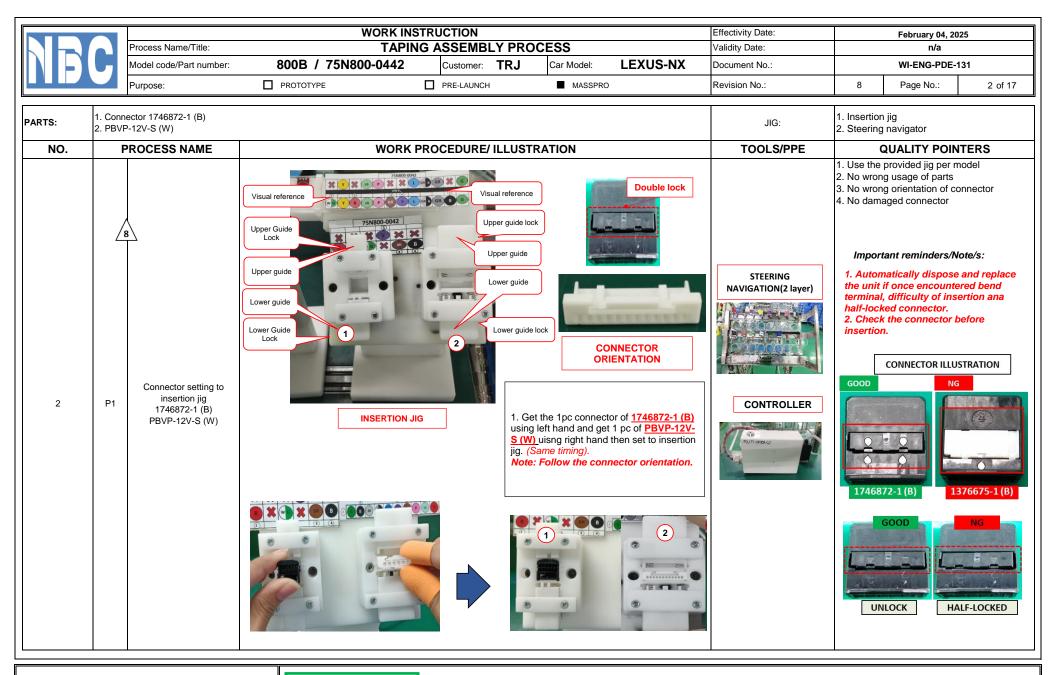
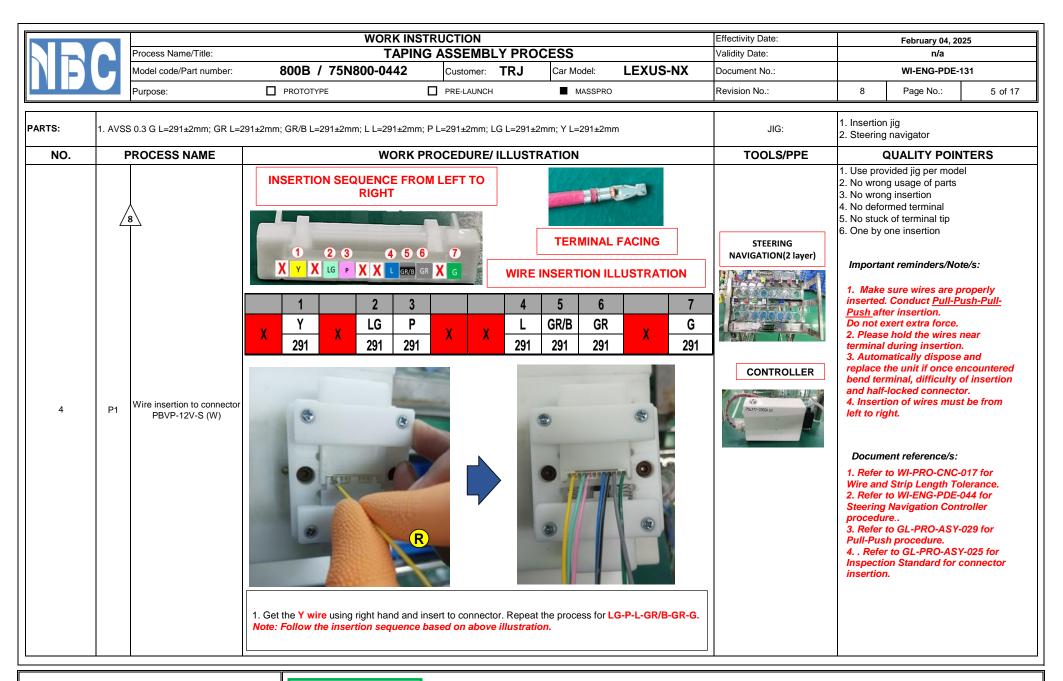
				WC	ORK INSTRUCTION				Effec	tivity Date:		February 04, 20	25
			Process Name/Title:		TAPING ASSEMBLY PROC	ESS			Validi	ty Date:		n/a	
			Model code/Part number:	800B / 75N800-	0442 Customer: TRJ	Car Model:	LEX	(US-NX	Docu	ment No.:		WI-ENG-PDE-1	31
			Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSP	RO		Revis	sion No.:	8	Page No.:	1 of 17
PARTS:		L=291± L=123±	2mm; GR L=291±2mm; GR/B 3mm; Black VM tube (Sunpre	L=291±2mm; L L=291±2mm; P L= ne) Ø6 L=120±3mm; Connector PB	,	m; Black VM tu				JIG:		g navigator	T-D0
N	0.	-	PROCESS NAME		WORK PROCEDURE/ ILLUSTR	ATION				TOOLS/PPE		QUALITY POIN	IERS
			8	Connector PBVP-08V-S (W)/ Box	Table Lay-out Black VM tube (Sunprene) Ø6 L=120±3mm			2 Layer Navigation	p	Bafety Instruction Be sure to wear rescribed persona otective equipme during operation gloves, finger cots etc.)	nt Docum	nent reference/s to WI-PRO-CNC-0 ngth Tolerance	
1	I	P1 Table lay-out Master sample Black VM tube (Sunprene) Ø8.5 L= 123±3mm Master sample 1. No deformed terminal 2. No wrong usage of parts											
		Insertion Jig B Connector 1746872-1 (B)/ Box Connector PBVP-12V-S (W)/ Box Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.											
				Revisio	n History					Prepared by	Reviewed by	Approved by	Noted by
02/04/25	8	Update \	Work procedue/Illustration and o		ertion jig as costumer claim countermeasure. ay-out and inclusion of empty box for location e of Measurement.	D. Castillo	C. Villanueva	A. Arañes	n/a				·
