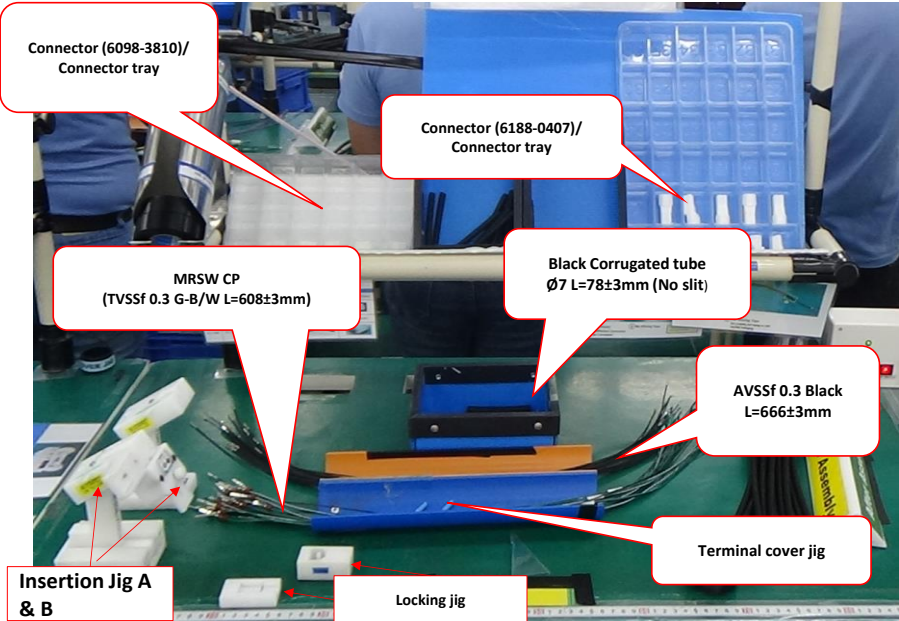
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	Process Name/Title: OFFLINE ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 800B / 7N0104-7020A		Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:	WI-ENG-PDE-808		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	1 of 10


PARTS:		1. All parts (Connector 6098-3810(W); Connector 6188-0407(W); MR SW CP(G,B/W L=608±3mm); Black Corrugated tube(no slit) Ø5 L=75±3mm and Ø7 L=78±3mm; AVSSf 0.3 B L=666±3mm;				JIG:		1. Insertion jig 2. Locking jig 3. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	n/a	<div style="text-align: center;"> TABLE LAY-OUT </div> 				<div style="border: 1px dashed red; padding: 5px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 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 dashed red; padding: 5px; margin-top: 10px;"> 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-071 Wire and Strip Length Tolerance 1. No missing parts/tools 2. No excess parts/tools 3. No wrong positions of parts/tools	




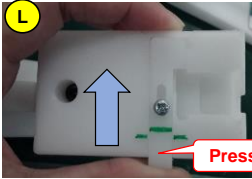
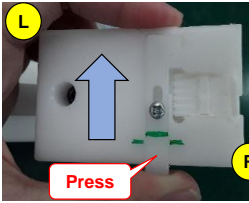
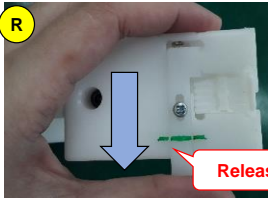
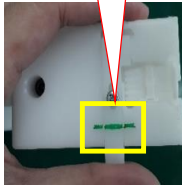
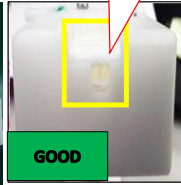
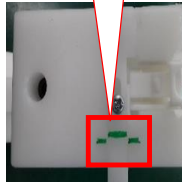
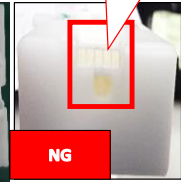
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06/1824	0	Initial issue.				D. Castillo	C. Villanueva	A. Arañes	n/a	n/a	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date: June 18, 2024	

