



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

September 13, 2024

Model code/Part number:

922B / 7L0123-7022A

Customer:

TRQSS

Car Model:

LEXUS-NX

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

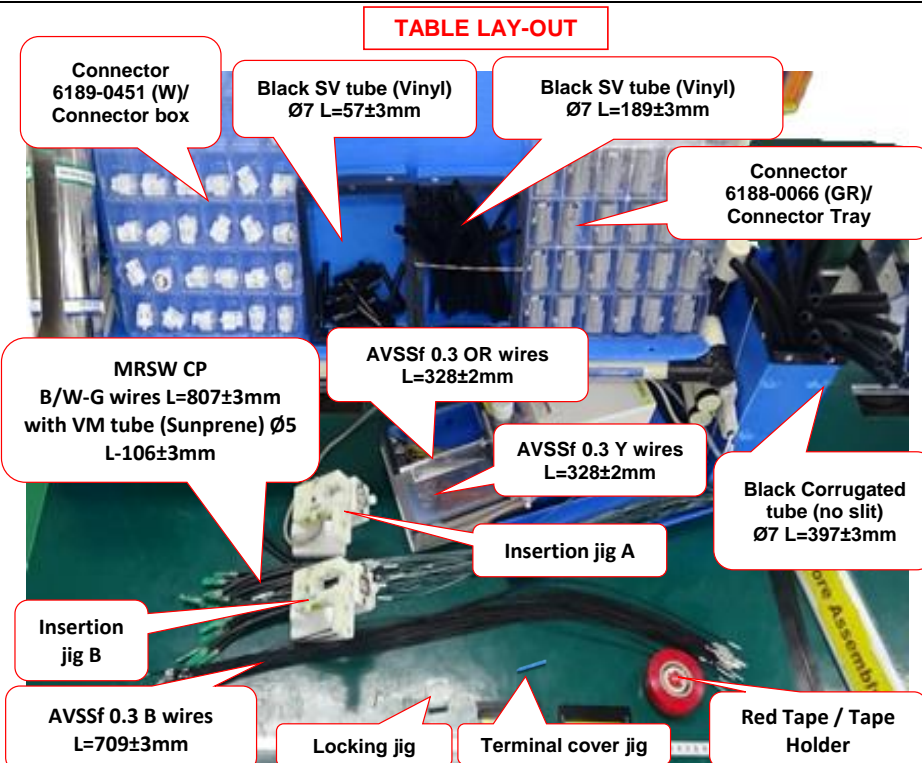
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PARTS:		1. Connector 6189-0451 (W); Black SV tube (vinyl) Ø7 L=57±3mm; AVSSf 0.3 Y-OR wires L=328±2mm; MRSW CP (B/W-G wires L=807±3mm w/ Black VM tube (Sunprene) Ø5 L=106±3mm); AVSSf 0.3 B wires L=709±3mm; Black SV tube Ø7 L=189±3mm; Connector 6188-0066(GR); Black Corrugated tube (no slit) Ø7 L=397±3mm; Red tape		JIG:	1. Insertion jig with switch cover 2. Insertion jig 3. Locking jig 4. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1			Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to WI-PRO-KIT-006 Rev.7 Wire Taping 1. No missing parts/tools 2. No excess parts/tools 3. No wrong position of parts/tools
Revision History				Prepared by	Reviewed by
09/13/24	1	Change pre launch to mass pro.		A. Hernandez	C. Villanueva
09/10/24	0	Initial issue. Additional Spot taping process; Transfer process 8 and 10 from P2 due to process improvement. Aligned switch cover to insertion jig. Improved Table lay-out and Visual inspection.		A. Hernandez	C. Villanueva
Eff. Date	Rev. No	Details of Change		Revised	Reviewed
				Approved	Noted
				Est. Date:	September 10, 2024

