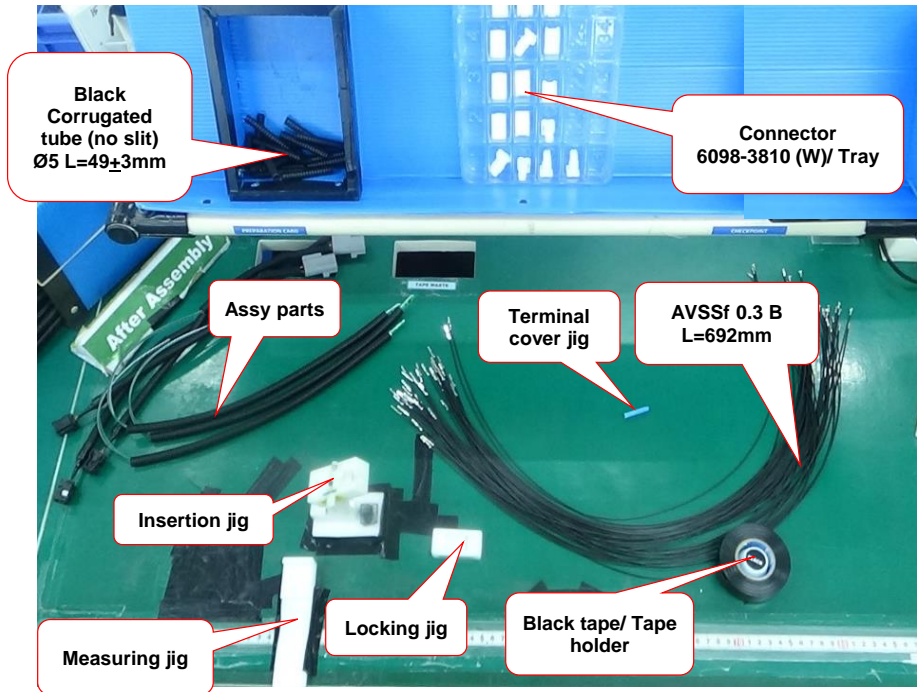
	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date:	September 4, 2024		
	Process Name/Title:				Validity Date:	n/a		
	Model code/Part number: 241B / 7L0049-7023		Customer: TRQSS	Car Model: LEXUS ES	Document No.:	WI-ENG-PDE-422B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	3	Page No.:	1 of 9

PARTS:		1. Assy parts; Black Corrugated tube Ø5 L=49±3mm; Connector 6098-3810 (W); AVSSf 0.3 B L=692±3mm; Black tape		JIG:	1. Insertion jig 2. Locking jig 3. Locking jig
NO.	PROCESS NAME	3	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Table Lay-out	<div style="text-align: center;"> <div style="border: 1px solid red; padding: 2px; display: inline-block;">TABLE LAYOUT</div>  </div>	<div style="border: 1px solid red; padding: 5px; margin-bottom: 5px;"> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 5px;"> 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 solid red; padding: 5px;"> 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-017 for Wire and Strip Length Tolerance 1. No missing parts/tools 2. No excess parts/tools

Revision History				Prepared by	Reviewed by	Approved by	Noted by
09/04/24	3	Transfer process 2-5 from P1; transfer taping 4 and Y-taping 1 to P3; additional spot taping due to process improvement. Improved Table lay-out and Visual inspection/Quality checkpoints.	D. Castillo	C. Villanueva	A. Arañes	n/a	
10/17/23	2	Update template and inclusion of Car Model	A. Hernandez	J. Loterte	C. Villanueva	A. Arañes	
12/16/22	1	Improve quality pointers: Reminders/notes and references. Inclusion of Quality checkpoints	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	

Est. Date:	March 04, 2022
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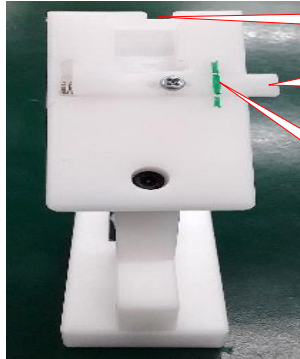
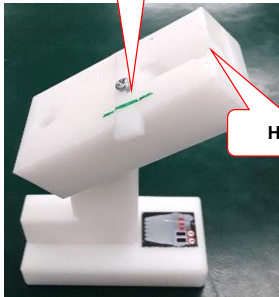
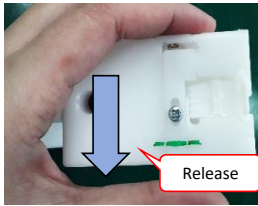
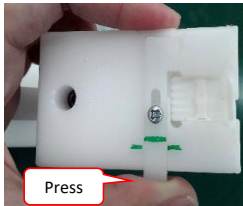
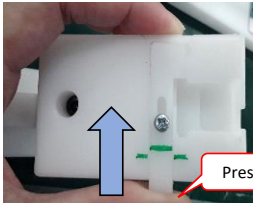

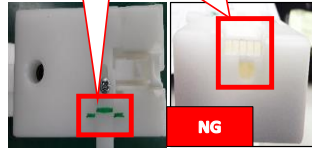
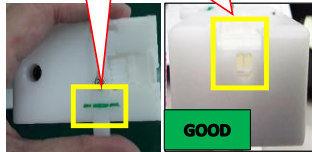
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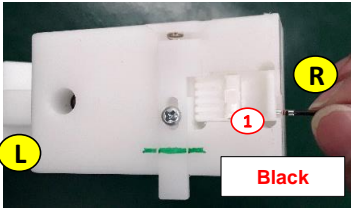
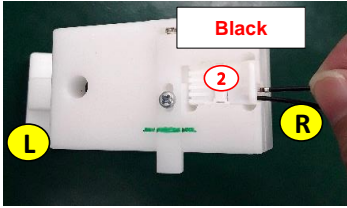
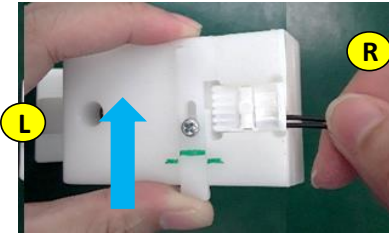
PARTS:	1. Connector 6098-3810 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Connector insertion to insertion jig 6098-3810 (W)	<div><div>INSERTION JIG</div><div></div><div></div><div>Insertion jig orientation</div><div></div><div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6098-3810 (W) into jig using right hand and release the lock.</div><div><div>3. Check the holes/terminal slot for B-B wires.</div></div></div></div> <div>N/A</div> <div><div>Connector Orientation Illustration</div><div></div><div>1. Use provided jig per model 2. No wrong orientation of connector</div></div>		

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	TAPING ASSEMBLY PROCESS			Validity Date:	n/a							
	Process Name/Title:			Model code/Part number:	241B / 7L0049-7023	Customer:	TRQSS	Car Model:	LEXUS ES	Document No.:	WI-ENG-PDE-422B	
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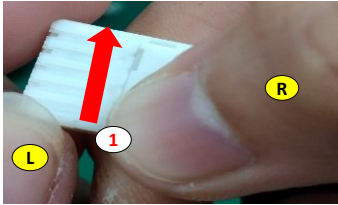
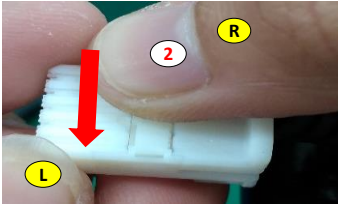
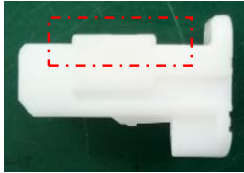
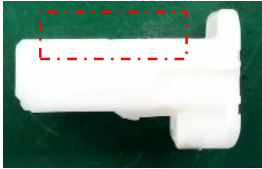

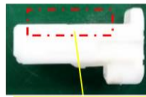
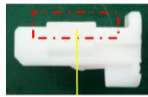
PARTS:	1. AVSSf 0.3 B L=692±3mm 2. Corrugated tube ø5 L=49±3mm (No slit)			JIG:	1. Insertion jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
3	<div>3</div> <div>Wire insertion to Corrugated tube ø5 L= 49±3mm (no slit)</div>	<div></div> <div>1. Get the corrugated tube ø5 L=49±3mm using left hand and get two (2) of Black wires then insert using right hand.</div>			N/A	1. No wrong use of parts		
4	<div>P2</div> <div>Wire insertion to connector 6098-3810 (W)</div>	<div></div> <div>Wire facing</div> <div></div> <div>1. Get the first Black wire and insert to terminal slot ① using right hand.</div> <div></div> <div>2. Get the 2nd Black wire and insert to terminal slot ② using right hand.</div> <div></div> <div>3. 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>			N/A	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>Important reminders/Note/s: 1. Insertion sequence starts from left to right. 2. Please hold the wire near terminal. 3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>		

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	Model code/Part number: 241B / 7L0049-7023		Customer: TRQSS	Car Model: LEXUS ES	Document No.:	WI-ENG-PDE-422B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	3	Page No.:	4 of 9

PARTS:	1. Assy parts			JIG:	1. Locking Jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
5	P2 Connector Lock	<div><div></div><div></div><div></div><div></div><div></div><div>1. Put the connector into locking jig using right hand then press 2x using both hands. Touch the connector lock to confirm if properly locked.</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> 	<div>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</div> <div>CONNECTOR LOCK CONDITION</div> <div><div>GOODFully Locked</div><div>NGUnLocked</div></div> <div>1. Use the provided locking jig per model 2. No unlock/half-locked connector</div>		

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PARTS:

1. Assy parts
2. Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

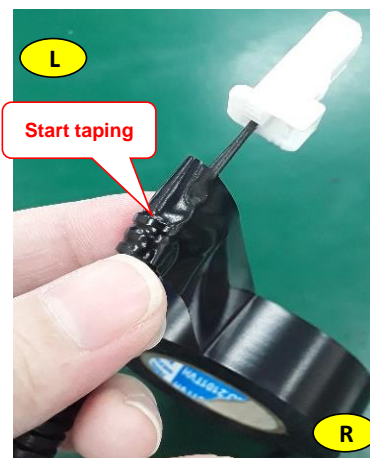
TOOLS/PPE

QUALITY POINTERS

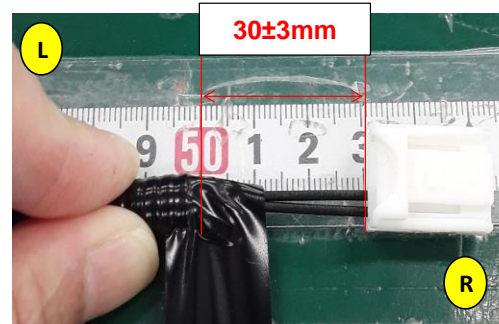
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P2

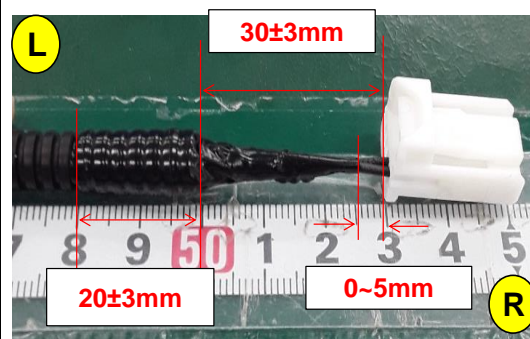
Taping 2
COT to wire near
Connector



1. Hold corrugated tube using left hand then get black tape and conduct pre-taping using right hand.



2. Measure the end of the corrugated tube up to the edge of connector **30±3mm** using both hands. Continue taping process.



3. After taping, check the measurement and tape condition.

MEASURING
TAPE



Important reminders and Note/s:
1. Please use calibrated/verified measuring tape when getting the measurement.


Document reference/s:
1. Refer to WI-PRO-ASY-001 for taping procedure.


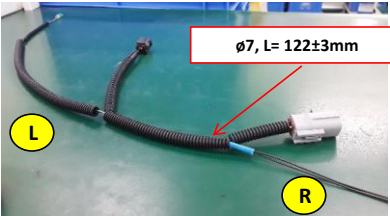


1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong dimension
6. No wrong use of tape

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	Process Name/Title:			Model code/Part number:	241B / 7L0049-7023	Customer:	TRQSS	Car Model:	LEXUS ES	Document No.:	WI-ENG-PDE-422B	
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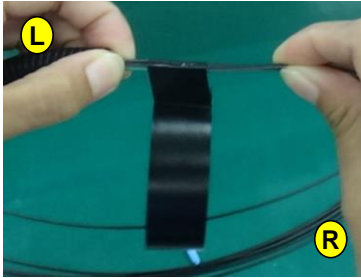

PARTS:		1. Assy parts 2. Black Corrugated tube $\varnothing 7$ L-122 \pm 3mm		3. Black Corrugated tube $\varnothing 7$ L-312 \pm 3mm		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS
7	P2	<div><div></div><div>1. Get the terminal cover jig using left hand. Hold the 2 Black wires and insert to terminal cover jig using right hand.</div><div></div><div>2. Get the assy parts using left hand. Insert the 2 Black wires in COT (no slit) $\varnothing 7$, L= 122\pm3mm and $\varnothing 7$, L= 312\pm3mm.</div><div></div><div>3. Remove the terminal cover jig after insertion.</div></div> <div><div>TERMINAL COVER JIG</div></div> <div>1. No wrong insertion to corrugated 2. No deformed terminal</div>					

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	Process Name/Title:		Model code/Part number: 241B / 7L0049-7023		Customer: TRQSS		Car Model: LEXUS ES	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.: WI-ENG-PDE-422B		Revision No.: 3		Page No.: 7 of 9	

PARTS:		1. Black tape 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	Wire insertion to VM tube (Sunprene) Ø5 L=106±3mm (Assy parts)	<div></div> <div>1. Hold the VM tube (Sunprene) Ø5 L=106±3mm using left hand and insert the 2 Black wires using right hand.</div>		N/A	1. No wrong insert 2. No deformed terminal
9	P2 <div></div> Spot taping	<div></div> <div>1. Hold the assy parts using left hand, get Black tape and attach in the middle of COT and VM tube (Sunprene) then start taping using both hand. Make 2 windings then cut the tape.</div> <div></div> <div>2. After taping, check the wire alignment and taping condition.</div>		N/A	1. No loose tape 2. No missing tape

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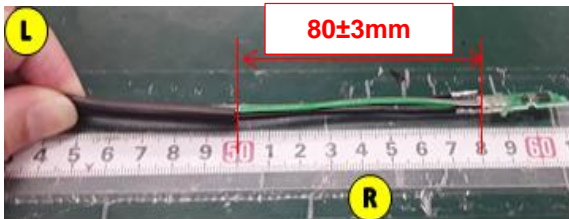
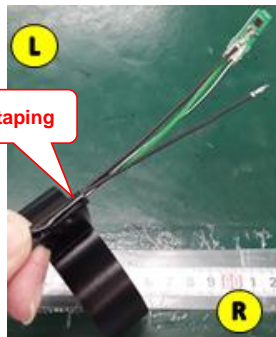
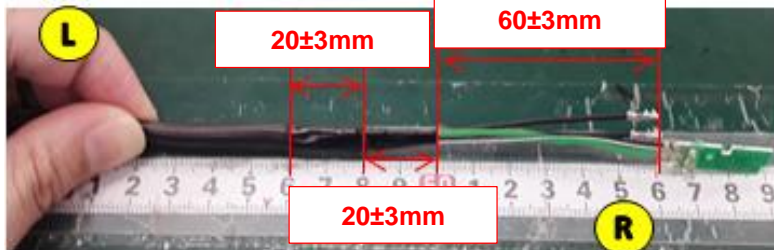

