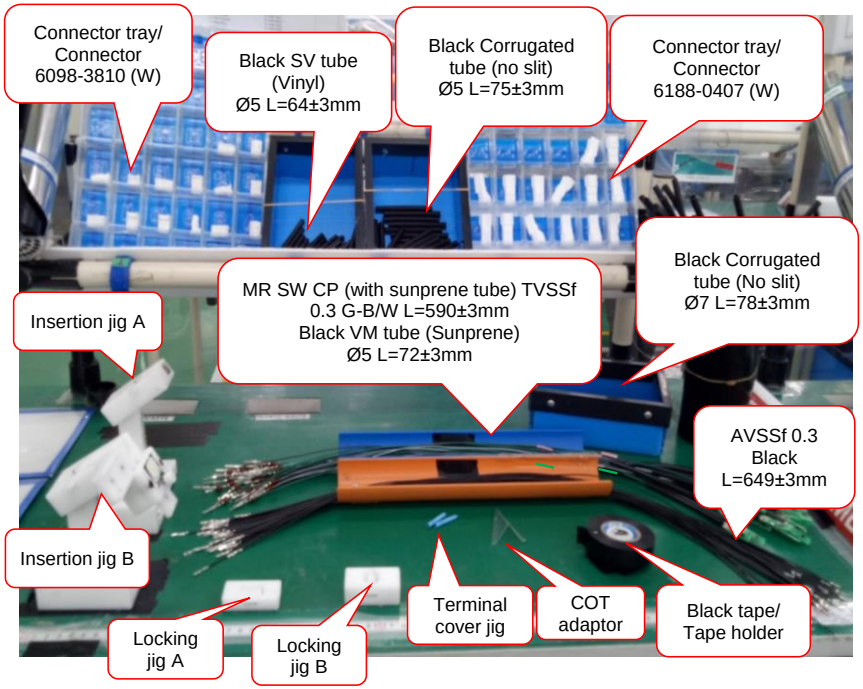
	WORK INSTRUCTION			Effectivity Date:	October 14, 2024		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 220D / 7L0134-7020B	Customer: TRQSS	Car Model: LEXUS-LM	Document No.:	WI-ENG-PDE-1099A		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.:	1 of 12

PARTS:	1. All parts: Connector 6098-3810(W); Connector 6188-0407(W); MR SW CP(G,B/W L=590±3 with VM tube (Sunprene) L=72±3mm); Black SV tube (Vinyl) Ø5 L=64±3mm; Black Corrugated tube (no slit) Ø5 L=75±3mm; Black Corrugated tube (no slit Ø7 L=78±3mm; AVSSf 0.3 Black L=649±3mm; Black tape	JIG:	1. Insertion jig 2. Locking jig 3. Terminal cover jig 4. Adaptor

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	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.	***Document reference/s:*** *1. Refer to **WI-PRO-CNC-071** Wire and Strip Length Tolerance.* 1. No missing parts/tools 2. No excess parts/tools 3. No wrong positions of parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
10/14/24	1	Change from Pre-launch to Masspro.	D.Castillo	C.Villanueva	A. Arañes	n/a
10/09/24	0	Initial issue. Transfer Wire insertion to COT to P2.	D.Castillo	C.Villanueva	A. Arañes	n/a

Prepared by	Reviewed by	Approved by	Noted by
D.Castillo	C.Villanueva	A. Arañes	n/a
Est. Date:	October 08, 2024		

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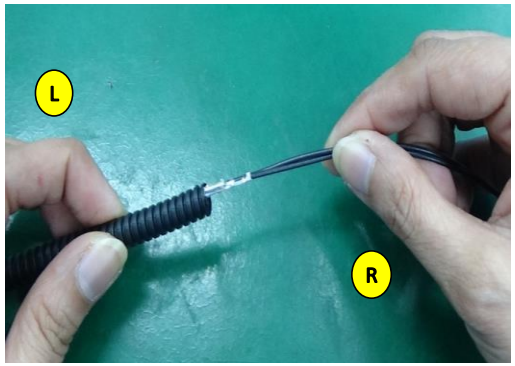
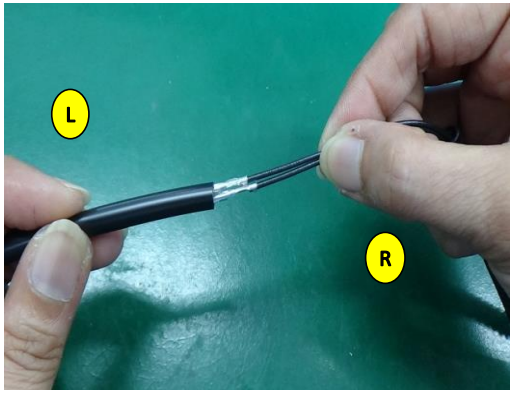
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 220D / 7L0134-7020B	Customer: TRQSS	Car Model: LEXUS-LM	Document No.:	WI-ENG-PDE-1099A	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 2 of 12

