
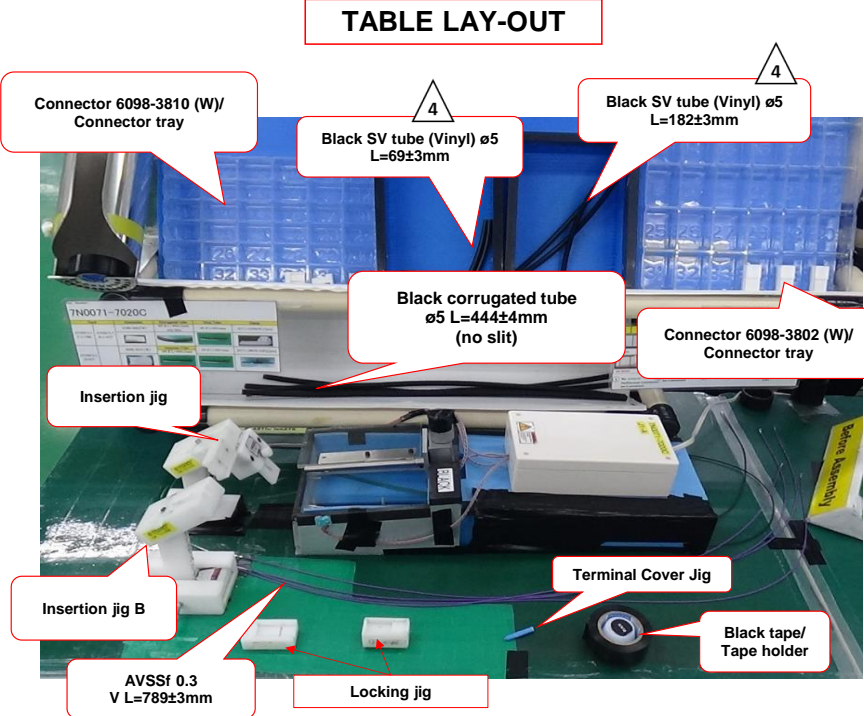


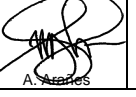


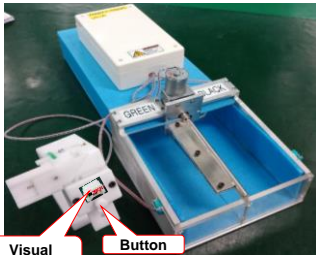


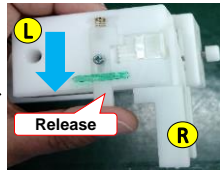

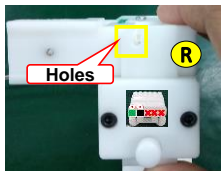


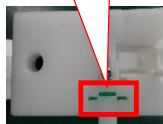

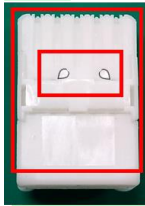
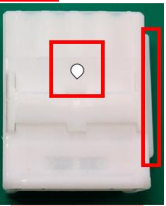


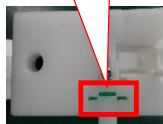

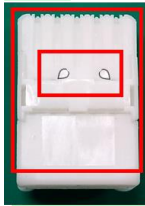
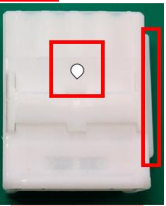
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	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date: n/a	
	Model code/Part number: 800B/900B/910B / 7N0071-7020C		Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.: WI-ENG-PDE-456A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: 4		Page No.: 1	of 10

PARTS: 	1. Connector 6098-3810 (W); Connector 6098-3802 (W); Black SV tube (Vinyl) ø5 L=182±3mm; AVSSf 0.3 V L=789±3mm; Black tape [1pc.]; Black SV tube (Vinyl) ø5 L=69±3mm; Black corrugated tube ø5 L=444±4mm		JIG:	1. Insertion jig with and without switch cover 2. Locking jig 3. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Table Lay-out		<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>	Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 1. No missing parts/tools 2. No excess parts/tools