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Black tape 2. Assy parts	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	P2 Taping 3 Corrugated tube to VM tube (Sunprene)	<div></div> <div></div> <div></div> <div>1. Measure from end of VM tube (Sunprene) up to end of terminal pointed tip and edge of hotmelted wire $80\pm 3\text{mm}$ using both hands.</div> <div>2. Hold the VM tube (Sunprene) using left hand, get the Black tape then start taping using both hands.</div> <div>3. After taping, check the measurement, wire alignment & tape condition.</div>	<div>MEASURING TAPE</div> 	<div>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</div> <div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</div>

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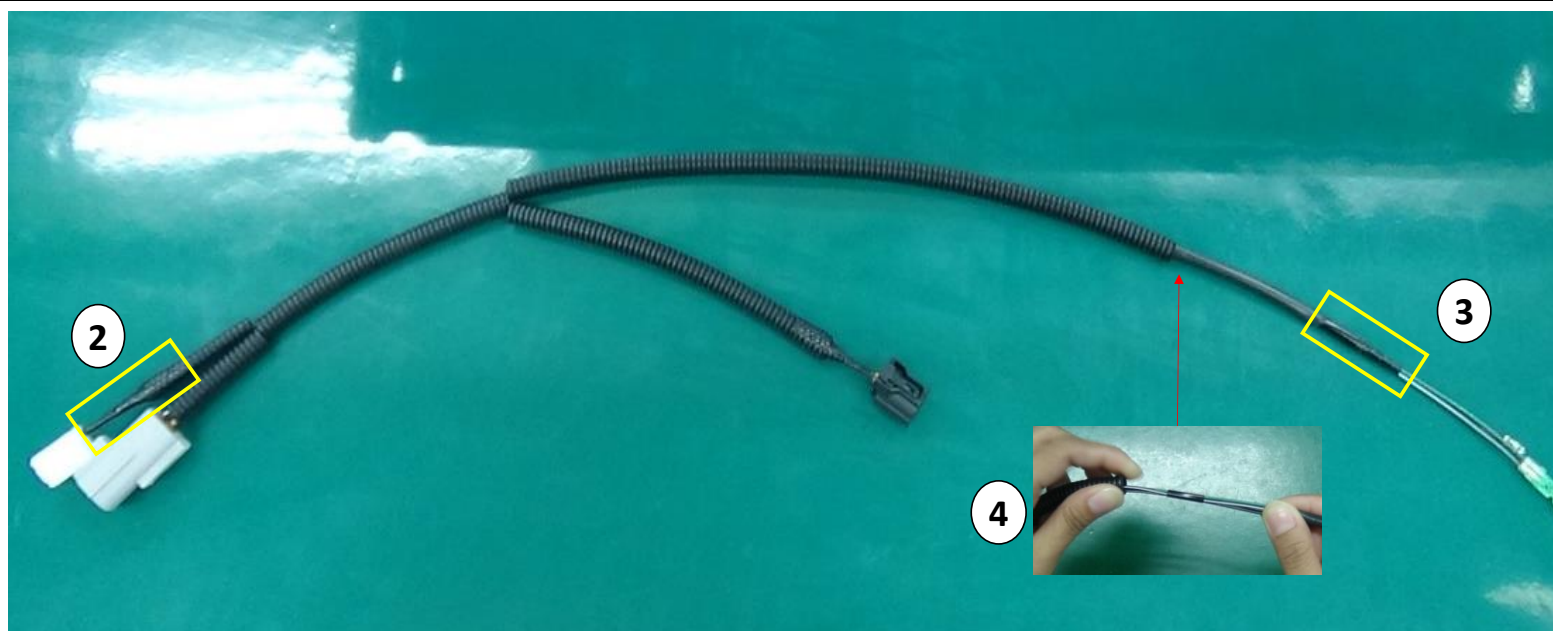
Page No.:

9 of 9**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P2****7L0049-7023****1****GOOD****NO GOOD****1****No Unlocked/ Half-locked
connector****2****3****4****No Missing Tape/ Spot Tape**

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