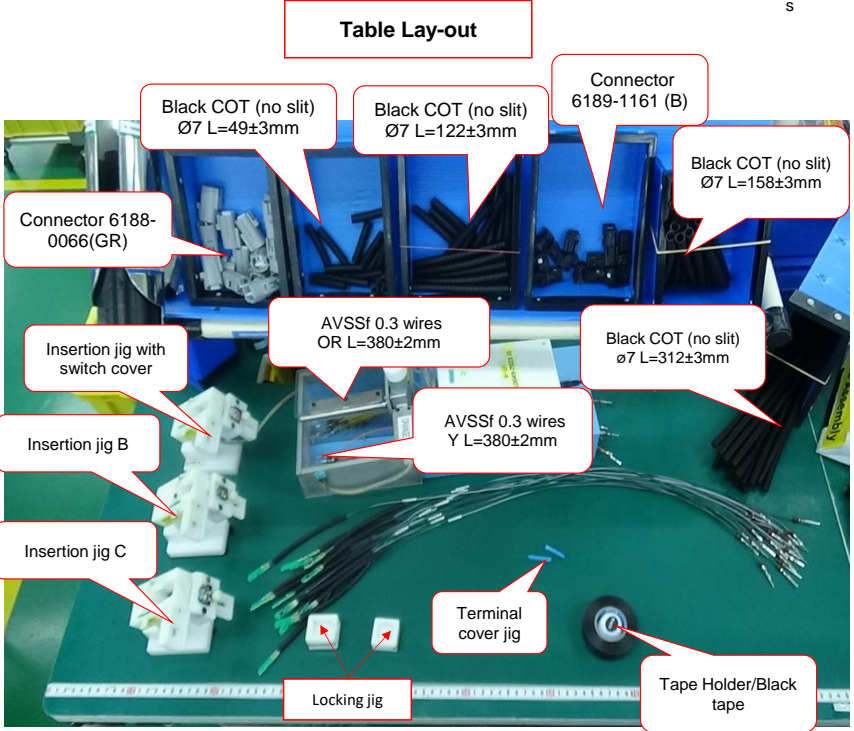



	<b>WORK INSTRUCTION</b>						Effectivity Date:		<b>September 4, 2024</b>	
	<b>TAPING ASSEMBLY PROCESS</b>						Validity Date:		n/a	
	Process Name/Title:			Model code/Part number: <b>241B / 7L0049-7023</b>			Customer: <b>TRQSS</b>		Car Model: <b>LEXUS ES</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Document No.: <b>WI-ENG-PDE-422A</b>			Revision No.: <b>2</b>		Page No.: <b>1 of 12</b>	


<b>PARTS:</b>		1. Connector 6188-0066 GR; 6189-1161 (B); AVSSf 0.3 wires Y-OR L=380±2mm; MRSW CP (TVSSf 0.3 G-B/W L=679±3mm; Black VM tube (Sunprene) Ø5 L=106±3mm); Black Corrugated tube (no slit) Ø7 L=49±3mm; Corrugated tube (no slit) Ø7 L=122±3mm; Corrugated tube (no slit) Ø7 L=158±3mm; Corrugated tube (no slit) Ø7 L=312±3mm; Black tape				JIG:		1. Insertion jig with switch cover 2. Locking jig 3. Terminal cover jig		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>3 WORK PROCEDURE/ ILLUSTRATION</b>				<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>			
1	P1	<div><p><b>Table Lay-out</b></p></div>				<div><p><b>Safety Instruction</b> Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p><p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p><p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p></div>		<div><p><b>Document reference/s:</b> 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to WI-PRO-KIT-006 for Wire Taping with Vinyl Tube</p><p>1. No missing parts/tools 2. No excess parts/tools</p></div>		