04/06/23	7	Improve	the insertion jig and the proced	ure.		D. Castillo	J. Loterte	C. Villanueva	. Arañes				
01/19/23	6	Changed	term of Black sunprene tube to B	Black VM tube (Sunprene). Additional Qu	ality pointers.	D. Castillo	J. Loterte	C	. Arañes	D. Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No			Details of Change		Revised	Reviewed	Approved	Noted	Est. Date:	June 24, 2020		
			Details of Change Revised Reviewed Approved Noted Est. Date: June 24, 2020										



				STRUCTION			Effectivity Date:		February 04, 202	25
		Process Name/Title:	TAPIN		Validity Date:		n/a			
		Model code/Part number:	800B / 75N800-0442	LEXUS-NX	Document No.:		WI-ENG-PDE-1	31		
		Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO)	Revision No.:	8	Page No.:	3 of 17
PARTS:		, , , , , , , , , , , , , , , , , , ,	160±2mm; BR L=160±2mm; B L=160±2mm;				JIG:	Insertion Steering	g navigator	
NO.	P	ROCESS NAME	WORK I	PROCEDURE/ ILLUS	TRATION		TOOLS/PPE	(QUALITY POIN	TERS
2	/8	Connector setting to insertion jig 1746872-1 (B) PBVP-12V-S (W) (Continuation)	2. Press the upper and lower guide usionly open.		AFTER PRES		STEERING NAVIGATION(2 layer)	2. No wrong	provided jig per mod g usage of parts g orientation of conn ged connector	
3	P1	Wire insertion to connector 1746872-1 (B)	INSERTION SEQUENCE FROM LEF 2ND ROW 1ST ROW (LEFT TO RIGHT)	T TO RIGHT X 1 R 160	1. Get the R hand and in slot 1. Rep W/G-BR-B v Note: Folio	X X X X X X X X X X X X X X X X X X X	CONTROLLER	 No wrong No wrong No defor No stuck 	rided jig per model g usage of parts g insertion med terminal of terminal tip one insertion.	

