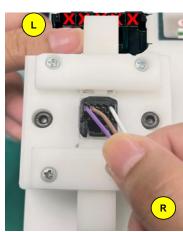
				W	ORK INSTRUC	TION				Effectivity Date:		May 14, 2025	:
		F	Process Name/Title:		TAPING ASS	SEMBLY PRO	CESS			Validity Date:		n/a	
	-1	N	Nodel code/Part number:	412D / 75V117	7-7112 Cu	stomer: TRJ	Car Model:	LEX	XUS-ES	Document No.:		WI-ENG-PDE-12	259
		F	Purpose:	PROTOTYPE	■ PRI	E-LAUNCH	☐ MASSPR	RO		Revision No.:	0	Page No.:	1 of 21
PARTS:		L=72±3mr	m; Connector PBVP-10V-S	ube, Black tape); Connector PBVPs (W); Connector 4A1232-0000 (B); 28±2mm; GR/B L=224±2mm; LG L	; AVSS 0.3 V L=141±	2mm; BR L=143±2m	m; W/G L=145±2	2mm; AVS		JIG:	Insertion Steering		
NO).	PR	ROCESS NAME		WORK PROCE	DURE/ ILLUST	RATION			TOOLS/PPE		QUALITY POIN	TERS
				Connector PBVP-10V-S (W)	Black SV tube (Vinyl) Ø7 L=117±3mm	(L wire wit	sy parts h Black SV tub ick tape)	be,	2 Layer Navigation	Safety Instruction Be sure to wear required personal protective equipmen during operation (gloves, finger cots, etc.)	1. Refer and Strip 2. Refer	ent reference/s to WI-PRO-CNC-Co Length Tolerance to WI-ENG-PDE-1 y process (Pre-ass	17 for Wire 151 for Taping
1		P1	Table lay-out					(k SV tube Vinyl) _= 72±3mm	Housekeeping 1. Maintain and alway practice 5's. 2. Personal things or the workplace is prohibited. Keep it in your locker.	1. No defor	med terminal y usage of parts	
				Jig B	sertion Jig A Empty box for Preassy	Conne 4A1232-0			nnector -12V-S (W)	Alert level For any trouble, inforr the Assembly Assistar Supervisor or Line Leader for immediate corrective action.	nt		
				Revisi	ion History					Prepared by	Checked by	Reviewed by	Approved by
										. Toparod by			
Ţ													
											Show	1/	
05/14/25	0	Initial issue					D.Castillo	J.Loterte	C. Villanueva A.	Arañes D. Castillo	J.Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No			Details of Change			Revised	Checked	Reviewed A	pproved Est. Date: M	ay 14, 2025		



			WORK INS	STRUCTION			Effectivity Date:		May 14, 2025	
		Process Name/Title:	TAPIN	IG ASSEMBLY PRO	CESS		Validity Date:		n/a	
		Model code/Part number:	412D / 75V117-7112	Customer: TRJ	Car Model:	LEXUS-ES	Document No.:		WI-ENG-PDE-12	259
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	☐ MASSPRO)	Revision No.:	0	Page No.:	2 of 21
PARTS:		ector 4A1232-0000 (B) ector PBVP-12V-S (W)					JIG:	Insertion Steering		
NO.	F	PROCESS NAME	WORK I	PROCEDURE/ ILLUSTI	RATION		TOOLS/PPE		QUALITY POIN	ΓERS
2	P1	Connector setting to insertion jig 4A1232-0000 (B) and PBVP-12V-S (W)	Insertion Jig Virefe Upper 1 2 Lower guide	sual rence Guide Cor 1. Get the 1 pc of 4A pc of PBVP-12V-S (V insert to insert to serve the continuous to the contin	Press	ation 1 2 R sing left hand and 1 g right hand then	STEERING NAVIGATION (2 layer) CONTROLLER	No wrorNo wror	provided jig per m ng usage of parts ng orientation of co aged connector	