PARTS:	1. Black SV tube (Vinyl) Ø5 L=64±3mm 2. Black Corrugated tube Ø5 L=75±3mm (no slit)	3. Assy parts	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1	Wire Insertion to Black Corrugated tube Ø5 L=75±3mm (no slit)	 1. Get 2pcs of Black wire using right hand and get corrugated tube Ø5, L=75±3mm (no slit) using left then insert.	n/a	1. No wrong usage of parts
3		Wire Insertion to Black SV tube (Vinyl) Ø5 L=64±3mm	 2.Hold the assy part using right hand then get the SV tube (Vinyl) ø5 L= 64±3mm using left hand and insert the Black wires.	n/a	1. No wrong usage of parts

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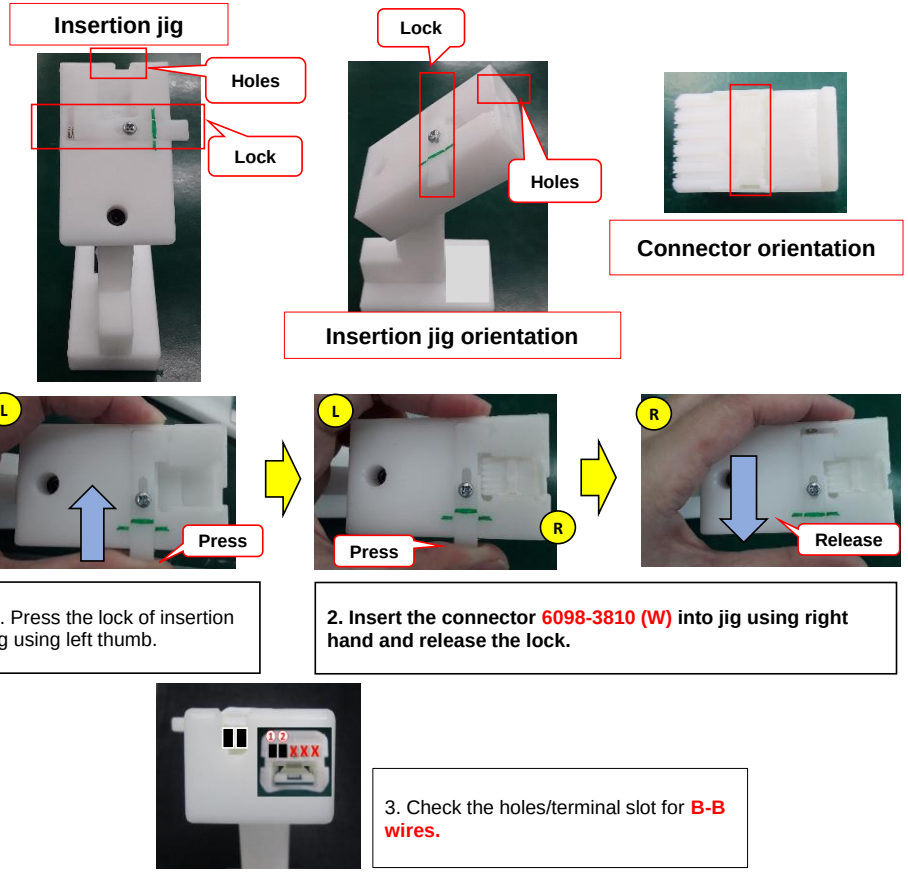
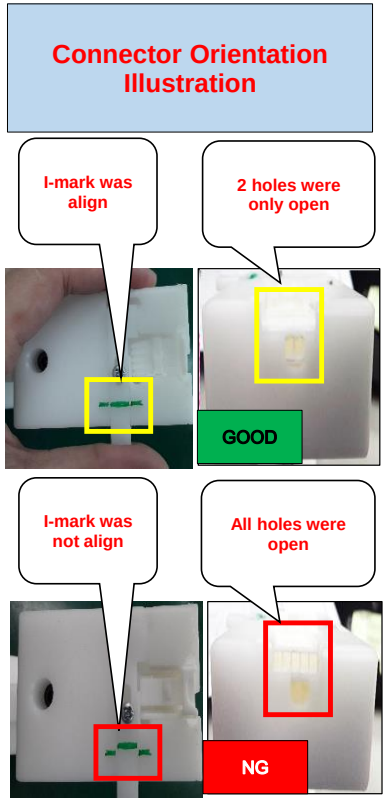
	WORK INSTRUCTION			Effectivity Date:	October 14, 2024		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number:	220D / 7L0134-7020B	Customer: TRQSS / Car Model: LEXUS-LM	Document No.:	WI-ENG-PDE-1099A		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.:	3 of 12

