (25±3mm)</div></div><div><div><div></div><div><div>3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be 25±3mm)</div></div></div><div><div><div></div><div><div>4. Wind the tape backward 1/2 shifting</div></div></div><div><div><div></div><div><div>5. Wind the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.</div></div></div></div></div></div></div></div>			n/a	<p>Important reminders/Note/s:</p> <p>1. Use <u>yellow tape</u> for easy visualization of tape shifting, but actual should be <u>BLACK TAPE</u>. 2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape</p>

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WORK INSTRUCTION

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TAPING ASSEMBLY PROCESS

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410D/412D / 7N0235-7020

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PARTS:

1. Assy parts

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

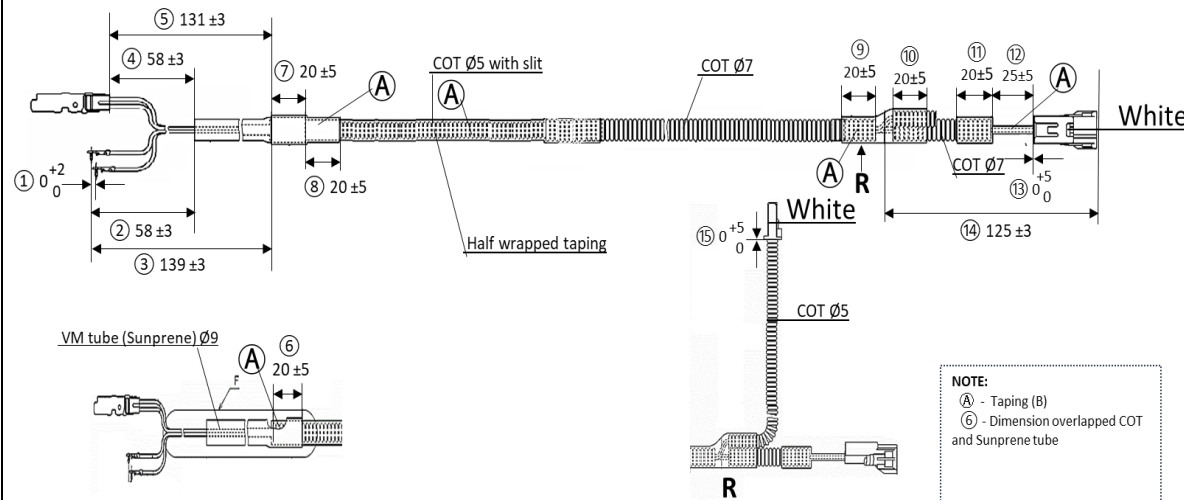
TOOLS/PPE

QUALITY POINTERS

16

P1

Measurement



1. No wrong dimension

Important reminders/Notes

1. Please use calibrated/verified measuring tape when fetting the measurement.
2. For Hatsumono, Nakamono and Owarimono

Document reference/s:

1. Please refer to WI-PRO-ASY-056 for Sub-Assy Hatsumono, Nakamono and Owarimono inspection.

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☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

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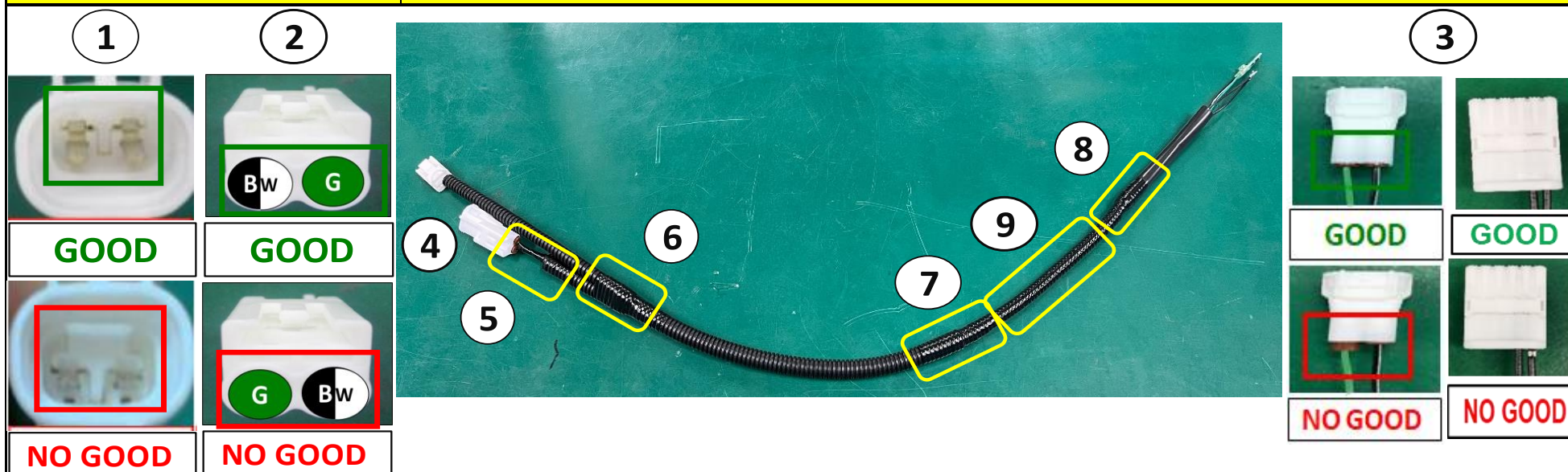
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**TAPING - P1****7N0235-7020****① No Unlock/Halflock Connector****② No Wrong Insert****③ No Terminal Backing Out****④ No Deformed Terminal****⑤ ⑥ ⑦ ⑧ No Missing tape****⑨ Checked Half-wrap taping (No exposed COT)**

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