



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 22, 2024

Process Name/Title:

Model code/Part number:

800B/900B/910B / 7N0101-7020D

Customer: TRJ

Car Model:

LEXUS-NX/RX

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

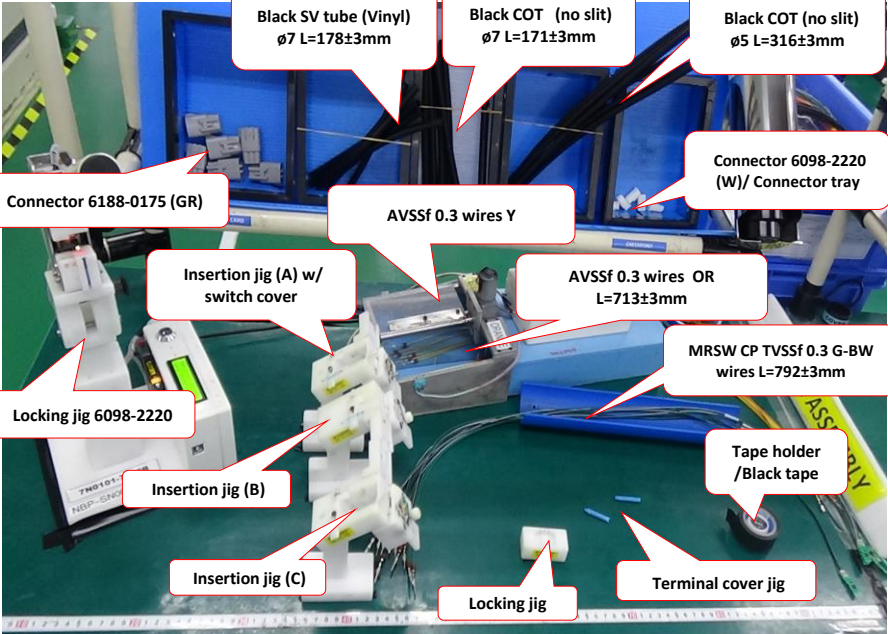
WI-ENG-PDE-1134A

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PARTS:		1. Connector 6188-0175 (GR) 4. Black COT (no slit) ø7 L=171±3mm 7. MRSW CP TVSSf 0.3 G-BW wires L=792±3mm		2.Connector 6098-2220 (W) 5. Black COT (no slit) ø5 L=316±3mm 8. Black Tape		3.Black SV tube (Vinyl) ø7 L=178±3mm 6. AVSSf 0.3 wires Y/ OR L=713±3mm		JIG:	1. Insertion jig with & w/o switch cover 2. Locking jig 3. Terminal cover jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS
1	P1	Table Lay-out	<div>TABLE LAY-OUT</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>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to WI-PRO-KIT-005 Wire Taping without Vinyl Tube</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>

Revision History

				Prepared by		Reviewed by	Approved by	Noted by
10/22/24	1	Change from Pre-launch to Masspro.	A. Hernandez	C. Villanueva	A. Arañes	n/a		
10/17/24	0	Initial Issue.	A. Hernandez	C. Villanueva	A. Arañes	n/a		
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 17, 2024

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PARTS:		1. Connector 6188-0175 (GR)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1 Connector setting to Insertion jig 6188-0175 (GR)	<div><div><div>Insertion jig with switch cover</div><div><div><div>I-mark</div><div>Lock</div></div><div>Visual reference</div></div><div><div>INSERTION JIG ORIENTATION</div><div>CONNECTOR ORIENTATION</div></div></div><div><div><div>L</div><div><div>Press</div></div><div>R</div></div><div><div>L</div><div><div>Press</div></div><div>R</div></div><div><div>L</div><div><div>Release</div></div><div>R</div></div></div><div><div>1. Press the lock using left thumb.</div><div>2. Get the connector 6188-0175 (GR) using right hand and insert to insertion jig. Release the lock after insertion. <i>Note: Follow the connector orientation.</i></div><div><div><div>L</div><div><div>Hole</div></div></div><div>3. Push the lower wire guide upward using left thumb. Slot for Yellow wire will be opened.</div></div></div></div>		n/a	<div><div>Connector Orientation Illustration</div><div><div><div>I-mark is align</div><div>1 hole is open</div></div><div>GOOD</div><div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div></div></div>

