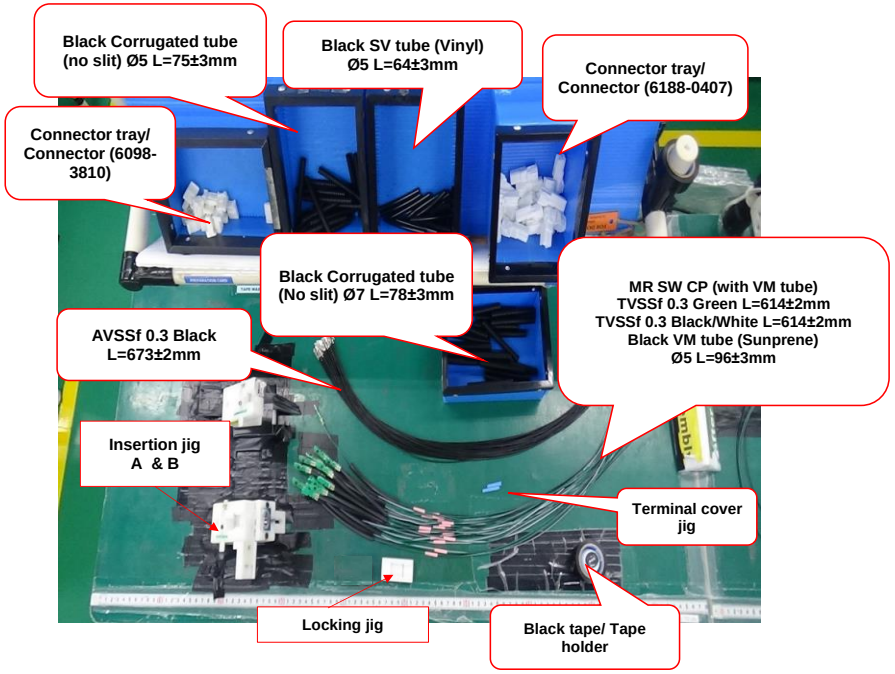
	WORK INSTRUCTION			Effectivity Date:	July 04, 2024		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 922B / 7L0124-7022	Customer: TRQSS	Car Model: LEXUS NX	Document No.:	WI-ENG-PDE-266A		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	4	Page No.:	1 of 9

PARTS:	1. All parts (Connector 6098-3810(W); Connector 6188-0407(W); MR SW CP(G,B/W L=614±2 with VM tube (Sunprene) L=96±3mm); Black Vinyl tube Ø5 L=64±3mm; Black Corrugated tube(no slit) Ø5 L=75±3mm & Ø7 L=78±3mm; AVSSf 0.3 Black L=673±2mm); Black tape	JIG:	1. Insertion jig 2. Locking jig 3. Terminal cover jig

NO.	PROCESS NAME		4 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
07/04/24	4	Transfer Black corrugated tube to Black SV tube (Vinyl) Black SV tube (Vinyl) to wire near connector to P2 and transfer Taping 1 from P2 due to process improvement. Transfer Connector lock process to Clamp assembly jig due to jig improvement. Inclusion of car model " LEXUS-NX". Improved Table lay-out and Visual inspection/Quality checkpoints.	D.Castillo	J.Loterte	C.Villanueva	A. Arañes
02/10/24	3	Work instruction improvement: Change process sequence (Page 2-6) and remove some process due to additional MP from 3MP to 4MP. Change term Black sunprene tube to Black VM tube (Sunprene); Black Vinyl tube to Black SV tube (Vinyl). Inclusion of Quality checkpoint (Page 9).	D.Castillo	J.Loterte	C.Villanueva	A. Arañes
10/22/22	2	Change part number due to design change. Add note for Wire and Strip Length Tolerance.	D.Castillo	J.Loterte	C.Villanueva	A. Arañes

Prepared by	Reviewed by	Approved by	Noted by
D.Castillo	C.Villanueva	A. Arañes	n/a
Est. Date:	June 5, 2021		