			WORK IN	ISTRUCTION			Effectivity Date:	T	February 04, 202	25
		Process Name/Title:	TAPII	NG ASSEMBLY PRO		Validity Date:		n/a	-	
		Model code/Part number:	800B / 75N800-0442	Customer: TRJ	LEXUS-NX	Document No.:		WI-ENG-PDE-1	31	
		Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO)	Revision No.:	8	Page No.:	4 of 17
PARTS:	1. AVSS	6 0.3 R L=160±2mm; W/G L=	160±2mm; BR L=160±2mm; B L=160±2mm	n; V L=160±2mm			JIG:	1. Insertion 2. Steering	n jig g navigator	
NO.	F	PROCESS NAME	WORK	PROCEDURE/ ILLUST	RATION		TOOLS/PPE		QUALITY POIN	
3	P1	Wire insertion to connector 1746872-1 (B) (Continuation	3. Press the upper and lower guide lock hands (same timing). Hold the wires hand and gently pull out the connecto Note: Please see above illustration 4. After rethe assy p	2. Get the V wire using right hand a insert to terminal 5. Note: Follow the insertion seque based on the illustration. PRESSING Ck with both using right or from jig.	e and slot	R Assy parts	STEERING NAVIGATION(2 layer) CONTROLLER	2. No wror 3. No wror 4. No defo 5. No stuc 6. One by Impo 1. Plea during 2. Make inserte Condu inserte Do not 3. Auto the uni termina and ha Docume 1. Refer Pull-Pui 2. Refer Wire an 3. Refer	ct Pull-Push-Pull- on. t exert extra force. omatically dispose it if once encounte al and difficulty of alf locked connecte ent references: r to GL-PRO-ASY-(sh procedure. r to WI-PRO-CNC-(of Strip Length Too r to WI-PNG-PDE-C g Navigation Cont	ote/s: ear terminal roperly Push after e and replace ered bend insertion or. 029 for 017 for lerance



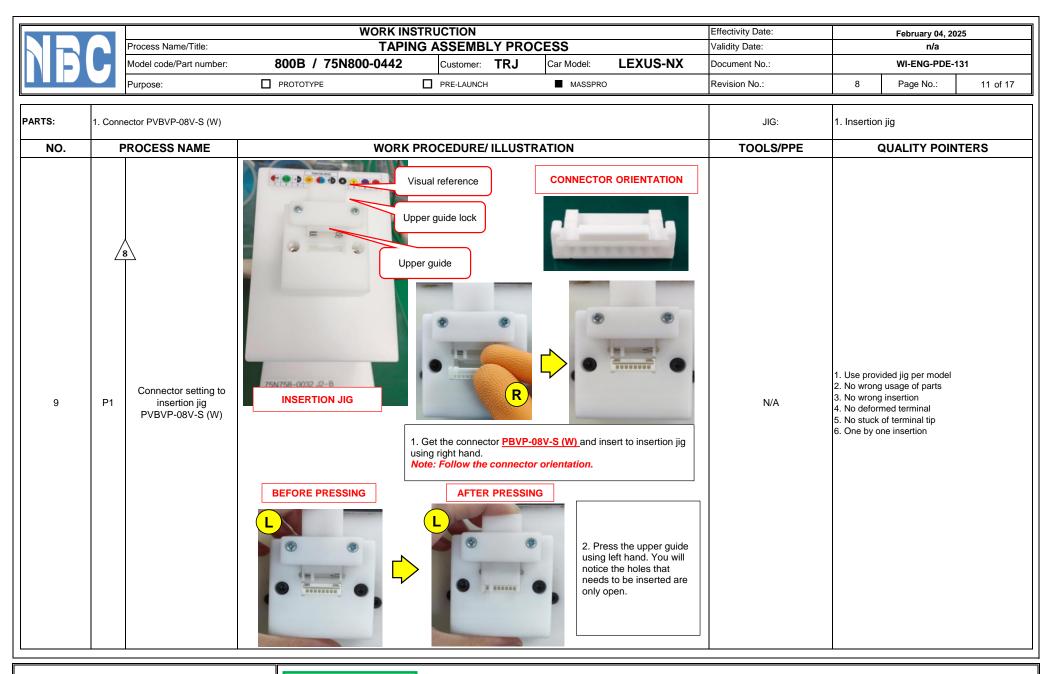
			WOR	K INSTRUCTION			Effectivity Date:	$\overline{}$	February 04, 202	E
		Process Name/Title:		APING ASSEMBLY PRO	CESS		Validity Date:	+	n/a	.5
		Model code/Part number:	800B / 75N800-04	Document No.:		WI-ENG-PDE-1	31			
		Purpose:	☐ PROTOTYPE	Customer: TRJ PRE-LAUNCH	■ MASSPRO	LEXUS-NX	Revision No.:	8	Page No.:	6 of 17
PARTS:	1. AVSS	6 0.3 G L=291±2mm; GR L=2	91±2mm; GR/B L=291±2mm; L L=29	1±2mm; P L=291±2mm; LG L=291±2	mm; Y L=291±2mm		JIG:	1. Insertion 2. Steering	, 0	
NO.	F	PROCESS NAME	WC	ORK PROCEDURE/ ILLUSTF	RATION		TOOLS/PPE	(QUALITY POIN	ΓERS