PARTS:	1. Connector 6098-3810 (W)			JIG:	1. Insertion jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
4	P1	Connector setting to insertion jig (6098-3810)		n/a	1. Use the provide jig per model 2. No wrong orientation of connector 

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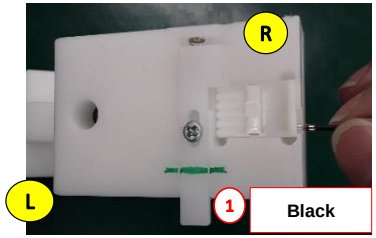
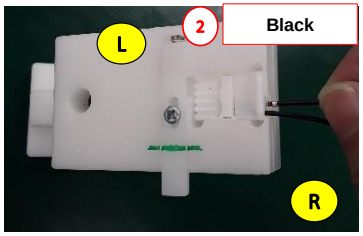
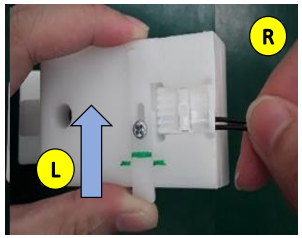
PARTS:	1. Assy parts	JIG:	1.Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1	Wire insertion to connector 6098-3810 (W)	 **Terminal facing**  1. Get the first **Black wire** and insert to **Slot 1** of connector using right hand. *Note: Insertion should be left to right.*  2. Get the **2nd Black wire** then insert to connector **slot 2** using right hand.  3. After insertion, push the lock using left thumb 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 deformed terminal 5. No wrong wire facing ***Important reminders/note/s:*** *1. Please hold the wire near terminal during insertion.* *2. Insertion of wire must be inserted.* *3. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion.* *Do not exert extra force.* ***Document reference/s:*** *1. Refer to **WI-PRO-CNC-017** for Wire and Strip lenght Tolerance.* *2. Please refer to **GL-PRO-ASSY-029** for Pull-Push procedure.*

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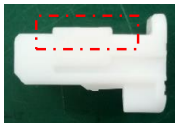
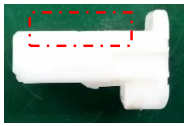
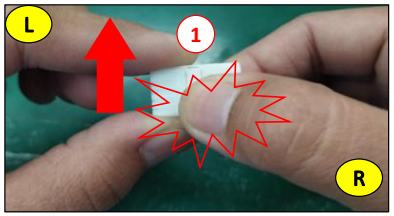
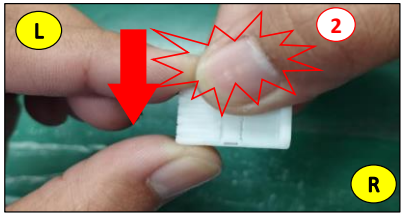
PARTS:	1. Assy parts	JIG:	1. Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1	Connector lock	  Before Pressing  After Pressing 1. Put the connector into locking jig using right hand then press to lock **2x**.   2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.	LOCKING JIG 	1. Use provided jig tools per model 2. No unclock/ half-locked connector. ***Important reminders/note/s:*** *1. Manual locking may cause damaged connector lock.*

