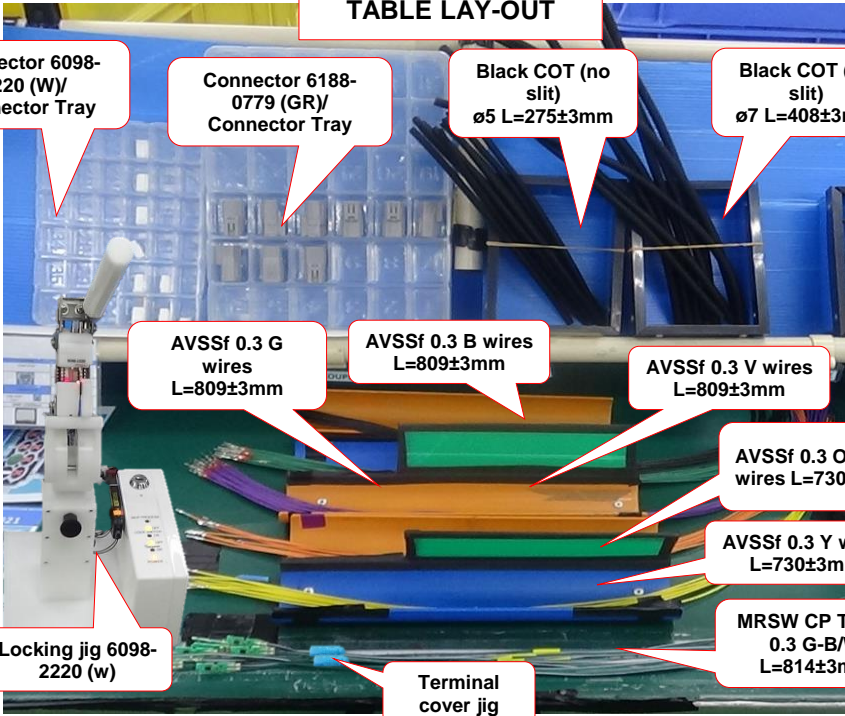



	<b>WORK INSTRUCTION</b> <b>TAPING ASSEMBLY PROCESS</b>				Effectivity Date:	October 22, 2024	
	Process Name/Title:				Validity Date:	n/a	
	Model code/Part number:	240B / 7M0516-7021B	Customer:	TRJ	Car Model:	LEXUS-ES	
	Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Document No.:	WI-ENG-PDE-1091A	
					Revision No.:	1	Page No.: 1 of 10

PARTS:		1. All parts: Connector 6098-2220 (W); Connector 6188-0779 (GR); Black COT (no slit) ø5 L=275±3mm; Black COT (no slit) ø7 L=408±4mm; AVSSf 0.3 Y-OR wire L=730±3mm; MRSW CP TVSSf 0.3 G-B/W L=814±3mm; AVSSf 0.3 G-V-B wires L=809±3mm				JIG:	1. Terminal cover jig 2. Locking jig 6098-2220 (W)
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS
1	P1	<div> <div>TABLE LAY-OUT</div>  <div>Connector 6098-2220 (W)/ Connector Tray</div> <div>Connector 6188-0779 (GR)/ Connector Tray</div> <div>Black COT (no slit) ø5 L=275±3mm</div> <div>Black COT (no slit) ø7 L=408±3mm</div> <div>AVSSf 0.3 G wires L=809±3mm</div> <div>AVSSf 0.3 B wires L=809±3mm</div> <div>AVSSf 0.3 V wires L=809±3mm</div> <div>AVSSf 0.3 OR wires L=730±3mm</div> <div>AVSSf 0.3 Y wires L=730±3mm</div> <div>MRSW CP TVSSf 0.3 G-B/W L=814±3mm</div> <div>Locking jig 6098-2220 (w)</div> <div>Terminal cover jig</div> </div>				<div> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div> <b>Housekeeping</b>            1. Maintain and always practice 5's.            2. Personal things on the workplace is prohibited. Keep it in your locker.         </div> <div> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>	<b>Document references:</b> 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. WI-PRO-KIT-005 Wire Taping without Vinyl Tube  1. No missing parts/tools 2. No excess parts/tools

Revision History							Prepared by	Reviewed by	Approved by	Noted by		
							 M. Ariola	 C. Villanueva	 A. Arañes	n/a		
10/22/24	1	Change purpose from Pre-launch to Masspro.			M. Ariola	C. Villanueva					A. Arañes	n/a
10/17/24	0	Initial issue.			M. Ariola	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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## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

October 22, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

240B / 7M0516-7021B

Customer: TRJ

Car Model:

LEXUS-ES

Document No.:

WI-ENG-PDE-1091A

Purpose:



PROTOTYPE



PRE-LAUNCH



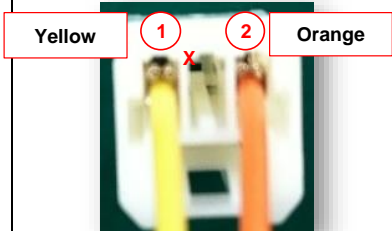
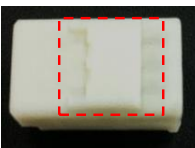

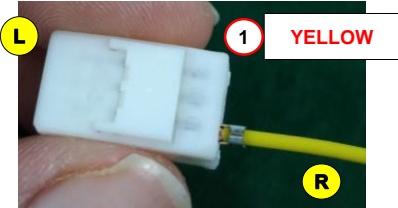
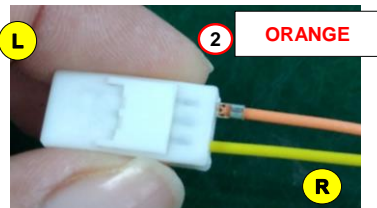
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PARTS:	1. Connector 6098-2220 (W) 2. AVSSf 0.3 Y-OR wires L=730±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1  Wire insertion to Connector 6098-2220 (W)	<div><div>Yellow</div><div>1</div><div>2</div><div>Orange</div></div> <div><div>CONNECTOR ORIENTATION</div></div> <div><div>TERMINAL FACING</div></div> <div><div>L</div><div>1</div><div>YELLOW</div><div>R</div><div>1. Hold the connector <b>6098-2220 (W)</b> using left hand then insert the <b>Yellow wire</b> to terminal <b>slot 1</b> using right hand.</div></div> <div><div>L</div><div>2</div><div>ORANGE</div><div>R</div><div>2. Hold the connector <b>6098-2220 (W)</b> using left hand then insert the <b>Orange wire</b> to terminal <b>slot 2</b> 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 6. No wrong orientation of connector</div> <div><b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal.</b> <b>2. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b></div> <div><b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b> <b>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b></div>

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October 22, 2024

Process Name/Title:

Model code/Part number:

240B / 7M0516-7021B

Customer: TRJ

Car Model:

LEXUS-ES

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1091A

Purpose:



PROTOTYPE



PRE-LAUNCH



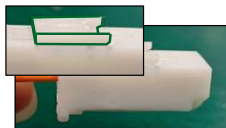
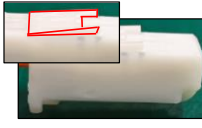
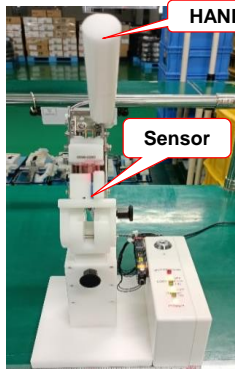
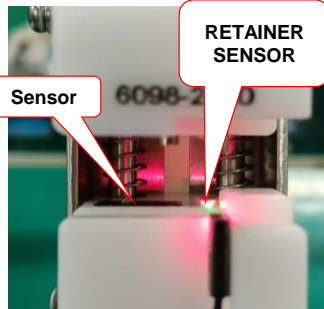
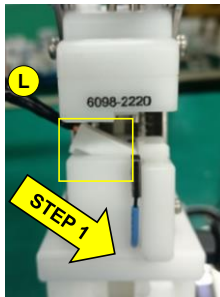
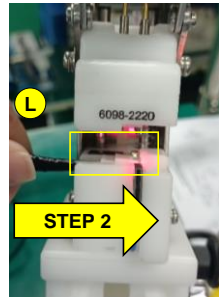
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1 Connector lock	<div><div><div>CONNECTOR RETAINER ILLUSTRATION SIDE VIEW</div><div><div><div>GOOD</div></div><div><div>NG</div></div></div><div><div><div>HANDLE</div><div>Sensor</div></div><div><div>RETAINER SENSOR</div><div>Sensor</div></div><div><div>STEP 1</div></div><div><div>STEP 2</div></div></div><div>2. 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. <b>NOTE: CONNECTOR LOCKING JIG WILL NOT FUNCTION IF CONNECTOR NOT REACH THE SENSOR.</b></div></div><div></div><div><p>1. Please ensure that Connector lock/retainer will not touch or hit by any object prior insertion into locking jig to avoid half-lock connector.</p><p>2. Maintain 10mm proper holding of wire to connector</p><p>3. Connector must be fully inserted to connector slot.</p><p>4. Make sure no offset setting before locking process.</p><p>5. No wrong setting of connector.</p><p>6. No damaged connector lock</p><p>7. No unlocked/ half-locked connector.</p><p><b>Important reminders/Note/s:</b></p><p>1. <i>Incomplete locking process will alarm the jig.</i></p><p>2. <i>No retainer in connector cannot proceed.</i></p><p>3. <i>If encountered abnormality, <b>STOP</b> and immediately <b>CALL</b> the attention of the leader. <b>WAIT</b> for further instruction and continue the process.</i></p></div></div>		