4	P1	Wire insertion to connector PBVP-12V-S (W) (Continuation)	GOOD Terminal condition Note: *Make sure the termina *Avoid hitting the termi	FRONT OF TERMINAL GOOD Terminal condition If was in proper alignment before inal into the connector during we tention of Immediate superior alignment in the superior and into the connector during we tention of Immediate superior and into the connector during we tention of Immediate superior and into the connector during we tention of Immediate superior and into the connector during we tention of Immediate superior and into the connector during we tention of Immediate superior and into the connector during we tention of Immediate superior and into the connector during we tention of Immediate superior and into the connector during we tention of Immediate superior and into the connector during we tention of Immediate superior and into the connector during we tention of Immediate superior and into the connector during we tention of Immediate superior and into the connector during we tention of Immediate superior and into the connector during we tention of Immediate superior and Immediate superior a	Damaged terminal NO G Terminal e insert. ire insertion, if en	countered abnorma	NT VIEW OF TERMINAL NO GOOD Terminal codition	2. No wrong 3. No wrong 4. No deforr 5. No stuck 6. One by o Import 1. Mainsert Push Do no 2. Ple termin 3. Aun replace encool diffict locke 4. Inst left to Docur 1. Refi Wire a 2. Refi Steeri proce 3. Refi Pull-P 4. Refi Inspec	ned terminal of terminal of terminal tip ne insertion retant reminders/Nuke sure wires are ted. Conduct <u>Pullial after insertion.</u> In exert extra force as a hold the wire to mail during insertion and during insertion and connector. In the sure wires are to mail force and terminal during insertion and connector. In the sure wires must be right. In the sure wires wires wire to WI-PRO-CNO and Strip Length. In the sure wires wire to WI-PRO-CNO and Strip Length. In the sure wires wire wires wire to WI-PRO-CNO and Strip Length. In the sure wires are the sure wires wire wires	properly Push-Pull- e. s near on. se and ninal, nd half- ust be from C-017 for Tolerance. E-044 for ntroller Y-029 for

				STRUCTION	0500		Effectivity Date:		February 04, 202	25
		Process Name/Title: Model code/Part number:	800B / 75N800-0442	NG ASSEMBLY PRO Customer: TRJ	Car Model:	LEXUS-NX	Validity Date: Document No.:		n/a WI-ENG-PDE-1	31
		Purpose:	□ PROTOTYPE	□ PRE-LAUNCH	■ MASSPRO		Revision No.:	8	Page No.:	7 of 17
PARTS:	1. Assy 2. Black	parts VM tube (Sunprene) Ø8.5 L:	/\				JIG:	Insertion Steering	n jig g navigator	
NO.	P	ROCESS NAME	^{∕8} \ WORK	PROCEDURE/ ILLUST	RATION		TOOLS/PPE		QUALITY POIN	TERS
5	P1	Wire insertion to Black VM tube (Sunprene) Ø8.5 L=123±3mm	1. Hold the wires using left hand, get the L=123±3mm using right hand then inser		2. Press the using right	e lower guide lock hand. Holes that need are only open.		2. No defor	Today day	
