



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model code/Part number:

922B / 7L0123-7022A

Customer:

TRQSS

Car Model:

LEXUS-NX

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

September 13, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1042B

Revision No.:

1

Page No.:

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PARTS:

1. Assy parts; Connector 6098-3810 (W); Black SV tube (Vinyl) Ø7 L=95±3mm; Black Tape; Blue tape

JIG:

1. Insertion jig
2. Terminal cover jig
3. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

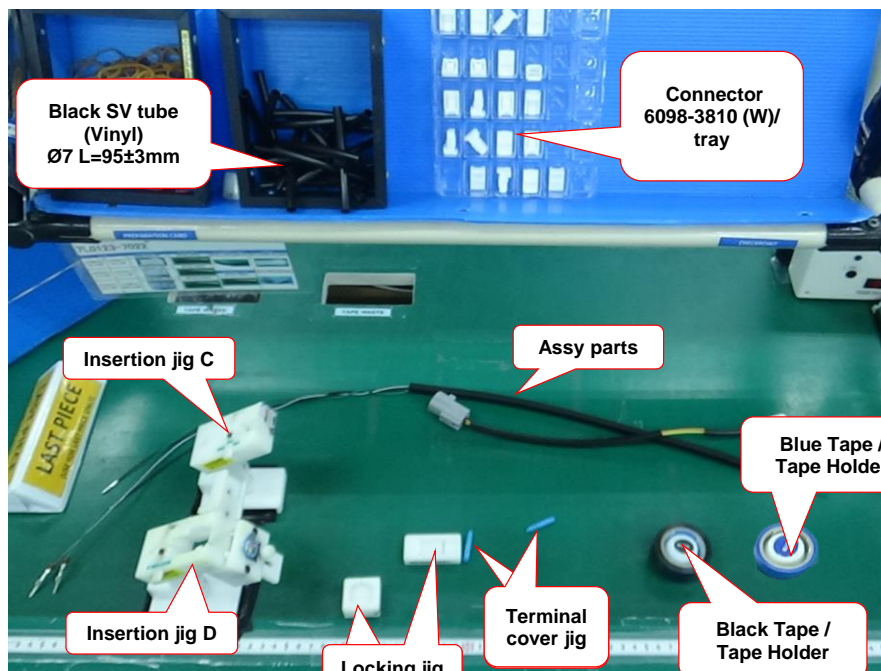
QUALITY POINTERS

1

P2

Table lay-out

TABLE LAY-OUT



Safety Instruction

Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. No missing parts/tools
2. No excess parts/tools
3. No wrong position of parts/tools

Revision History

							Prepared by	Reviewed by	Approved by	Noted by
09/13/24	1	Change pre-launch to mass pro.	A.Hernandez	C. Villanueva	A. Arañes	n/a				
09/09/24	0	Initial issue. Transfer process 2, process 7-10 from P1 and process 11 from P3; change process sequence of process 3 due to process improvement. Improved Table lay-out and Visual inspection.	A.Hernandez	C. Villanueva	A. Arañes	n/a	A.Hernandez	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 09, 2024		

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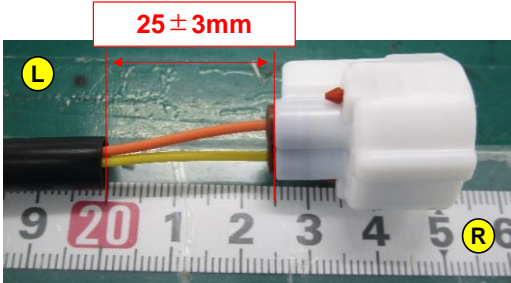
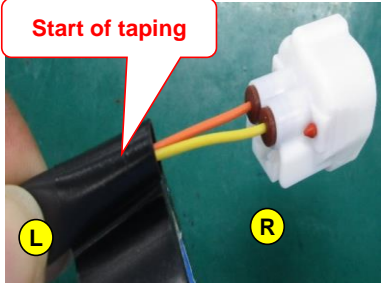
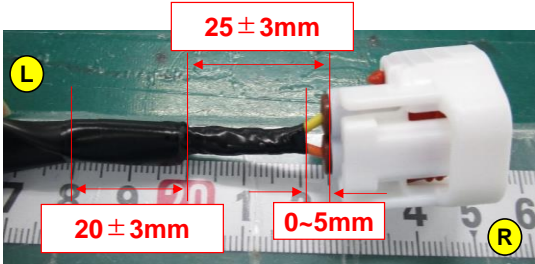