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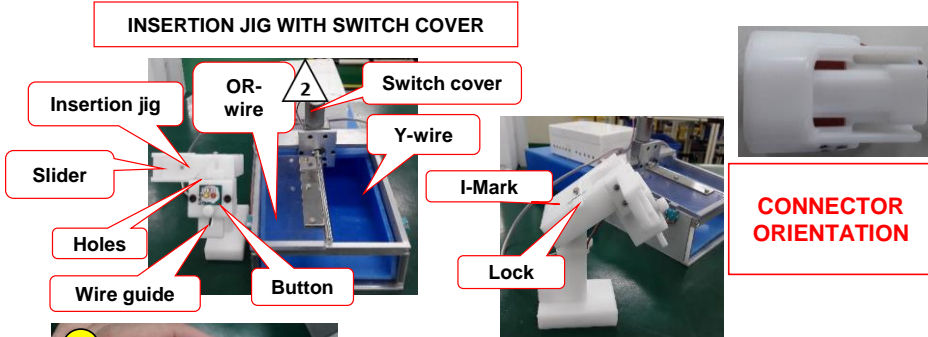
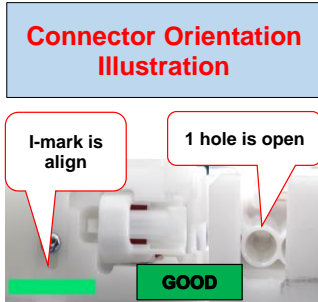

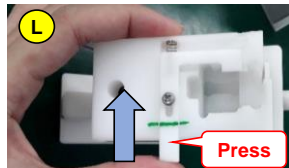
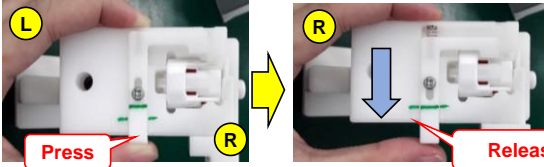
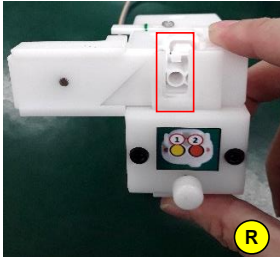
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PARTS:	1. Connector 6189-0451 (W)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Connector setting to insertion jig 6189-0451 (W)	<div><div>INSERTION JIG WITH SWITCH COVER</div><div></div><div></div><div><div>INSERTION JIG ORIENTATION</div><div></div></div><div><div>1. Press the lock of insertion jig using left thumb.</div><div></div></div><div><div>2. Insert the connector 6189-0451 (W) into jig using right hand then release the lock using left thumb. Note: Follow the connector orientation.</div><div></div></div><div><div>3. Push the guide using right hand. The slot for Yellow wire will be opened.</div><div></div></div></div> <div>n/a</div> <div><div>Connector Orientation Illustration</div><div>I-mark is align1 hole is openGOOD</div><div>I-mark is NOT align1 hole is openNG</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></div>		

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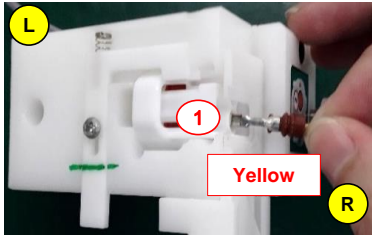
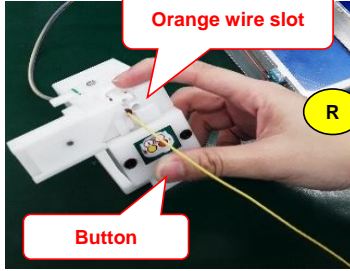
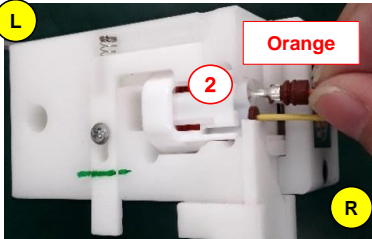
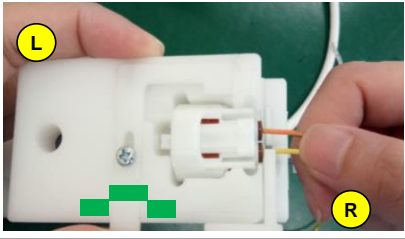
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PARTS:		1. AVSSf 0.3 Y wire L=328±2mm 2. AVSSf 0.3 OR wire L=328±2mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1	Wire insertion to connector 6189-0451 (W)	<div><p>WIRE FACING</p></div> <div><p>1. Hold the insertion jig using left hand, get Yellow wire and insert to connector slot 1 using right hand.</p></div> <div><p>2. Press the button using right thumb, slot for Orange wire will be opened.</p></div> <div><p>3. Hold the insertion jig using left hand, get Orange wire and insert to connector slot 2 using right hand.</p></div> <div><p>4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div>	n/a	<p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Please hold the wire near terminal.2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.3. Insertion of wires must be from left to right <p>Document references:</p> <ol style="list-style-type: none">1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance <ol style="list-style-type: none">1. No loose insertion2. No wrong insertion3. One by one insertion4. No deform terminal5. No wrong wire facing