Revision History								Prepared by	Reviewed by	Approved by	Noted by		
06/03/24	4	Transfer Black vinyl tube to wire near connector taping (G-B wire) to WI-ENG-PDE-456B. Transfer Wire insertion to Black corrugated tube ø5 L=444±4mm (no slit) from WI-ENG-PDE-456B due to Process improvement. Change term from Vinyl tube to SV tube (Vinyl). Update table lay-out and improved Visual inspection.				D. Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
04/24/23	3	Inclusion of quality checkpoints				J. Loterte	C. Villanueva	A. Arañes	n/a				
10/28/22	2	Improve quality pointers: Reminders/notes and references in process no.1,2,3,4,6,7,8,9 and 11 due to document improvement. Work procedure/illustration in process no.4 and 9 - connector lock.				M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	March 28, 2022		

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		WORK INSTRUCTION			Effectivity Date:		June 3, 2024		
		TAPING ASSEMBLY PROCESS			Validity Date:		n/a		
		Model code/Part number: 800B/900B/910B / 7N0071-7020C		Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:		WI-ENG-PDE-456A	
		Purpose: <input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:		4	Page No.: 2 of 10

PARTS:		1. Connector 6098-3810 (W)				JIG:		1. Insertion jig with switch cover	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
2	P1	<div><div><div>Insertion Jig w/ switch cover</div><div>Visual reference</div><div>Button</div></div><div><div>Insertion Jig Orientation</div><div><div>I-mark</div><div>Lock</div></div><div><div>Double lock</div></div><div>CONNECTOR ORIENTATION</div></div><div><div><div><div>L</div><div>Press</div></div><div><div>R</div><div>Release</div></div></div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6098-3810 (W) using right hand and release the lock using left hand. <i>Note: Follow the connector orientation.</i></div><div><div><div>R</div><div>Holes</div></div><div><div>R</div><div>Holes</div></div><div>3. Push the guide using right thumb, hole for G wires will be opened.</div></div></div></div> <div>n/a</div> <td colspan="2"><div><div>Connector Orientation Illustration</div><div><div><div>I-mark was align</div></div><div><div>1 hole were only open</div></div><div>GOOD</div></div><div><div><div>I-mark is NOT align</div></div><div><div>1 hole were open</div></div><div>NG</div></div></div><div>CONNECTOR ILLUSTRATION</div><div><div><div>GOOD</div><div>6098-3810 (W)</div></div><div><div>NG</div><div>6098-5677 (W)</div></div></div><div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div></td>				<div><div>Connector Orientation Illustration</div><div><div><div>I-mark was align</div></div><div><div>1 hole were only open</div></div><div>GOOD</div></div><div><div><div>I-mark is NOT align</div></div><div><div>1 hole were open</div></div><div>NG</div></div></div> <div>CONNECTOR ILLUSTRATION</div> <div><div><div>GOOD</div><div>6098-3810 (W)</div></div><div><div>NG</div><div>6098-5677 (W)</div></div></div> <div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div>			

CONNECTOR ILLUSTRATION



GOOD

6098-3810 (W)



NG

6098-5677 (W)

1. Use the provided jig per model


2. No wrong orientation of connector


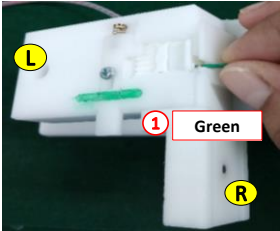
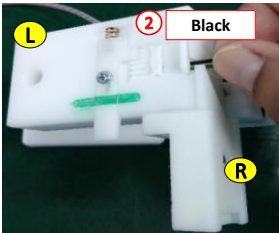
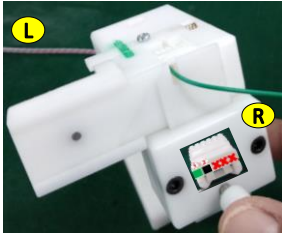
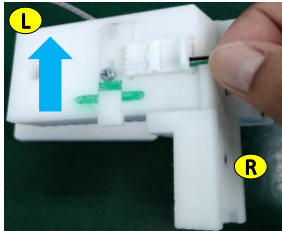
3. No wrong use of connector

