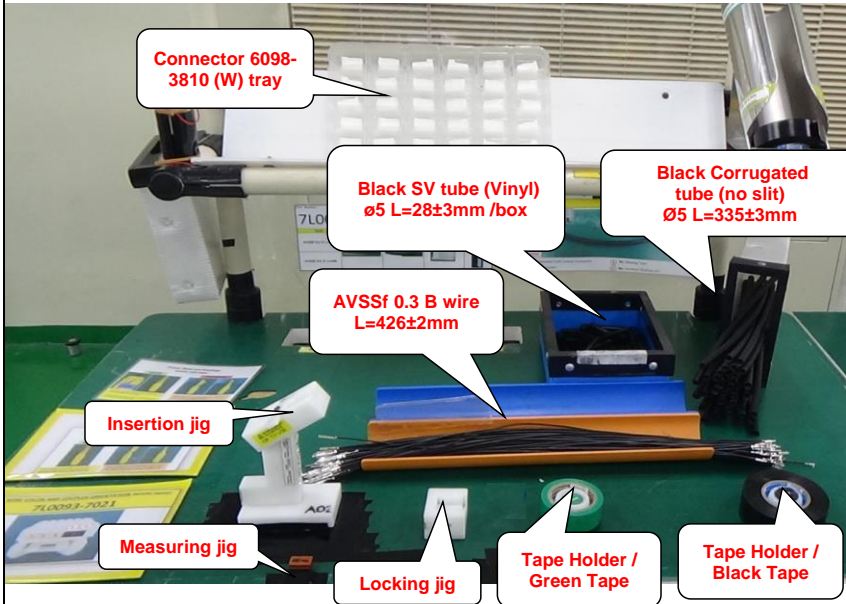
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	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 707B / 7L0093-7021		Customer: TRQSS		Car Model: Lexus-ES (Hybrid)	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.: WI-ENG-PDE-218		Revision No.: 4		Page No.: 1 of 8	

PARTS:		1. Connector 6098-3810 (W); Black corrugated tube (no slit) ø5 L=335±3mm; Black SV tube (vinyl) ø5 L=28±3mm; AVSSf 0.3 B wires L=426±2mm;Black tape; Green tape		JIG:		1. Insertion jig 3.Measuring jig 2. Locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1	P1 Table Lay-out	<div><div>TABLE LAY-OUT</div></div>		<div><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></div>		<div>Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>	

Revision History							Prepared by	Reviewed by	Approved by	Noted by
09/04/24	4	Change process sequence due to removal of cover jig. Separate Clamp assembly to Clamp assembly process due to process improvement. Inclusion of car model "LEXUS-ES (HYBRID)" and Measurement. Update table lay-out and Visual inspection/Quality checkpoints.					D. Castillo	C.Villanueva	A. Arañes	n/a
05/10/23	3	Work instruction improvement. Inclusion of batching (Page 1) and Quality pointers (Page 10). Change term from vinyl tube to SV tube (Vinyl).					D. Castillo	J. Loterte	C.Villanueva	A. Arañes
08/30/22	2	Merged P1 and P2 process due 1MP improvement project. Additional quality pointers in wire insertion refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance. Update connector lock process. Additional table lay-out.					D. Castillo	J. Loterte	C.Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change					Revised	Reviewed	Approved	Noted


Est. Date:		December 04, 2020	
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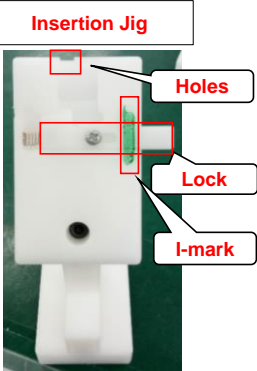
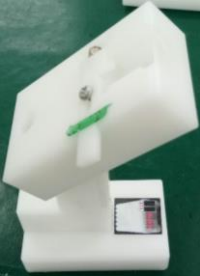

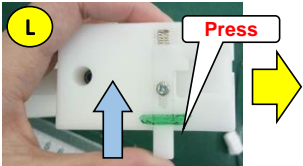
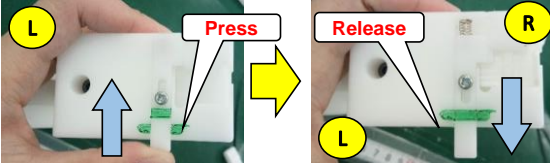

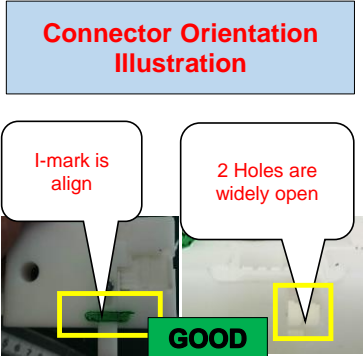
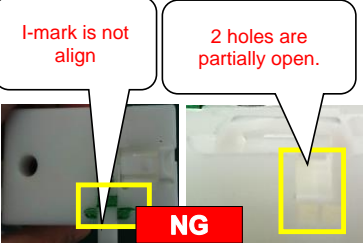
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	Model code/Part number: 707B / 7L0093-7021		Customer: TRQSS	Car Model: Lexus-ES (Hybrid)	Document No.: WI-ENG-PDE-218		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	4	Page No.:	2 of 8