			WORK INSTRU	JCTION		Effectivity Date:		May 14, 2025	
		Process Name/Title:	TAPING A	ASSEMBLY PROC	ESS	Validity Date:		n/a	
		Model code/Part number:	412D / 75V117-7112	Customer: TRJ	Car Model: LEXUS-ES	Document No.:		WI-ENG-PDE-12	259
		Purpose:	PROTOTYPE	PRE-LAUNCH	☐ MASSPRO	Revision No.:	0	Page No.:	3 of 21
PARTS:	1. AVSS	6 0.3 V L=141±2mm; BR L=14	43±2mm; W/G L=145±2mm			JIG:	Insertion Steering		
NO.	F	PROCESS NAME	WORK PRO	CEDURE/ ILLUSTRA	ATION	TOOLS/PPE	(QUALITY POIN	TERS
3	P1	Wire insertion to Connector 4A1232-0000 (B)	INSERTION SEQUENCE FROM LEFT TO RIGHT INSERTION SEQUENCE	WIRE V B 141 14 X S ster to right hand then inso wire after insertion.	FACING INSERTION ILLUSTRATION 2 BR X X W/0 145 X X X X	— I NAVIGATION (2 laver)	2. No wron 3. One by 0 4. No wron 5. No defoi 6. No stuck Importan 1. Make inserted. Push afti Do not e. 2. Please terminal 3. Autom replace tenounts difficulty locked c 4. Inserti left to rig Docume 1. Refer t Wire and 2. Refer t Steering procedur 3. Refer t	med terminal to of terminal tip at reminders/Note sure wires are pr Conduct <u>Pull-Pu</u> er insertion. xert extra force. In during insertion. attically dispose the unit if once ered bend termin of insertion and onnector. ion of wires must ight. To WI-PRO-CNC-0 I Strip Length Tol To WI-ENG-PDE-0 Navigation Conti	e/s: roperly ush-Pull- near and nal, I half- t be from 017 for lerance. 144 for roller

NB	Process Name/Title: Model code/Part number:	412D / 75V117-7112	G ASSEMBLY PRO	Car Model:	LEXUS-ES	Effectivity Date: Validity Date: Document No.:		May 14, 202 n/a WI-ENG-PDE-	1259
PARTS:	Purpose:	PROTOTYPE	PRE-LAUNCH	☐ MASSPRO)	Revision No.:	1. Insertion	Page No.:	4 of 21
NO.	1. AVSS 0.3 V L=141±2mm; BR L= PROCESS NAME	·	PROCEDURE/ ILLUST	RATION		JIG: TOOLS/PPE	2. Steering	Navigation QUALITY POIL	NTERS
4	Wire insertion to Connector 4A1232-0000 (B)					STEERING NAVIGATION (2 layer) CONTROLLER	2. No wroi 3. One by 4. No wroi 5. No defc 6. No stud Importa 1. Make inserted Push af Do not t 2. Pleas termina 3. Autor replace	povided jig per moding usage of parts one insertion or med terminal sk of terminal tip ant reminders/Notes sure wires are jud. Conduct Pull-fiter insertion. Exert extra force is hold the wires I during insertious the unit if once tered bend termi	ote/s: properly Push-Pull- near n. e and



2. Press the Upper and lower button using both hands. Remove the 1st connector with inserted wires using right hand.



- difficulty of insertion and halflocked connector.
- 4. Insertion of wires must be from left to right.

Document reference/s:

- 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.
 2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..
- 3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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			WORK INS	STRUCTION			Effectivity Date:		May 14, 2025	
		Process Name/Title:	TAPIN	IG ASSEMBLY PRO	CESS		Validity Date:		n/a	
		Model code/Part number:	412D / 75V117-7112	Customer: TRJ	Car Model:	LEXUS-ES	Document No.:		WI-ENG-PDE-12	259
		Purpose:	☐ PROTOTYPE	■ PRE-LAUNCH	☐ MASSPRO		Revision No.:	0	Page No.:	5 of 21
PARTS:	1. Assy 2. Balck	tape					JIG:	n/a		
NO.	F	PROCESS NAME	WORK F	PROCEDURE/ ILLUST	[RATION		TOOLS/PPE	(QUALITY POIN	TERS
5	P1	Taping 1 Wire taping	1. Measure from wire up to connector 6 the taping2 process using both hands. 1/3 shifting 3. Make 2 winding then 1/3 shifting until	3±2mm then continue	the Black tape us then start taping. 55±1mm	5~10mm		5. No wror 6. No miss 7. No insu Importa 1. Pleas	off tape e tape ng dimension ng use of tape sing tape fficient tape output o	verified