4. No damaged connector

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	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 800B/900B/910B / 7N0071-7020C		Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:	WI-ENG-PDE-456A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	4	Page No.:	3 of 10


PARTS:	1. AVSSf 0.3 G-B wires L=677±3mm			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to Connector 6098-3810 (W)	<div><p>Wire facing</p></div> <div><p>1. Get the Green wire then insert to terminal slot 1 using right hand.</p></div> <div><p>2. Get the Black wire then insert to terminal slot 2 using right hand.</p></div> <div><p>2. Press the button using right thumb. The slot for B wires will be opened.</p></div> <div><p>4. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</p></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.</p> <p>2. Make sure wires are properly inserted.</p> <p>Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>3. Insertion of wires must be from left to right</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p>


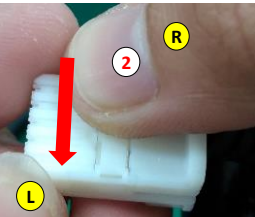
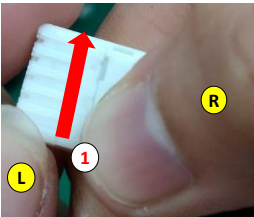
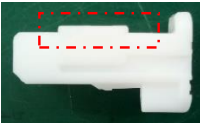
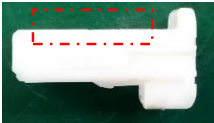

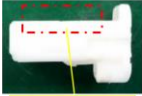
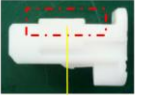

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	Model code/Part number: 800B/900B/910B / 7N0071-7020C		Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:	WI-ENG-PDE-456A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	4	Page No.:	4 of 10


PARTS:	<div><div>4</div><div>1. Assy parts 2. Black SV tube (Vinyl) ø5 L=69±3mm</div></div>	JIG:	1. Locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1 Connector Lock	<div><div><p>1. Put the connector into locking jig using right hand then press 2x using both hands. Touch the connector lock to confirm if properly locked.</p></div><div><p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div><div><p>Before Pressing</p></div><div><p>After Pressing</p></div></div>	<div><div>LOCKING JIG</div></div>	<div><p>Important reminders/Note/s:</p><p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p><p>1. Use the provided locking jig per model 2. No unlock/half-locked connector</p><div><div>CONNECTOR LOCK CONDITION</div><div><div><p>GOOD Fully Locked</p></div><div><p>NG UnLocked</p></div></div></div></div>
5	<div><div>4</div><div>Wire insertion to Black SV tube (Vinyl) ø5 L=69±3mm</div></div>	<div><div><p>1. Get the Black SV tube (Vinyl) ø5 L=69±3mm using right hand then insert the G-B wires.</p></div></div>	n/a	1. No wrong use of parts

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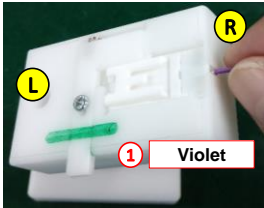
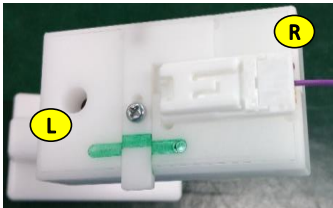
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		Process Name/Title:		Model code/Part number: 800B/900B/910B / 7N0071-7020C		Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:		WI-ENG-PDE-456A				
		Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:		4	Page No.:	5 of 10
		PARTS:		1. Connector 6098-3810 (W)				JIG:		1. Insertion jig				
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS				
6		P1		<div><div><div><div><div>INSERTION JIG</div><div>Holes</div><div>Lock</div><div>I-mark</div></div><div><div>Lock</div><div>I-mark</div><div>Holes</div></div><div>CONNECTOR ORIENTATION</div></div><div><div>INSERTION JIG ORIENTATION</div></div></div><div><div><div><div><div><div>↑</div><div>L</div><div>Press</div></div><div>1. Press the lock of insertion jig using left thumb.</div></div><div><div><div>↑</div><div>L</div><div>Press</div></div><div>2. Insert the connector 6098-3802 (W) into jig using right hand then release the lock. <i>Note: Follow the connector orientation.</i></div></div><div><div><div>↓</div><div>L</div><div>Release</div></div><div>3. Check the holes/terminal slot for V wires.</div></div></div></div></div></div> <div>n/a</div> <td colspan="4"><div><div>Connector Orientation Illustration</div><div><div><div>I-mark was align</div><div>1 hole were only open</div></div><div><div><div>GOOD</div><div>I-mark is NOT align</div><div>1 hole were open</div></div><div>NG</div></div></div><div>CONNECTOR ILLUSTRATION</div><div><div><div>GOOD</div><div>6098-3810 (W)</div></div><div><div>NG</div><div>6098-5677 (W)</div></div></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></td>				<div><div>Connector Orientation Illustration</div><div><div><div>I-mark was align</div><div>1 hole were only open</div></div><div><div><div>GOOD</div><div>I-mark is NOT align</div><div>1 hole were open</div></div><div>NG</div></div></div><div>CONNECTOR ILLUSTRATION</div><div><div><div>GOOD</div><div>6098-3810 (W)</div></div><div><div>NG</div><div>6098-5677 (W)</div></div></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>						

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	Model code/Part number: 800B/900B/910B / 7N0071-7020C		Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:	WI-ENG-PDE-456A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	4	Page No.:	6 of 10

PARTS: 	1.Black SV tube (Vinyl) ø5 L=182±3mm 2. AVSSf 0.3 V L=789±3mm		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	 Wire insertion to Black SV tube (Vinyl) ø5 L=182±3mm	  <div>1. Get the Black SV tube (Vinyl) ø5 L=182±3mm using right hand then insert the V wires.</div>	n/a	1. No wrong use of parts 2. No deformed terminal
8	P1 Connector setting to Insertion jig 6098-3802 (W)	 <div>Wire facing</div>  <div>Violet</div> <div>1. Get the Violet wire then insert to terminal slot 1 using right hand.</div>  <div>2. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</div>	n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing Important reminders/Note/s: 1. <i>Please hold the wire near terminal.</i> 2. <i>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.</i> <i>Do not exert extra force.</i> 3. <i>Insertion of wires must be from left to right.</i> 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

Model code/Part number: 800B/900B/910B / 7N0071-7020C

Customer: TRJ

Car Model: LEXUS-NX/RX

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

June 3, 2024

Validity Date:

n/a

Document No.:






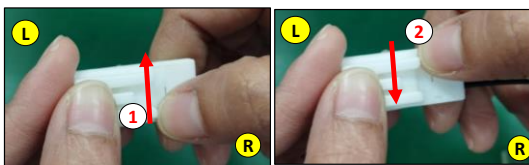





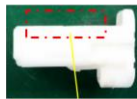
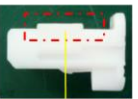
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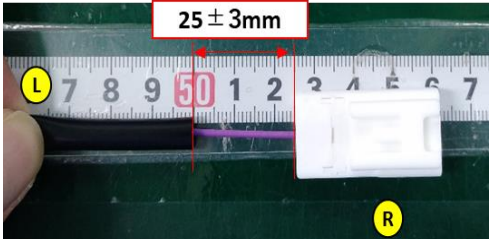
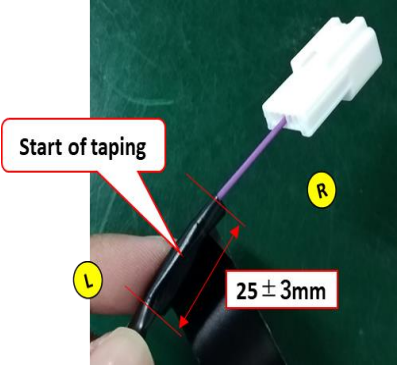
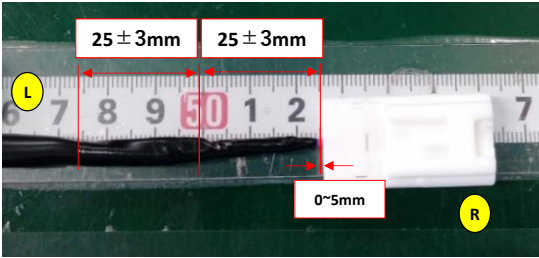

PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P1 Connector Lock	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div> <div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div> <div><p>Right thumb-Lower Left thumb-middle</p><p>3. Press the lower parts of connector using right hand while left hand holding the middle.</p></div> <div><p>Right thumb-upper Left thumb-middle</p><p>4. Press the upper part of connector using right hand while left hand holding the middle.</p></div> <div><p>Right thumb-middle Left thumb-middle</p><p>5. Lift then press the connector in the middle using left and right hand.</p></div> <div><p>6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div>	<div></div> <div><p>Before pressing</p><p>After pressing</p></div> <div><div><p>GOOD</p><p>Full Lock</p></div><div><p>NG</p><p>Half Lock</p></div></div> <div><p>CONNECTOR LOCK CONDITION</p><div><p>GOOD</p><p>Fully Locked</p></div><div><p>NG</p><p>UnLocked</p></div></div> <div><p>Important reminders/Note/s:</p><p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p><p>1. Use the provided locking jig per model 2. No unlock/half-lock connector</p></div>	

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	4	Page No.:	8 of 10


PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
10	<div><div>4</div><div>Taping 1</div><div>Black SV tube (Vinyl) to wire near connector (V wire)</div></div>	<div><div>1. Measure from end of tube up to edge of connector 25±3mm using both hands.</div><div>2. Hold the tube using left hand, get the Black tape using right hand then start taping process using both hands.</div><div>3. After taping, check the measurement and taping condition.</div></div>	<div><div>MEASURING TAPE</div></div>	<div>Important reminders/Note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</div>	





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	WORK INSTRUCTION				Effectivity Date:		June 3, 2024	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 800B/900B/910B / 7N0071-7020C		Customer: TRJ	Car Model: LEXUS-NX/RX		Document No.: WI-ENG-PDE-456A
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		4	Page No.: 9 of 10

PARTS:		1.Black corrugated tube ø5 L=444±4mm 2. Assy parts		JIG:	1. Terminal Cover Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1 <div>4</div> Wire insertion to Black corrugated tube ø5 L=444±4mm (no slit)	<div> 1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the B-G-V wires using left hand.</div> <div> 2. Get the corrugated tube (no slit) ø5 L=444±4mm using right hand then insert the B-G-V wires using left hand.</div> <div> 3. After insertion, remove the terminal cover jig using right hand.</div>		<div>TERMINAL COVER JIG</div> 	1. No wrong use of parts 2. No deformed terminal

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**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 3, 2024

Validity Date:

n/a

Model code/Part number: **800B/900B/910B / 7N0071-7020C**Customer: **TRJ**Car Model: **LEXUS-NX/RX**

Document No.:

WI-ENG-PDE-456A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

4

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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION****P1****7N0071-7020C**

①



GOOD

②



GOOD

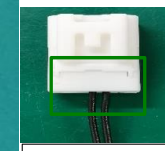
③



④



⑤



GOOD

⑦



NO GOOD

⑥

① ② No **Unlock/Halflocked Connector**⑥ No **Missing Tape**③ ④ No **Wrong Insert**⑦ No **Deform Terminal**⑤ No **Terminal Backing Out**

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