				STRUCTION					Effec	tivity Date:		September 4, 20)24
		Process Name/Title:	TAPIN	NG ASSEMBL	Y PROCI	ESS			Valid	ity Date:		n/a	
		Model code/Part number:	241B / 7L0049-7023	LEX	XUS ES	Docu	ment No.:		WI-ENG-PDE-42	22A			
		Purpose:	PROTOTYPE	PRE-LAUNCH		MASSP	RO		Revis	sion No.:	2	Page No.:	1 of 12
PARTS:	tube (S tube (n	Sunprene) Ø5 L=106±3mm) o slit) Ø7 L=158±3mm; Co	9-1161 (B); AVSSf 0.3 wires Y-OR L=38; Black Corrugated tube (no slit) Ø7 L=4 rrugated tube (no slit) Ø7 L=312±3mm; I	9±3mm; Corrugate Black tape	ed tube (no s	slit) Ø7 L=12				JIG:	2. Locking 3. Termina	l cover jig	
NO.	F	PROCESS NAME	<u>∕3\</u> WORK	PROCEDURE/	ILLUSTRA	TION				TOOLS/PPE		QUALITY POIN	TERS
1	P1	Table Lay-out	Insertion jig B Insertion jig C	AVSSf 0.3 wires OR L=380±2mm	(no slit)	97 L=	(B)	er/Black	pr (Bafety Instruction Be sure to wear required persona ottective equipmeduring operation gloves, finger cotetion etc.) Housekeeping Maintain and alw practice 5's. Personal things the workplace is rohibited. Keep it your locker. Alert level or any trouble, information or Line adsertion or Line adder for immedia corrective action	Docum 1. Referand Str 2. Referand Str 2. Referand Str 2. No excellent in Document in Docum	ent reference/s: r to WI-PRO-CNC- ip Length Toleral r to WI-PRO-KIT-C with Vinyl Tube ing parts/tools ss parts/tools	nce 1006 for Wire
			Revision history							Prepared by	Reviewed by	Approved by	Noted by
09/04/24 2	Transfer Visual in	some process to P2 due to processpection/Quality checkpoints. Ali	cess improvement. Inclusion of car model "LEXU igned switch cover to insertion jig	JS ES". Improved Tabl	le lay-out and	D. Castillo	C. Villanueva	A. Arañes	n/a				
12/16/22 1	Improve	quality pointers: Reminders/note	es and references. Inclusion of Quality checkpoir	nts		M. Catapang	J. Loterte	villanueva	A. Arañes	O +110	1/1 .11	Alas	
03/04/22 0	Initial iss	sue				Catapang	J. Loterte	C. Villanueva	A. Arañes	D. Castillo	() Villanueva	A. Arañes	n/a
Eff. Date Rev. No			Details of Change			Revised	Reviewed	Approved	Noted -	Est. Date:	March 04, 2022		



	_		WORK INS	STRUCTION			Effectivity Date:		September 4, 20	24
		Process Name/Title:		NG ASSEMBLY PROC	ESS		Validity Date:		n/a	
		Model code/Part number:	241B / 7L0049-7023	Customer: TRQSS	LEXUS ES	Document No.:		WI-ENG-PDE-42	2A	
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO		Revision No.:	2	Page No.:	2 of 12
PARTS:	1. Coni	nector 6188-0066 (GR)					JIG:	1. Insertior	n jig with switch cov	ver
NO.	F	PROCESS NAME	WORK I	PROCEDURE/ ILLUSTRA	TION		TOOLS/PPE	(QUALITY POINT	TERS
2	P1	Connector setting to Insertion jig 6188-0066 (GR)	Orange wire Visual reference Press R 1. Press the lock using left hand.	Yellow wire	Connector Instance Orio Orio	orientation ertion jig ientation Release R gright hand and insertion.	N/A	I-m. not 1. Use the 2. No wron 3. No wron	CONNECTOR ORIENT ILLUSTRATION 1 ho	are open odel onector