			WORK INST	TRUCTION			Effectivity Date:	T	May 14, 2025	
		Process Name/Title:	TAPING	G ASSEMBLY PRO	CESS		Validity Date:	1	n/a	
		Model code/Part number:	412D / 75V117-7112	Customer: TRJ	Car Model:	LEXUS-ES	Document No.:		WI-ENG-PDE-1	259
		Purpose:	PROTOTYPE	PRE-LAUNCH	☐ MASSPRO)	Revision No.:	0	Page No.:	6 of 21
PARTS:	2. Balck	<u> </u>					JIG:	Insertion Steering	Navigation	
NO.	ı	PROCESS NAME	WORK P	PROCEDURE/ ILLUSTI	RATION		TOOLS/PPE	(QUALITY POIN	TERS
			55±1mm	5~10mm	4. After taping measurement condition .		STEERING NAVIGATION (2 layer)	2. No wror 3. One by 4. No wror 5. No defo 6. No stuc	ovided jig per mode ng usage of parts one insertion ng insertion ormed terminal ek of terminal tip	
6	P1	Taping 1 Wire taping (Continuation)			parts to er	ping, put the assy mpty box. ow the illustration.	CONTROLLER	1. Make inserted Push aft Do not e 2. Pleas: terminal 3. Auton replace encount difficulty	e sure wires are p d. Conduct <u>Pull-Pi</u> ter insertion. exert extra force, the hold the wires i d during insertion matically dispose the unit if once tered bend termin y of insertion and connector.	roperly ush-Pull- near and



Document reference/s:

left to right.

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..

4. Insertion of wires must be from

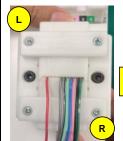
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

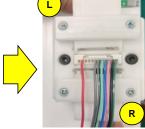
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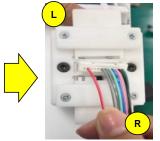
		<u> </u>	WORK IN	NSTRUCTION	N						Effectivity Date:		May 14, 2025	<u> </u>
		Process Name/Title:	TAP	ING ASSEN	VIBLY F	ROCE	ESS				Validity Date:		n/a	
		Model code/Part number:	412D / 75V117-7112	Custom	ner: TR	\J	Car Mode	d:	LEXUS-	ES	Document No.:		WI-ENG-PDE-1	259
		Purpose:	PROTOTYPE	■ PRE-LAU	JNCH		☐ MAS	SPRO			Revision No.:	0	Page No.:	7 of 21
PARTS:	1. AVS	S 0.3 R L=240±2mm; L L=89:	±2mm; GR L=228±2mm; GR/B L=224±2mr	m; LG L=226±2r	nm; P L=2	:30±2mm;	; B L=234:	<u>⊧</u> 2mm; G	L=232±2m	m	JIG:	Insertion Steering	, 0	
NO.		PROCESS NAME	WORK	K PROCEDU	RE/ ILL	USTRA	TION				TOOLS/PPE		QUALITY POIN	
			INSERTION SEQUENCE FROM LI	5 6 7 8		WIRF		The bod	TERMIN FACIN	G		2. No wron 3. One by 4. No wron 5. No defo 6. No stuck	vided jig per mode ng usage of parts one insertion ng insertion irmed terminal k of terminal tip nt reminders/Note sure wires are pi	ee/s:
							HOLKIIC		JINATIO		STEERING	inserted.	. Conduct <u>Pull-Pu</u> er insertion.	
			1	3	4	5	6	7	8	9	NAVIGATION (2 layer)	Do not e	xert extra force. e hold the wires r	near terminal
			X R X X	GR 228	GR/B 224	LG 226	L 224	P 230	B 234	G 232		during in 3. Autom the unit i	nsertion. natically dispose if once encounte	and replace red bend
7	P1	Wire insertion to Connector	3		(mx		-					half-lock	difficulty of inse sed connector. ion of wires must	
		PBVP-12V-S (W)	No. of the last of								CONTROLLER		nt reference/s:	
					,	O		M	•		Tis it's OUTSING	and Strip 2. Refer to Steering procedur 3. Refer to Push pro- 4. Refer to	to GL-PRO-ASY-(ocedure. to GL-PRO-ASY-(on Standard for c	ce. 044 for troller 029 for Pull- 025 for
			1. Get the R wire using right hand the B and G wires. Check the wire after Note: Follow the insertion sequence.	r insertion.			the proce	ss for GF	R, GR/B LO	G, L, P,		Ter	rminal tip must b	e visible