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Black Tape		3. Black SV tube (Vinyl) Ø7 L=95±3mm		JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	P2	Taping 2 Black vinyl tube to wire near connector	<div><div><p>25 ± 3mm</p></div><div><p>1. Measure from end of SV tube (Vinyl) up to edge of connector 25±3mm using both hands.</p></div><div><p>Start of taping</p></div><div><p>2. Get the Black tape using right hand then start taping process using both hands.</p></div><div><p>25 ± 3mm</p><p>20 ± 3mm</p><p>0~5mm</p></div><div><p>3. After taping, check the measurement, wire alignment and taping condition.</p></div></div> <div><div>MEASURING TAPE</div></div>			<p>Important reminders and Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p>	
3		Wire insertion to Black SV tube (Vinyl) Ø7 L=95±3mm (Assy parts)	<div><p>1. Get the Black SV tube (Vinyl) Ø7 L=95 ± 3mm using left hand and insert to two (2) Black wires (Assy parts) using right hand.</p></div>			n/a	<p>1. No wrong usage of parts 2. No deformed terminal</p>

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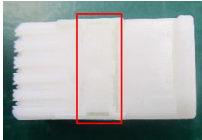
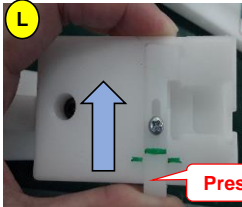
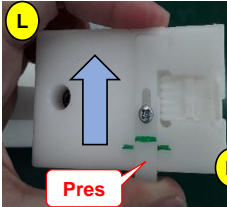
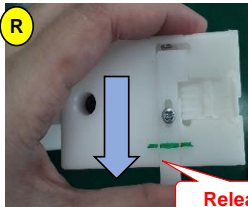





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PARTS:	1. Connector 6098-3810 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2 Connector setting to Insertion jig 6098-3810 (W)	<div><div>INSERTION JIG</div><div></div><div><div>INSERTION JIG</div><div></div><div></div><div>CONNECTOR ORIENTATION</div></div><div><div>L</div><div></div><div>Pres</div></div><div><div>L</div><div></div><div>Pres</div></div><div><div>R</div><div></div><div>Release</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. <i>Note: Follow the connector orientation.</i></div><div></div><div>3. Check the holes/terminal slot for B-B wires.</div></div>	n/a	<div><div>Connector Orientation Illustration</div><div><div>I-mark is align</div><div>2 Holes are widely open</div><div></div><div>GOOD</div></div><div><div>I-mark is not align</div><div>No holes are open</div><div></div><div>NG</div></div><div>CONNECTOR ILLUSTRATION</div><div><div>GOOD</div><div></div><div>6098-3810 (W)</div></div><div><div>NG</div><div></div><div>6098-5677 (W)</div></div></div> <div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</div>

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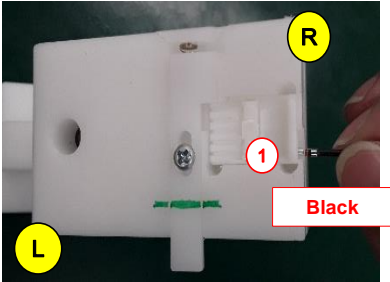
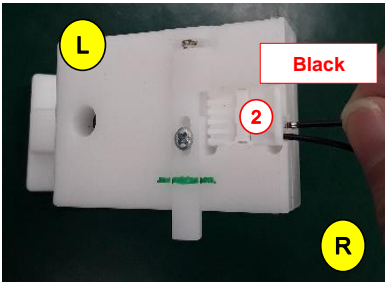
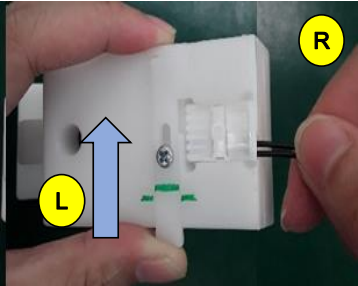
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PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2 Wire insertion to connector 6098-3810 (W)	<div data-bbox="792 400 1046 528"></div> <div data-bbox="1052 432 1305 499"><div>WIRE FACING</div></div> <div data-bbox="568 549 956 831"></div> <div data-bbox="555 842 943 1002"><div>1. Get the 1st Black wire then insert to connector slot 1 using right hand.</div></div> <div data-bbox="1075 549 1462 831"></div> <div data-bbox="1079 842 1467 1002"><div>2. Get the 2nd Black wire then insert to connector slot 2 using right hand.</div></div> <div data-bbox="607 1031 963 1318"></div> <div data-bbox="978 1090 1458 1276"><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></div>		n/a	<p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Please hold the wire near terminal.2. Make sure wires are properly inserted.Conduct Pull-Push-Pull-Push after insertion.Do not exert extra force.3. Insertion of wires must be from left to right <p>Document references:</p> <ol style="list-style-type: none">1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance <ol style="list-style-type: none">1. No loose insertion2. No wrong insertion3. One by one insertion4. No deform terminal5. No wrong wire facing

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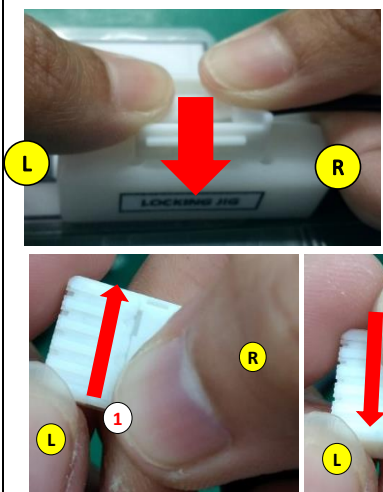

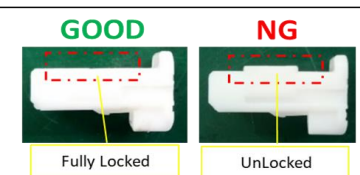
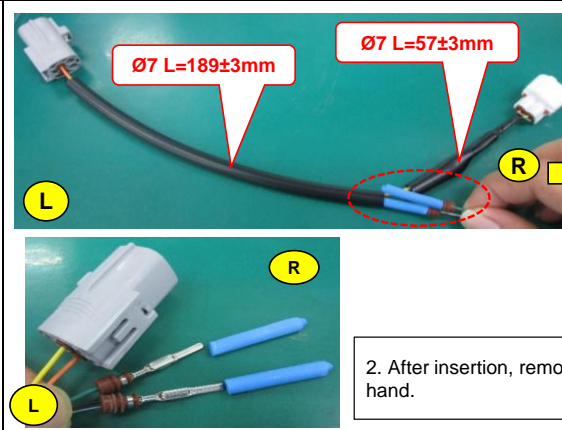

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PARTS:	1. Assy parts			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	Connector lock	 <p>1. Put the connector into locking jig using both thumb then press to lock 2x. Check the connector lock if properly locked.</p> <p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p>		 <p>LOCKING JIG</p>	<p>Important reminders/Note/s:</p> <p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <p>Document reference/s:</p> <p>1. Refer to GL-PRO-ASY-017 for the verification of connector lock.</p> <p>1. Use the provided locking jig per model 2. No unlock/half-locked connector</p> <p>CONNECTOR LOCK CONDITION</p>  <p>GOOD Fully Locked NG UnLocked</p>
7	Wire insertion to assy parts	 <p>Ø7 L=189±3mm Ø7 L=57±3mm</p> <p>1. Hold the SV tube Ø7 L=189±3mm using left hand then insert the assy parts using right hand.</p> <p>2. After insertion, remove the terminal cover jig using right hand.</p>		 <p>TERMINAL COVER JIG</p>	<p>1. No wrong usage of parts 2. No damaged rubber seal 3. No wrong insertion</p>

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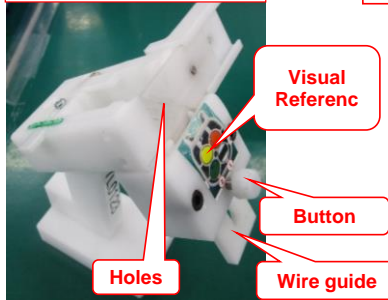
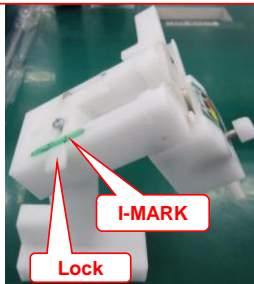

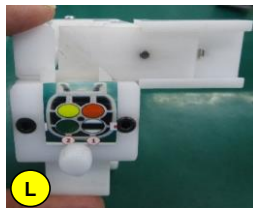
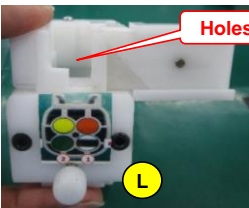
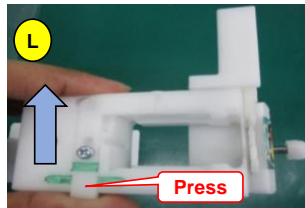
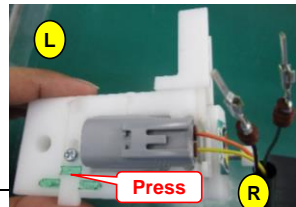
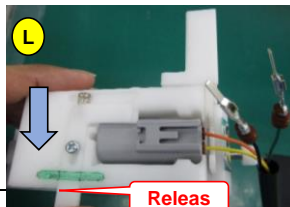

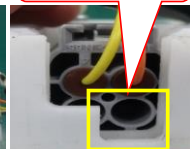

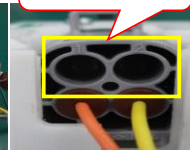
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PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P2	<div><div><div>INSERTION JIG</div></div><div><div>INSERTION JIG ORIENTATION</div></div><div><div>CONNECTOR ORIENTATION</div></div></div> <div><div><div>Holes</div><div>L</div></div><div><div>Holes</div><div>L</div></div><div><div>L</div><div>Press</div></div></div> <div><div><div>L</div><div>Press</div><div>R</div></div><div><div>L</div><div>Releas</div></div><div><div>3. Insert the connector 6188-0066 (GR) into jig using right hand then release the lock. Note: Follow the connector orientation.</div></div></div>		n/a	<div><div><div>Connector Orientation Illustration</div><div><div>I-mark is align</div></div><div><div>1 hole is open</div></div></div><div>GOOD</div><div><div>I-mark is NOT align</div></div><div><div>2 holes are open</div></div></div> <div>NG</div> <div><div>1. Use the provided jig per model</div><div>2. No wrong orientation of connector</div><div>3. No wrong use of connector</div><div>4. No damaged connector</div></div>