PARTS:	1. Connector 6098-3810 (W)			JIG:	1.Insertion jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
2	P1 Connector Setting to Insertion jig 6098-3810 (W)	<div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div></div> <div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the connector 6098-3810 (W) using right hand and release the lock.</p><p>3. Check the holes/terminal slot for B-B wires.</p></div>			n/a	<div></div> <div></div> <p>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p>		

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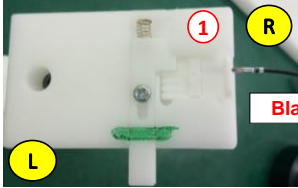
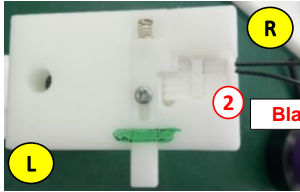
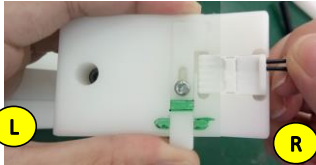
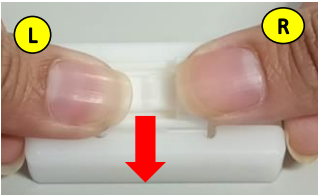
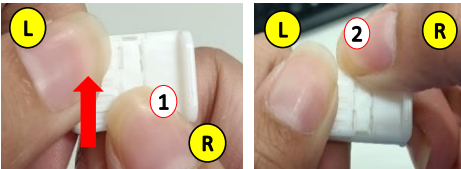
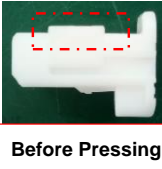


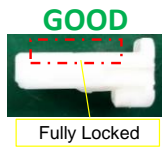
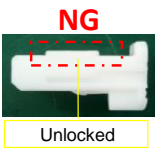
PARTS:	1. AVSSf 0.3 B wires L=426±2mm [2pcs] 2. Corrugated tube Ø5 L=335±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to Corrugated tube Ø5 L=335±3mm (no slit)	 <div>1. Get black corrugated tube Ø5 L=335±3mm using left hand and insert Black wire L=426±2mm using right hand.</div>	n/a	1. No wrong use of parts 2. No deformed terminal

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	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Process Name/Title:			Document No.:	WI-ENG-PDE-218		
	Model code/Part number: 707B / 7L0093-7021		Customer: TRQSS	Car Model: Lexus-ES (Hybrid)	Revision No.: 4 Page No.: 4 of 8		
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO							


PARTS:	1. Assy parts			JIG:	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
4	Wire Insertion to Connector 6098-3810 (W) P1	<div><p>1. Get the First Black wire and insert to Slot 1 of connector using right hand.</p></div> <div><p>2. Get the 2nd Black wire and insert to Slot 2 of connector using right hand.</p></div> <div><p>3. 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	<div>1. No loose insertion 2. No wrong dimension 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</div> <div>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</div>	
5	Connector lock	<div><p>1. Put the connector into locking jig using right hand then press to lock 2x using both hands. Touch the connector lock 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>LOCKING JIG</div> 	<div><div><p>GOOD Fully Locked</p></div><div><p>NG Unlocked</p></div></div> <div>Important reminders/Note/s: 1. Manual locking may cause damaged connector</div> <div>Document references: 1. Refer to GL-PRO-ASY-017 for the verification of lock</div>	


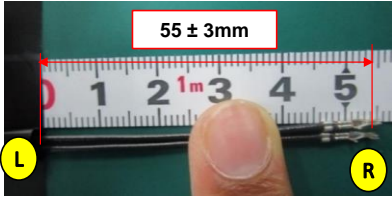
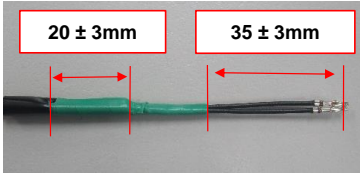

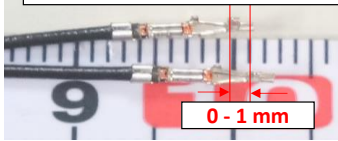
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	Model code/Part number: 707B / 7L0093-7021		Customer: TRQSS	Car Model: Lexus-ES (Hybrid)	Document No.:	WI-ENG-PDE-218		
	Purpose: <input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	4	Page No.:	5 of 8