6		Wire insertion to Black VM tube (Sunprene) Ø8.5 L=123±3mm (Assy Parts)	Hold the Black VM tube (Sunpren hand and get the assy part then inseusing right hand.	ne) using left ert the wires		Connector facing and position of connector should be on the left side of harness.	n/a		g usage of parts med terminal	

			WORK IN	STRUCTION			Effectivity Date:		February 04, 202	25
		Process Name/Title:	TAPII	NG ASSEMBLY PRO	CESS		Validity Date:		n/a	
		Model code/Part number:	800B / 75N800-0442	Customer: TRJ	Car Model:	LEXUS-NX	Document No.:		WI-ENG-PDE-1	31
		Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO)	Revision No.:	8	Page No.:	8 of 17
PARTS:	1. Assy	parts PROCESS NAME	WORK	PROCEDURE/ ILLUSTI	RATION		JIG:	Insertior Steering		rers
7	P1	Wire insertion to connector PBVP-12V-S (W)	INSERTION SEQUENCE FROM INSERTION SEQUENCE FR	WIRE INSERTION ILLU 3 4 BR V L 11 160 160 291 and and support the wire by d. Repeat the process for R	JSTRATION GR/B GR 291 291 the left index fing BR-V-B wires	5 B G 160 291		2. No wron 3. No wron 4. No defo 5. No stuck 6. One by Importa 1. Make inserted Push aft Do not e 2. Please terminal 3. Auton replace bend ter and half 4. Insert left to rig Docum 1. Refer Wire and 2. Refer Steering procedu 3. Refer Pull-Pus 4 Refer	rmed terminal to of terminal tip one insertion Interminders/Note of terminders/Note of terminders/Note of terminders/Note of terminer of the wires are produced to the wires of the unit if once erminal, difficulty of the unit if once of the wires must of the wires must of the wires of the unit if once of the unit if one of the unit of t	e/s: coperly csh-Pull- ear and countered f insertion r. be from 117 for erance. 44 for coller 129 for

		1					1=	ı		1
				TRUCTION	0500		Effectivity Date:		February 04, 202	5
		Process Name/Title:		G ASSEMBLY PRO			Validity Date:		n/a	
		Model code/Part number:	800B / 75N800-0442	Customer: TRJ	Car Model:	LEXUS-NX	Document No.:		WI-ENG-PDE-13	31
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO		Revision No.:	8	Page No.:	9 of 17
PARTS:	1. Ass	y parts					JIG:	Insertion Steering		
NO.		PROCESS NAME	WORK F	PROCEDURE/ ILLUSTE	RATION		TOOLS/PPE		QUALITY POINT	
			Proper alignment of te	erminal to connector	Imprope	er alignment of tern	ninal to connector	2. No wrong 3. No wrong 4. No defor	med terminal	
	4	8		The same of the sa		34		6. One by o	of terminal tip one insertion rtant reminders/N	
