NO. PROCESS NAME  WORK PROCEDURE/ILLUSTRATION  TOULS/PPE  QUALITY POINTERS  TABLE LAY-OUT  Safety Instruction Be sure to wears graderized persons during operation (glows; finger cnts, etc.)  I. Revision finitory  Revision											Effec	ctivity Date:		June 18, 2024			
Puppose:											Valid	Validity Date: n/a					
1. Assay parts; Black Corrugated tube (no sit) 95 L=75±3mm; Black SV tube (Vinyl) 95 L=64±3mm  NO. PROCESS NAME  WORK PROCEDURE/ ILLUSTRATION  TABLE LAY-OUT  Safety Instruction Be sure to wear prostable gersonal protective equipment of units governor for the production of units governor or fine Loader for the production of t				Model code/Part number:	900B.910B / 7N0104-702	Customer:	TRJ	Car Model:	LEXU	JS-NX/R	<b>X</b> Docu	ıment No.:		WI-ENG-PDE-41	0A		
NO. PROCESS NAME  WORK PROCEDURE/ILLUSTRATION  TOLS/PPE  QUALITY POINTERS  TABLE LAY-OUT  Safety Instruction 8: sure to wear 8: sure to wear 8: sure to wear 9: sure to wear 1: Infere rots, etc. 1: Refer to W.ENG-PDE-888 for 0/filling on the 1: Infere rots, etc. 1: Refer to W.ENG-PDE-888 for 0/filling assembly process 1: No massing parts/loods 2: No access parts/loods 2: No access parts/loods 2: No access parts/loods 3: No access parts/loods 4: No access parts/loods 4: No access parts/loods 4: No access parts/loods 5: No access parts/loods 5: No access parts/loods 6: No access parts/loods 7: No access parts/loods 7	шШ			Purpose:	PROTOTYPE	PRE-LAUNCH	ı	MASS	PRO		Revi	sion No.:	4	Page No.:	1 of 6		
NO. PROCESS NAME WORK PROCEDURE/ILLUSTRATION TOOLS/PPE QUALITY POINTERS  TABLE LAY-OUT  Safety Instruction Be sure to wear greater the personnel during operation (glows; finger cnts, etc.)  Black Corregated tube (no sit) 65 L=72 stimm  Black Sy tube (viny) 65 L=44 stimm  Black Sy tube (viny) 65 L=44 stimm  Black Sy tube (viny) 65 L=44 stimm  Black Sy tube (viny) 65 L=64 stimm  Black Sy t														<u> </u>			
TABLE LAY-OUT  Safety Instruction Be sure to wear protective equipment during operation lighors, finger cots, etc.  1. Refer to Wi-ENG-PDE-808 for Offline assembly process  1. No missing partshoots  2. No excess partshoots  1. No missing partshoots  2. No excess partshoots  3. No excess partshoots  4. Separate some process to Office assembly process. Traveler some process to Wile-NOS-PDE-1108 due to process  3. Work instruction  4. Separate some process to Office assembly process. Traveler some process to Wile-NOS-PDE-1108 due to process  3. Work instruction improvement. Change MP from 3049 to 24P. Traveler process from P2 (Page 2-Page 10-11). Change form  3. No instruction improvement. Change MP from 3049 to 24P. Traveler process from P2 (Page 2-Page 10-11). Change form  3. Work instruction improvement. Change MP from 3049 to 24P. Traveler process from P2 (Page 2-Page 10-11). Change form  3. Work instruction improvement. Change MP from 3049 to 24P. Traveler process from P2 (Page 2-Page 10-11). Change form  3. Work instruction improvement. Change MP from 3049 to 24P. Traveler process from P2 (Page 2-Page 10-11). Change form  3. Work instruction improvement. Change MP from 3049 to 24P. Traveler process from P2 (Page 2-Page 10-11). Change form  3. Under the C. Williamov  4. A Arabites  4. A A	PARTS:	IRTS: 1.Assy parts; Black Corrugated tube (no slit) Ø5 L=75±3mm; Black SV tube (Vinyl) Ø5 L=64±3mm										JIG:	1.Terminal	1.Terminal cover jig			
1 P1 Table Lay-out  Black Corregated tube (on sitt) 95 L-75:3mm  Black Struction  Collision  Black Struction  Black Struction  Black Struction  Black Struction  Black Struction  Black Struction  Collision  Black Struction  Black Struction  Collision  Black Struction  Black Struction  Black Struction  Collision  Black Struction  Black Struction  Black Struction  Collision  Action  Collision  Black Struction  Collision  Collision  Collision  Action  Acti	N	٥.	P	PROCESS NAME WORK PROCEDURE/ ILLUSTRATION										QUALITY POINTERS			
Black Sty tube (Viny)  Table Lay-out  Revision History  Revision H						TABLE LAY-	OUT			#		Be sure to wear prescribed persona	1				
06/18/24 4 Separate some process to Offline assembly process. Transfer some process to WI-ENG-PDE410B due to process improvement. Update table lay-out and Quality checkpoints.  D.Castillo	1		P1 Table Lay-out  Black Corrugated tube (no sit) Ø5 L=64:3mm  Black SV tube (Viny) Ø5 L=64:3mm  Black SV tube (Viny) Ø5 L=64:3mm  Black SV tube (Viny) Ø5 L=64:3mm  Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.  Assy part  Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective for immediate corrective.											808 for			
worls/24 4 improvement. Update table lay-out and Quality checkpoints.  D.Castillo a A. Aranes na na A. Aranes na A. Aranes na A. Aranes na A. Aranes na na na A. Aranes na na na A. Aranes na		Revision History										Prepared by	Reviewed by	Approved by	Noted by		
work instruction improvement. Update table lay-out and Quality checkpoints.  Work instruction improvement. Change MP from 3MP to 2MP. Transfer process from P2 (Page 2,Page 10-11). Change term D.Castillo J. Loterte C.Villanuev a A. Arañes A. Arañes and the process of the proce												1					
12/09/22 2 Improve Quality pointers: Reminders/Notes and references on pages no.1,3,4,6,7,9,10 and 11 due to document improvements. Improve Work procedure/illustration on process 4 due to process improvement. Inclusion of Quality pointers.  M. Ariola  J. Loterte  a  A. Arañes  D. Castillo	06/18/24	4							C.Villanuev a	A. Arañes	n/a						
improvements. Improve Work procedure/illustration on process 4 due to process improvement. Inclusion of Quality pointers.  M. Ariola  J. Loterte  a  A. Aranes  D. Castillo  C. Villanueva  A. Aranes  n/a	03/18/23	3							J. Loterte		A. Arañes						
Eff. Date Rev. No Details of Change Revised Reviewed Approved Noted Est. Date: April 12, 2022			improvements. Improve Work procedure/illustration on process 4 due to process improvement. Inclusion of Quality pointers. M. Ariola J. Loterte a A. Aranes J. Loterte a A. Aranes							A. Arañes	n/a						
	Eff. Date	Rev. No			Details of Change			Revised	Reviewed	Approved	Noted	Est. Date:	April 12, 2022				



			WORK INST	RUCTION		Effectivity Date:		June 18, 2024				
		Process Name/Title:		Validity Date:	n/a							
		Model code/Part number:	900B.910B / 7N0104-7020A	Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:		WI-ENG-PDE-41	0A			
		Purpose:	☐ PROTOTYPE	G ASSEMBLY PROCESS A Customer: TRJ Car Model: LEXUS-NX/RX Document No.: WI-ENG-PDE-410A  PRE-LAUNCH MASSPRO Revision No.: 4 Page No.:  3. Black tape 4. Black SV tube (Vinyl) Ø5 L=64±3mm  PROCEDURE/ ILLUSTRATION  TOOLS/PPE  1. Get the Black SV tube (Vinyl) Ø5 L=64±3mm using right hand and insert B-B wires using left hand.  TERMINAL COVER JIG  TERMINAL COVER JIG	2 of 6							
PARTS:	1. Blac 2. Assy	k Corrugated tube (No slit)	Ø5 L=75±3mm		1) Ø5 L=64±3mm	JIG:	JIG: 1. Terminal cover jig					
NO.	F	PROCESS NAME	WORK PR	OCEDURE/ ILLUSTR	ATION	TOOLS/PPE	(	QUALITY POINTERS				
2		Wire insertion to Black SV tube (Vinyl) Ø5 L=64±3mm		L=64±3mm using wires using left ha	right hand and insert B-B	n/a	1. No wrong	) use of part.				
3	P1	Wire insertion to Black Corrugated tube (No slit) Ø5 L=75±3mm	1. Get the terminal cover jig using right hat then insert the B-B wires using left hand.	2. Get the right hand hand.  3. After inser cover jig usir	e Black COT Ø5 L=75±3mm using d and insert B-B wires using left		1. No Wroi 2. No defoi	ng use of parts rmed terminal				

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			WORK INSTRUCTION	Effectivity Date:	June 18, 202	4				
		Process Name/Title:	TAPING ASSEM	Validity Date:	n/a					
		Model code/Part number:	900B.910B / 7N0104-7020A Customer	TRJ	Car Model:	LEXUS-NX/RX	Document No.:		WI-ENG-PDE-4	10A
		Purpose:	PROTOTYPE PRE-LAUNG	Н	MASSPR	0	Revision No.:	4	Page No.:	3 of 6
PARTS:	1. Assy 2. Blac						JIG:	n/a		
NO.		PROCESS NAME	TOOLS/PPE	QUALITY POINTERS						
4	P1	Taping 1 Black corrugated tube to Black SV tube (Vinyl) near connector	1. Fix the corruga and SV tube (Vin both hands. Mak gap between cor tube and SV tube and tagent	/l) using e sure no ugated (Vinyl).	s using both		MEASURING TAPE  6789 1234 \$ 6789	1. Pleas measur measur 2. Must SV tube 1. No flip 2. No per 3. No loo 4. No mis 5. No wro	be no gap between the control of the	verified tting the



			WORK INST				Effectivity Date:		June 18, 202	4
		Process Name/Title:		G ASSEMBLY PROC	CESS		Validity Date:		n/a	
		Model code/Part number:	900B.910B / 7N0104-7020A	Customer: TRJ	Car Model:	LEXUS-NX/RX	Document No.:		WI-ENG-PDE-4	10A
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPF	RO	Revision No.:	4	Page No.:	4 of 6
PARTS:	1. Assy 2. Black						JIG:	n/a		
NO.	F	PROCESS NAME	WORK PI	ROCEDURE/ ILLUSTR	TOOLS/PPE	QUALITY POINTERS				
5	P1	Taping 2 Black SV tube (Vinyl) to wire near connector	1. Hold SV tube (Vinyl) using left hand measure from SV tube (Vinyl) up to er connector 25±3mm.  25±3mm	ind of	R	2. Get Black tape using right hand, hold the SV tube (Vinyl) (ø5 L=64±3mm) using left hand then fold the vinyl tube and start taping using right hand.  k the measurement .	MEASURING TAPE	1. Pleas measur 1. No flip-or 2. No peel- 3. No loose 4. No missi 5. No wrong	ut tape off tape tape	/verified



			WORK INSTRU				Effectivity Date:		June 18, 202	4
		Process Name/Title:		ASSEMBLY PROC	CESS		Validity Date:		n/a	
		Model code/Part number:	900B.910B / 7N0104-7020A	Customer: TRJ	Car Model:	LEXUS-NX/RX	Document No.:		WI-ENG-PDE-41	10A
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPR	RO	Revision No.:	4	Page No.:	5 of 6
PARTS:	1. Assy 2. Black		WORK PRO	OCEDURE/ ILLUSTR	RATION		JIG:	n/a	QUALITY POIN	TERS
6	P1	Taping 3 COT to Wire near Connector	Start of taping  R  25±3mm	1. Hold the Corrugate start taping using right start taping using right and the connector 25±3mm	ed tube using length thand.  then continue	R	MEASURING TAPE	1. Please measure  1. Please measure  Docume 1. WI-PRO  1. No flip-c 2. No peel 3. No loose 4. No miss 5. No wron	e use calibrated/ving tape when getoment.  ent reference/s O-ASY-001 for tape out tape off tape e tape	Note/s: verified ting the



			,								June 18, 2024	
		Process Name/Title:		TAPING	ASSEMBLY PRO	CESS		Validity Date:	n/a			
		Model code/Part number:	900B.910B / 7N01	104-7020A	Customer: TRJ	Car Model:	LEXUS-NX/RX	Document No.:	WI-ENG-PDE-4		1 <b>0A</b>	
		Purpose:	PROTOTYPE		PRE-LAUNCH	MASSPE	20	Revision No.:	4	Page No.:	6 of 6	
		1								1		
PARTS:	n/a							JIG:	n/a			
				4 VISUA	AL INSPECTION/ QU	IALITY CHEC	CKPOINTS					
				<u></u>	AL INOI LOTION QU	ALITT OHE	on on o					
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$       \langle$	<u>1</u> ) No	o Missing COT	•	(3) N	No Missing ta	pe to C	OT and SV to	ube (Vinyl)				
	_							( , 1)				
	2 No	Missing SV	tubo (Vinyl)	(4) N	lo Missins to	no to Ci	OT to wine m	nar cannacter				
		2 20	lube (villyi)		NO IVIISSING TO	he to co	Ji to wire no	ear connector				

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