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	Process Name/Title:			Model code/Part number:	800B / 7N0104-7020A	Customer:	TRJ	Car Model:	LEXUS-NX/RX	Document No.:	WI-ENG-PDE-808	
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PARTS:	1. Connector 6098-3810 (W)			JIG:	1.Insertion jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
2	n/a	<div><div><p>INSERTION JIG</p><p>Holes</p><p>Lock</p></div><div><p>INSERTION JIG ORIENTATION</p><p>I-MARK</p></div><div><p>CONNECTOR ORIENTATION</p></div></div> <div><div><p>L</p><p>Press</p></div><div><p>L</p><p>Press</p></div><div><p>R</p><p>Release</p></div></div> <div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the connector 6098-3810 (W) into jig using right hand and release the lock. <i>Note: Follow the connector orientation.</i></p><p>3. Check the holes/terminal slot for B-B wires.</p></div>			n/a	<div><div><p>I-mark was align</p></div><div><p>2 holes were only open</p><p>GOOD</p></div></div> <div><div><p>I-mark is NOT align</p></div><div><p>All holes were open</p><p>NG</p></div></div> <p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p>		

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800B / 7N0104-7020ACustomer: **TRJ**

Car Model:

LEXUS-NX/RX

Document No.:

WI-ENG-PDE-808

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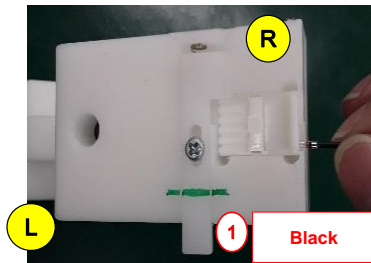
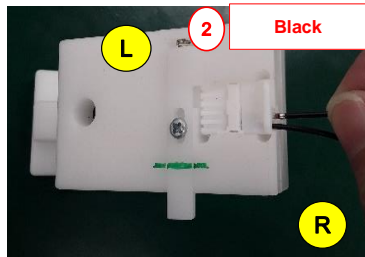
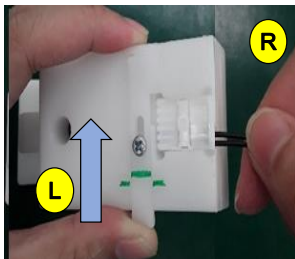
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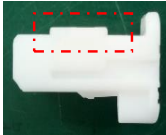

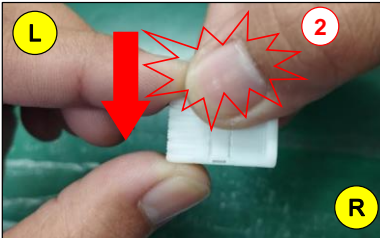
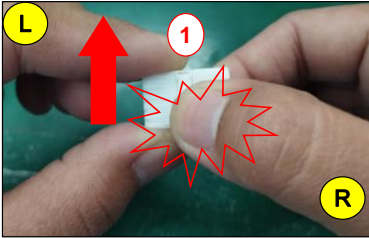

PARTS:	1. AVSSf 0.3 B L=666±3mm [2pcs.]		JIG:	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	n/a Wire insertion to connector 6098-3810 (W)	<div><div>WIRE FACING</div></div> <div></div> <div></div> <div><div>1. Get the 1st Black wire then insert to connector slot 1 using right hand.</div><div>2. Get the 2nd Black wire then insert to connector slot 2 using right hand.</div></div> <div><div>3. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</div></div>	n/a	<p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal during insertion. 2. Insertion of wire must be inserted. 3. Make sure wires are properly inserted. <u>Conduct Pull-Push-Pull-Push after insertion.</u> <u>Do not exert extra force.</u></p> <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>Document reference/s:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip lenght Tolerance 2. Please refer to GL-PRO-ASSY-029 for Pull-Push procedure.</p>

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	Process Name/Title:		Model code/Part number: 800B / 7N0104-7020A		Customer: TRJ	Car Model: LEXUS-NX/RX		Document No.:	WI-ENG-PDE-808		
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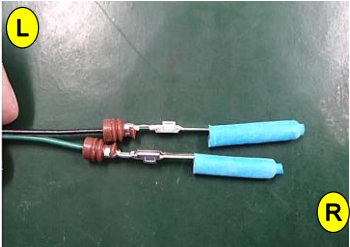



PARTS:	1. Assy parts			JIG:	1. Locking jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
4	n/a	Connector lock	<div><div>Before Pressing</div><div>After Pressing</div><div>1. Put the connector into locking jig using right hand then press to lock 2x.</div><div>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</div></div>			<div>LOCKING JIG</div> 	Important reminders/Note/s: 1. Manual locking may cause damaged connector lock 1. Use provided jig tools per model 2. No unlock/ half-locked connector.

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	Process Name/Title: OFFLINE ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 800B / 7N0104-7020A		Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:	WI-ENG-PDE-808	
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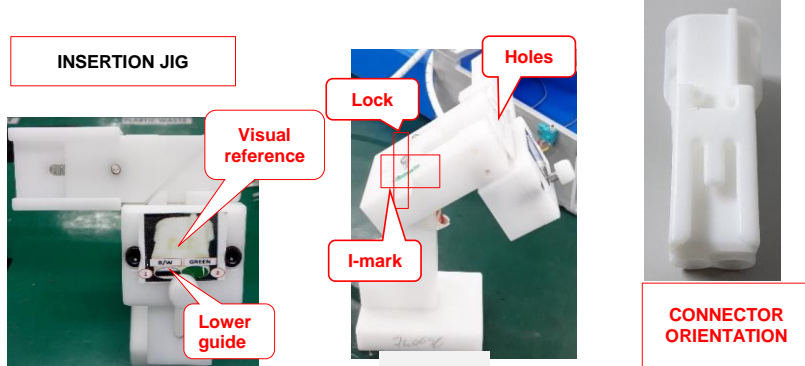
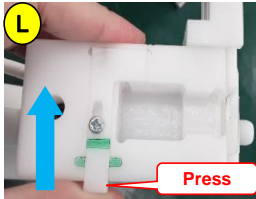
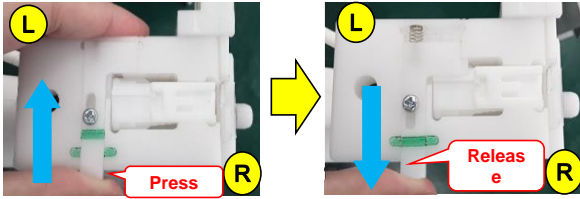
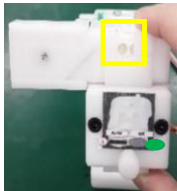


PARTS:	1. MRSW CP TVSSf 0.3 G-B/W L=608±3mm 2. Black Corrugated tube Ø7 L=78±3mm (no slit)			JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	n/a	<div><div><p>1. Get the terminal cover jig using right hand then insert the G and B/W wires.</p></div><div><p>2. Get the Corrugated Ø7 L=78±3mm (no slit) using right hand and insert the G and B/W wires</p></div><div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div></div>		<div><div>TERMINAL COVER JIG</div></div>	<p>Important reminders/Note/s:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance</p> <p>1. No wrong use of parts 2. No deformed terminal</p>

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		Model code/Part number: 800B / 7N0104-7020A		Customer: TRJ	Car Model: LEXUS-NX/RX		Document No.:		WI-ENG-PDE-808	
		Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		0	Page No.:	6 of 10
PARTS:		1. Connector 6188-0407 (W)				JIG:		1. Insertion jig		
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS		
6		n/a		<div>Connector setting to Insertion jig 6188-0407 (W)</div> <div></div> <div><p>1. Press the lock of insertion jig using left thumb.</p></div> <div><p>2. Insert the connector 6188-0407 (W) into jig using right hand and release the lock. <i>Note: Refer to above illustration for correct setting.</i></p></div> <div><p>3. Press the lower wire guide using right thumb. Terminal slot for B/W wire will be open.</p></div>		n/a		<div>Connector Orientation Illustration</div> <div></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>		

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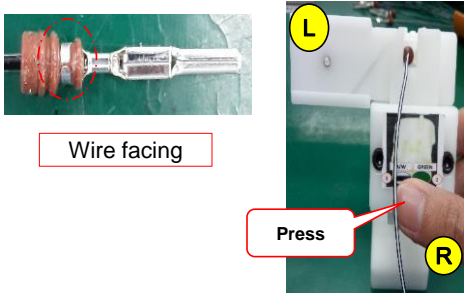
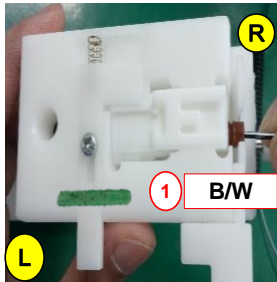
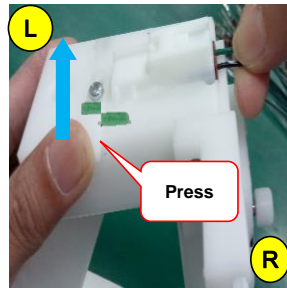
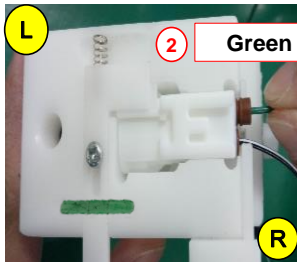
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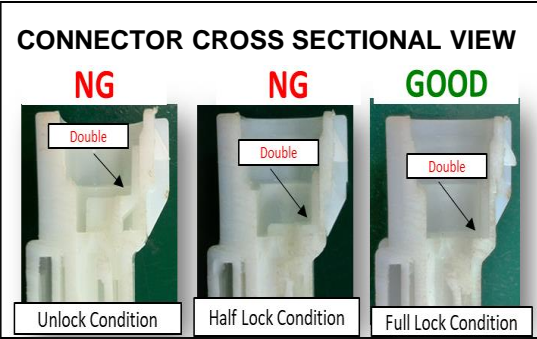

PARTS:		1. MRSW CP (TVSSf 0.3 G-B/W L=608±3mm)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	n/a Wire Insetion to Connector 6188-0407 (W)	<div><div><p>1. Hold the Insertion jig using left hand. Get Black/White wire then insert to terminal slot 1 using right hand.</p><p>2. Push the button using right hand. The slot for Green wire will be opened.</p></div><div><p>3. Get Green wire then insert to terminal slot 2 using right hand.</p><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></div>		n/a	<p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal during insertion. 2. Insertion of wire must be inserted. 3. Make sure wires are properly inserted. <u>Conduct Pull-Push-Pull-Push after insertion.</u> Do not exert extra force.</p> <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>Document reference/s:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip lenght Tolerance 2. Please refer to GL-PRO-ASSY-029 for Pull-Push procedure.</p>

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	Model code/Part number: 800B / 7N0104-7020A		Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:	WI-ENG-PDE-808		
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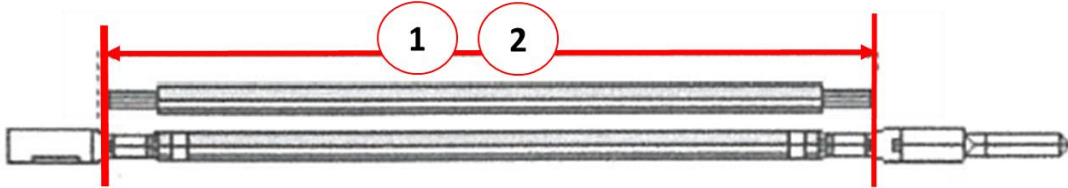

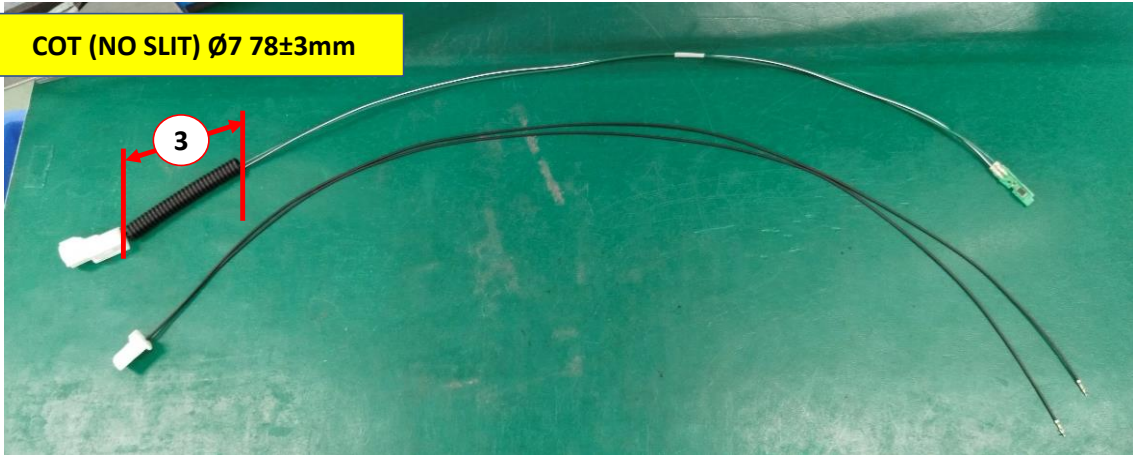
PARTS:	1.Assy parts			JIG:	1.Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	n/a	<div><div></div><div></div></div> <div>CONNECTOR CROSS SECTIONAL VIEW </div> <div>1. Put the connector into locking jig using right hand then press to lock 2x. Check the connector lock if properly locked.Touch the condition of lock after pressing.</div>		<div>LOCKING JIG</div> 	<p>Important reminders/Note/s:</p> <p>1. Manual locking may cause damaged connector lock</p> <p>1. Use the provided locking per model 2. No unlock/half-locked connector</p>