		Wire insertion to	GOOD Terminal condition	FRONT OF TERMINAL GOOD Terminal condition	Damaged terminal	OF TERMINAL FR	NO GOOD Terminal codition	insert Push Do no 2. Ple termin 3. Aut replac enco diffict locked	ake sure wires are ted. Conduct <u>Pull-</u> after insertion. It exert extra force ase hold the wire that during insertic tomatically dispose the unit if once untered bend termulty of insertion and connector.	Push-Pull- e. s near on. se and ninal, nd half-
7	P1	connector PBVP-12V-S (W) (Continuation)	Note: *Make sure the terminal was in prop *Avoid hitting the terminal into the call the attention of Immediate supe	connector during wire ins	ertion, if encour		top the process and	left to	ertion of wires mu right. nent reference/s:	ust be from
			ha ur	Hold the wires using right and and then press the llock button using left umb.		© R	3. Gently pull out the connector from jig then check the terminal tip condition.	Wire a 2. Refe Steerii proced 3. Refe Pull-P 4. Refe Inspec	er to WI-PRO-CNC and Strip Length T er to WI-ENG-PDE ng Navigation Col dure er to GL-PRO-AS' ush procedure. er to GL-PRO-AS' ction Standard for actor insertion.	Folerance. E-044 for ntroller Y-029 for Y-025 for

				STRUCTION		Effectivity Date:		February 04, 202	25
		Process Name/Title:		NG ASSEMBLY PRO		Validity Date:		n/a	
		Model code/Part number:	800B / 75N800-0442	Customer: TRJ	Car Model: LEXUS-N	Document No.:		WI-ENG-PDE-1	31
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	■ MASSPRO	Revision No.:	8	Page No.:	10 of 17
PARTS:	1. Black	VM tube (Sunprene) Ø6 L=1	20±3mm			JIG:	n/a		
NO.	F	PROCESS NAME	WORK	PROCEDURE/ ILLUST	RATION	TOOLS/PPE		QUALITY POIN	TERS
8	P1	Wire insertion to Black VM tube (Sunprene) Ø6 L=120±3mm	2. After insertion, check the terr	minal appearance and then	1. Get the Black VM (Sunprene) Ø6 L=120±3mm using righand then insert the vusing left hand. R set aside the assy parts.		1. Wir other.	g usage of parts	

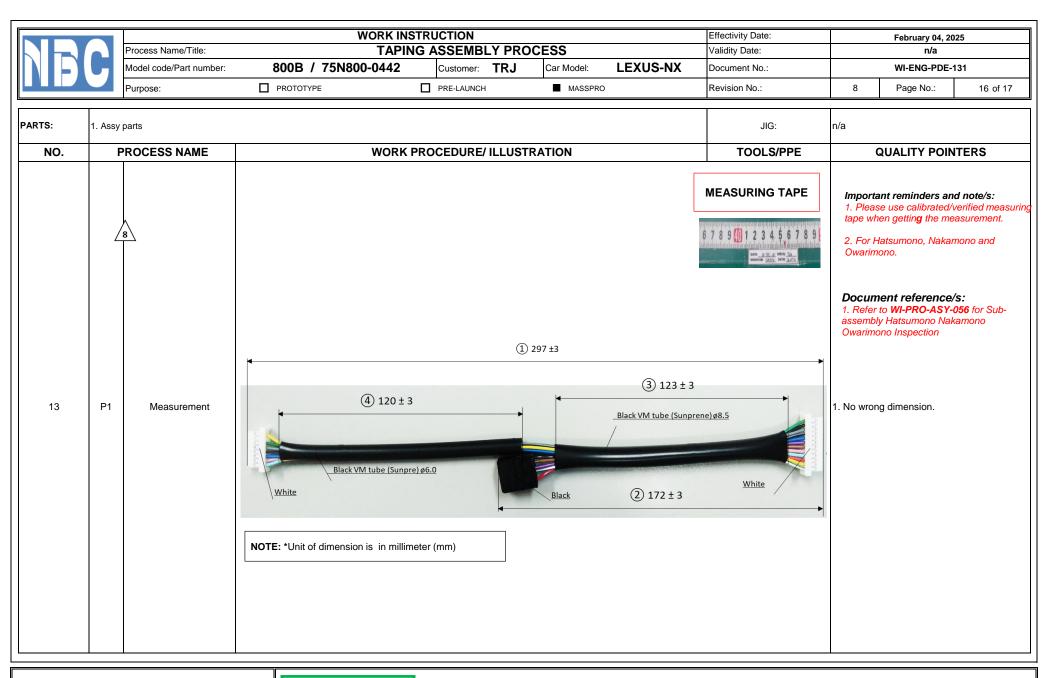


			WORK IN	STRUCTION			Effectivity Date:		February 04, 202	25
		Process Name/Title:	TAPIN	NG ASSEMBLY PRO	CESS		Validity Date:		n/a	
		Model code/Part number:	800B / 75N800-0442	Customer: TRJ	Car Model:	LEXUS-NX	Document No.:		WI-ENG-PDE-1	31
		Purpose:	PROTOTYPE	PRE-LAUNCH	■ MASSPRO)	Revision No.:	8	Page No.:	12 of 17
PARTS:	1. Assy	parts					JIG:	1. Insertion	n jig	
NO.	F	PROCESS NAME	WORK	PROCEDURE/ ILLUST	RATION		TOOLS/PPE	(QUALITY POIN	TERS