	_		WORK INS	TRUCTION				Effectivity Date:	1	September 4, 20	124
	AL	Process Name/Title:			Y PROCESS			Validity Date:		n/a	
		Model code/Part number:	241B / 7L0049-7023	Customer:	LEXUS ES	Document No.:		WI-ENG-PDE-42	2A		
		Purpose:	PROTOTYPE	PRE-LAUNCH	M	ASSPRO		Revision No.:	2	Page No.:	3 of 12
PARTS:	1. AVS	Sf 0.3 wires Y-OR L=380±	2mm					JIG:	1. Insertion	n jig with switch co	ver
NO.	F	PROCESS NAME	WORK F	ROCEDURE/	ILLUSTRATION			TOOLS/PPE	(QUALITY POIN	TERS
3	P1	Wire Insertion to connector 6188-0066 (GR)	1. Hold the insertion jig using left hand. 1. Hold the insertion jig using left hand. Get the Yellow wire and insert to connector using right hand. 2. Orange wire and insert to connector using right hand.			ss ush the Id the wi	lock using left ires and gently	N/A	3. One by 4. No defo 5. No wro Import 1. Plea 2. Mak inserte Condu inserti Do not Docum 1. Refe Pull-P 2. Refe	ng insertion one insertion rm terminal ng wire facing tant reminders/No use hold the wire to e sure wires are ed. uct Pull-Push-Pull-	near terminal. properly -Push after



			WORK INST	RUCTION			Effectivity Date:		September 4, 20	024
		Process Name/Title:	TAPING	ASSEMBLY I	PROCESS		Validity Date:		n/a	
		Model code/Part number:	241B / 7L0049-7023	Customer: TF	LEXUS ES	Document No.:		WI-ENG-PDE-42	22A	
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO)	Revision No.:	2	Page No.:	4 of 12
PARTS:	1. Black 2. Black	Corrugated tube (no slit) of Corrugated tube (no slit) of Corrugated tube (no slit)	ø7 L=49±3mm ø7 L=122±3mm	3. Black Corrug 4. Assy parts	ated tube (no slit) ø7 L	=158±3mm	JIG:	n/a		
NO.	F	ROCESS NAME	WORK PR	ROCEDURE/ ILL	USTRATION		TOOLS/PPE	(QUALITY POIN	TERS
4	P1	Wire insertion to COT (no slit) Ø7 L= 49±3mm Ø7 L= 122±3mm Ø7 L= 158±3m	1. Hold the wires using left hand. Get the Corrugated tube (no slit) Ø7 L= 49±3mm using right hand and insert the wires. COT (no slit) Ø7 L=49±3mm COT (no slit) Ø7 L=49±3mm	3. Hold the Corrugate right hand	2. Hold the wires usince Corrugated tube (no susing right hand and in the wires using left handed tube (no slit) Ø7 Left and insert the wires.	d. Get the 158±3mm using	N/A		ng use of parts rmed terminal	



			WORK IN	STRUCTION			Effectivity Date:	T	September 4, 2	024
		Process Name/Title:	TAPIN	IG ASSEMBL	LY PROCESS		Validity Date:		n/a	
		Model code/Part number:	241B / 7L0049-7023	Customer:	TRQSS Car Model:	LEXUS ES	Document No.:		WI-ENG-PDE-4	22A
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO		Revision No.:	2	Page No.:	5 of 12
PARTS:	1. Coni	nector 6189-1161 (B)					JIG:	1. Insertion	n jig	
NO.	F	PROCESS NAME	WORK	PROCEDURE/	ILLUSTRATION		TOOLS/PPE		QUALITY POIN	TERS
5	P1	Connector setting to insertion jig 6189-1161 (B)	Visual reference	Hole Lock Button INSE 2. Get the conninsert to insert to insertio Note: Follow the lock 3. Push the lock	rk	Release right hand and rinsertion.	N/A	1. Use the 2. No wror 3. No wror	GOOD	e is open e is open model ennector



	_		WORK INST	RUCTION			Effectivity Date:	$\overline{}$	September 4, 20	024
		Process Name/Title:		G ASSEMBLY PI	ROCESS		Validity Date:		n/a	
		Model code/Part number:	241B / 7L0049-7023	Customer: TRO	LEXUS ES	Document No.:		WI-ENG-PDE-42	22A	
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	0	Revision No.:	2	Page No.:	6 of 12
PARTS:	1. Blac 2. Assy						JIG:	1. Insertior	n Jig	
NO.	F	PROCESS NAME	WORK PI	ROCEDURE/ ILLU	STRATION		TOOLS/PPE	(QUALITY POIN	TERS
6	P1	Wire Insertion to Connector 6189-1161 (B)	1. Hold the insertion jig using left hand. the Yellow wire and insert to connector using right hand. 2 Orange wire 3. Get the Orange wire and insert to connector using right hand.	Get 2. P Oral 4. After in and then	nge wire will be oper	ck using left thumb	N/A	3. One by 4. No defo 5. No wron Importa. 1. Pleas termina. 2. Make properly Conduc after ins Do not e	ng insertion one insertion orm terminal ng wire facing out reminders/Note the hold the wire no sure wires are y inserted. tt Pull-Push-Pull-F	ear Push