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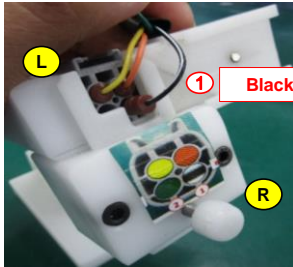
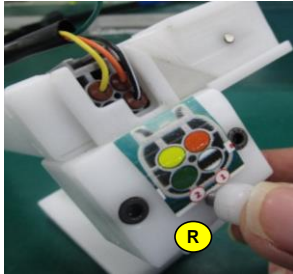
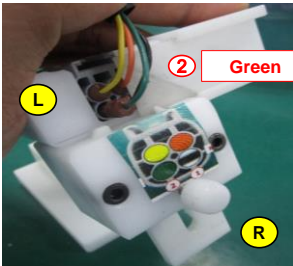
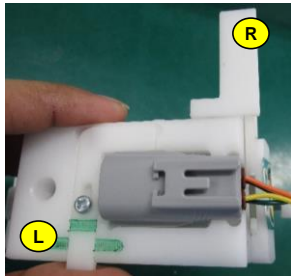
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PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P2	<div><div><div>WIRE FACING</div></div><div><div><div>1. Hold the insertion jig using left hand, get Black/white wire then insert to connector slot 1 using right hand.</div></div><div><div><div>2. Press the button using right hand, slot for Green wire will be opened.</div></div><div><div><div>3. Hold the insertion jig using left hand, get Green wire then insert to connector slot 2 using right hand.</div></div><div><div><div>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.</div></div></div></div><div>n/a</div><div><p>Important reminders/Note/s:</p><ol style="list-style-type: none">1. Please hold the wire near terminal.2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.3. Insertion of wires must be from left to right<p>Document references:</p><ol style="list-style-type: none">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></div></div></div>		

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☐ PRE-LAUNCH

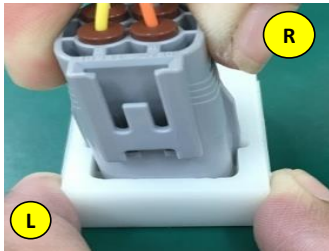

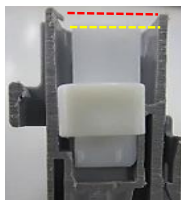



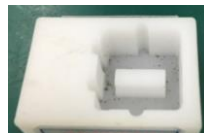
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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	P2	Connector lock	<div><div></div><div><p>1. Put the connector into locking jig using right hand then press 2x. Touch the connector lock if properly locked.</p></div><div><div><div><p>Connector Cross Sectional View</p><div><div><p>NG</p><p>Unlock Condition</p></div><div><p>NG</p><p>Half Lock Condition</p></div><div><p>GOOD</p><p>Full Lock Condition</p></div></div></div></div></div><div><div><p>Before pressing</p></div><div><p>After pressing</p></div></div></div>	<div><p>LOCKING JIG</p></div>	<p>Important reminders/Note/s:</p> <p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <p>1. Use the provided locking jig per model 2. No unlock/half-lock connector</p>

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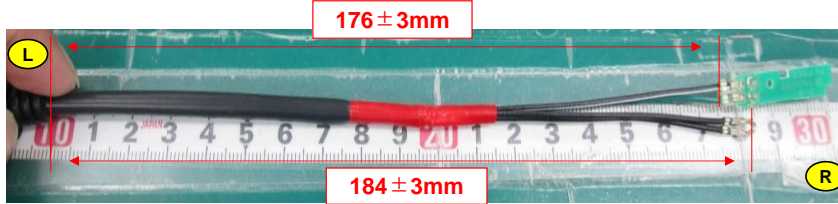
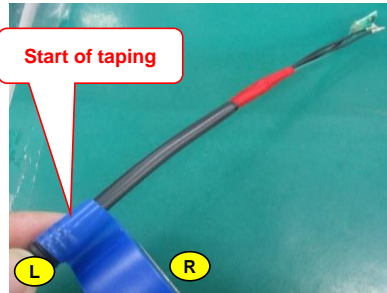
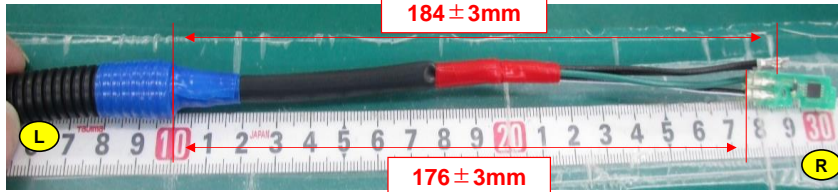

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PARTS:		1. Assy parts 2. Blue tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P2 Taping 3 Black corrugated tube to Black VM tube (Sunprene)	 <p>1. Measure from end of sunprene tube up to edge of hotmelted wire 176±3mm and up to terminal pointed tip 184±3mm using both hands.</p>  <p>2. Get the Blue tape using right hand then start taping process using both hands.</p>  <p>3. After taping, check the measurement and taping condition.</p>		MEASURING TAPE 	<p>1. No flip-out tape 2.No peel-off tape 3. No loose tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape</p> <p>Important reminders and Note/s: 1. Use BLUE TAPE only. 2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p>