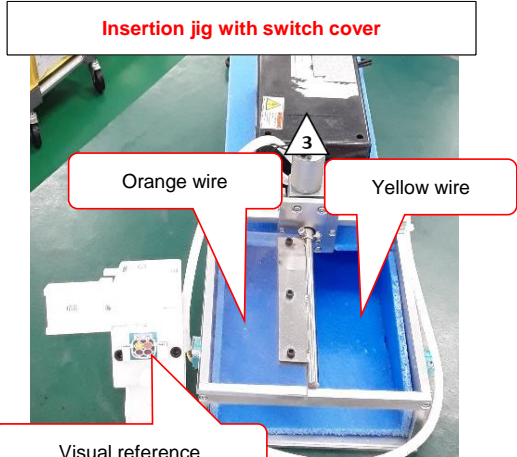

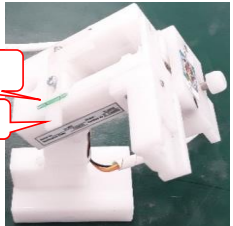
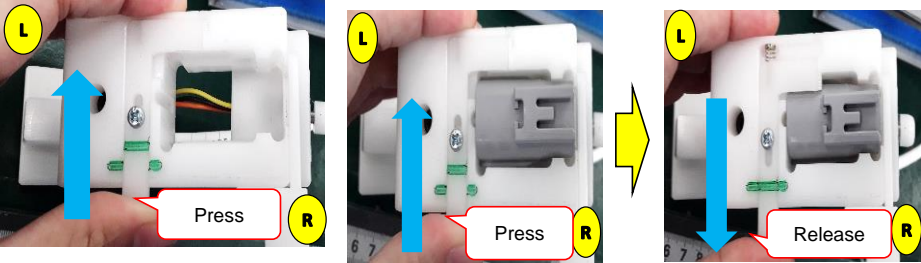
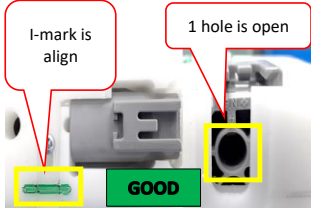
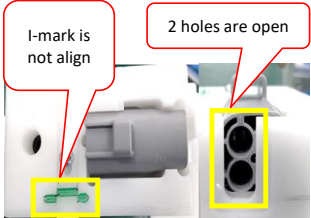
Revision History						Prepared by		Reviewed by		Approved by		Noted by	
09/04/24	2	Transfer some process to P2 due to process improvement. Inclusion of car model "LEXUS ES". Improved Table lay-out and Visual inspection/Quality checkpoints. Aligned switch cover to insertion jig				D. Castillo	C. Villanueva	A. Arañes	n/a				n/a
12/16/22	1	Improve quality pointers: Reminders/notes and references. Inclusion of Quality checkpoints				M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
03/04/22	0	Initial issue				M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	March 04, 2022		

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	Model code/Part number: <b>241B / 7L0049-7023</b>		Customer: <b>TRQSS</b>	Car Model: <b>LEXUS ES</b>	Document No.: <b>WI-ENG-PDE-422A</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	2	Page No.:	2 of 12

<b>PARTS:</b>	1. Connector 6188-0066 (GR)			JIG:	1. Insertion jig with switch cover			
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
2	P1 Connector setting to Insertion jig 6188-0066 (GR)	<div><div>Insertion jig with switch cover</div><div></div><div></div><div></div><div></div><div><p>1. Press the lock using left hand.</p><p>2. Get the connector 6188-0066 (GR) using right hand and insert to insertion jig. Release the lock after insertion. <b>Note: Follow the connector orientation.</b></p></div></div>			N/A	<div><div>CONNECTOR ORIENTATION ILLUSTRATION</div><div></div><div></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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# WORK INSTRUCTION

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## TAPING ASSEMBLY PROCESS

Effectivity Date:

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Model code/Part number:

241B / 7L0049-7023

Customer:

TRQSS

Car Model:

LEXUS ES

Document No.:

WI-ENG-PDE-422A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


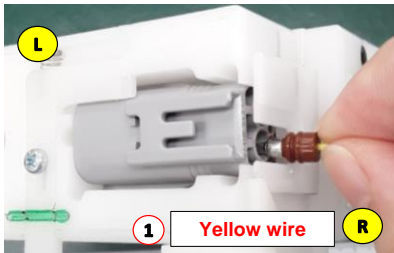
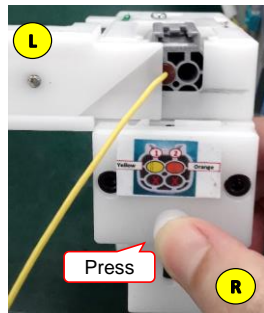
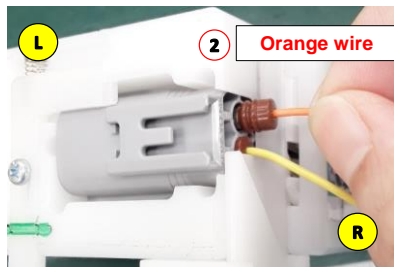
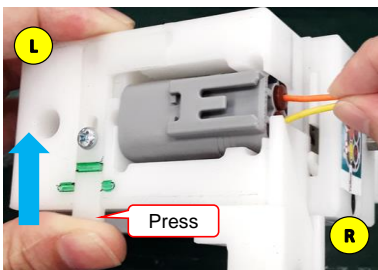
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PARTS:	1. AVSSf 0.3 wires Y-OR L=380±2mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1  Wire Insertion to connector 6188-0066 (GR)	<div><p>Wire facing</p></div> <div><p>1. Hold the insertion jig using left hand. Get the <b>Yellow wire</b> and insert to connector using right hand.</p></div> <div><p>2. Press the button using right thumb. slot for <b>Orange wire</b> will be open.</p></div> <div><p>3. Get the <b>Orange wire</b> and insert to connector using right hand.</p></div> <div><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 deform terminal 5. No wrong wire facing</p> <p><b>Important reminders/Note/s:</b></p> <p><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></p> <p><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></p>

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Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**September 4, 2024**

Model code/Part number:

**241B / 7L0049-7023**

Customer:

**TRQSS**

Car Model:

**LEXUS ES**

Document No.:

**WI-ENG-PDE-422A**

Purpose:

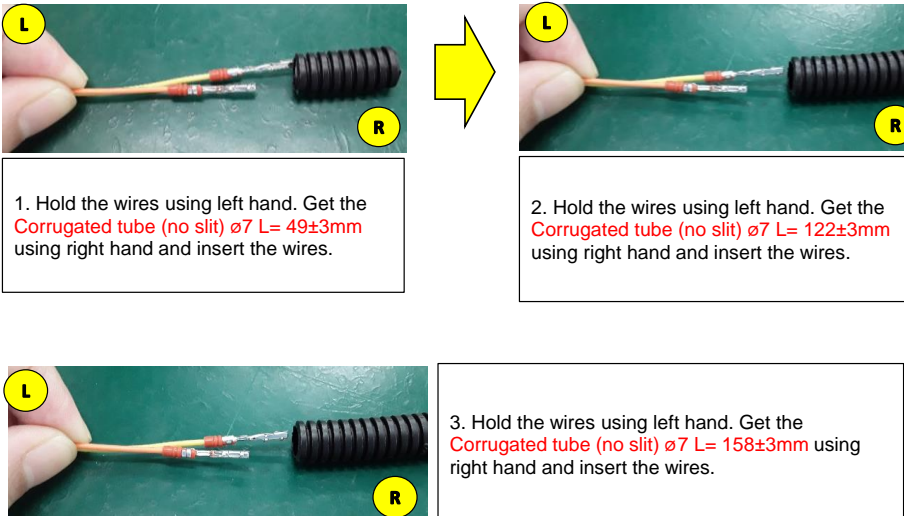
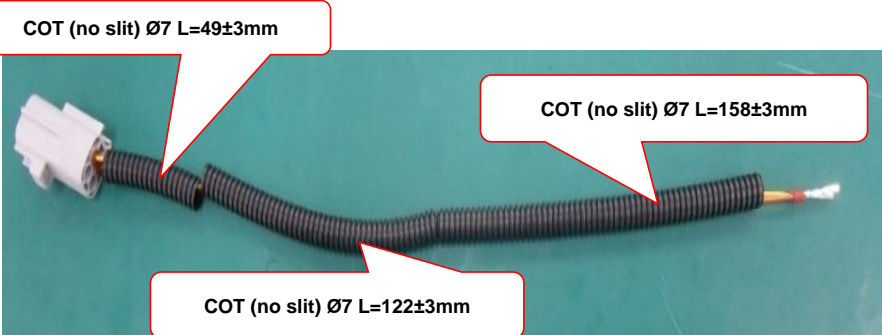
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<b>PARTS:</b>		1. Black Corrugated tube (no slit) $\varnothing 7$ L=49 $\pm$ 3mm 2. Black Corrugated tube (no slit) $\varnothing 7$ L=122 $\pm$ 3mm	3. Black Corrugated tube (no slit) $\varnothing 7$ L=158 $\pm$ 3mm 4. Assy parts	JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
4	P1	<p>Wire insertion to COT (no slit) <math>\varnothing 7</math> L= 49<math>\pm</math>3mm <math>\varnothing 7</math> L= 122<math>\pm</math>3mm <math>\varnothing 7</math> L= 158<math>\pm</math>3m</p>  <p>1. Hold the wires using left hand. Get the <b>Corrugated tube (no slit) <math>\varnothing 7</math> L= 49<math>\pm</math>3mm</b> using right hand and insert the wires.</p> <p>2. Hold the wires using left hand. Get the <b>Corrugated tube (no slit) <math>\varnothing 7</math> L= 122<math>\pm</math>3mm</b> using right hand and insert the wires.</p> <p>3. Hold the wires using left hand. Get the <b>Corrugated tube (no slit) <math>\varnothing 7</math> L= 158<math>\pm</math>3mm</b> using right hand and insert the wires.</p> 		N/A	1. No wrong use of parts 2. No deformed terminal