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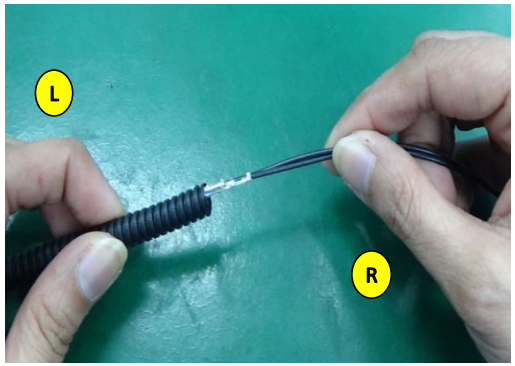
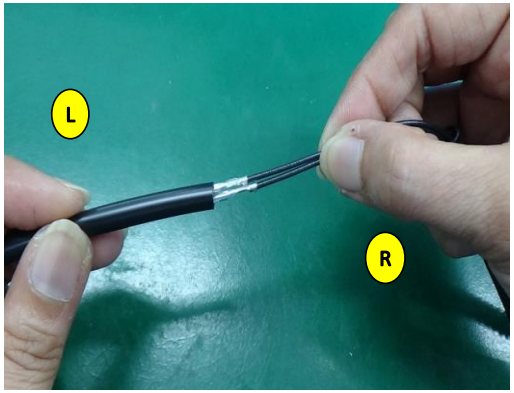
	WORK INSTRUCTION			Effectivity Date:	July 04, 2024		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 922B / 7L0124-7022	Customer: TRQSS	Car Model: LEXUS NX	Document No.:	WI-ENG-PDE-266A		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	4	Page No.:	2 of 9

PARTS:	1. Black SV tube (Vinyl) Ø5 L=64±3mm 2. Black Corrugated tube Ø5 L=75±3mm (no slit)	3. Assy parts 4. AVSSf 0.3 B L=673±3mm [2pcs.]	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.		

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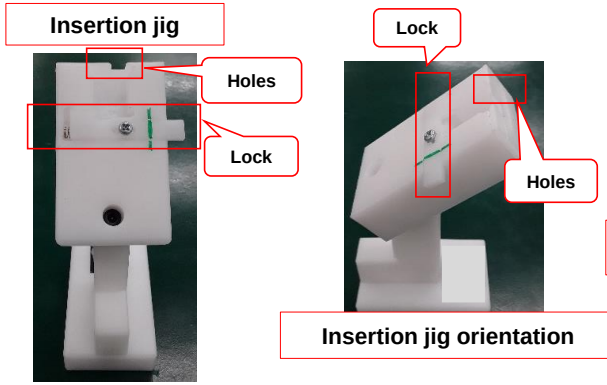
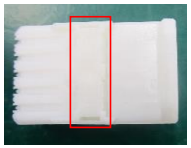
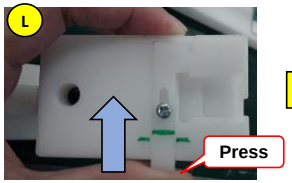
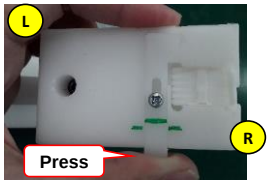
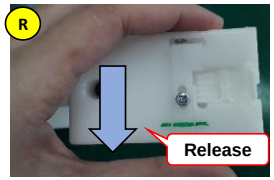
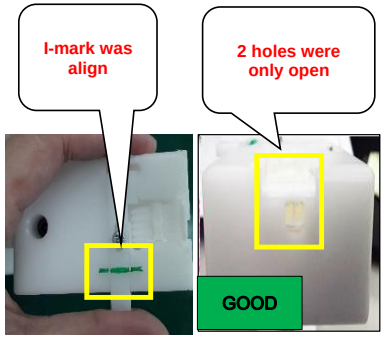
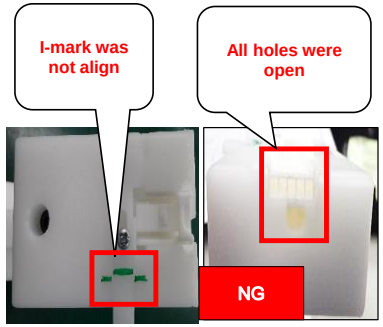
	WORK INSTRUCTION			Effectivity Date:	July 04, 2024	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 922B / 7L0124-7022	Customer: TRQSS	Car Model: LEXUS NX	Document No.:	WI-ENG-PDE-266A	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	4	Page No.: 3 of 9