			WORK INS	STRUCTION			Effectivity Date:		September 4, 20	024
		Process Name/Title:	TAPIN	IG ASSEMBLY F	PROCESS		Validity Date:		n/a	
		Model code/Part number:	241B / 7L0049-7023	LEXUS ES	Document No.:		WI-ENG-PDE-42	22A		
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO)	Revision No.:	2	Page No.:	7 of 12
PARTS:	1. Black 2. Assy						JIG:	1. Locking	jig	
NO.	Р	ROCESS NAME	WORK	PROCEDURE/ ILL	JSTRATION		TOOLS/PPE	(QUALITY POIN	TERS
7		Connector lock	1. Put the conn locking jig and jusing both hand connector lock locked. Before pressing After Pressing	push down 2x ds. Check the if properly	NG NC Unlock Condition Half Lo Conditi	xk Full tock Condition	LOCKING JIG	1. MAN CAUSE CONNE	ant reminders/No IUAL LOCKING M E DAMAGED ECTOR ck/half-locked con laged lock	AY
8	P1	Taping 1 COT to wire near connector	1. Hold the assy parts using left hand Black tape then conduct pre-taping using both hands. 25±3mm 20±3mm 0~5mm	from COT to Continue tap 3. Affand t	25±3mm assy parts using left have connector 25±3mm or connector 25±3mm or connector process using both the response of the process using both the response of the process using both the response of the process using both the process using the pr	using both hands. th hands.	MEASURING TAPE 6 7 8 9 10 1 2 3 4 5 6 7 8 9 1	1. Plea measu measu Docum 1. Refe taping 1. No flip- 2. No peel 3. No loos 4. No miss 5. No wror	-off tape e tape	/verified etting the

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			WORK INS	STRUCTION			Effectivity Date:		September 4, 202	24
		Process Name/Title:	TAPIN	IG ASSEMBLY PRO	CESS		Validity Date:		n/a	
		Model code/Part number:	241B / 7L0049-7023	Customer: TRQS	Car Model:	LEXUS ES	Document No.:		WI-ENG-PDE-422	2A
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPR	RO	Revision No.:	2	Page No.:	8 of 12
PARTS:	1. Black	Corrugated tube ø7 L=3° W CP (TVSSf 0.3 G-B/W I	12±3mm (no slit) _=679±3mm; Black VM tube (Sunprene)	Ø5 L=106±3mm) 3. A	ssy parts		JIG:	1. Termina	l cover jig	
NO.	F	ROCESS NAME	WORK	PROCEDURE/ ILLUST	RATION		TOOLS/PPE	(QUALITY POINT	ERS
9		Wire insertion to COT Ø7 L= 312±3mm (no slit)	1. Get the terminal cover jig u hand then insert to both terminal B/W wires using right hand.	inals G- L=312±3m	corrugated tube m (no slit) usir the G-B/W wire	ng right hand	TERMINAL COVER JIG		ng use of parts rmed terminal	
10	P1	Wire insertion to Assy	1. Hold the wires using right hand. COT (no slit) Ø7 L=49±3mm 3. Hold the corrugated tube Ø7 L=49±3mm using left hand then inser the G-B/W wires using right hand.	COT (no	R slit) Ø7 L=49±3 COT (no s	2. Get the assy parts using left hand, insert the wires in COT ø7 L=122mm using right hand. 4. After insertion, remove the cover jig using right hand.		No defor	ng use of parts rmed terminal insertion of parts	

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		WORK INSTRUCTION	Effectivity Date:	September 4, 2024
	Process Name/Title:	TAPING ASSEMBLY PROCESS	Validity Date:	n/a
	Model code/Part number:	241B / 7L0049-7023	Document No.:	WI-ENG-PDE-422A
	Purpose:	□ PROTOTYPE □ PRE-LAUNCH ■ MASSPRO	Revision No.:	2 Page No.: 9 of 12
1. Assy	parts		JIG:	1. Insertion jig
F	ROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
P1	Connector setting to insertion jig 6188-0066 (GR) (Assy parts)	Visual reference Button INSERTION JIG ORIENTATION INSERTION JIG ORIENTATION 1. Press the guide using right thumb. The slot for G wire will be opened. 2. Press the lock of insertion jig using left thumb. 3. Insert the connector 6188-	N/A	I-mark is align I-mark is NOT align 2 Holes are opened 1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector
	F	Model code/Part number: Purpose: 1. Assy parts PROCESS NAME Connector setting to insertion jig 6188-0066 (GR)	Process Name/Title: Model code/Part number: Purpose: Purpose: Process Name WORK PROCEDURE/ ILLUSTRATION INSERTION JIG WORK PROCEDURE/ ILLUSTRATION INSERTION JIG INSERTION JIG Connector setting to insertion jig 6188-0066 (GR) (Assy parts) 1. Press the guide using right thumb. The slot for G wire will be opened. 1. Press the guide using right thumb. The slot for G wire will be opened. 3. Insert the connector of 188-0066 (GR) with insertion jig using left thumb. 3. Insert the connector of 188-0066 (GR) with inserted Y-OR wire using right hand. More: Follow the connector orientation.	Process Name/Tife: TAPING ASSEMBLY PROCESS Validity Deter: Model code/Pern number: 241B / TL0049-7023 Customer: TRQSS Car Model: LEXUS ES Document No.:



	_		WORK INSTRUC	CTION	Effectivity Date:		September 4, 20	24
		Process Name/Title:		SSEMBLY PROCESS	Validity Date:		n/a	
		Model code/Part number:		Customer: TRQSS Car Model: LEXUS ES	Document No.:		WI-ENG-PDE-42	2A
		Purpose:	PROTOTYPE P	PRE-LAUNCH MASSPRO	Revision No.:	2	Page No.:	10 of 12
PARTS:	1. Assy	parts			JIG:	1. Insertion	jig	
NO.	F	ROCESS NAME	WORK PROC	EDURE/ ILLUSTRATION	TOOLS/PPE	(QUALITY POINT	ΓERS
12	P1	Wire insertion to connector 6188-0066 (GR) (Assy parts)	1. Hold the insertion jig using left hand, get Green wire then insert to connector slot 1 using right hand. 3. Hold the insertion jig using left hand, get Black/White wire then insert to connector slot 2 using right hand.	WIRE FACING 2. Press the button using right hand, slot for Black/White wire will be opened. 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.		4. No deformation of the second of the secon	g insertion one insertion on terminal ng wire facing ont reminders/Note of hold the wire ne sure wires are inserted.	ush

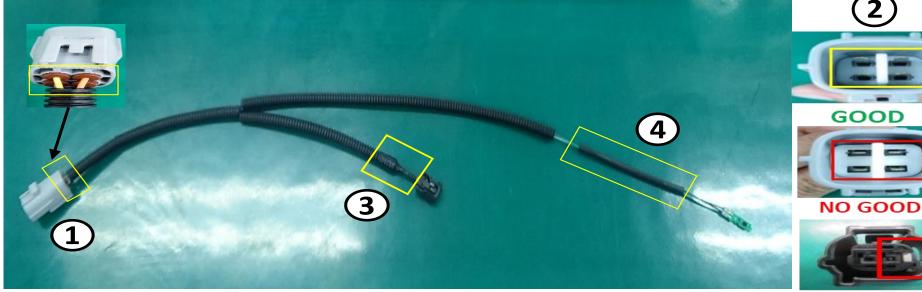


			WORK IN	STRUCTION				Effectivity Date:		September 4, 2	024
		Process Name/Title:	TAPIN	IG ASSEMB	LY PROC	ESS		Validity Date:		n/a	
		Model code/Part number:	241B / 7L0049-7023	Customer:	TRQSS	Car Model:	LEXUS ES	Document No.:		WI-ENG-PDE-4	22A
		Purpose:	PROTOTYPE	PRE-LAUNCH	ł	MASSPRO)	Revision No.:	2	Page No.:	11 of 12
PARTS:	1. Assy	parts						JIG:	1. Locking	Jig	
NO.	F	PROCESS NAME	WORK	PROCEDURE	/ ILLUSTR	ATION		TOOLS/PPE	(QUALITY POIN	TERS
13	P1	Connector lock	R R R R R R R R R R R R R R R R R R R	1. Put the then press locked.	connector into 2x. Touch the 2	to locking jig us he connector	DD	LOCKING JIG	Impoi 1. MA CAUS	provided locking j	lote/s: MAY DNNECTOR



			WORK I		Effectivity Date:	September 4, 2024				
		Process Name/Title:	TAP	ING ASSEMBLY	Y PROCESS		Validity Date:		n/a	
		Model code/Part number:	241B / 7L0049-7023	Customer:	TRQSS Car Model:	LEXUS ES	Document No.:		WI-ENG-PDE-4	22A
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	ı	Revision No.:	2	Page No.:	12 of 12
	1	•					1	1		
PARTS:	1. Assy	parts	٨				JIG:	n/a		
	I		<u></u>	ISUAL INSPECTI	ON/ QUALITY CHEC	KPOINTS	-			

7L0049-7023



- **3** No MISSING TAPE
- No MISSING VM TUBE 4 (SUNPRENE)



GOOD



GOOD

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2

No WRONG INSERT

No UNLOCKED/ HALF-

LOCKED CONNECTOR

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