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241B / 7L0049-7023

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TRQSS

Car Model:

LEXUS ES

Validity Date:

n/a

Purpose:

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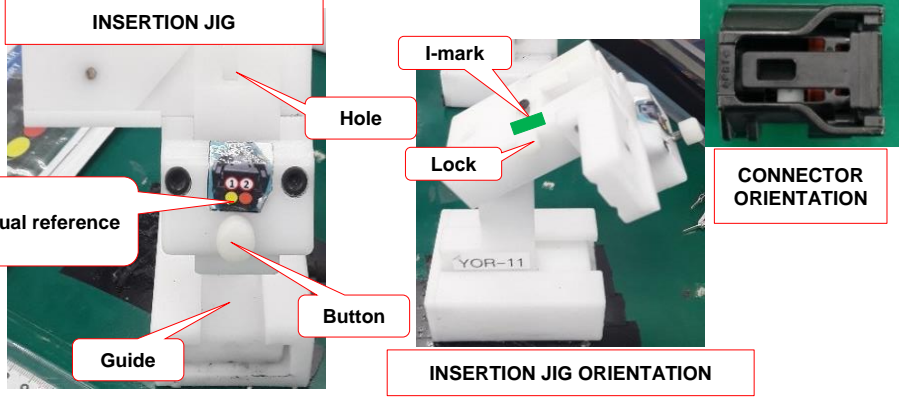
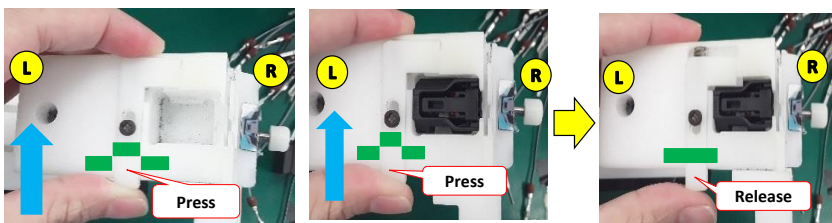
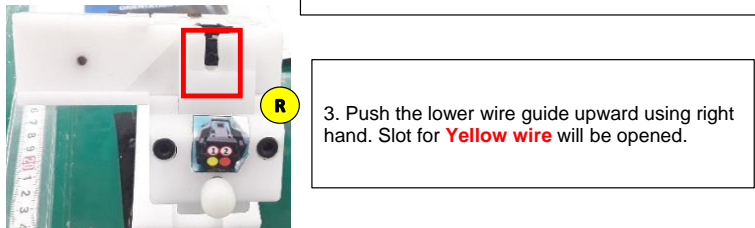


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PARTS:	1. Connector 6189-1161 (B)			JIG:	1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
5	P1	Connector setting to insertion jig 6189-1161 (B)			N/A	
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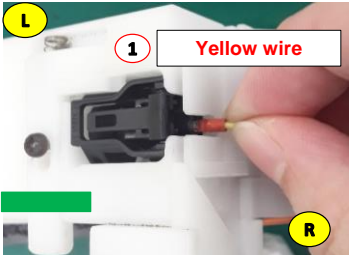
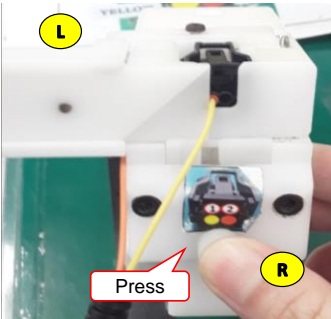
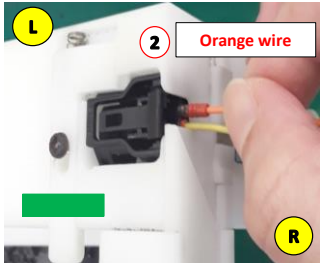
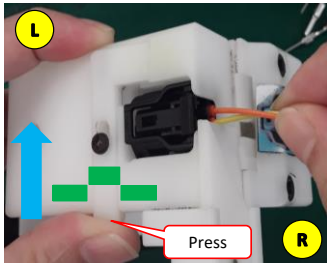
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	Model code/Part number: 241B / 7L0049-7023		Customer: TRQSS	Car Model: LEXUS ES	Document No.: WI-ENG-PDE-422A		
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PARTS:		1. Black tape 2. Assy parts		JIG:	1. Insertion Jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
6	P1  Wire Insertion to Connector 6189-1161 (B)	<div><p>Wire facing</p></div> <div><p>1. Hold the insertion jig using left hand. Get the <b>Yellow wire</b> and insert to connector using right hand.</p></div> <div><p>2. Press the button using right thumb. slot for <b>Orange wire</b> will be open.</p></div> <div><p>3. Get the <b>Orange wire</b> and insert to connector using right hand.</p></div> <div><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 deform terminal 5. No wrong wire facing</p> <p><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. Do not exert extra force.</b></p> <p><b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b></p>	

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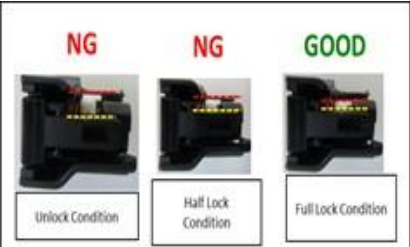

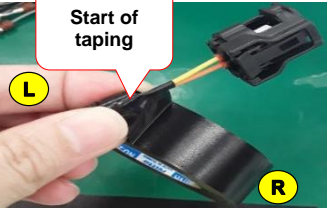
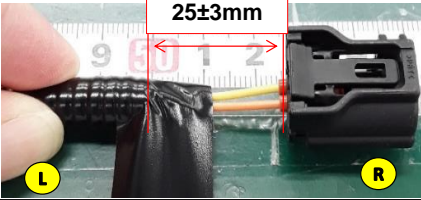
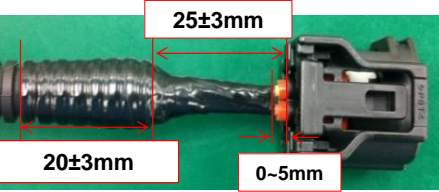

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	Model code/Part number: <b>241B / 7L0049-7023</b>		Customer: <b>TRQSS</b>	Car Model: <b>LEXUS ES</b>	Document No.:	WI-ENG-PDE-422A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.:	7 of 12




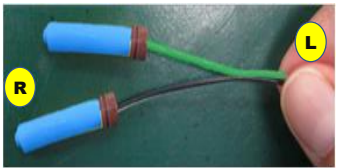

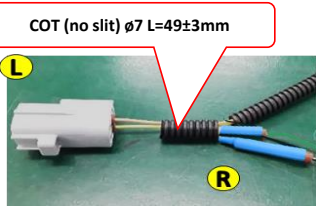

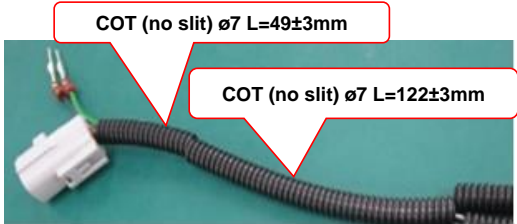

<b>PARTS:</b> 1. Black tape 2. Assy parts		<b>JIG:</b> 1. Locking jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>
7	Connector lock	 <p>1. Put the connector into locking jig and push down <b>2x</b> using both hands. Check the connector lock if properly locked.</p> <div>   </div> 	<div>LOCKING JIG</div> 
8	Taping 1 COT to wire near connector	<div>   </div> <p>1. Hold the assy parts using left hand, get <b>Black tape</b> then conduct pre-taping using both hands.</p> <p>2. Hold the assy parts using left hand and measure from COT to connector <b>25±3mm</b> using both hands. Continue taping process using both hands.</p> <div>  </div> <p>3. After taping, check the measurement and taping condition.</p>	<div>MEASURING TAPE</div> 


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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.:	8 of 12	

<b>PARTS:</b>		1. Black Corrugated tube $\phi 7$ L=312 $\pm$ 3mm (no slit) 2. MRSW CP (TVSSf 0.3 G-B/W L=679 $\pm$ 3mm; Black VM tube (Sunprene) $\phi 5$ L=106 $\pm$ 3mm) 3. Assy parts		JIG:	1. Terminal cover jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
9	Wire insertion to COT $\phi 7$ L= 312 $\pm$ 3mm (no slit)	<div>  <p>1. Get the terminal cover jig using right hand then insert to both terminals <b>G-B/W wires</b> using right hand.</p> </div> <div>  <p>2. Get the corrugated tube <b><math>\phi 7</math> L=312<math>\pm</math>3mm (no slit)</b> using right hand then insert the <b>G-B/W wires</b> using left hand.</p> </div>		<div> <b>TERMINAL COVER JIG</b> </div> 	1. No wrong use of parts 2. No deformed terminal
10	Wire insertion to Assy	<div>  <p>1. Hold the wires using right hand.</p> </div> <div>  <p>2. Get the assy parts using left hand, insert the wires in COT <b><math>\phi 7</math> L=122mm</b> using right hand.</p> </div> <div>  <p>3. Hold the corrugated tube <b><math>\phi 7</math> L=49<math>\pm</math>3mm</b> using left hand then insert the <b>G-B/W wires</b> using right hand.</p> </div> <div>  <p>4. After insertion, remove the cover jig using right hand.</p> </div> <div>  <p>COT (no slit) <math>\phi 7</math> L=122<math>\pm</math>3mm</p> <p>COT (no slit) <math>\phi 7</math> L=49<math>\pm</math>3mm</p> </div>		<div> <b>TERMINAL COVER JIG</b> </div> 	1. No wrong use of parts 2. No deformed terminal 3. No wrog insertion of parts

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## TAPING ASSEMBLY PROCESS

Effectivity Date:

September 4, 2024

Model code/Part number:

241B / 7L0049-7023

Customer:

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Car Model:

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Document No.:

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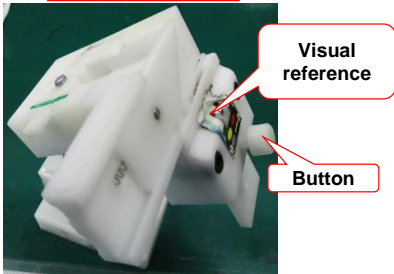
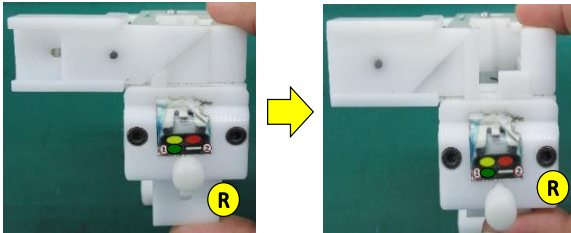
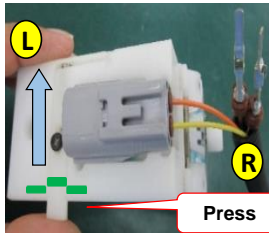
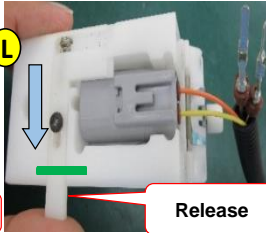
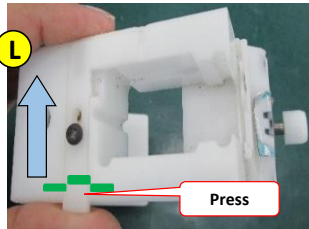
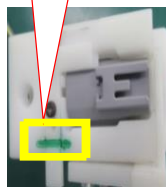
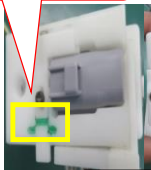
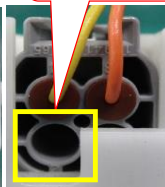
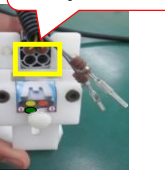
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PARTS:	1. Assy parts		JIG:	1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1  Connector setting to insertion jig 6188-0066 (GR) (Assy parts)	<div><div>INSERTION JIG</div><div></div><div>CONNECTOR ORIENTATION</div><div></div><div>1. Press the guide using right thumb. The slot for <b>G wire</b> will be opened.</div><div></div><div></div><div>2. Press the lock of insertion jig using left thumb.</div><div></div><div>3. Insert the connector <b>6188-0066 (GR)</b> with inserted <b>Y-OR wire</b> using right hand. <b>Note: Follow the connector orientation.</b></div></div> <div>N/A</div> <div><div><div>I-mark is align</div><div></div><div>GOOD</div></div><div><div>I-mark is NOT align</div><div></div><div>NG</div></div><div><div>1 Hole is open</div><div></div></div><div><div>2 Holes are opened</div><div></div></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>			

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**WORK INSTRUCTION**

Effectivity Date:

**September 4, 2024**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Validity Date:

n/a

Model code/Part number:

**241B / 7L0049-7023**

Customer:

**TRQSS**

Car Model:

**LEXUS ES**

Document No.:

**WI-ENG-PDE-422A**

Purpose:


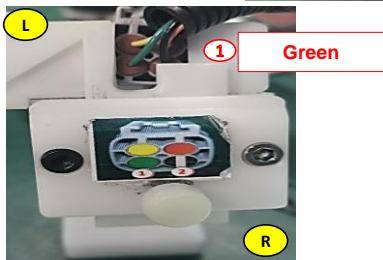
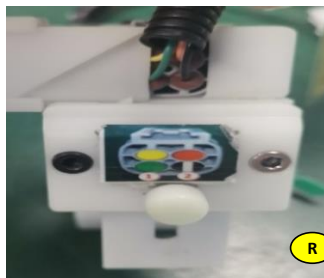
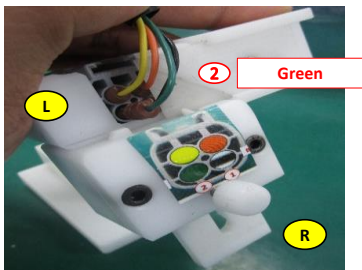
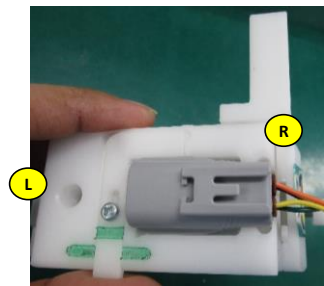
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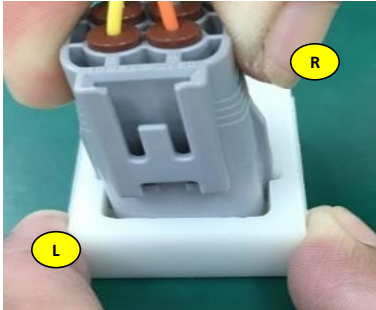


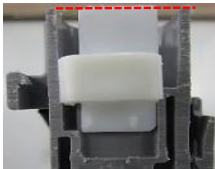
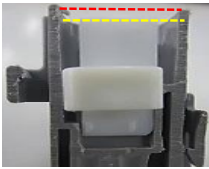
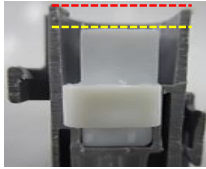
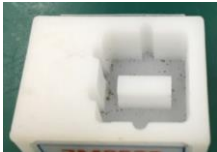
<b>PARTS:</b>	1. Assy parts			JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
12	P1  Wire insertion to connector 6188-0066 (GR) (Assy parts)	<div><div>WIRE FACING</div></div> <div><div>1. Hold the insertion jig using left hand, get <b>Green wire</b> then insert to connector slot <b>1</b> using right hand.</div></div> <div><div>2. Press the button using right hand, slot for <b>Black/White wire</b> will be opened.</div></div> <div><div>3. Hold the insertion jig using left hand, get <b>Black/White wire</b> then insert to connector slot <b>2</b> using right hand.</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 deform terminal 5. No wrong wire facing</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			Effectivity Date:	September 4, 2024							
	TAPING ASSEMBLY PROCESS			Validity Date:	n/a							
	Process Name/Title:			Model code/Part number:	241B / 7L0049-7023	Customer:	TRQSS	Car Model:	LEXUS ES	Document No.:	WI-ENG-PDE-422A	
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:	2	Page No.:	11 of 12