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)	 Insertion jig orientation  Connector orientation    1. Press the lock of insertion jig using left thumb. **2. Insert the connector 6098-3810 (W) into jig using right hand and release the lock.** 3. Check the holes/terminal slot for **B-B wires.**	n/a	1. Use the provide jig per model 2. No wrong orientation of connector **Connector Orientation Illustration**  

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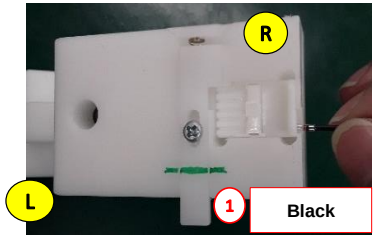
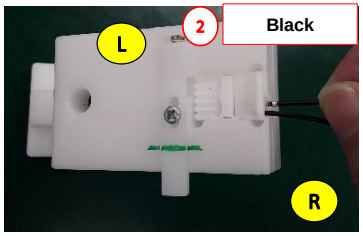
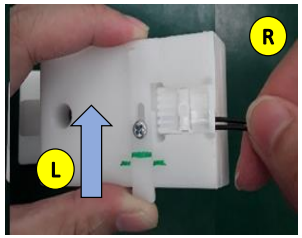
PARTS:	1. Assy parts	JIG:	1.Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1	Wire insertion to connector 6098-3810 (W)	**Wire 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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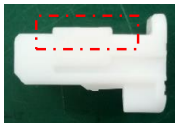
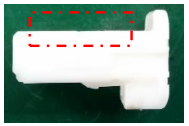
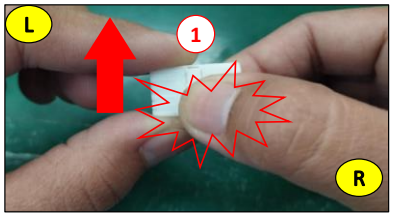
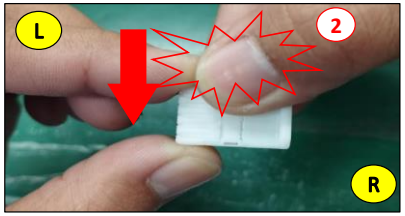
PARTS:	1. Assy parts	JIG:	1. Locking jig

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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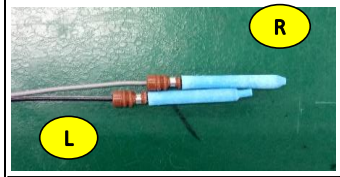
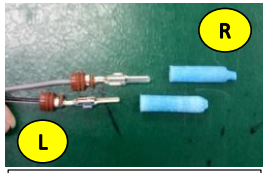
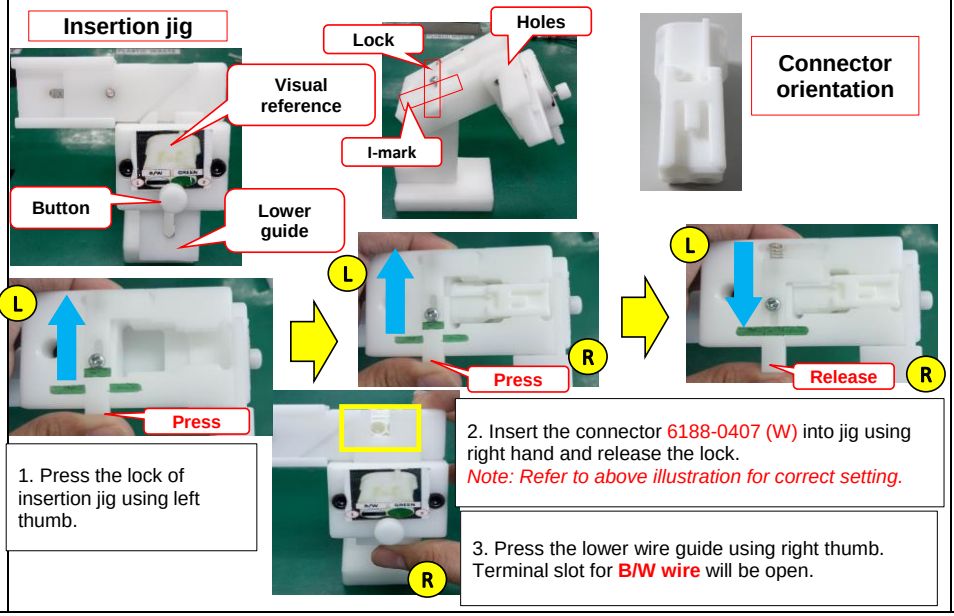
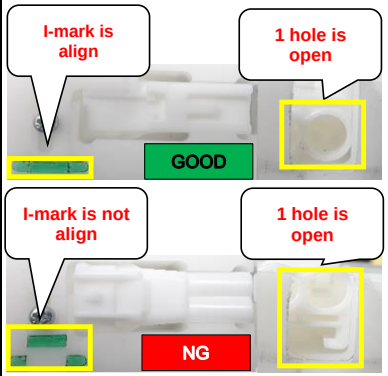
	WORK INSTRUCTION			Effectivity Date:	July 04, 2024	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 922B / 7L0124-7022	Customer: TRQSS	Car Model: LEXUS NX	Document No.:	WI-ENG-PDE-266A	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	4	Page No.: 6 of 9

