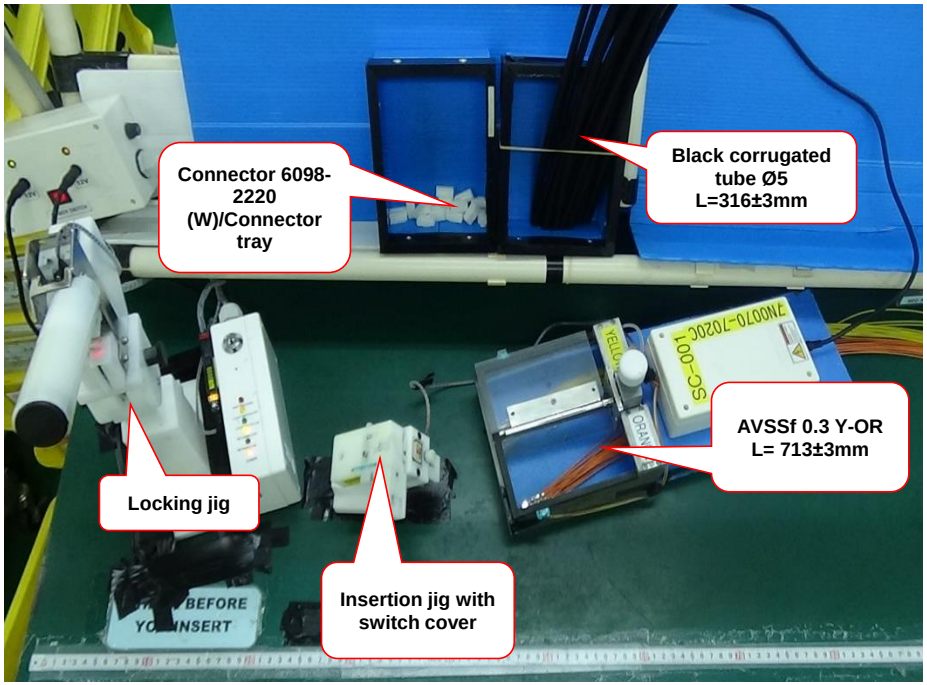
	WORK INSTRUCTION			Effectivity Date:	June 11, 2024		
	Process Name/Title:	OFFLINE ASSEMBLY PROCESS		Validity Date:	-		
	Model code/Part number: 900B/910B / 7N0070-7020C	Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:	WI-ENG-PDE-528		
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	2	Page No.:	1 of 8

PARTS:	1. Connector 6098-2220 (W); Black corrugated tube Ø5 L=316±3mm; AVSSf 0.3 Y-OR wire L= 713±3mm	JIG:	1. Insertion jig switch cover 2. Locking jig

NO.	PROCESS NAME		⚠2 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	n/a	⚠2 Table Lay-out	TABLE LAY-OUT  	**Safety Instruction** Be sure to wear prescribed 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.

Revision History							Prepared by	Reviewed by	Approved by	Noted by
06/11/24	2	Excluded process from WI-ENG-PDE-460A and transferred to WI-ENG-PDE-528, previous process of WI-ENG-PDE-528 transferred to WI-ENG-PDE-460A due to new process distibution. Changed Table lay-out and Inclusion of Measurement on page no.7.	M. Ariola	C. Villanueva	A. Arañes	n/a				
10/07/22	1	Improve: Work procedure/illustration on process no. 4 Connector lock . Quality checkpoints: Reminders/Notes and refences on pg. 1 to 4	M. Ariola	C. Villanueva	A. Arañes	n/a	M. Ariola	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	May 18, 2022		

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

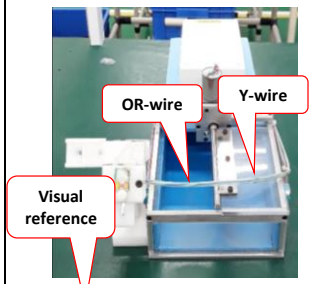
NBC (Philippines)
MASTER COPY

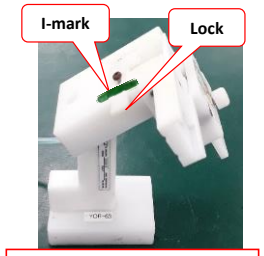
DCC Stamp

	WORK INSTRUCTION			Effectivity Date:	June 11, 2024	
	Process Name/Title:	OFFLINE ASSEMBLY PROCESS		Validity Date:	-	
	Model code/Part number: 900B/910B / 7N0070-7020C	Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:	WI-ENG-PDE-528	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 2	Page No.:	2 of 8