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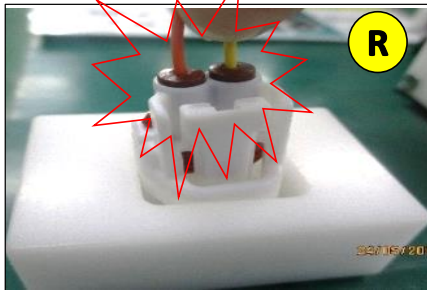




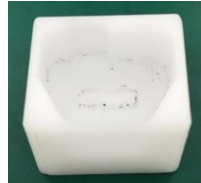
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PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1 Connector Lock	<div></div> <div><p>1. Put the connector into locking jig using right hand then press 2x to lock. Touch the connector lock to confirm if properly pressed.</p></div> <div><div><p>GOOD</p></div><div><p>NG</p></div></div> <div><p>2. Check the double lock deformation</p></div>	<div><p>BEFOREPRESSING</p></div> <div><p>AFTER PRESSING</p></div> <div><p>LOCKING JIG</p></div>	<p>1. No Unlock and half-locked 2. Use provided jig tools per model to avoid damaged lock.</p> <p>Important reminders/Note/s: 1. Manual locking may cause damaged connector</p>

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PARTS:		1. Assy parts 2. Black SV tube (Vinyl) Ø7 L=57±3mm	3. Black SV tube (Vinyl) Ø7 L=189±3mm	JIG:	1.Terminal cover jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1	Wire insertion to Black SV tube (Vinyl) Ø7 L=57±3mm and Black SV tube (Vinyl) Ø7 L=189±3mm	<div><div>1. Get the cover jig then insert to Y-OR wires using right hand.</div></div> <div><div>2. Get the SV tube (Vinyl) Ø7 L=57±3mm using right hand then insert the Y-OR wires using left hand.</div></div> <div><div>3. Get the SV tube (Vinyl) Ø7 L=189±3mm using right hand then insert the Y-OR wires using left hand.</div></div> <div><div>4. After insertion, remove the cover jig using right hand.</div></div>		<div>TERMINAL COVER JIG</div> 	1. No wrong usage of parts 2. No damaged rubber seal

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PARTS:		1. Connector 6188-0066 (GR)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1 Connector setting to insertion jig 6188-0066 (GR)	<div><div>INSERTION JIG FOR Y/OR</div><div>Wire guide</div><div>Holes</div><div>Visual Reference</div><div>Wire guide</div><div>Button</div></div> <div><div>INSERTION JIG</div><div>I-</div><div>Lock</div><div>CONNECTOR ORIENTATION</div></div> <div><div>L</div><div>Press</div><div>1. Press the lock of insertion jig using left thumb.</div></div> <div><div>L</div><div>Pres</div><div>2. Insert the connector 6188-0066 (GR) into jig using right hand then release the lock. Note: Follow the connector orientation.</div></div> <div><div>L</div><div>Releas</div><div>3. Push the guide using right thumb. The slot for Y wire will be opened.</div></div> <div><div>R</div></div> <div><div>R</div></div>		n/a	<div>Connector Orientation Illustration</div> <div><div>I-mark is</div><div>1 hole is open</div><div>GOOD</div></div> <div><div>I-mark is NOT align</div><div>2 holes are</div><div>NG</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>