PARTS:	1. Black Corrugated tube (No Slit) Ø7 L=78±3mm 2. Connector 6188-0407 (W)	3. MR SW CP(G,B/W L=614±2 with VM tube (Sunprene) L=96±3mm); Black Vinyl tube Ø5 L=64±3mm	JIG:	1. Terminal cover jig 2. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7		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.*
8	P1	Connector setting to insertion jig 6188-0407 (W)	 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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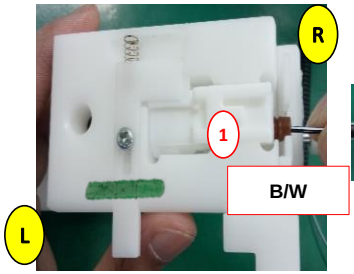
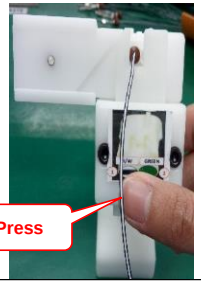
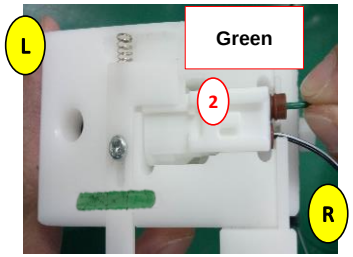
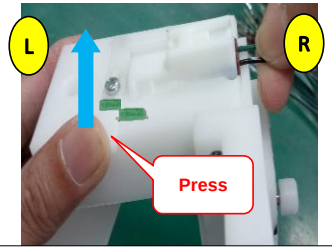
PARTS:	1. Assy parts	JIG:	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P1	Wire Insertion to connector 6188-0407 (W)	 Wire facing  Press 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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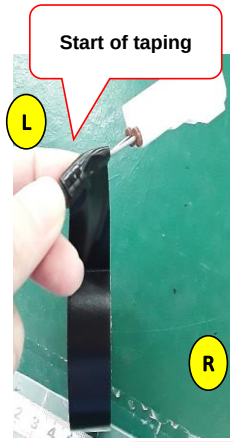