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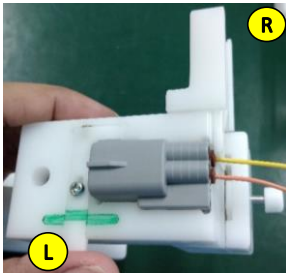
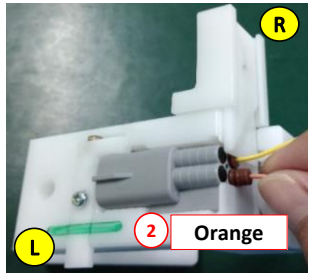

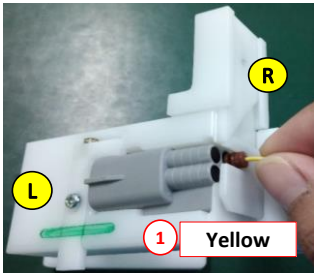
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PARTS:		1. Connector 6188-0175 (GR) 2. AVSSf 0.3 wires Y L=713±3mm 3. AVSSf 0.3 wires OR L=713±3mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to connector 6188-0175 (GR)	<div><p>1. Hold the insertion jig using left hand. Get Yellow wire then insert to terminal slot 1 using right hand. <i>Note : Conduct Pull-Push-Pull-Push after insertion.</i></p><p>2. Press the button using right thumb. The slot for Orange wire will be opened.</p><p>3. Get the Orange wire then insert to terminal slot 2 using right hand. <i>Note : Conduct Pull-Push-Pull-Push after insertion.</i></p><p>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.</p></div>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal.</p> <p>2. Make sure wires are properly inserted.</p> <p>Conduct Pull-Push-Pull-Push after insertion.</p> <p>Do not exert extra force.</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p>

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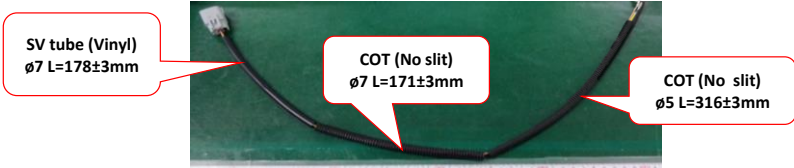
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PARTS:		1. Assy parts 2. Black SV tube (Vinyl) $\phi 7$ L=178 \pm 3mm 3. Black COT (no slit) $\phi 7$ L=171 \pm 3mm 4. Black COT (no slit) $\phi 5$ L=316 \pm 3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	Wire insertion to Black SV tube (Vinyl) $\phi 7$ L=178 \pm 3mm	<div></div> <div>1. Get the Black SV tube (Vinyl) $\phi 7$ L=178\pm3mm using right hand then insert the Y-OR wires using left hand.</div>	n/a	1. No wrong use of parts 2. No deformed terminal
5		Wire insertion to Black corrugated tube (no slit) $\phi 7$ L=171 \pm 3mm (1ST) $\phi 5$ L=316 \pm 3mm (2ND)	<div></div> <div>1. Get the Black COT (no slit) $\phi 7$ L=171\pm3mm using right hand then insert the Y-OR wires.</div> <div></div> <div>2. Get the Black COT (no slit) $\phi 5$ L=316\pm3mm using right hand then insert the Y-OR wires.</div> <div></div>	n/a	1. No wrong use of parts 2. No deformed terminal

