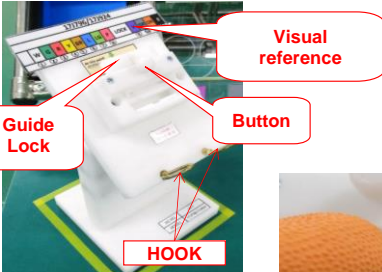
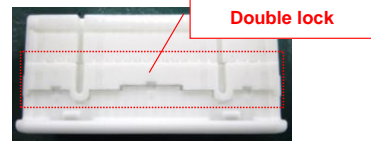




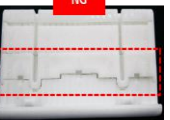
	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date:	March 14, 2025		
	Process Name/Title:				Validity Date:	n/a		
	Model code/Part number: 241B / 17J924-7051		Customer: TRP	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-092A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	17	Page No.:	1 of 3

PARTS:	1. Connector 1827842-1 (W)			JIG:	1. Insertion jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
1	P1 <div style="border: 1px solid black; padding: 5px; text-align: center; margin: 10px 0;"> 17 HIGH </div> Connector setting to insertion jig 1827842-1 (W)	<div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  </div> <div style="text-align: center;">  </div> </div> <div style="text-align: center; margin: 10px 0;">  </div> <div style="border: 1px solid black; padding: 5px; margin: 10px 0;"> 1. Get the connector 1827842-1 (W) using left hand then set to insertion jig. </div> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  </div> <div style="text-align: center;">  </div> </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>	<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Important reminders/Note/s: 1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector 5. No half-locked connector Important reminders/Note/s: 1. <i>Automatically dispose and replace the unit if once encountered Bend terminal, Difficulty of insertion, Half-locked connector.</i> 2. <i>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.</i> 3. <i>Follow the connector orientation.</i> </div> <div style="border: 1px solid black; padding: 5px; text-align: center; margin-bottom: 10px;"> Connector must be no damaged/half-locked/locked </div> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <div style="background-color: green; color: white; padding: 2px 5px; font-weight: bold;">GOOD</div>  <div style="border: 1px solid red; padding: 2px; font-weight: bold;">UNLOCK</div> </div> <div style="text-align: center;"> <div style="background-color: red; color: white; padding: 2px 5px; font-weight: bold;">NG</div>  <div style="border: 1px solid red; padding: 2px; font-weight: bold;">HALF-LOCKED</div> </div> </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		
08/02/23	16	Updated template; Inclusion of CAR MODEL "LEXUS-ES" . (Refer to ENGDRR-146 for Document revision request)	M. Ariola	J. Loterte	C. Villanueva	A. Arañes		
03/2/23	15	Change WIP flow 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

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

March 14, 2025

Model code/Part number:

241B / 17J924-7051

Customer: TRP

Car Model:

LEXUS-ES

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Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

17

Page No.:

2 of 3

PARTS:

1. CIVUS 0.13 W L=183±2mm; G L=186±2mm; R L=184±2mm; Y L=180±2mm; BR L=178±2mm; L L=184±2mm;
LG L=176±2mm; P L=177±2mm; V L=177±2mm; GR L=179±2mm; OR L=181±2mm; B L=181±2mm; G L=1±193mm; R L=192±2mm; B L=193±2mm;

JIG:

1. Insertion jig

NO.

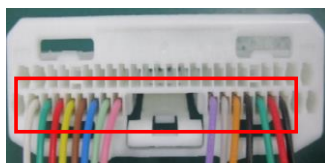
PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

WIRE INSERTION ILLUSTRATION

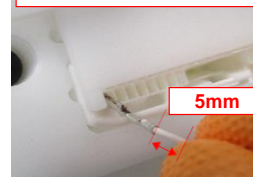


17J924-7051																			
X																			
X	W	G	R	Y	BR	L	LG	P	LOCK	V	GR	OR	B	G	R	B	X	X	
-	183	186	184	180	178	184	176	177	-	177	179	181	181	193	192	193	-	-	

GOOD SHORT
terminalNG LONG
terminal

Terminal facing

Standard hold in wire



5mm

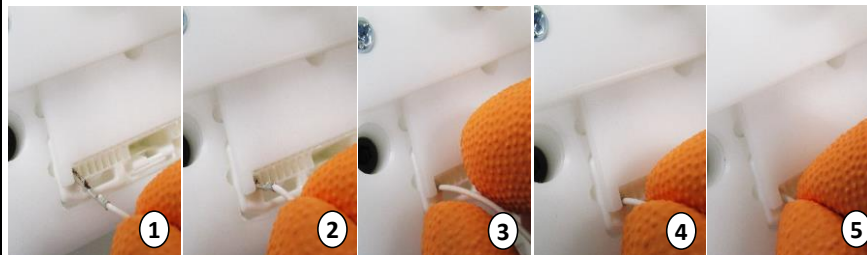
Finger COTS



17

MEDIUM

Wire insertion to connector
(Group 1 & 3 wires)
1827842-1 (W)



1. Get the wire and hold it 5mm away from terminal.
2. Half insert the wire.
3. Release wire to check the color.
4. Conduct point checking in visual
5. Hold again 5mm away from terminal
6. Fully inserted wires (avoid bending during insertion)

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
6. No bend terminal/wires

Important reminders/Note/s:

1. Automatically dispose and replace the unit if once encountered Bend terminal, Difficulty of insertion, Half-locked connector.
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.
3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
4. Follow the insertion sequence based on the visual reference
5. Hold on wire during insertion must be 5mm away from terminal end.

Document references:

1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

17

Page No.:

3 of 3

PARTS:	1. Assy parts			JIG:	1. Insertion jig 2. WIP Holder
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	<div>17</div> <div>MEDIUM</div> <div>Wire insertion to connector (Group 1 & 3 wires) 1827842-1 (W) (Continuation)</div> <div>P1</div>	<div><div>Button</div><div><div>L</div><div>BEFORE PRESSING</div></div><div><div>L</div><div>AFTER PRESSING</div></div><div><div>R</div></div><div>6. Press the button using left thumb.</div><div>7. Hold the wires using right hand then gently pull out the connector from jig. Check the insertion condition.</div></div>		<div>Finger COTS</div> <div></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 6. No bend terminal/wires</div> <div><div>No bend terminal/wires</div><div><div>GOOD</div><div>NG</div></div><div><div>No damaged/whitens</div></div></div>
3	Pass WIP to P2	<div>3 PIECES FLOW</div> <div></div> <div>1. Pass WIP to WIP Holder. Note: Three pieces flow.</div>		<div>WIP HOLDER</div> <div></div>	<div>1. No WIP overflow</div>

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