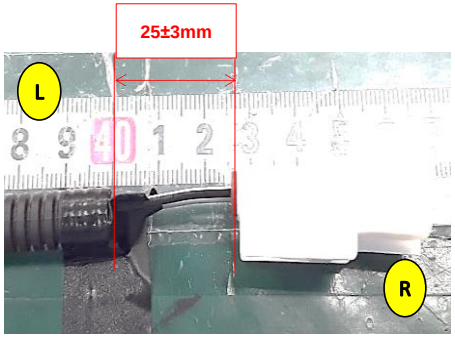
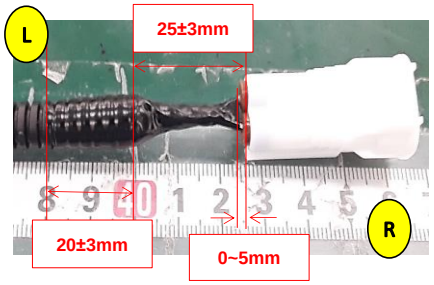
PARTS:	1. Assy parts 2. Black tape [1pc]	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	4 P1	Taping 1 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.	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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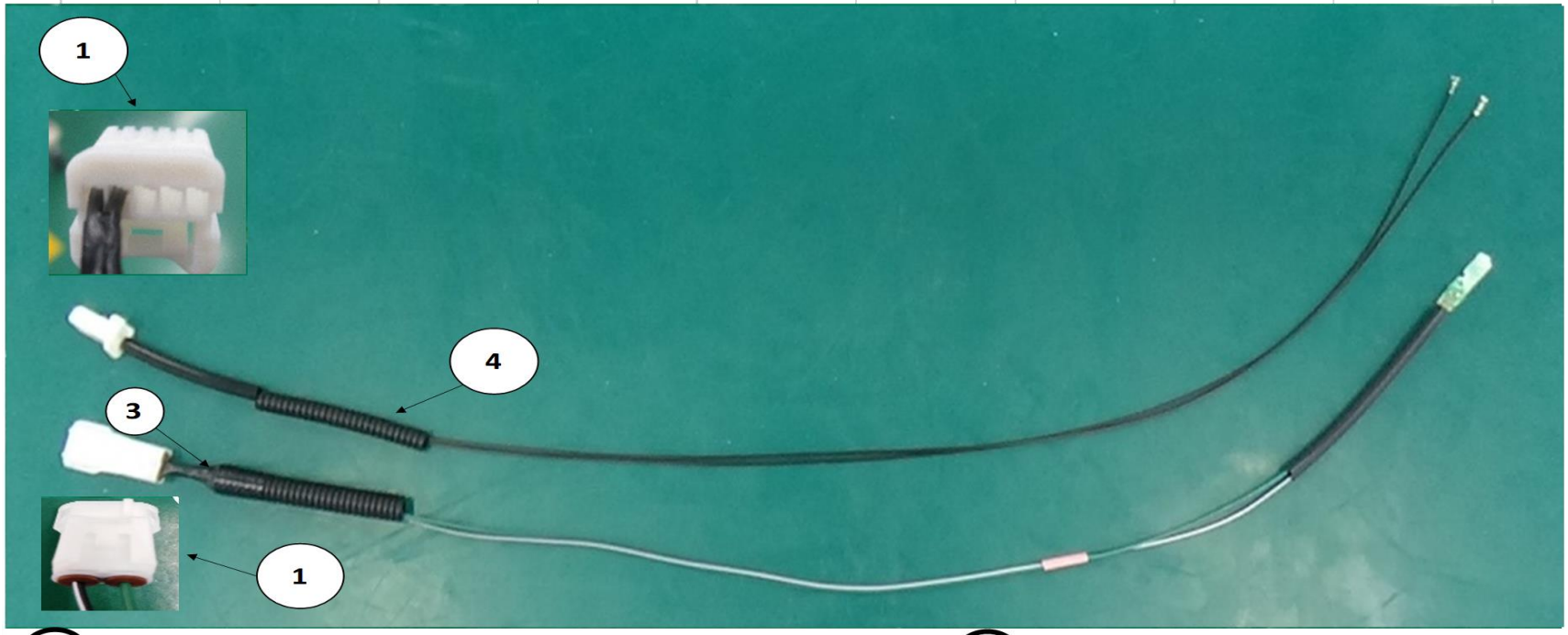
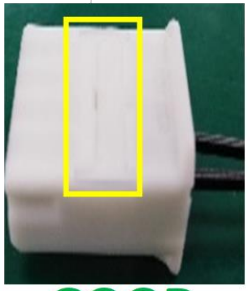
PARTS:	1. Assy parts	JIG:	n/a

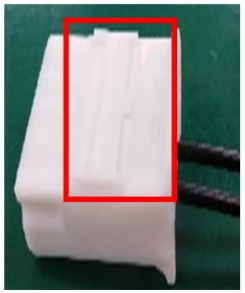
4 **VISUAL INSPECTION/ QUALITY CHECKPOINTS**

P1 7L0124-7022





GOOD



NO GOOD

1 No WRONG INSERT

2 No UNLOCKED/HALFLOCKED CONNECTOR

3 No MISSING TAPE

4 No MISSING COT

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