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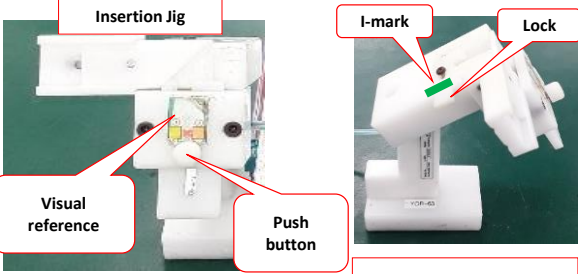
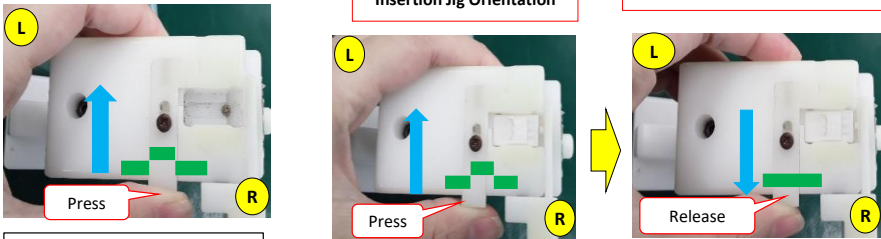
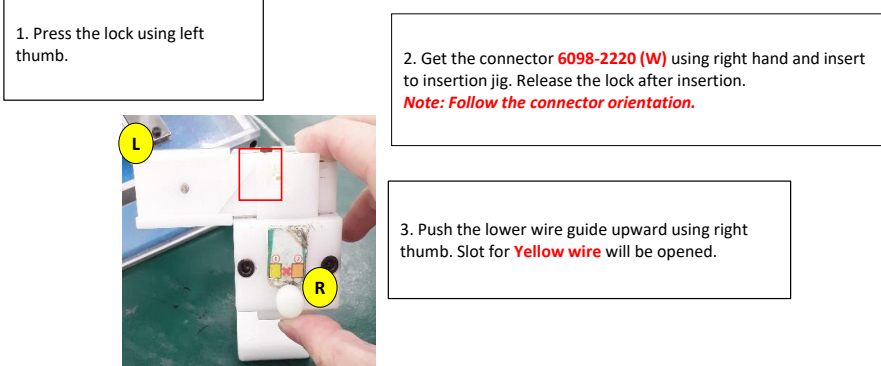
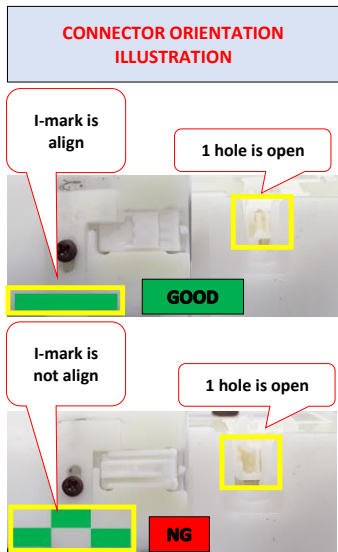
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PARTS:		1. Connector 6098-2220 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1 Connector setting to Insertion jig 6098-2220 (W)	<div><div></div><div></div><div></div></div> <div><p>1. Press the lock using left thumb.</p><p>2. Get the connector 6098-2220 (W) using right hand and insert to insertion jig. Release the lock after insertion. Note: Follow the connector orientation.</p><p>3. Push the lower wire guide upward using right thumb. Slot for Yellow wire will be opened.</p></div>		n/a	<div><div><p>CONNECTOR ORIENTATION ILLUSTRATION</p></div><div><p>1. Use the provided jig per model</p><p>2. No wrong orientation of connector</p><p>3. No wrong use of connector</p><p>4. No damaged connector</p></div></div>