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

September 13, 2024

Validity Date:

n/a

Model code/Part number:

922B / 7L0123-7022A

Customer:

TRQSS

Car Model:

LEXUS-NX

Document No.:

WI-ENG-PDE-1042B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

10 of 10

PARTS:

1. Assy part

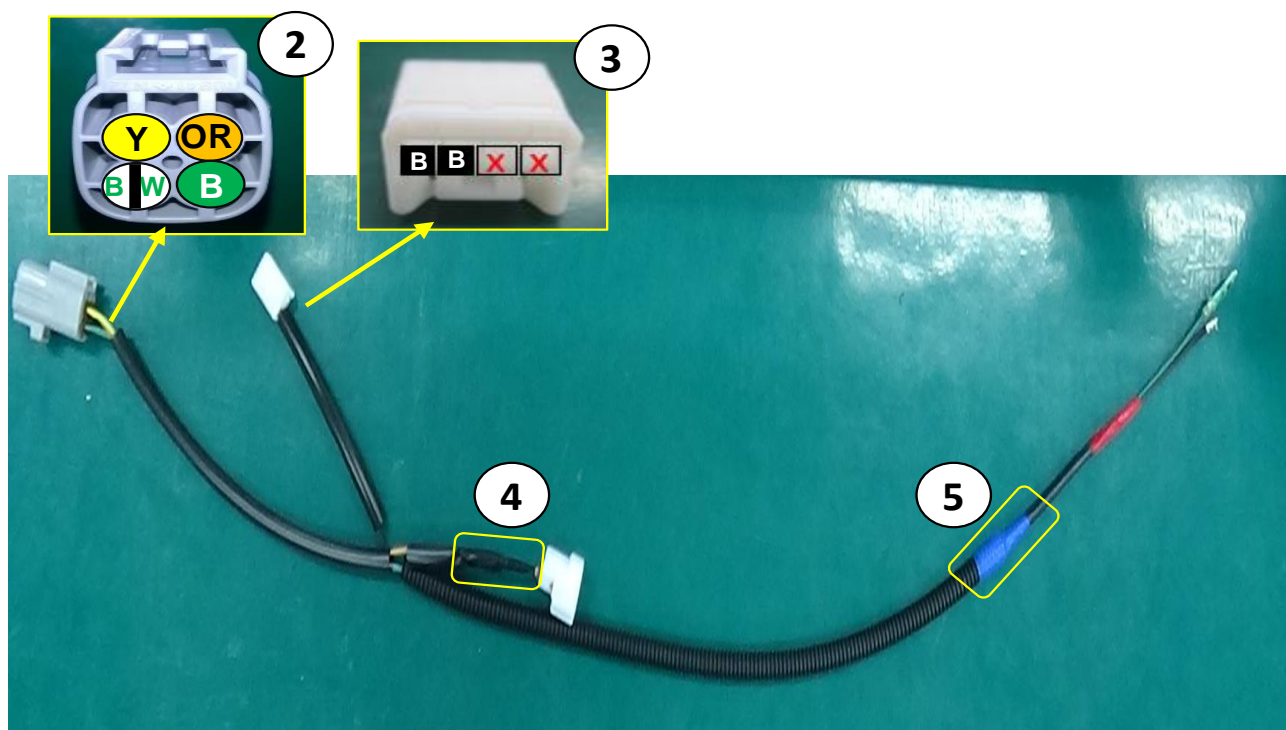
JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING - P2

7L0123-7022A



- 1 No Unlocked /Half-locked Connector
- 2 3 No Wrong Insert
- No Missing Tape/
- 4 No Wrong used of tape (Black tape)
- No Missing Tape/
- 5 No Wrong used of tape (BLUE tape)
- 6 No Deformed Terminal
- 7 No Terminal Backing out

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