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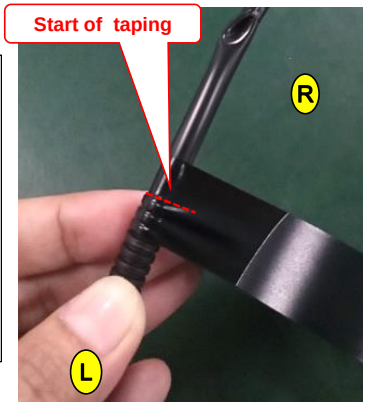
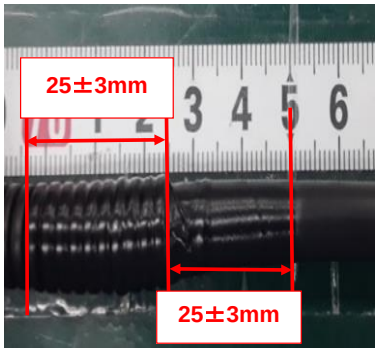
	WORK INSTRUCTION			Effectivity Date:	October 14, 2024		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number:	220D / 7L0134-7020B	Customer: TRQSS	Car Model:	Document No.:	WI-ENG-PDE-1099A	
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 6 of 12

PARTS:	1. Assy parts 2. Black tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1	Taping 1 Black Corrugated tube to SV tube (Vinyl) due to Connector	 1. Fix the corrugated tube and SV tube (Vinyl) using both hands. Make sure no gap between corrugated tube and SV tube (Vinyl).  2. Get the **Black tape** and start taping process using both hands.  3. After taping, check the measurement and taping condition.	Measuring tape 	***Important reminders/note/s:*** *1.Please use calibrated/verified measuring tape when getting the measurement.* ***Document references:*** *1. Please refer to **WI-PRO-ASY-001** for taping procedure.* 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension

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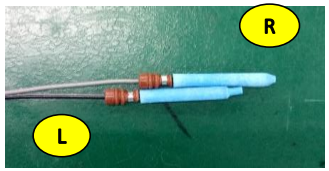
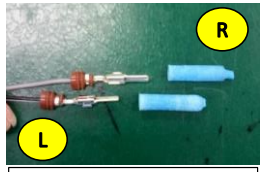
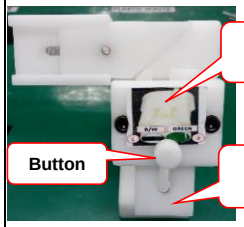
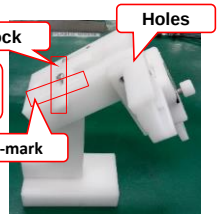
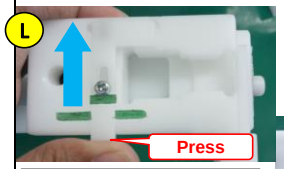
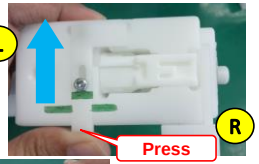
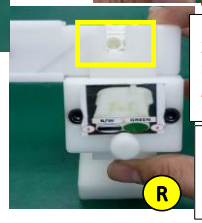
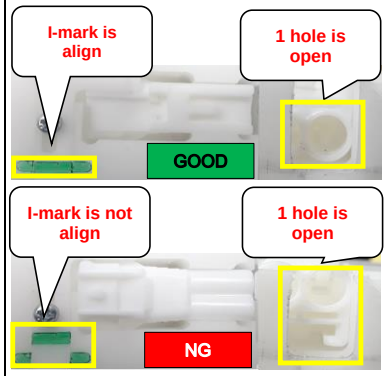
	Model code/Part number: 220D / 7L0134-7020B	Customer: TRQSS	Car Model: LEXUS-LM	Document No.:	WI-ENG-PDE-1099A	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 7 of 12

PARTS:	1. Black Corrugated tube (No Slit) Ø7 L=78±3mm 2. Connector 6188-0407 (W) 3. MR SW CP(G,B/W L=590±3 with VM tube (Sunprene) L=72±3mm)	JIG:	1. Terminal cover jig 2. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P1	Wire insertion to Black Corrugated tube Ø7 L=78±3mm	 1. Hold the **MR SW wires (Green and Black/White with VM tube (sunprene))** using left hand, get the terminal cover jig using right hand and insert to both terminals. 2. Get the **corrugated tube Ø7, L=78±3 (no slit)** using right hand and insert to wires.  3. After insertion, remove the terminal cover jig using right hand.	TERMINAL COVER JIG 	1. No wrong use of parts 2. No deformed terminal 3. No damge rubber seal ***Important reminders/Note/s:*** *1. Refer to **WI-PRO-CNC-017** for Wire and Strip length tolerance.*
9		Connector setting to insertion jig 6188-0407 (W)	Insertion jig   Connector orientation  1. Press the lock of insertion jig using left thumb.  2. Insert the connector 6188-0407 (W) into jig using right hand and release the lock. *Note: Refer to above illustration for correct setting.*  3. Press the lower wire guide using right thumb. Terminal slot for **B/W wire** will be open.	n/a	**Connector Orientation Illustration**  1. Use the provided jig per model 2. No wrong orientation of connector

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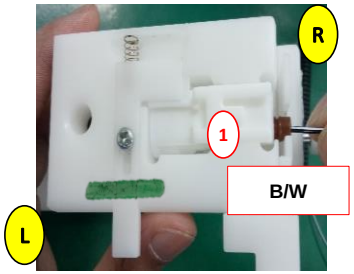
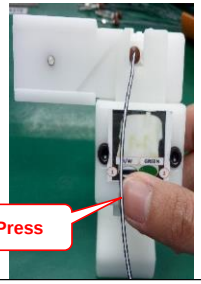
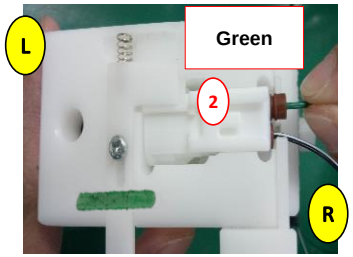
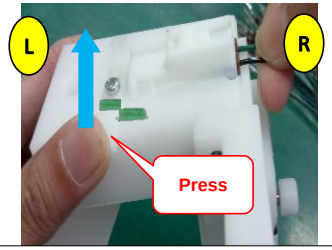
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number:	220D / 7L0134-7020B	Customer: TRQSS / Car Model: LEXUS-LM	Document No.:	WI-ENG-PDE-1099A		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.:	8 of 12

PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
10	P1	Wire Insertion to connector 6188-0407 (W)	 Terminal facing  1. Get **Black/White wire** then insert to terminal **slot 1** using right hand. 2. Push the button after insertion. Hole for Green wire will be open.   3. Get **Green wire** then insert to terminal **slot 2** 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 deformed terminal 5. No wrong wire facing ***Important reminders/Note/s:*** *1. Please hold the wire near terminal during insertion.* *2. Insertion of wire must be inserted.* *3. Make sure wires are properly inserted.* *Conduct **Pull-Push-Pull-Push** after insertion.* *Do not exert extra force.* ***Document reference/s:*** *1. Refer to **WI-PRO-CNC-017** for Wire and Strip lenght Tolerance.* *2. Please refer to **GL-PRO-ASSY-029** for Pull-Push procedure.*