10	P1		INSERTION SEQUENCE FROM	LEFT TO RIGHT WIR 3 4 G GR G 291 291 291 3	WIRE RE INSERTION IL S 6 GR/B L 291 291 eft index the	FACING LUSTRATION T 10 P LG 291 291	N/A	1. Use pro 2. No wror 3. No wror 4. No defo 5. No stuc 6. One by Importa 1. Make inserted Push afi Do not e 2. Pleas terminal 3. Autor replace bend ter and half 4. Insert left to rig Docum 1. Refer Wire and 2. Refer Steering procedu 3. Refer Pull-Pus 4 Refe	wided jig per mode ng usage of parts ng insertion numed terminal k of terminal tip one insertion ant reminders/Note e sure wires are pr l. Conduct Pull-Pu ter insertion. exert extra force. e hold the wires n d during insertion. natically dispose the unit if once er rminal, difficulty o f-locked connecto ion of wires must ght. nent reference/s: to WI-PRO-CNC-C d Strip Length Tol to WI-ENG-PDE-O g Navigation Contaire. et o GL-PRO-ASY-C sh procedure. er to GL-PRO-ASY-C sh procedure.	e/s: coperly sh-Pull- ear and countered f insertion r. be from 117 for erance. 44 for coller 129 for

			WORK IN	STRUCTION		Effectivity Date:	T	
		Process Name/Title:	TAPIN	Validity Date:	February 04, 20:	25		
		Model code/Part number:	800B / 75N800-0442	Customer: TRJ	Car Model: LEXUS-NX	Document No.:	WI-ENG-PDE-1	31
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	8 Page No.:	13 of 17
PARTS:	1. Ass	/ parts				JIG:	1. Insertion jig	
NO.		PROCESS NAME	WORK	PROCEDURE/ ILLUSTF	RATION	TOOLS/PPE	QUALITY POIN	
			Proper alignment of to	erminal to connector	Improper alignment of terr	minal to connector	Use provided jig per mode No wrong usage of parts No wrong insertion No deformed terminal	I
		8		The			5. No stuck of terminal tip6. One by one insertion	
10	P1	Wire insertion to connector PBVP-08V-S (W) (Continuation)	BACK VIEW OF TERMINAL GOOD Terminal condition Note: *Make sure the terminal was in pro *Avoid hitting the terminal into the call the attention of Immediate sup	connector during wire ins	Damaged terminal NO GOOD Terminal condition Part. Section, if encountered abnormality	NO GOOD Terminal codition	Important reminders/l 1. Make sure wires an inserted. Conduct Pul. Push after insertion. Do not exert extra force. Please hold the wire terminal during insertions. Automatically dispose replace the unit if once encountered bend tendifficulty of insertion a locked connector. 4. Insertion of wires muleft to right. Document reference/s:	e properly -Push-Pull- ee. es near on. es and e minal, and half- ust be from