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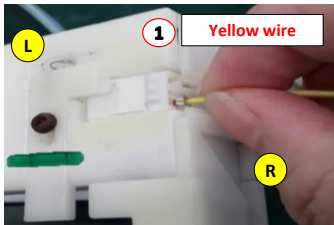
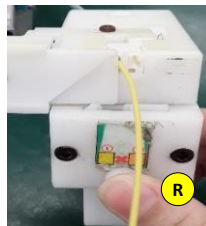
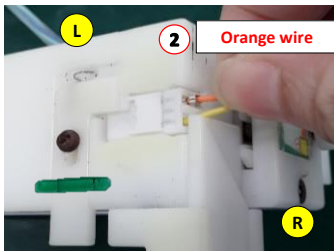
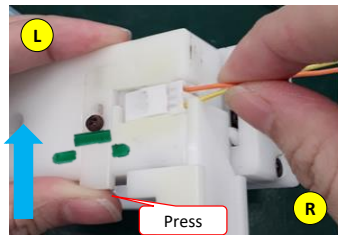
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PARTS:		1. Assy parts 2. Connector 6098-2220 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1 Wire Insertion to Connector 6098-2220 (W)	<div><div>Terminal facing</div></div> <div><div>1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot 1 using right hand. Conduct Pull-Push-Pull-Push after insertion.</div></div> <div><div>2. Press the button using right thumb. The slot for Orange wire will be opened.</div></div> <div><div>3. Get the Orange wire then insert to terminal slot 2 using right hand. Conduct Pull-Push-Pull-Push after insertion.</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>		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. 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.</div> <div>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure</div>

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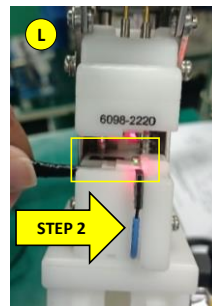
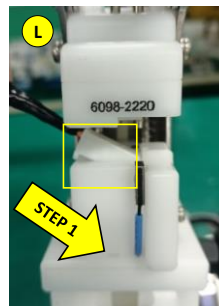
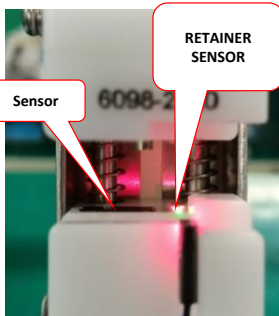
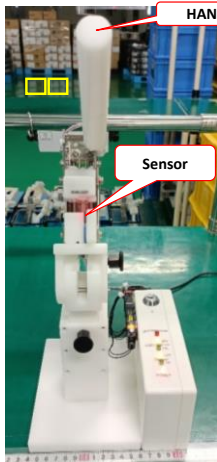
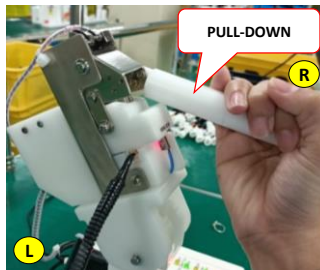
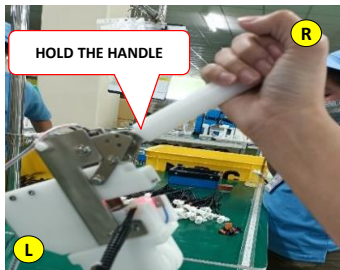
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PARTS:		1. Assy parts		JIG:	1. Locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
8	P1	Connector lock				<div><div></div><div><p>1. Hold the assy parts using left hand and insert into connector locking jig based on the direction of arrow. Make sure the connector touch the sensor. Sound will be heard if properly lock.</p><p>NOTE: CONNECTOR LOCKING JIG WILL NOT FUNCTION IF CONNECTOR NOT REACH THE SENSOR.</p></div><div><div></div><div><p>2. Hold the handle of the connector locking jig using right hand then gently pull down and bring back to original position after locking. Note: Pull down one time only.</p></div></div><div><p>1. Maintain 10mm proper holdeing of wire to connector</p><p>2.Connector must be fully inserted to connector slot.</p><p>3. Make sure no offset setting before locking process.</p><p>4. No wrong setting of connector.</p><p>5. No damaged connector lock</p><p>6. No unlocked/ half-locked connector.</p><p>Important reminders/Note/s:</p><p>1. Incomplete locking process will alarm the jig.</p><p>2. No retainer in connector cannot proceed.</p><p>3. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</p></div></div>