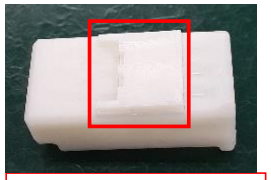
PARTS:	1. Connector 6098-2220(W)			JIG:	1. Insertion jig with switch cover
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
2	n/a	⚠2 Connector setting to insertion jig 6098-2220(W)		N/A	

INSERTION JIG ILLUSTRATION

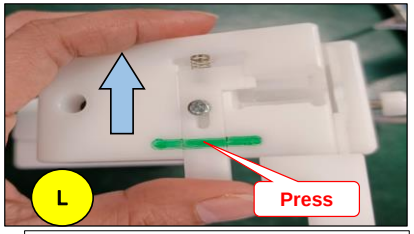




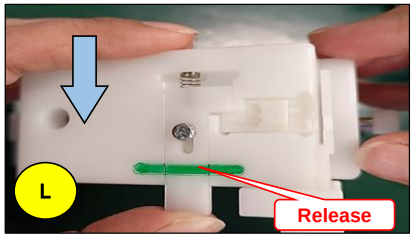
INSERTION JIG ORIENTATION



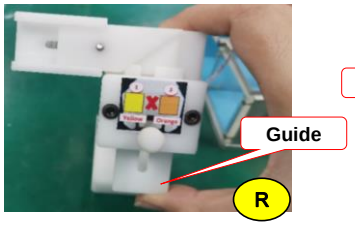
CONNECTOR ORIENTATION

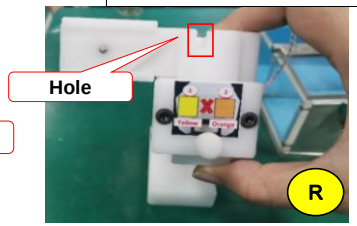


1. Press the lock of insertion jig using left thumb.



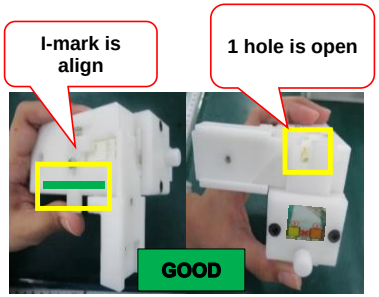
2. Insert the connector **6098-2220 (W)** into jig using right hand and release the lock.
Note: Follow the connector orientation.

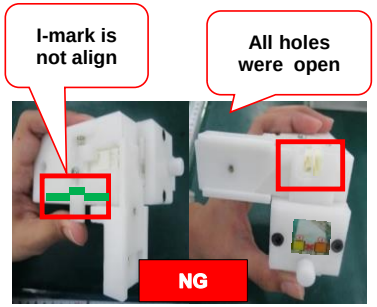




3. Push the guide using left hand. The slot for **Y wire** will be opened.

Connector Orientation Illustration





1. Use the provided jig per model
2. No wrong orientation of connector
3. No wrong use of connector
4. No damaged connector