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	Process Name/Title:		Model code/Part number: 900B.910B / 7N0104-7020A		Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.: WI-ENG-PDE-808	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		0	Page No.: 9 of 10

PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
10	CLAMP ASSY	<div>Measurement</div> <div>Note: 1. Measurement point: End of core wire to the end of core wire 2. Terminal is reference only.</div> <div></div> <div></div> <div></div>	MEASURING TAPE	<div>1. No wrong dimension.</div> <div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div>	

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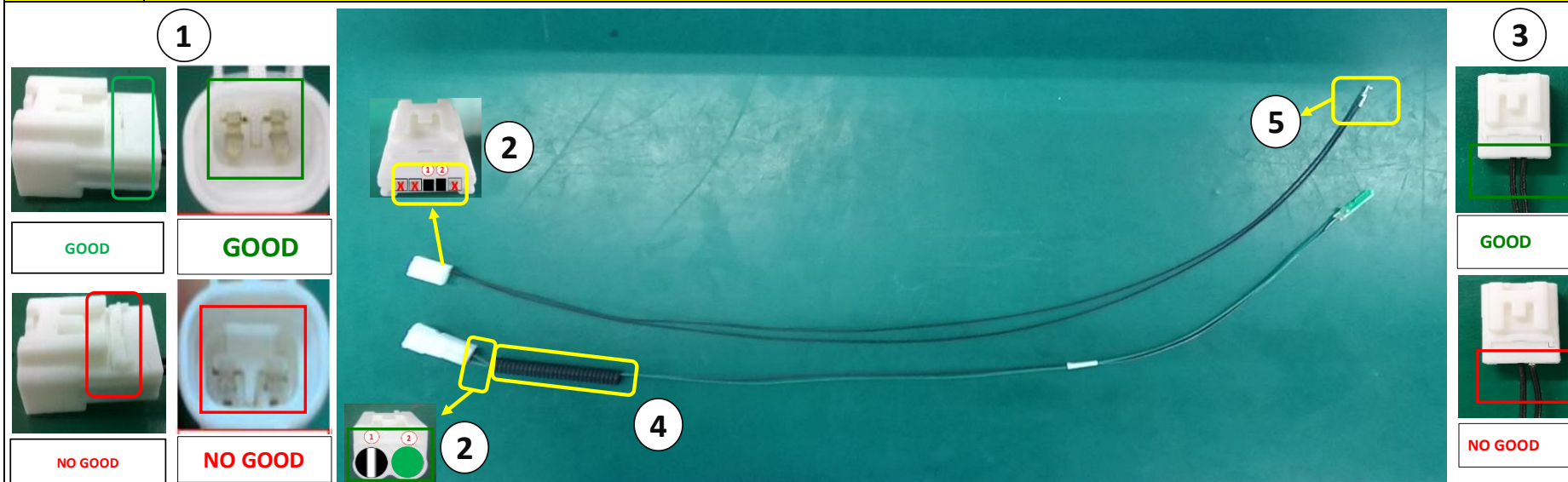
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**OFFLINE****7N0104-7020A****1 No Unlocked/ Half Locked Connector****3 No Terminal Backing Out****5 No Deform Terminal****2 No Wrong Insert****4 No MISSING COT**

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