NA		Process Name/Title:		TRUCTION G ASSEMBLY PRO	CESS		Effectivity Date: Validity Date:		May 14, 2025 n/a	1
		Model code/Part number:	412D / 75V117-7112	Customer: TRJ	Car Model:	LEXUS-ES	Document No.:		WI-ENG-PDE-1	259
		Purpose:	☐ PROTOTYPE	■ PRE-LAUNCH	☐ MASSPRO		Revision No.:	0	Page No.:	8 of 21
PARTS:	1. Assy	parts					JIG:	Insertion Steering	jig Navigation	
NO.		PROCESS NAME	WORK P	PROCEDURE/ ILLUST	RATION		TOOLS/PPE		QUALITY POIN	TERS
			Proper alignment of termi	inal to connector	Imprope	r alignment of te	1. Use provided jig per model 2. No wrong usage of parts 3. One by one insertion 4. No wrong insertion 5. No deformed terminal 6. No stuck of terminal tip Important reminders/Note/s: 1. Make sure wires are properly			
8	P1	Wire insertion to Connector PBVP-10V-S (W) (Continuation)	GOOD	GOOD Terminal condition	Damaged terminal NO Termina	OF TERMINAL GOOD condition	NO GOOD Terminal codition	Push aft Do not e 2. Pleass during ii 3. Auton the unit terminal half-lock 4. Insert to right. Docume 1. Refer and Stri	Conduct <u>Pull-Purer</u> insertion. Exert extra force. In e hold the wires insertion. In attically dispose If once encounte, If difficulty of insertion If one wires must If one wires must If of wires must If our reference/s: If o WI-PRO-CNC-Io If our to WI-PRO-PDE-I	near terminal and replace red bend rition and be from left 017 for Wire ce.

*Avoid hitting the terminal into the connector during wire insertion, if encountered abnormality stop the process and call the attention of Immediate superior and Automatically disposed and replace the unit.







3. Press the upper and lower lock by both hands and hold the assy part by right hand. Check the wire after insertion

- Steering Navigation Controller procedure..
- 3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
- 4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.



Terminal tip must be visible

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			WORK II	NSTRUCTION		Effectivity Date:		May 14, 2025	
		Process Name/Title:	TAP	ING ASSEMBLY PRO	DCESS	Validity Date:		n/a	
		Model code/Part number:	412D / 75V117-7112	Customer: TRJ	Car Model: LEXUS-ES	Document No.:		WI-ENG-PDE-12	259
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	☐ MASSPRO	Revision No.:	0	Page No.:	9 of 21
PARTS:	1. Assy 2. Black					JIG:	n/a		
NO.	I	PROCESS NAME	WORK	K PROCEDURE/ ILLUST	TRATION	TOOLS/PPE		QUALITY POIN	TERS
9	P1	Taping 2 Wire taping	1. Measure from wire up to end of continue the taping process using both shifting 1/3 shifting 3. Make 2 winding then 1/3 shifting	7 8 9 60 1 Innector 116±2mm then the hands.		MEASURING TAPE 6 7 8 9 @ 1 2 3 4 5 6 7 8 9 9	5. No wror 6. No miss 7. No insu Importa 1. Plea measu	off tape e tape ng dimension ng use of tape	verified

			WORK INS	STRUCTION			Effectivity Date:	T	May 14, 2025	
		Process Name/Title:		IG ASSEMBLY PR	OCESS		Validity Date:		n/a	
		Model code/Part number:	412D / 75V117-7112	Customer: TRJ	Car Model:	LEXUS-ES	Document No.:		WI-ENG-PDE-12	259
		Purpose:	☐ PROTOTYPE	■ PRE-LAUNCH	☐ MASSPRO		Revision No.:	0	Page No.:	10 of 21
PARTS:	1. Assy 2. Black	parts SV tube (Vinyl) Ø8.5 L=72±	3mm				JIG:	1. Insertion	jig	
NO.	F	PROCESS NAME	WORK	PROCEDURE/ ILLUS	TRATION		TOOLS/PPE	(QUALITY POIN	TERS
10	P1	Wire insertion to Black SV tube (Vinyl) Ø8.5 L=72±3mm	1. Hold the assy parts using right hand. Holes that need to be insert are only of the last state of th	R wire	Press the upper guide		n/a	1. No wror 2. No defo 3. No tang	ng usage of parts rmed terminal lled wires	