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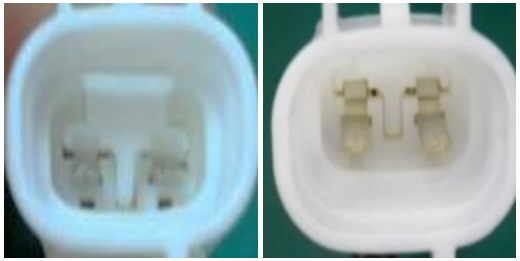
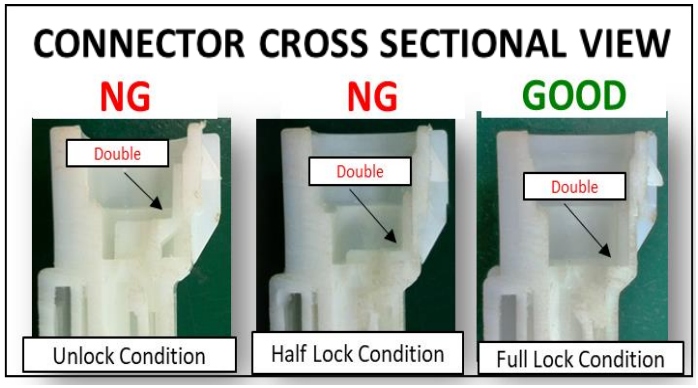
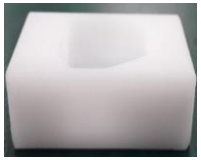
PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
11	P1	Connector lock	 1. Put the connector into locking jig using right hand then press to lock **2x.** Check the connector lock if properly locked.Touch the condition of lock after pressing.  **Before lock** **After lock** 	**LOCKING JIG** 	***Important reminders/Note/s:*** ***1. Manual locking may cause damaged connector lock.*** 1. Use the provided locking per model 2. No unlock/half-locked connector

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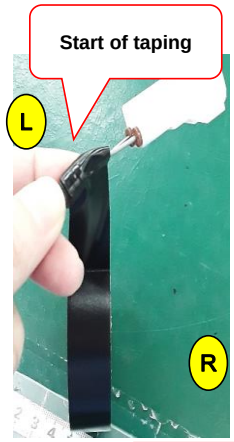
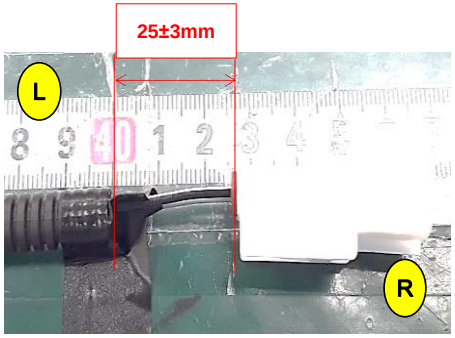
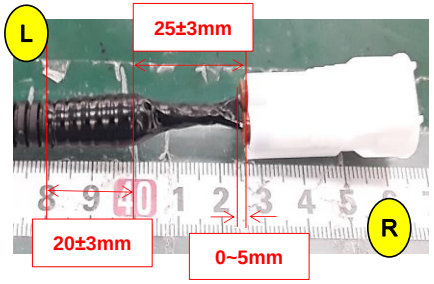
	Model code/Part number:	220D / 7L0134-7020B	Customer: TRQSS / Car Model: LEXUS-LM	Document No.:	WI-ENG-PDE-1099A		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.:	10 of 12

PARTS:	1. Assy parts 2. Black tape [1pc]			JIG:	n/a
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
12	P1	Taping 2 Corrugated tube to wire near connector	 1. Hold the COT using left hand. Get **Black tape** using right hand and conduct pre taping.  2. Measure the end of COT to connector **25±3mm** and continue taping process.  3. After taping, check the dimension and taping condition.		***Important reminders/note/s:*** *1.Please use calibrated/verified measuring tape when getting the measurement.* ***Document references:*** *1. Please refer to **WI-PRO-ASY-001** for taping procedure.* 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension

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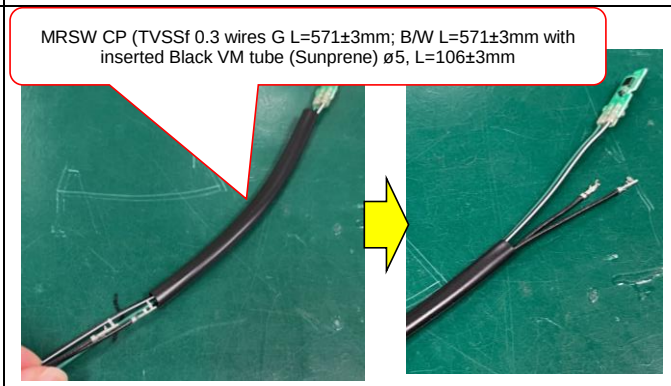
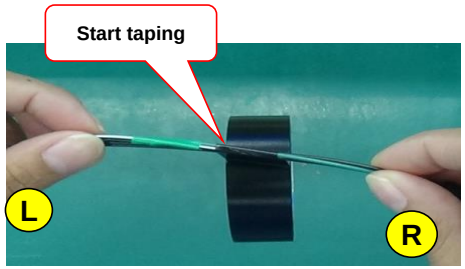
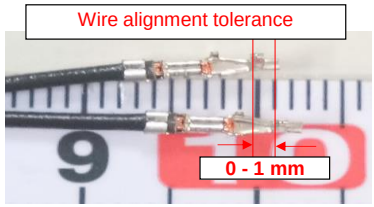
PARTS:	1. Assy parts 2. Black tape [1pc]	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
13	P1	Wire insertion to Black VM tube (Sunprene) ø5, L=106±3mm	 1. Get the hotmelted wire with VM tube (Sunprene) **ø5, L=106±3mm** using right hand. Get the 2 Black wires **L=51mm** and insert to VM tube (Sunprene) **ø5, L=106±3mm** using left hand.	n/a	1. No wrong use of parts 2. No deformed terminal
14		Spot Taping	 1. Align Hotmelted and 2 Black wires. Terminal pointed tip and hotmelted terminl must be. *Note: Follow the correct illustration.*  2. Hold the assy parts using left hand, get **Black tape** and position the tape near wire tape then start taping using both hands. Make **2 windings** then cut the tape. 3. After taping, check the taping condition.	n/a	1. No flip-out tape. 2. No peel-off tape. 3. No loose tape. 4. No missing tape. 5. No wrong use of tape. 

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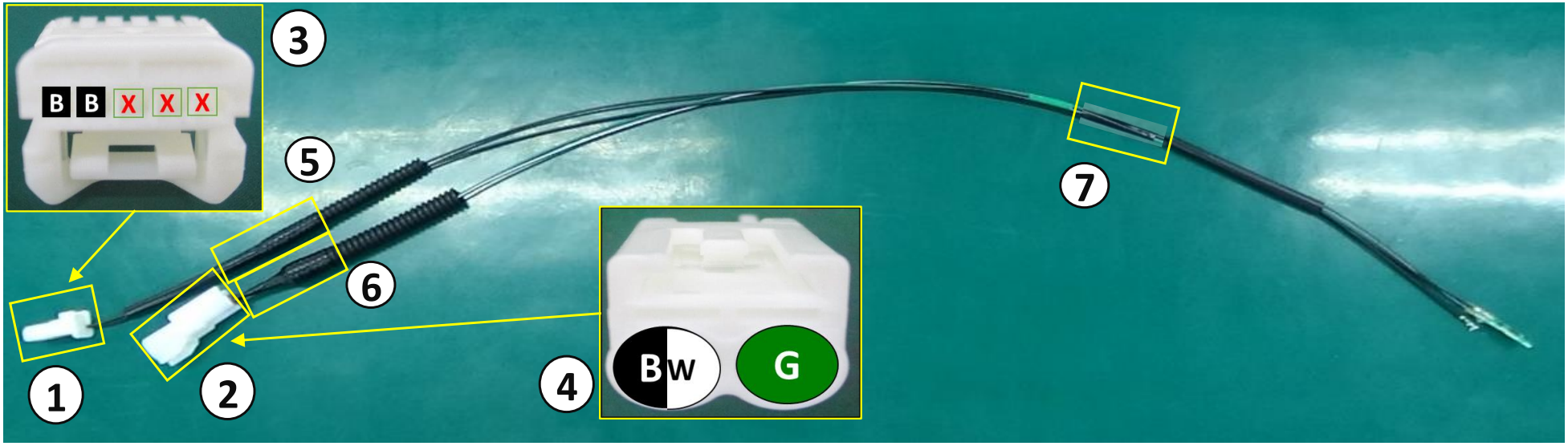
	WORK INSTRUCTION			Effectivity Date:	October 14, 2024		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 220D / 7L0134-7020B	Customer: TRQSS	Car Model: LEXUS-LM	Document No.:	WI-ENG-PDE-1099A		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.:	12 of 12

PARTS:	1. Assy parts	JIG:	n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING - P1 7L0134-7020B



1 2 No Unlocked/Half-locked connector

5 6 7 No Missing tape

9 No Terminal backing out

3 4 No Wrong Insert

8 No Deformed terminal

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