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. Put the connector into locking jig using right hand then press <b>2x</b>. Touch the connector lock if properly locked.</div><div><div>Before pressingAfter pressing</div></div><div><div>Connector Cross Sectional View</div><div><div><div>Unlock Condition</div></div><div><div>Half Lock Condition</div></div><div><div>Full Lock Condition</div></div></div></div><div><div>LOCKING JIG</div></div><div><div>Important reminders/Note/s:</div><div>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</div><div>1. Use the provided locking jig per model</div><div>2. No unlock/half-lock connector</div></div></div>					

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

September 4, 2024

Model code/Part number:

**241B / 7L0049-7023**

Customer:

**TRQSS**

Car Model:

**LEXUS ES**

Document No.:

**WI-ENG-PDE-422A**

Purpose:

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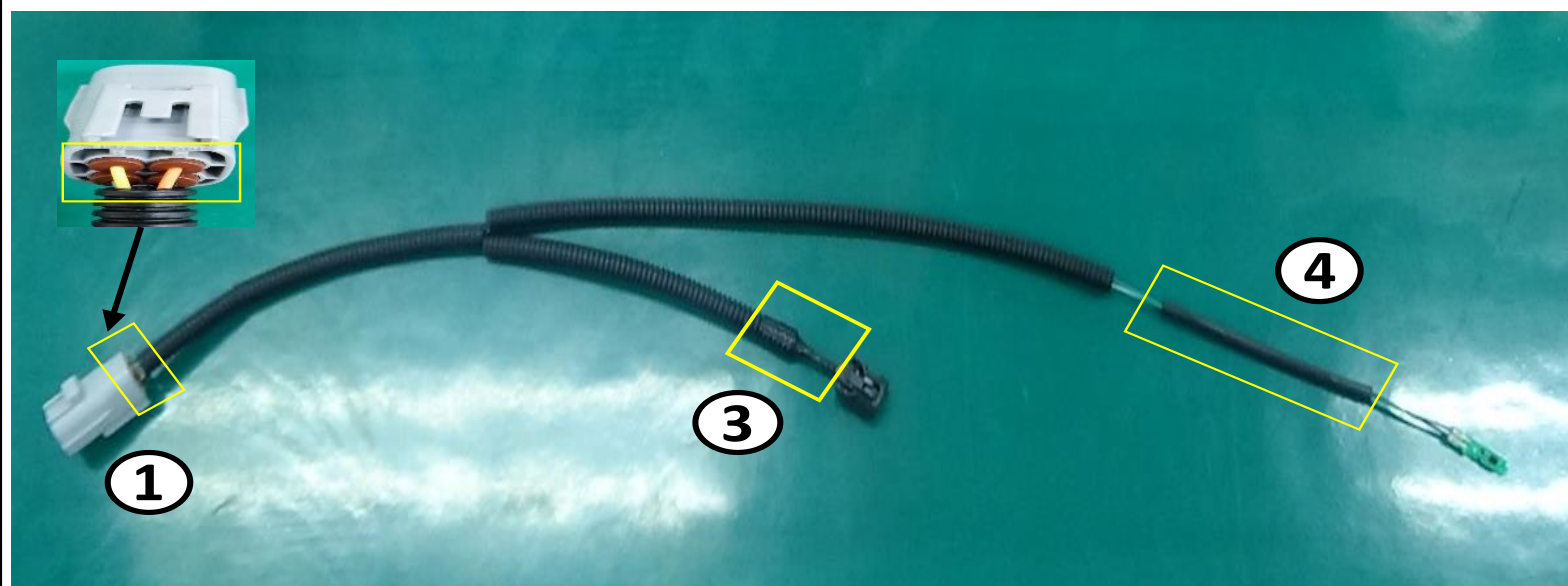
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P1****7L0049-7023****① No WRONG INSERT****② No UNLOCKED/ HALF-LOCKED CONNECTOR****③ No MISSING TAPE****④ No MISSING VM TUBE (SUNPRENE)****②****GOOD****NO GOOD****NO GOOD****GOOD**

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