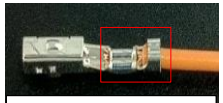
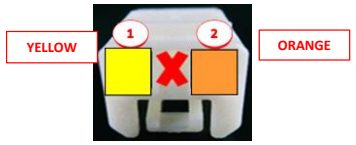
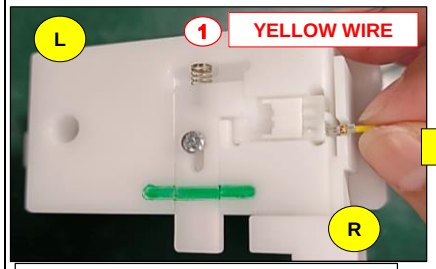
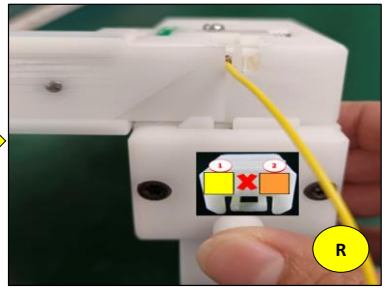
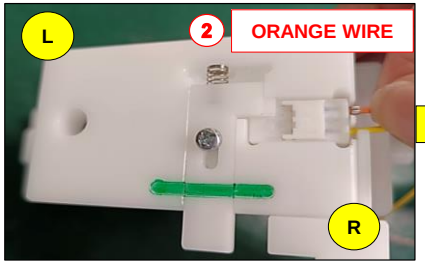
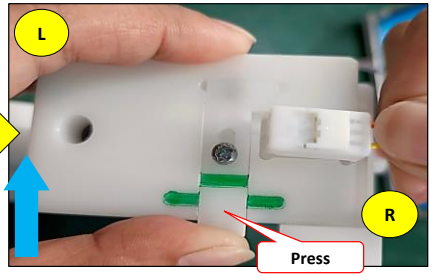
CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

NBC	WORK INSTRUCTION			Effectivity Date:	June 11, 2024
	Process Name/Title:	OFFLINE ASSEMBLY PROCESS		Validity Date:	-
	Model code/Part number: 900B/910B / 7N0070-7020C	Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:	WI-ENG-PDE-528
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 2	Page No.: 3 of 8

PARTS:	1. AVSSf 0.3 Y L=713±3mm 2. AVSSf 0.3 OR L=713±3mm	JIG:	1. Insertion jig with switch cover

NO.	PROCESS NAME		⚠2 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	n/a	⚠2 Wire insertion to connector 6098-2220 (W)	   1. Hold the insertion jig using left hand. Get the **Y wire** and insert to connector using right hand. Conduct **2x pull-push** after insertion.  2. Press the button using right thumb the slot for **OR wire** will be opened.  3. Get the **OR wire** and insert to connector using right hand.  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.	n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing ***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.*** ***Document references:*** ***1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.*** ***2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance***

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

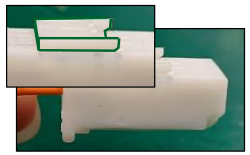
	WORK INSTRUCTION			Effectivity Date:	June 11, 2024	
	Process Name/Title:	OFFLINE ASSEMBLY PROCESS		Validity Date:	-	
	Model code/Part number: 900B/910B / 7N0070-7020C	Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:	WI-ENG-PDE-528	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 2	Page No.:	4 of 8

PARTS:	1. Assy parts	JIG:	1. Locking jig

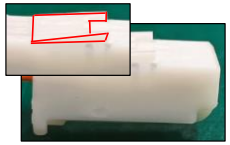
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	n/a	⚠2 Connector lock			1. Please ensure that Connector lock/retainer will not touch or hit by any object prior insertion into locking jig to avoid half-lock connector. 2. Maintain 10mm proper holding of wire to connector 3.Connector must be fully inserted to connector slot. 4. Make sure no offset setting before locking process. 5.No wrong setting of connector. 6. No damaged connector lock 7. No unlocked/ half-locked connector. ***Important reminders/Note/s:*** ***1. Incomplete locking process will alarm the jig.*** ***2. No retainer in connector cannot proceed.*** ***3. If encountered abnomality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.***