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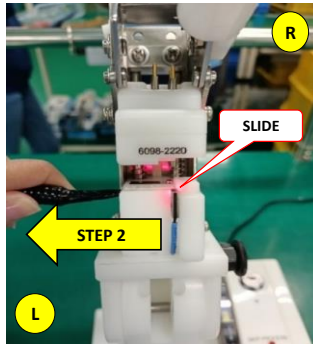
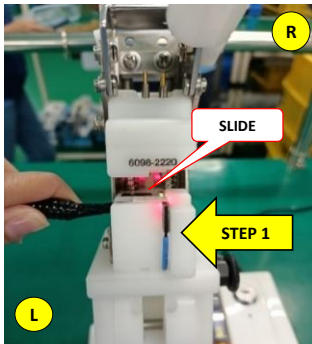
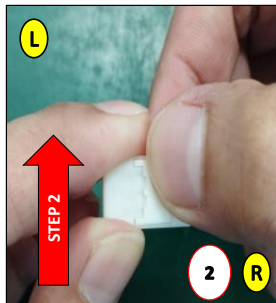
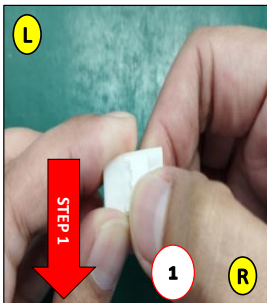
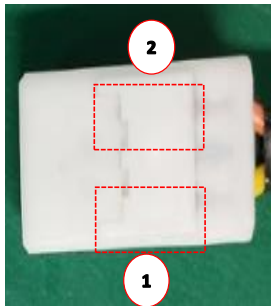
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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1	<div><div>3. Remove the locked connector using left hand based on the illustration, follow the direction of arrow.</div></div> <div><div>4. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</div></div>			<div>1. Maintain 10mm proper holding of wire to connector 2. Connector must be fully inserted to connector slot. 3. Make sure no offset setting before locking process. 4. No wrong setting of connector. 5. No damaged connector lock 6. No unlocked/ half-locked connector.</div> <div>Important reminders/Note/s: 1. Incomplete locking process will alarm the jig. 2. No retainer in connector cannot proceed. 3. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</div>

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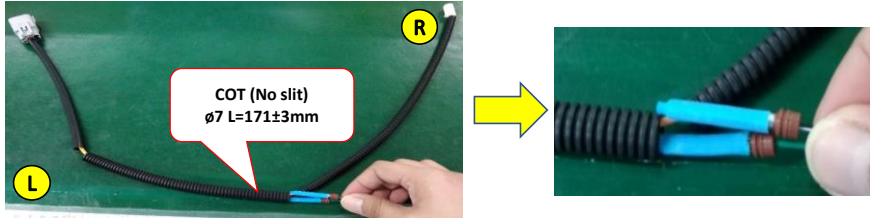
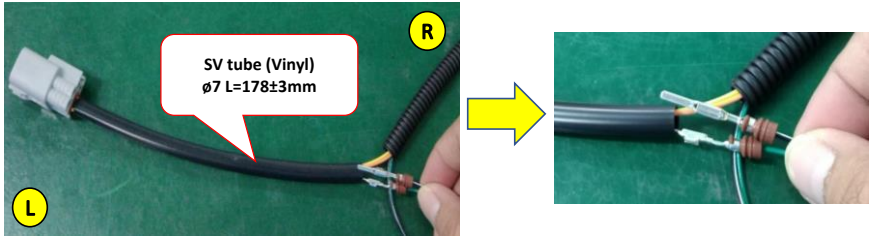

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PARTS:		1. Assy parts 2. MRSW CP TVSSf 0.3 G-BW wires L=792±3mm		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	P1	<div></div> <div></div> <div></div> <div><p>2. Hold the corrugated tube (no slit) $\varnothing 7$ L=171±3mm using left hand then insert G-B/W wires using right hand.</p><p>3. Hold the SV tube (Vinyl) $\varnothing 7$ L=178±3mm using left hand then insert G-B/W wires using right hand.</p></div>		<div>TERMINAL COVER JIG</div> 	1. No wrong use of parts 2. No deformed terminal