			L 2 h u	. Hold the wires using right and and then press the nlock button using left numb.	R	3. Gently pull out the connector from jig then check the terminal tip condition.	1. Refer to WI-PRO-CN Wire and Strip Length 2. Refer to WI-ENG-PD Steering Navigation Coprocedure 3. Refer to GL-PRO-AS Pull-Push procedure. 4. Refer to GL-PRO-AS Inspection Standard for connector insertion.	C-017 for Tolerance. E-044 for ontroller Y-029 for Y-025 for

			WORK IN	STRUCTION		Effectivity Date:		February 04, 20	25	
		Process Name/Title:	TAPII	NG ASSEMBLY PRO	CESS		Validity Date:		n/a	
		Model code/Part number:	800B / 75N800-0442	Customer: TRJ	Car Model:	LEXUS-NX	Document No.:		WI-ENG-PDE-1	31
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	■ MASSPRO)	Revision No.:	8	Page No.:	14 of 17
PARTS:	1. Assy	parts					JIG:	n/a		
NO.	F	ROCESS NAME	WORK	PROCEDURE/ ILLUST	RATION		TOOLS/PPE	(QUALITY POIN	TERS
11	P1	Wire arrangement	Terminal tip is visible Terminal tip is not visible	CORRECT FACING Double lock upward WRONG FACING	Termin	Hold the harness ng both hands and nduct the correct cing. The property of th	n/a			

			WORK INSTR	RUCTION			Effectivity Date:	T	February 04, 202	5
	AL	Process Name/Title:		ASSEMBLY PRO	CESS		Validity Date:		n/a	-
		Model code/Part number:	800B / 75N800-0442	Customer: TRJ	Car Model:	LEXUS-NX	Document No.:		WI-ENG-PDE-13	11
		Purpose:	☐ PROTOTYPE ☐	PRE-LAUNCH	MASSPRO		Revision No.:	8	Page No.:	15 of 17
PARTS:	1. Assy	parst					JIG:	n/a		
NO.	F	PROCESS NAME	WORK PR	OCEDURE/ ILLUSTR	RATION		TOOLS/PPE		QUALITY POINT	ERS
			Check the connector lock, locking of connector is included in Steering electrical test.	2. Check the wire align no tangled wires.	nment. Make sure	(not fully inserte	minal if with backing out d) or deformed terminal.		MASTER SAN	PLE
12	P1	Visual/By Two's Inspection	Black VM tube (Sunprene)			Black VIVI to	De (Outriprono)	Document reference/s: 1. Refer to WI-QAD-QAC-252 Steering Electrical Test 1. No wrong facing of harness		
		·	Check the orientation of harness.	5. Compare to Master	sample by tapping			2. No Tang 3. No miss	gled wires sing parts	
			LINE 3.1		Master sa					



	WORK INSTRUCTION					Effectivity Date: February 04, 2025			
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	Model code/Part number:	800B / 75N800-0442	Customer: TRJ	Car Model:	LEXUS-NX	Document No.:	WI-ENG-PDE-131		
	Purpose:	☐ PROTOTYPE	PRE-LAUNCH	MASSPRO		Revision No.:	8	Page No.:	17 of 17
PARTS: 1. Ass	/ parts					JIG:	n/a		
VISUAL INSPECTION/ QUALITY CHECKPOINTS									
75N800-0442									
1. Check the connector lock, should be unlock. Black VM tube (Sunprene) Cood FACING Cood FACI									