CONNECTOR RETAINER ILLUSTRATION

SIDE VIEW

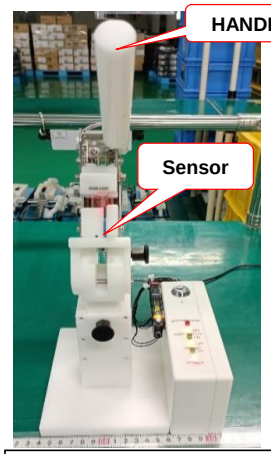


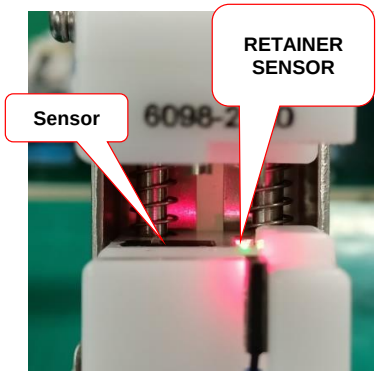
GOOD

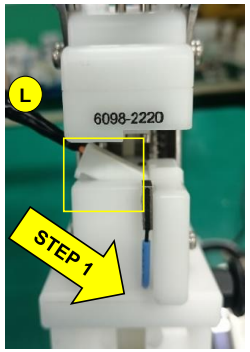


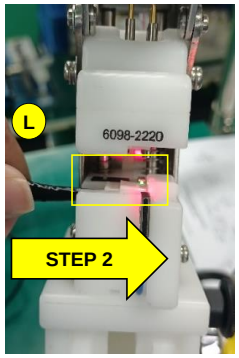
NG

1.Check the Retainer lock of connector before insertion to locking jig.
*Note: Must be **NO** half-locked condition prior connector locking.*









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.
NOTE: CONNECTOR LOCKING JIG WILL NOT FUNCTION IF CONNECTOR NOT REACH THE SENSOR.

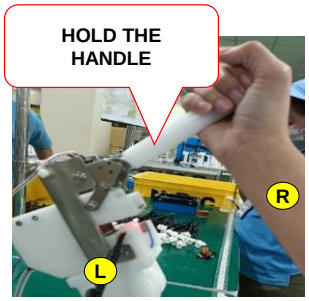
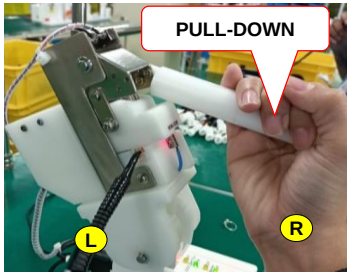
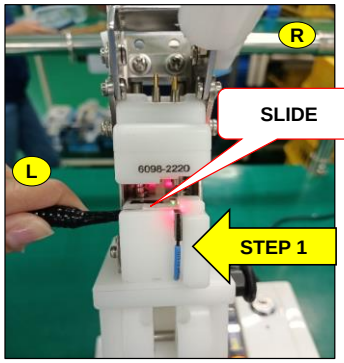
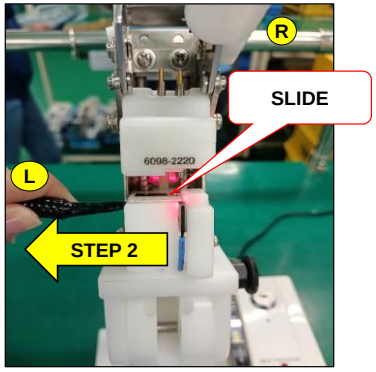
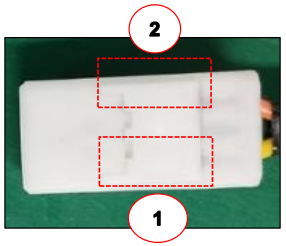
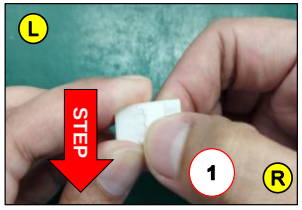
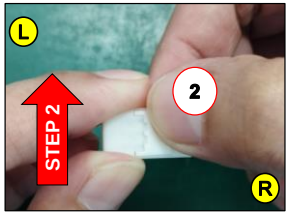
CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

	WORK INSTRUCTION			Effectivity Date:	June 11, 2024	
	Process Name/Title:	OFFLINE ASSEMBLY PROCESS		Validity Date:	-	
	Model code/Part number: 900B/910B / 7N0070-7020C	Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:	WI-ENG-PDE-528	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 2	Page No.:	5 of 8