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240B / 7M0516-7021B

Customer: TRJ

Car Model:

LEXUS-ES

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1091A

Purpose:



PROTOTYPE



PRE-LAUNCH




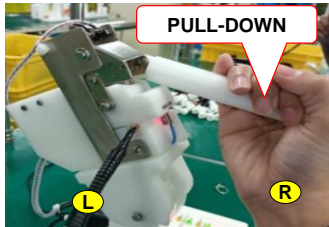
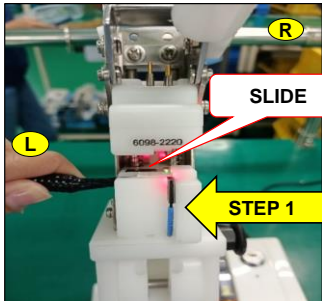
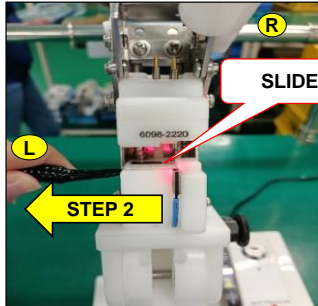
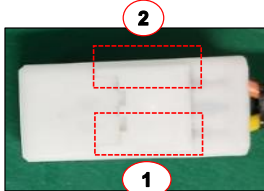

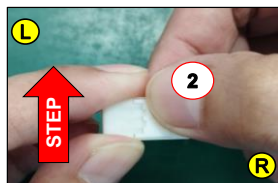
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1 Connector Lock (Continuation)	<div><div><div></div><div></div><div></div><div></div><div></div><div></div><div></div></div><div><p>3. Hold 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><p>4. Remove the locked connector using left hand based on the illustration, follow the direction of arrow.</p><p>5. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div></div>		<p>1. Please ensure that Connector lock/retainer will not touch or hit by any object prior insertion into locking jig to avoid half-lock connector.</p> <p>2. Maintain 10mm proper holding of wire to connector</p> <p>3.Connector must be fully inserted to connector slot.</p> <p>4. Make sure no offset setting before locking process.</p> <p>5.No wrong setting of connector.</p> <p>6. No damaged connector lock</p> <p>7. No unlocked/ half-locked connector.</p> <p><b>Important reminders/Note/s:</b></p> <p>1. <b>Incomplete locking process will alarm the jig.</b></p> <p>2. <b>No retainer in connector cannot proceed.</b></p> <p>3. <b>If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</b></p>

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240B / 7M0516-7021B

Customer: TRJ

Car Model:

LEXUS-ES

Document No.:

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Purpose:



PROTOTYPE



PRE-LAUNCH



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PARTS:		1. Assy parts 2. Black COT (no slit) $\phi 5$ L=275 $\pm$ 3mm 3. Black COT (no slit) $\phi 7$ L=408 $\pm$ 4mm		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1  Wire insertion to Black COT (no slit) $\phi 5$ L=275 $\pm$ 3mm (1st) $\phi 7$ L=408 $\pm$ 4mm (2nd)	 1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the <b>Y-OR wire</b> using left hand.  2. Get the corrugated tube $\phi 5$ L=275 $\pm$ 3mm (no slit) using right hand then insert the <b>Y-OR wire</b> using left hand.  3. Get the corrugated tube $\phi 7$ L=408 $\pm$ 4mm (no slit) using right hand then insert the <b>Y-OR wire</b> using left hand.  4. After insertion, remove the terminal cover jig using right hand. <div>TERMINAL COVER JIG</div>			1. No wrong use of parts 2. No deformed terminal

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Customer: TRJ

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PRE-LAUNCH



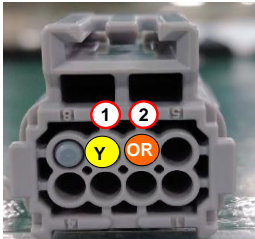


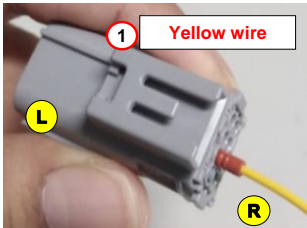
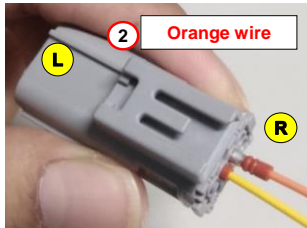
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1  Wire insertion to Connector 6188-0779 (GR)	<div><p><b>VISUAL REFERENCE</b></p></div> <div><p><b>CONNECTOR ORIENTATION</b></p></div> <div><p><b>TERMINAL FACING</b></p></div> <div><p><b>Yellow wire</b></p><p>1. Hold the connector <b>6188-0779 (GR)</b> using left hand, get the <b>Y wire</b> then insert to terminal slot <b>1</b> beside dummy seal using right hand.</p></div> <div><p><b>Orange wire</b></p><p>2. Hold the connector <b>6188-0779 (GR)</b> using left hand, get the <b>OR wire</b> then insert to terminal slot <b>2</b> beside Yellow wire using right hand.</p></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 6. No wrong orientation of connector</div> <div><b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal.</b> <b>2. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b></div> <div><b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b></div>

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

Effectivity Date:

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Model code/Part number:

240B / 7M0516-7021B

Customer: TRJ

Car Model:

LEXUS-ES

Document No.:

WI-ENG-PDE-1091A

Purpose:



PROTOTYPE



PRE-LAUNCH





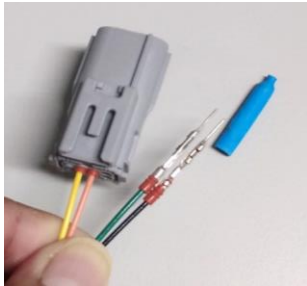

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PARTS:		1. Assy parts 2. MRSW CP TVSSf 0.3 G-B/W L=814±3mm		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1  Wire insertion to assy parts	<div></div> <div><p>1. Hold the wires using left hand and insert the terminal cover jig using right hand.</p></div> <div></div> <div><p>2. Get the assy parts, hold the corrugated tube <b>ø7 L=408±4mm</b> using left hand then insert the wires using right hand.</p></div> <div></div> <div><p>3. After insertion, remove the terminal cover jig using left hand.</p></div>		<div>TERMINAL COVER JIG</div> 	1. No wrong use of parts 2. No deformed terminal

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PROTOTYPE



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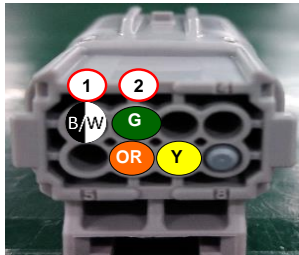


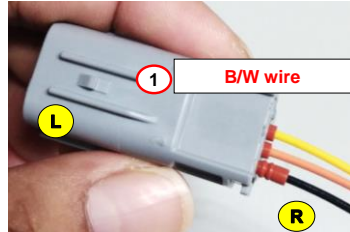
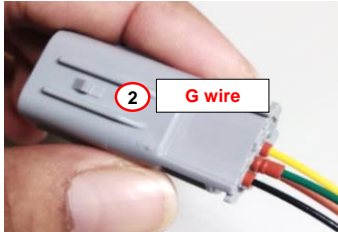
MASSPRO

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1

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1	<div><div><p>VISUAL REFERENCE</p></div><div><p>CONNECTOR ORIENTATION</p></div><div><p>TERMINAL FACING</p></div><div><p>1. Hold the connector <b>6188-0779 (GR)</b> using left hand, get the <b>B/W wire</b> then insert to terminal slot <b>1</b> using right hand.</p></div><div><p>2. Hold the connector <b>6188-0779 (GR)</b> using left hand, get the <b>G wire</b> then insert to terminal slot <b>2</b> using right hand.</p></div></div> <div>Wire insertion to Connector 6188-0779 (GR) (Assy parts)</div> <td>n/a</td> <td><div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing 6. No wrong orientation of connector</div><div><b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal.</b> <b>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b></div><div><b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b> <b>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b></div></td>		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 6. No wrong orientation of connector</div> <div><b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal.</b> <b>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b></div> <div><b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b> <b>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b></div>

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240B / 7M0516-7021B

Customer:

TRJ

Car Model:

LEXUS-ES

Document No.:

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Purpose:



PROTOTYPE



PRE-LAUNCH



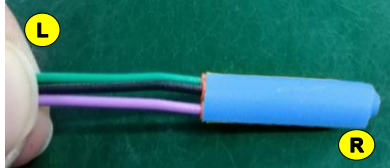
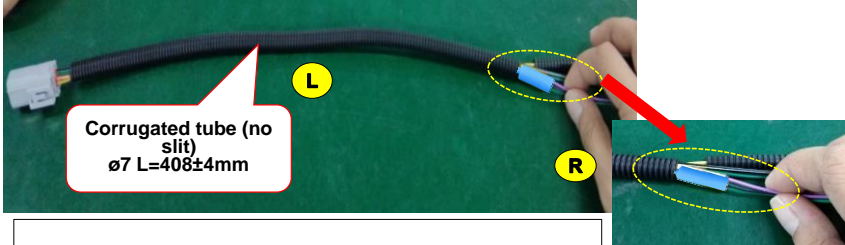


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PARTS:		1. Assy parts 2. AVSSf 0.3 wires G L=809±3mm ; V L=809±3mm; B L=809±3mm		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1	Wire insertion to assy parts	<div><p>1. Get the <b>V-G-B wires</b> using right hand then hold using left hand and insert the terminal cover jig using right hand.</p></div> <div><p>2. Hold the <b>corrugated tube (no slit) ø7 L=408±4mm</b> using left hand then insert the <b>V-G-B wires</b> using right hand.</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div>	<div>TERMINAL COVER JIG</div> 	<p><b>Document reference/s:</b> <b>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b></p>

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# WORK INSTRUCTION

## Process Name/Title: TAPING ASSEMBLY PROCESS

Effectivity Date:

October 22, 2024

Validity Date:

n/a

Model code/Part number: 240B / 7M0516-7021B

Customer: TRJ

Car Model: LEXUS-ES

Document No.:

WI-ENG-PDE-1091A

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS: n/a

JIG:

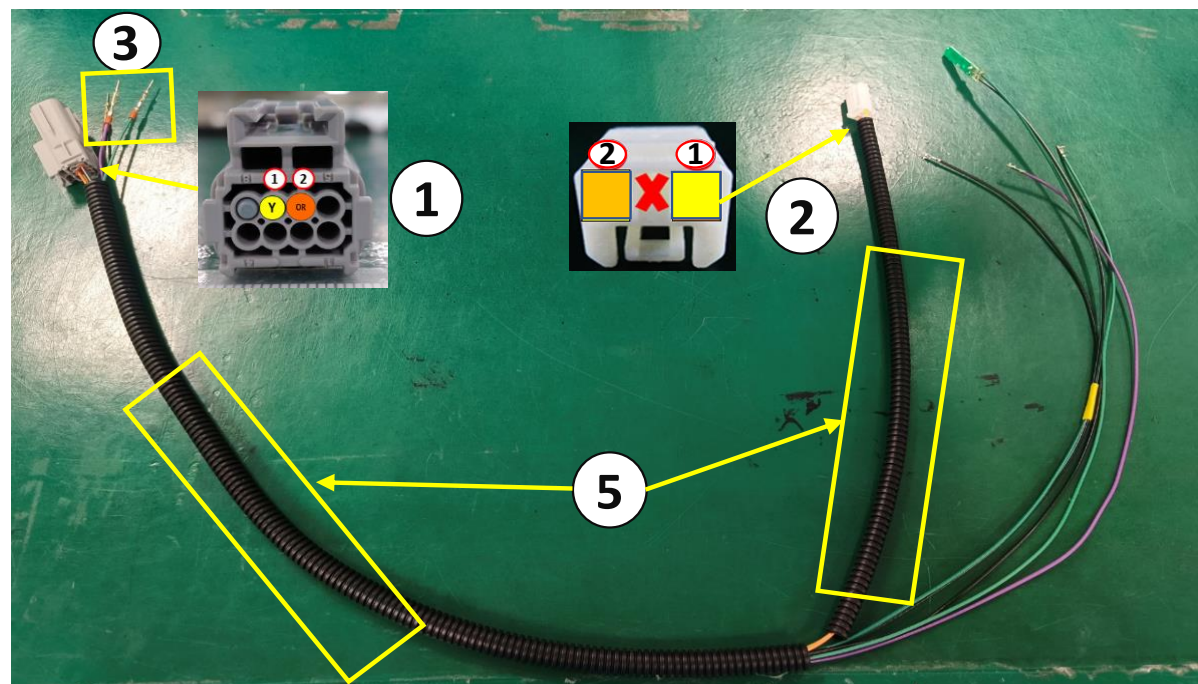
n/a



### 1 VISUAL INSPECTION/ QUALITY CHECKPOINTS

## TAPING - P1

## 7M0516-7021B



- 1 2 No Wrong Insert
- 3 No Deformed terminal
- 4 No Terminal Backing
- 5 No Missing COT

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