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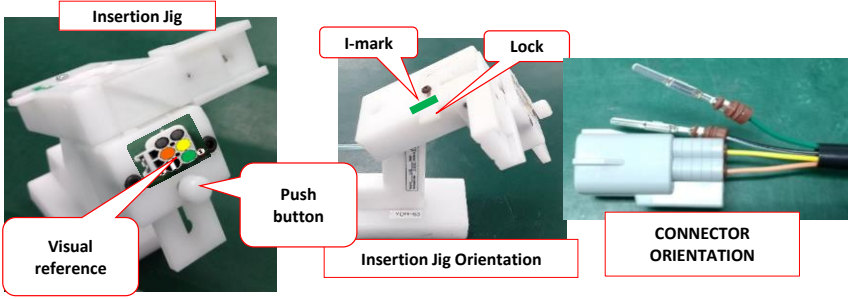
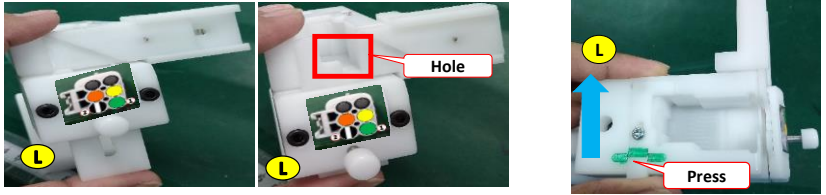
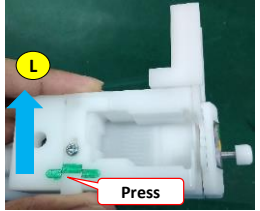
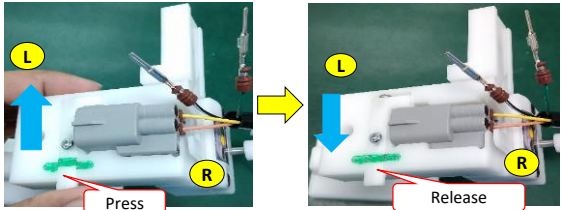
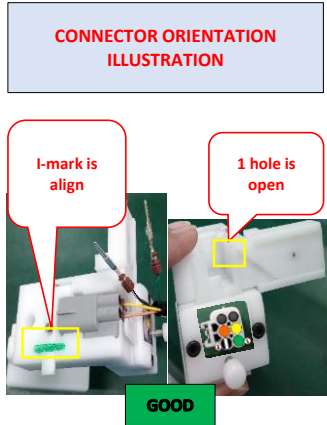
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PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1 Connector setting to insertion jig 6188-0175 (GR) (Assy parts)	   <p>1. Push the lower wire guide upward using left thumb. Slot for Green wire will be opened.</p> <p>2. Press the lock of the insertion jig using left hand.</p>  <p>3. Get the connector 6188-0175 (GR) (assy parts) using right hand and insert to insertion jig. Release the lock after insertion. Note: Follow the connector orientation.</p>		n/a	 <p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 22, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

800B/900B/910B / 7N0101-7020D

Customer: TRJ

Car Model:

LEXUS-NX/RX

Document No.:

WI-ENG-PDE-1134A

Purpose:


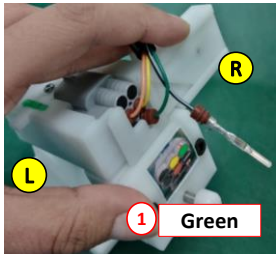
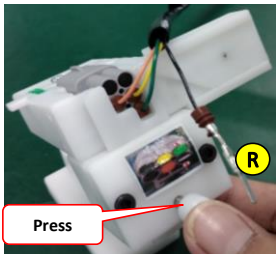
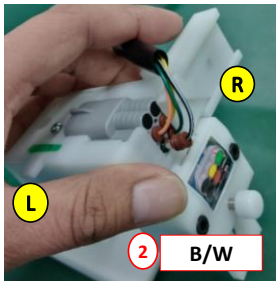
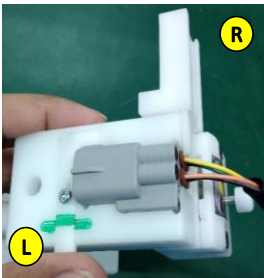
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Revision No.:

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PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
12	P1	<div><p>Terminal facing</p><p>1 Green</p><p>Press</p><p>1. Hold the insertion jig using left hand. Get Green wire then insert to terminal slot 1 using right hand.</p><p>2 B/W</p><p>2. Press the button using right hand. The slot for Black/white wire will be opened.</p><p>3. Get the Black/white wire then insert to terminal slot 2 using right hand. Conduct Pull-Push-Pull-Push after insertion.</p><p>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.</p></div>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p>Important reminders/Note/s:</p> <p>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.</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p>

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

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800B/900B/910B / 7N0101-7020D

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Purpose:

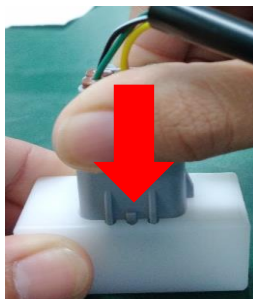



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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
13	P1	Connector lock	<div><div>1. Hold the connector using left hand then press 2x to lock using right hand. Touch the connector lock to confirm if properly locked.</div><div><div>Before pressingAfter pressing</div><div>NOTE: SET ASIDE THE ASSY PARTS</div></div></div>	<div>LOCKING JIG</div> 	<p>Important reminders/Note/s:</p> <p>1. Manual locking may cause damaged connector lock.</p> <p>1. Use the provided jig per connector 2. No unlock/half-locked connector</p>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

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October 22, 2024

Process Name/Title:

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n/a

Model code/Part number: 800B/900B/910B / 7N0101-7020D

Customer: TRJ

Car Model: LEXUS-NX/RX

Document No.:

WI-ENG-PDE-1134A

Purpose:

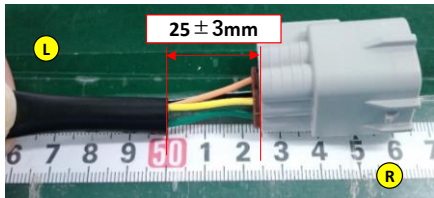
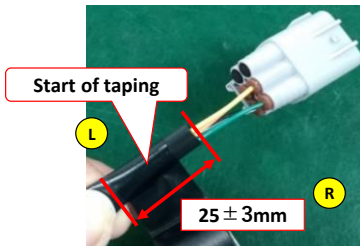
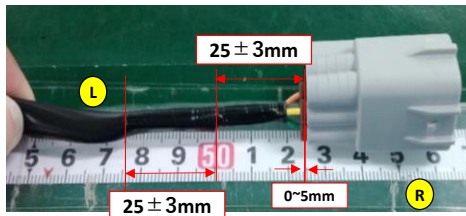

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
14	P1 Taping 1 Black SV tube (Vinyl) to wire near connector	<div><p>1. Measure from end of tube up to edge of connector 25±3mm using both hands.</p></div> <div><p>2. Hold the SV tube (Vinyl) using left hand, get the Black tape using right hand then start taping process using both hands.</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>		<div>MEASURING TAPE</div> 	<p>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</p> <p>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 1. Please refer to WI-PRO-ASY-001 for taping procedure.</p>

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PARTS:

1. Assy part

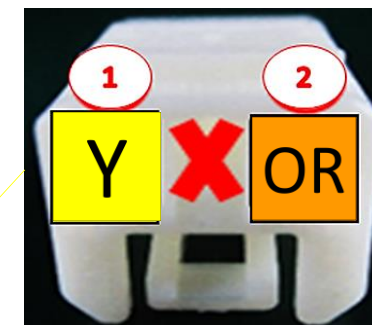
JIG:

n/a

VISUAL INSPECTION / QUALITY CHECKPOINTS

P1

7N0101-7020D



1 No Unlocked / Halflocked Connector

2 No Wrong Insert (2 Connector)

3 No Terminal Backing Out

4 No Deformed Terminal

5 No Missing Tape (Black Tape)

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