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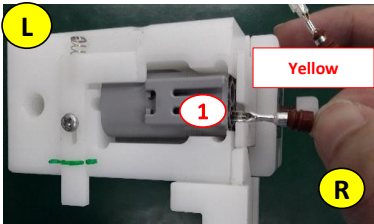
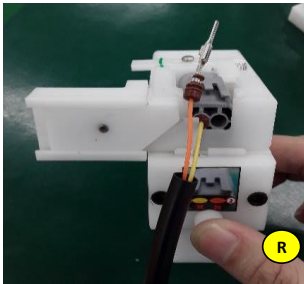
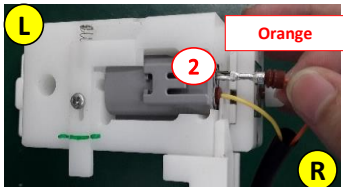
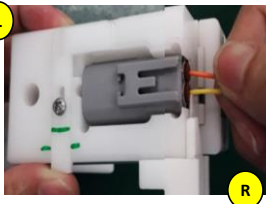

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PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1	<div><div>WIRE FACING</div></div> <div><div>1. Hold the insertion jig using left hand. Get the assy parts, insert the Yellow wire to connector slot 1 using right hand.</div></div> <div><div>2. Press the button using right thumb, slot for Orange wire will be opened.</div></div> <div><div>3. Get Orange wire then insert to connector slot 2 using right hand.</div></div> <div><div>4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</div></div> <div><div>Note: Set aside the assy part</div></div>		n/a	<p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Please hold the wire near terminal.2. Make sure wires are properly inserted.Conduct Pull-Push-Pull-Push after insertion.Do not exert extra force.3. Insertion of wires must be from left to right <p>Document references:</p> <ol style="list-style-type: none">1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance <ol style="list-style-type: none">1. No loose insertion2. No wrong insertion3. One by one insertion4. No deform terminal5. No wrong wire facing

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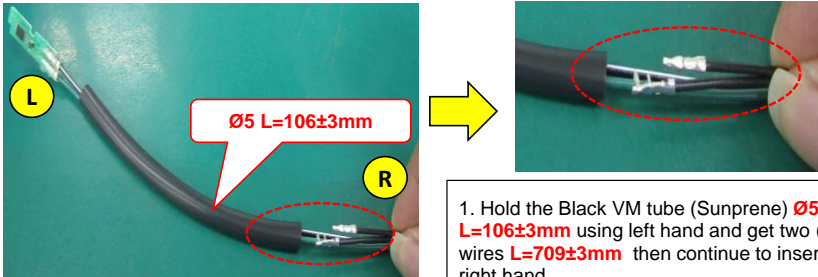
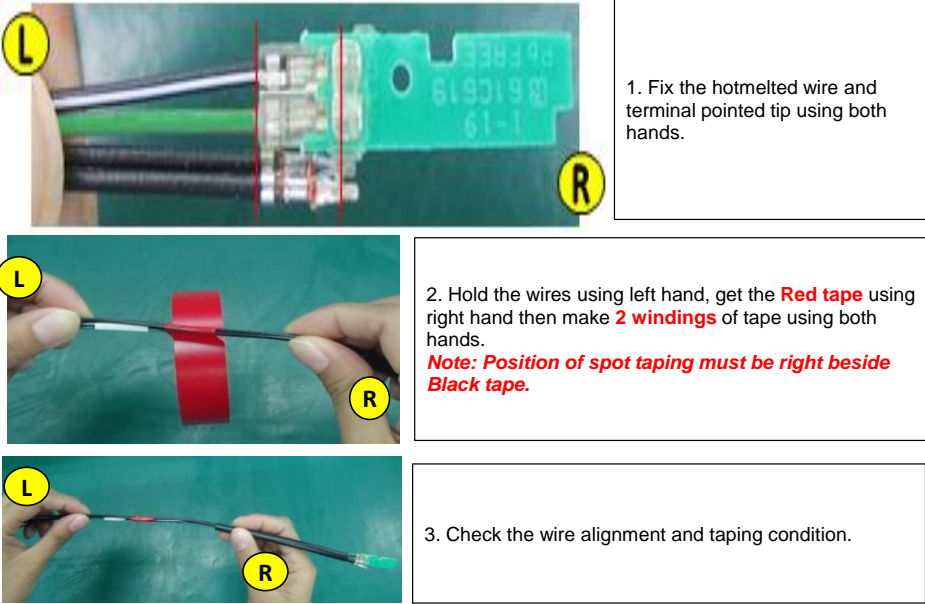
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PARTS:		1. AVSSf 0.3 B wires L=709±3mm [2pcs] 2. MRSW CP B/W-G wires L=807±3mm with Black VM tube (Sunprene) Ø5 L=106±3mm 3. Red tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	Wire insertion to assy parts (Black VM tube (sunprene) Ø5 L=106±3mm)	 <p>1. Hold the Black VM tube (Sunprene) Ø5 L=106±3mm using left hand and get two (2) Black wires L=709±3mm then continue to insert using right hand.</p>		n/a	1. No wrong usage of parts 2. No wrong insertion
9	Spot taping	 <p>1. Fix the hotmelted wire and terminal pointed tip using both hands.</p> <p>2. Hold the wires using left hand, get the Red tape using right hand then make 2 windings of tape using both hands. Note: Position of spot taping must be right beside Black tape.</p> <p>3. Check the wire alignment and taping condition.</p>		n/a	1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape

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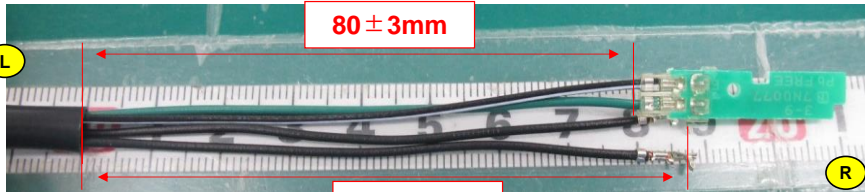
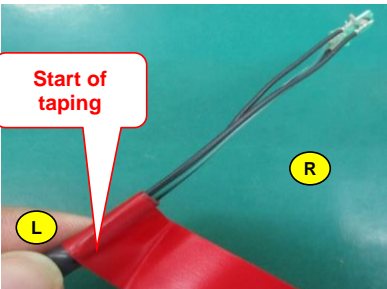
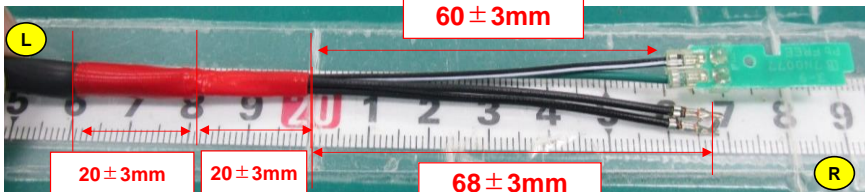

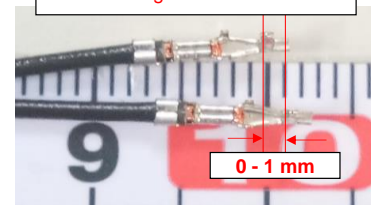
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PARTS:		1. Assy parts 2. Red Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	P1 Taping 1 Black VM tube (Sunprene) to wire near hotmelted wires and terminal pointed tip	 <p>1. Measure from end of sunprene tube up to edge of hotmelted wire 80±3mm and up to terminal pointed tip 88±3mm using both hands.</p>  <p>2. Get the Red tape using right hand then start taping process using both hands.</p>  <p>3. After taping, check the measurement and taping condition.</p>		<p>MEASURING TAPE</p> 	<p>1. No flip-out tape 2.No peel-off tape 3. No loose tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape</p> <p>Important reminders and Note/s: 1. Use BLUE TAPE only. 2. 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>Wire alignment tolerance</p> 

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PARTS:		1. Assy parts 2. Black Corrugated tube Ø7 L=397±3mm (no slit)		JIG:	1.Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1 Wire insertion to Black corrugated tube Ø7 L=397±3mm (no slit)	<div></div> <div>1. Get the cover jig then insert to G-B/W wires using right hand.</div> <div></div> <div>2. Get the corrugated tube Ø7 L=397±3mm (no slit) using right hand then insert the B-G-B/W wires using left hand.</div>		<div>TERMINAL COVER JIG</div> <div></div>	1. No wrong usage of parts 2. No damaged rubber seal

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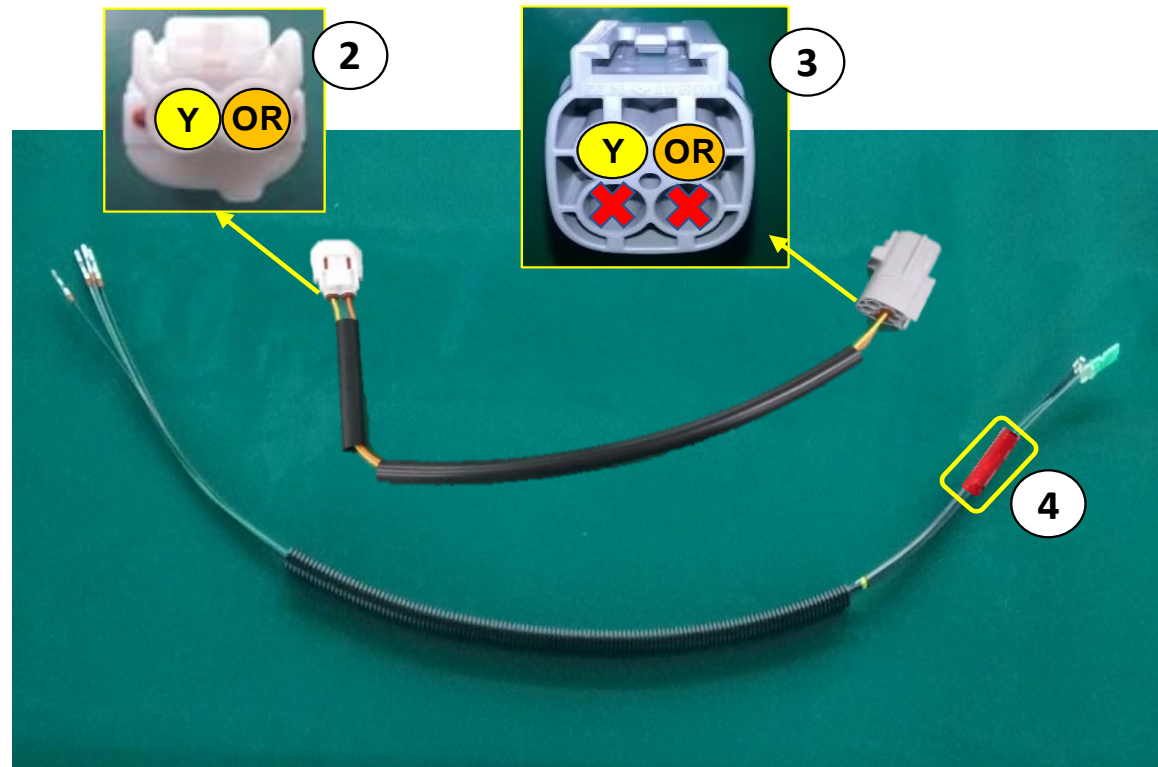
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PARTS:

1. Assy part

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P1****7L0123-7022A**

1 **No Unlocked /Half-locked Connector**

2 3 **No Wrong Insert**

4 **No Missing Tape/
No Wrong used of tape
(Red tape)**

5 **No Deformed Terminal**

6 **No Terminal Backing out**

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