PARTS:	1. Black SV tube (Vinyl) ø5 L=28±3mm 2. Green tape			3. Assy Parts	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
6	Wire insertion to SV tube (vinyl) ø5 L=28±3mm	 <div>Get the Black SV tube (Vinyl) ø5 L=28±3mm using right hand then insert the Black wires using left hand.</div>			n/a	1. No wrong use of parts 2. No deformed terminal
7	P1 Taping 1 SV tube (vinyl) to wire near terminal	 <div>1. Hold the SV tube (Vinyl) (Assy Part) using left hand. Measure from vinyl tube up to terminal pointed tip 55 ± 3mm.</div>  <div>2. Get Green tape, hold the SV tube (Vinyl) (ø5 L=28±3mm) using left hand then fold the SV tube (Vinyl) and start taping using both hands.</div> <div>3. After taping, check the measurement, wire alignment and tape condition.</div>			<div>MEASURING TAPE</div> 	1. No peel-off tape 2. No flip-out tape 3. No loose tape 4. No wrong use of tape 5. No wrong tape measurement Important reminder/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. Document references: 1. Please refer to WI-PRO-ASY-001 for taping procedure. <div>Wire alignment tolerance</div> 

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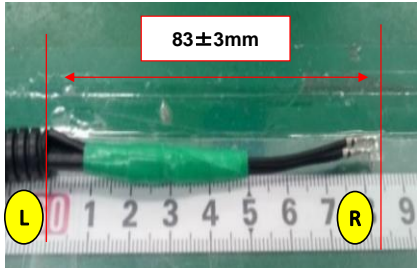
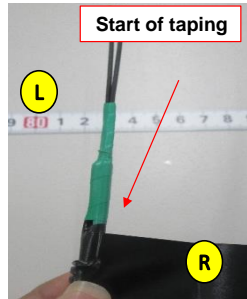
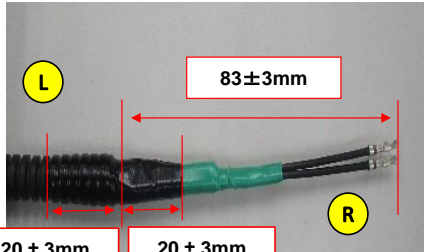

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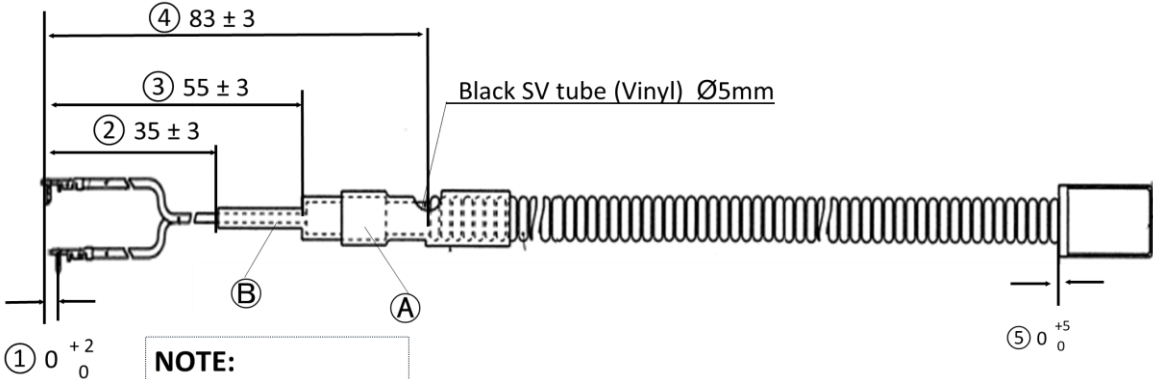

PARTS:		1. Assy part 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1 Taping 2 Corrugated tube SV tube (vinyl)	<div><div></div><div></div><div><div></div><div>1. Measure the end of corrugated tube up to the end of terminal pointed tip 83±3mm.</div><div>2. Get Black tape, hold the COT using left hand then start taping using right hand.</div><div>3. After taping, check the measurement and tape condition.</div></div><div><div>MEASURING TAPE</div></div></div>		<div>Important reminder/Note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document references:</div> <div>1. Please refer to WI-PRO-ASY-001 for taping procedure.</div> <div>1. No peel-off tape 2. No flip-out tape 3. No loose tape 4. No wrong use of tape 5. No wrong tape measurement</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.:	7 of 8

PARTS:	1. Assy part			JIG:	n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
9	P1 Measurement	<div><div>④ 83 ± 3</div><div>③ 55 ± 3</div><div>② 35 ± 3</div><div>① 0 ⁺²₀</div><div>NOTE: Ⓐ - Taping (B) Ⓑ - Taping (G)</div><div>Black SV tube (Vinyl) Ø5mm</div></div> <div><div>MEASURING TAPE</div></div>				<div>Important reminders and note/s: 1.Please use calibrated /verified measuring tape when getting the measurement. 2. For Hatsumono,Nakamono and Owarimono. Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection. 1.No wrong dimension</div>	

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1. Assy part

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING-P1****7L0093-7021****GOOD****NO GOOD****GOOD****NO GOOD****1****No Unlock / Halflock Connector****3****No Terminal Backing Out****2****No Wrong Insert****4****No Missing / Wrong useTape**

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