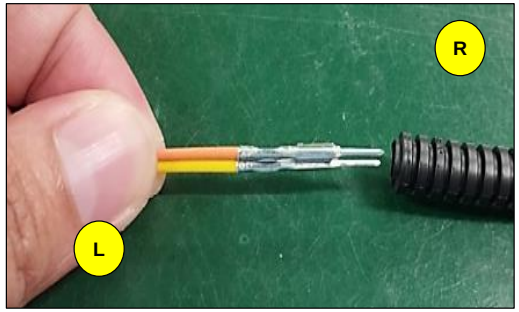
PARTS:	1. Assy parts	JIG:	1. Locking jig

NO.	PROCESS NAME		⚠2 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	n/a	⚠2 Connector lock (Continuation)	  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.   4. Remove the locked connector using left hand based on the illustration, follow the direction of arrow.    5. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.		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. 2. Maintain 10mm proper holding of wire to connector 3.Connector must be fully inserted to connector slot. 4. Make sure no offset setting before locking process. 5.No wrong setting of connector. 6. No damaged connector lock 7. No unlocked/ half-locked connector ***Important reminders/Note/s:*** ***1. Incomplete locking process will alarm the jig.*** ***2. No retainer in connector cannot proceed.*** ***3. If encountered abnomality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.***

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

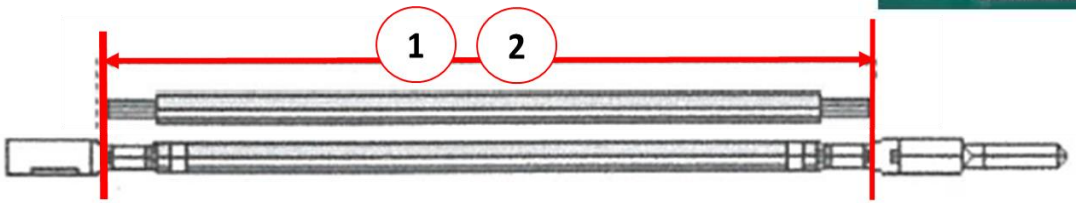
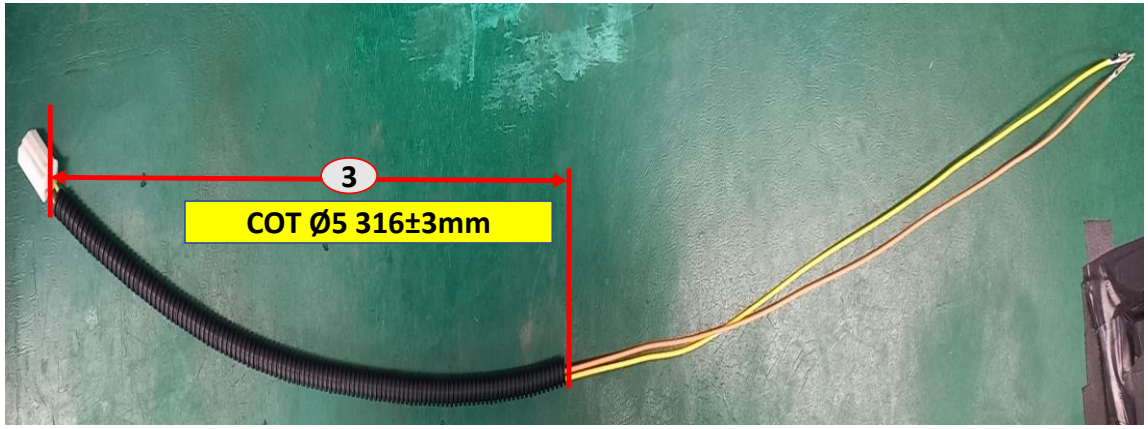
PARTS:	1. Assy parts			JIG:	n/a
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
5	n/a	⚠2 Wire insertion to Black Corrugated tube Ø5 L=316±3mm (No slit)	 1. Get the Black COT **Ø5 L=316±3mm (No slit)** using right hand and insert **Y-OR wires** using left hand.	n/a	1. No wrong use of parts 2. No deformed terminal