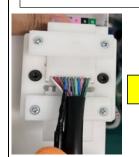
				STRUCTION			Effectivity Date:		May 14, 2025	1
		Process Name/Title:		IG ASSEMBLY PR	OCESS		Validity Date:		n/a	
		Model code/Part number:	412D / 75V117-7112	Customer: TRJ	Car Model:	LEXUS-ES	Document No.:		WI-ENG-PDE-1	259
		Purpose:	PROTOTYPE	PRE-LAUNCH	☐ MASSPRO)	Revision No.:	0	Page No.:	11 of 21
PARTS:	1. Assy	parts					JIG:	1. Insertion	jig	
NO.	I	PROCESS NAME	WORK I	PROCEDURE/ ILLUS	TRATION		TOOLS/PPE		QUALITY POIN	ITERS
11	P1	Wire insertion to assy parts	1. Hold the Black VM tube (Sunprer using left hand and insert the wires cassy parts (Connector with wire) usin right hand.	of	75V117-7111	Jig1-A	n/a		ng usage of parts rmed terminal lled wires	

			WORK INS	STRUCTION			Effectivity Date:		May 14, 2025	
		Process Name/Title:	TAPIN	NG ASSEMBLY PR	OCESS		Validity Date:		n/a	
		Model code/Part number:	412D / 75V117-7112	Customer: TRJ	Car Model:	LEXUS-ES	Document No.:		WI-ENG-PDE-12	259
		Purpose:	☐ PROTOTYPE	■ PRE-LAUNCH	☐ MASSPRO		Revision No.:	0	Page No.:	12 of 21
PARTS: 1	I. Assy _I	parts					JIG:	1. Insertion 2. Steering		
NO.	Р	ROCESS NAME	WORK	PROCEDURE/ ILLUS	TRATION		TOOLS/PPE	(QUALITY POIN	TERS
NO.	P1	Wire insertion to Connector PBVP-10V-S (W)	1 2 3 4 W/G R BR V L GR GR/B LG L 1 2 3 W/G R BR V	FT TO RIGHT P B G W 4 L GR GR/B 89 228 224 d and support the connector slot 1 on W/G and R	2. Get the assy Black tube tapir hand.	B G 234 232		1. Use pro 2. No wron 3. One by 4. No wron 5. No defo 6. No stud Importar 1. Make inserted. Push afte Do not e. 2. Please during in 3. Autom the unit i terminal, half-lock 4. Inserti to right. Docume. 1. Refer i and Strip 2. Refer of Steering procedul 3. Refer i 4. Refer of 4. Refer of	vided jig per mode ig usage of parts one insertion ig insertion rmed terminal the int reminders/Note sure wires are procedure, if once encounter difficulty of inserted connector, ion of wires must on WI-PRO-CNC-0 Length Tolerand to WI-PRO-CNC-0 Navigation Contree, to GL-PRO-ASY-0 cocedure, to GL-PRO-ASY-0 con Standard for co	v/s: operly sh-Pull- ear terminal and replace ed bend tion and be from left 17 for Wire ee. 44 for oller 29 for Pull-

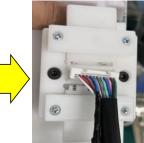
		Process Name/Title:	WORK INS	Effectivity Date: Validity Date:		May 14, 2025 n/a				
				NG ASSEMBLY PRO		I EVIIO EO				
		Model code/Part number:	412D / 75V117-7112	Customer: TRJ	Car Model:	LEXUS-ES	Document No.:	WI-ENG-PDE-1259		
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	☐ MASSPRO		Revision No.:	0	Page No.:	13 of 21
PARTS:	1. Assy	parts					JIG:	Insertion Steering	i jig Navigation	
NO.	PROCESS NAME WORK PROCEDURE/ ILLUSTRATION						TOOLS/PPE		QUALITY POIN	TERS
			Proper alignment of term	rminal to connector	1. Use provided jig per model 2. No wrong usage of parts 3. One by one insertion 4. No wrong insertion 5. No deformed terminal 6. No stuck of terminal tip Important reminders/Note/s: 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.					
13	P1	Wire insertion to Connector PBVP-10V-S (W) (Continuation)	GOOD Terminal condition Note:	GOOD Terminal condition	Damaged terminal NO G Terminal	OOD .	NO GOOD Terminal codition	2. Pleas during ii 3. Auton the unit terminal half-lock 4. Insert to right. Docume	exert extra force. e hold the wires r nsertion. natically dispose if once encounte, difficulty of inse ked connector. ion of wires must ent reference/s: to WI-PRO-CNC-t p Length Toleran to WI-ENG-PDE-t	and replace ed bend rtion and be from left 017 for Wire ce.

*Make sure the terminal was in proper alignment before insert.

*Avoid hitting the terminal into the connector during wire insertion, if encountered abnormality stop the process and call the attention of Immediate superior and Automatically disposed and replace the unit.







3. Press the upper lock by left hand and hold the assy part by right hand. Check the wire after insertion

- 2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..
- 3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
- 4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.



Terminal tip must be visible

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			WORK INS	STRUCTION			Effectivity Date:	T	May 14, 2025	
		Process Name/Title:	TAPIN	NG ASSEMBLY PR	ROCESS		Validity Date:		n/a	
		Model code/Part number:	412D / 75V117-7112	Customer: TRJ	Car Model:	LEXUS-ES	Document No.:		WI-ENG-PDE-12	259
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	☐ MASSPRO		Revision No.:	0	Page No.:	14 of 21
PARTS:	2. Assy		Bmm				JIG:	n/a		
NO.	F	PROCESS NAME	WORK	PROCEDURE/ ILLU:	STRATION		TOOLS/PPE		QUALITY POIN	TERS
14	P1	Wire insertion to Black SV tube (Vinyl) Ø7 L=117±3mm	L	R	(Vinyl) Ø7 Le	lack SV tube .=117±3mm using Hold the wire of sing left hand then res.	n/a	1. No wron 2. No defo 3. No tang	ng usage of parts ormed terminal gled wires	

	_		WORK INS	STRUCTION			Effectivity Date:	T	May 14, 2025	
	\triangle	Process Name/Title:		IG ASSEMBLY PRO	CESS		Validity Date:	+	n/a	
		Model code/Part number:	412D / 75V117-7112	Customer: TRJ	Car Model:	LEXUS-ES	Document No.:		WI-ENG-PDE-12	259
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	☐ MASSPRO		Revision No.:	0	Page No.:	15 of 21
PARTS:	1. Conn	ector PBVP-10V-S (W)					JIG:	1. Insertion	jig	
NO.	F	PROCESS NAME	WORK I	PROCEDURE/ ILLUST	RATION		TOOLS/PPE	,	QUALITY POIN	TERS
15	P1	Connector setting to insertion jig PBVP-10V-S (W)	Insertion Jig Virefe Upper	guide Press 2. Press the upper gui Holes that need to be	1. Get the 1 10V-S conn hand then in jig. Note: Follo orientation.	pc of PBVP- ector using right nsert to insertion w the connector R and in same timing. en.	n/a	No wrorNo wror	provided jig per m g usage of parts g orientation of co aged connector	



			WORK INS	TRUCTION				Effectivity Date:		May 14, 2025	
		Process Name/Title:	TAPIN	G ASSEMB	LY PRO	CESS		Validity Date:		n/a	
		Model code/Part number:	412D / 75V117-7112	Customer:	TRJ	Car Model:	LEXUS-ES	Document No.:		WI-ENG-PDE-12	259
		Purpose:	PROTOTYPE	PRE-LAUNCH	1	☐ MASSPR	0	Revision No.:	0	Page No.:	16 of 21
PARTS:	1. Assy	parts						JIG:	1. Insertion	jig	
NO.	F	PROCESS NAME	WORK I	PROCEDURE/	/ ILLUSTF	RATION		TOOLS/PPE		QUALITY POIN	TERS
			1 2 3 4 5 6 7 L GR/B LG GR P X G B	8		RE INSERTION	TERMINAL FACING		2. No wroi 3. One by 4. No wroi 5. No defc 6. No stuc Importa 1. Make inserted Push aft	ovided jig per mode ng usage of parts one insertion ng insertion ormed terminal ik of terminal tip nt reminders/Note sure wires are pr . Conduct <u>Pull-Pu</u> er insertion.	e/s: operly
16	P1	Wire insertion to Connector PBVP-10V-S (W)	L GR/B LG GR 224 224 226 228 1. Hold the L wire using right hand and 1 using right hand. Repeat the process Note: Follow the insertion sequence be	d support the wire on GR/B, LG, G	R e by left ind GR, P, G, B	and R wires.	R 240	n/a	2. Pleasiduring in 3. Auton the unit terminal half-lock 4. Insert to right. Docume 1. Refer and Strij 2. Refer Push pro 3. Refer	natically dispose a if once encounter, difficulty of inserted connector. ion of wires must ent reference/s: to WI-PRO-CNC-0 b Length Tolerand to GL-PRO-ASY-0 ocedure. to GL-PRO-ASY-Con Standard for content of the co	and replace ed bend rtion and be from left 17 for Wire se. 129 for Pull-

NI	<u> </u>	Process Name/Title:	WORK INST	RUCTION B ASSEMBLY PRO	OCESS		Effectivity Date: Validity Date:		May 14, 2025 n/a	j
		Model code/Part number:	412D / 75V117-7112	Customer: TRJ	Car Model:	LEXUS-ES	·	WI-ENG-PDE-1259		
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	☐ MASSPRO		Revision No.:	0	Page No.:	17 of 2
PARTS:	1. Assy	parts					JIG:	1. Insertion	jig	
NO.	I	PROCESS NAME	WORK PF		TOOLS/PPE					
			Proper alignment of termin BACK VIEW OF TERMINAL FR	ont of terminal	BACK VIEW O		FRONT VIEW OF TERMINAL	2. No wror 3. One by 4. No wror 5. No defo 6. No stuc Importal 1. Make inserted. Push aft Do not e. 2. Please during ir 3. Autom the unit i	1. Use provided jig per model 2. No wrong usage of parts 3. One by one insertion 4. No wrong insertion 5. No deformed terminal 6. No stuck of terminal tip Important reminders/Note/s: 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 2. Please hold the wires near termin during insertion. 3. Automatically dispose and replact the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.	

Note:

(Continuation)

*Make sure the terminal was in proper alignment before insert. *Avoid hitting the terminal into the connector during wire insertion, if encountered abnormality stop the process and call the attention of Immediate superior and Automatically disposed and replace the unit.

GOOD

Terminal condition



GOOD

Terminal condition



Damaged terminal

NO GOOD

Terminal condition

2. Press the upper lock by left hand and hold the assy part by right hand. Check the wire after insertion



Terminal codition

NO GOOD

- Document reference/s:
- 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.
- 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
- 3. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.

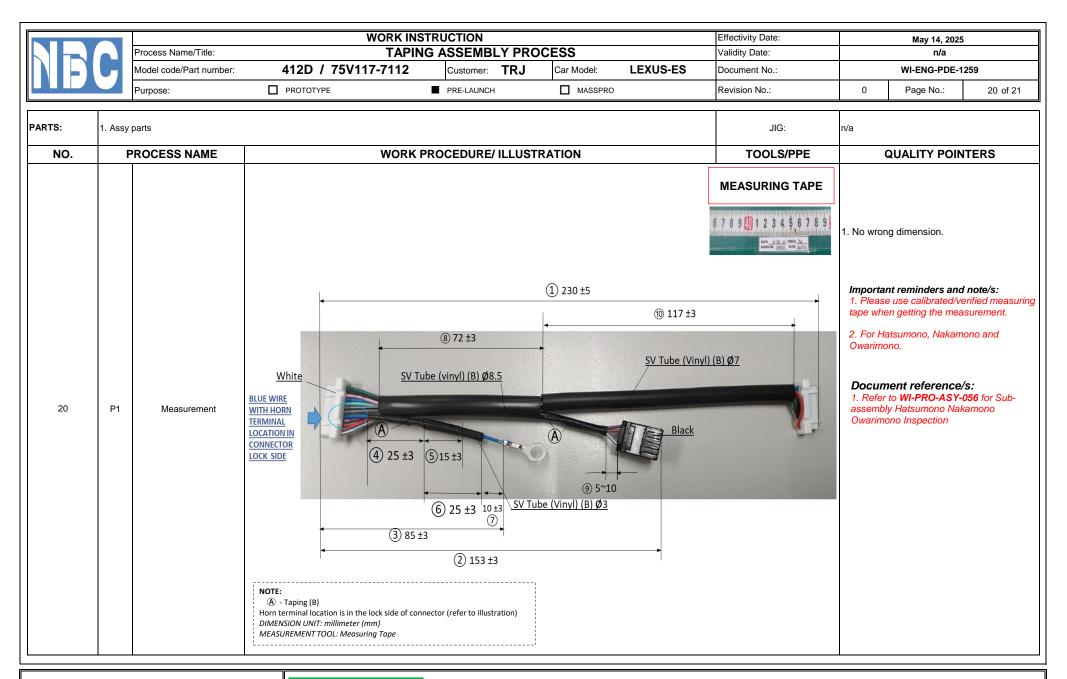


Terminal tip must be visible

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			WORK INSTI	RUCTION			Effectivity Date:		May 14, 2025	
		Process Name/Title:		ASSEMBLY PROC	CESS		Validity Date:		n/a	
		Model code/Part number:	412D / 75V117-7112	Customer: TRJ		LEXUS-ES	Document No.:		WI-ENG-PDE-12	259
		Purpose:		PRE-LAUNCH	☐ MASSPRO		Revision No.:	0	Page No.:	18 of 21
PARTS:	1. Assy	parts					JIG:	n/a		
NO.	F	PROCESS NAME	WORK PR	ROCEDURE/ ILLUSTR.	ATION		TOOLS/PPE	C	QUALITY POIN	TERS
18	P1	Wire folding/ Wire arrangement	Terminal tip is not visible Double lock Terminal tip is visible	uble	Horn terminal on connect	Conduct bending ar connector (PBVP-1) Note: Follow the illustration with the illustration of the illustrat	Terminal tip is not visible al tip is not visible	2. No wrong	g orientation of co g use of connector g terminal facing g facing of wire wit	r

			WORK INST	TRUCTION			Effectivity Date:		May 14, 2025	
		Process Name/Title:		3 ASSEMBLY	PROCESS		Validity Date:		n/a	
		Model code/Part number:	412D / 75V117-7112	Customer: TF	'RJ Car Model:	LEXUS-ES	Document No.:		WI-ENG-PDE-12	259
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	☐ MASSPRO		Revision No.:	0	Page No.:	19 of 21
PARTS:	1. Assy 2. Engi	parts neering sample					JIG:	n/a		
NO.	F	PROCESS NAME	WORK P	ROCEDURE/ ILL	LUSTRATION		TOOLS/PPE	(QUALITY POIN	TERS
			Check the connector lock. Locking of c is included to Steering electrical test.	2. Che Make	neck the wire alignment.	3. Check the ter (not fully inserte terminal.	minal if with backing out d) or no deformed	1. Ref	ument reference ier to WI-QAD-QA ng Electrical Test	
19	P1	Visual/By Two's Inspection	Black SV tube (Vinyl) ACTUAL PRODUCT		BI	Black SV tube (Vinyl	k SV tube (Vinyl)	ENG	GINEERING SAI	WPLE
			4. Check the orientation of harness. 5. Compare to Engineering sample by tapping.		neeing Sample					





	Process Name/Title:	WORK IN TAPI	Effectivity Date: Validity Date:		May 14, 2025 n/a				
- 7 5	Model code/Part number:	412D / 75V117-7112	Customer: TRJ	Car Model:	LEXUS-ES	Document No.:		WI-ENG-PDE-1	259
	Purpose:	PROTOTYPE	PRE-LAUNCH	☐ MASSPRO		Revision No.:	0	Page No.:	21 of
ΓS: 1. Assy	y parts					JIG:	n/a		
		VI	SUAL INSPECTION/ C	QUALITY CHECK	(POINTS	•			
ST	EERING			<mark>75V</mark> 1	17-7	112			
1. Check the no tangled v	e wire alignment. Make sure wires.	2. Check the orientation	of harness.	3. Check if no n missing tape.	nissing parts and	4. Make sure h		located on the	
	5. Check the lock, should	SECOND SECURITION AND			O.,	Black SV tu	be (Vinyl		
	Black SV	/ tube (Vinyl)			Black	SV tube (Vinyl)			
CONTRACTOR OF THE STATE OF THE						Check the terminal if wit	h backing	out (not fully ins	erted)

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