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

	WORK INSTRUCTION			Effectivity Date:	June 11, 2024	
	Process Name/Title:	OFFLINE ASSEMBLY PROCESS		Validity Date:	-	
	Model code/Part number: 900B/ 910B / 7N0070-7020C	Customer: TRX	Car Model: LEXUS-NX/RX	Document No.:	WI-ENG-PDE-528	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 2	Page No.:	7 of 8

PARTS:	1. Assy parts			JIG:	n/a
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
6	n/a	⚠2 Measurement	Note: 1. Measurement point: End of core wire to the end of core wire 2. Terminal is reference only.   		1. No wrong dimension ***Important reminders and note/s:*** ***1. Please use calibrated/verified measuring tape when getting the measurement.*** ***2. For Hatsumono, Nakamono and Owarimono.*** ***Document reference/s:*** *1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection*

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

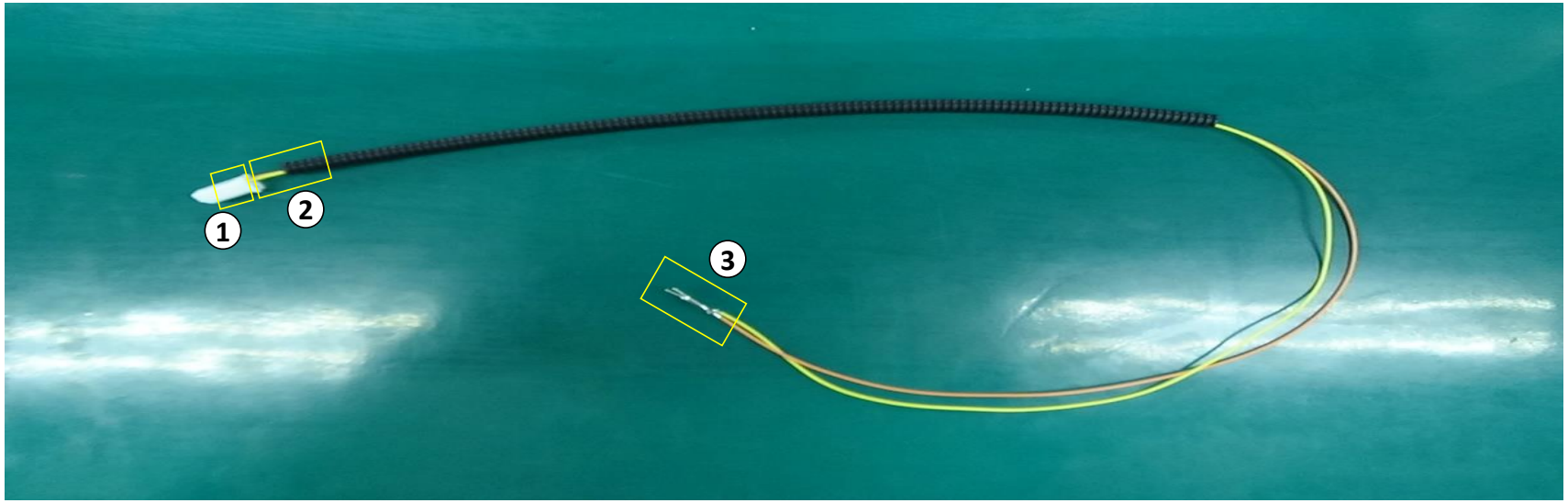
DCC Stamp

NBC	WORK INSTRUCTION			Effectivity Date:	June 11, 2024
	Process Name/Title:	OFFLINE ASSEMBLY PROCESS		Validity Date:	-
	Model code/Part number: 900B/910B / 7N0070-7020C	Customer: TRJ	Car Model: LEXUS-NX/RX	Document No.:	WI-ENG-PDE-528
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 2	Page No.: 8 of 8

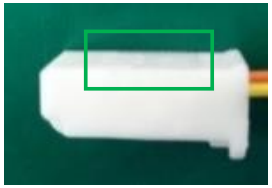
PARTS:	1. Assy parts	JIG:	n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS

OFFLINE INSERTION	**7N0070-7020C**



1



GOOD

NO GOOD

1 **No Unlock/ Halflock Connector**

2 **No Wrong Insert**

3 **No Deformed Terminal**

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp