



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	July 10, 2024		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-425A		
Revision No.:	3	Page No.:	1 of 13

PARTS:	1. Connector 6188-0066 (GR);Connector 6098-3802 (W);Connector 6189-1161 (B); AVSSf 0.3 wires Y-OR L=376±2mm; AVSSf 0.3 wires B L=749±3mm; MRSW CP TVSSf 0.3 G-B/W wires L=685±3mm; Black COT (no slit) Ø7 L=92±3mm; Black COT (no slit) Ø5 L=201±3mm; Black COT (no slit);Black COT (no slit) Ø5 L=163±3mm; Black tape	JIG:	1. Insertion jig with switch cover 2. Locking jig 3. Terminal cover jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	Table Lay-out	<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to WI-PRO-KIT-005 for Wire Taping without Vinyl Tube</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>

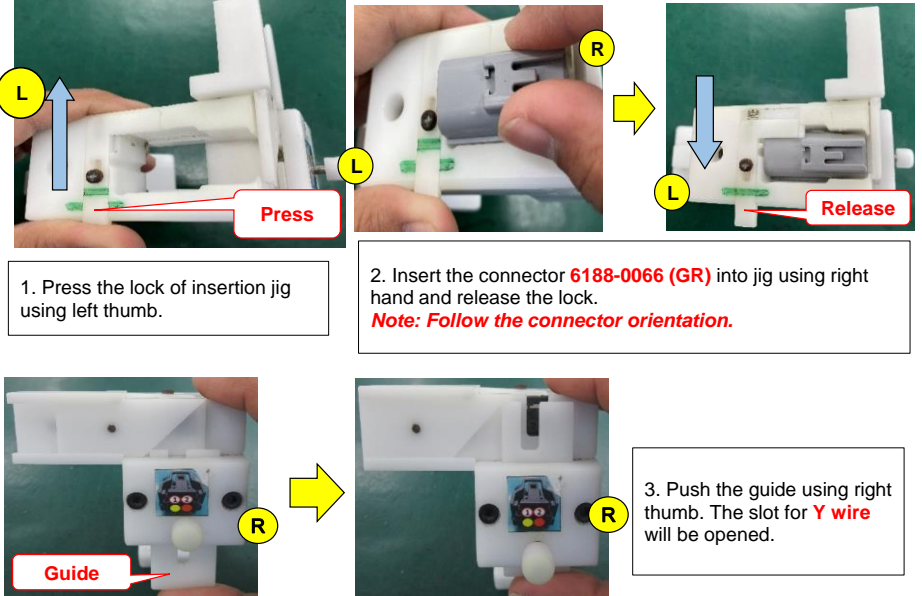

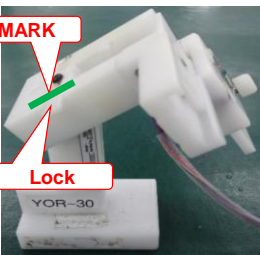
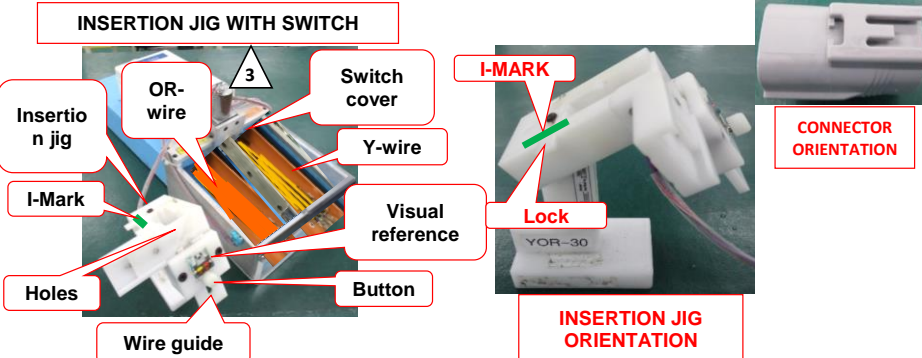
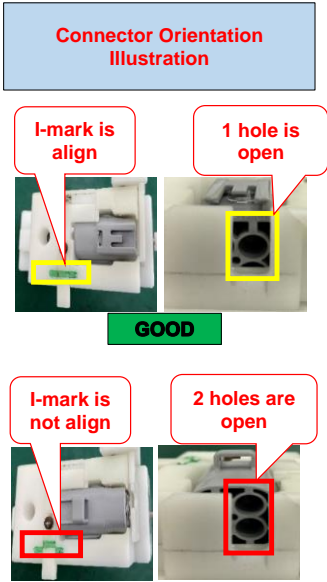
Revision History						Prepared by	Reviewed by	Approved by	Noted by
07/10/24	3	Change tape width to value (20±3mm). Aligned switch cover to insertion jig (OR-Y).	D.Castillo	C. Villanueva	A. Arañes	n/a			
09/07/23	2	Update template and inclusion of Car model.	A.Hernandez	J. Loterte	C. Villanueva	A. Arañes			
12/17/22	1	Improve quality pointers: Reminders/notes and references. Inclusion of Quality checkpoints	M. Catapang	J. Loterte	C. Villanueva	A. Arañes			
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	February 24, 2022	n/a

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	WORK INSTRUCTION				Effectivity Date:	July 10, 2024			
	TAPING ASSEMBLY PROCESS				Validity Date:	n/a			
	Process Name/Title:		Model code/Part number: 100B / 7M0594-7021		Customer: TRJ	Car Model: LEXUS UX	Document No.:	WI-ENG-PDE-425A	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		3	Page No.:	2 of 13

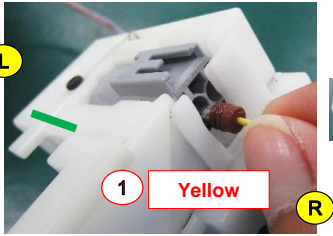
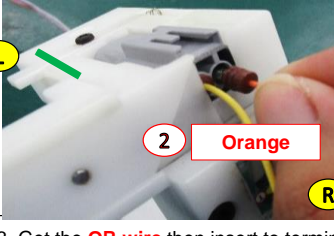
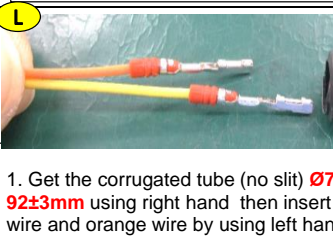
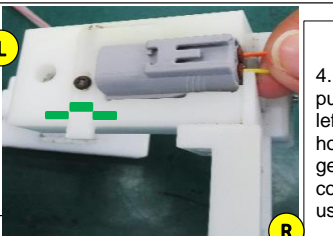

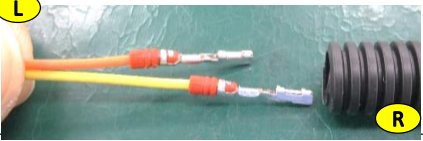

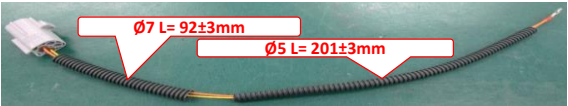
PARTS:		1. Connector 6188-0066 (GR) 2. AVSSf 0.3 Y/OR wire L=376±2mm		JIG:	1. Insertion jig with switch cover	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
2	P1 Connector setting to insertion jig 6188-0066 (GR)	<div></div>		N/A	<div><p>GOOD</p><p>NG</p></div> <div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div>	

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	Model code/Part number: 100B / 7M0594-7021		Customer: TRJ	Car Model: LEXUS UX	Document No.:	WI-ENG-PDE-425A		
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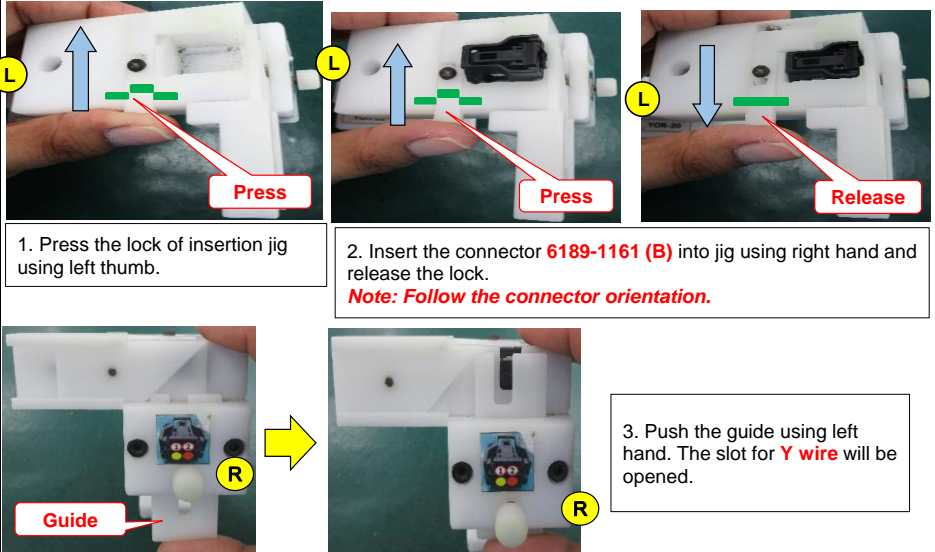
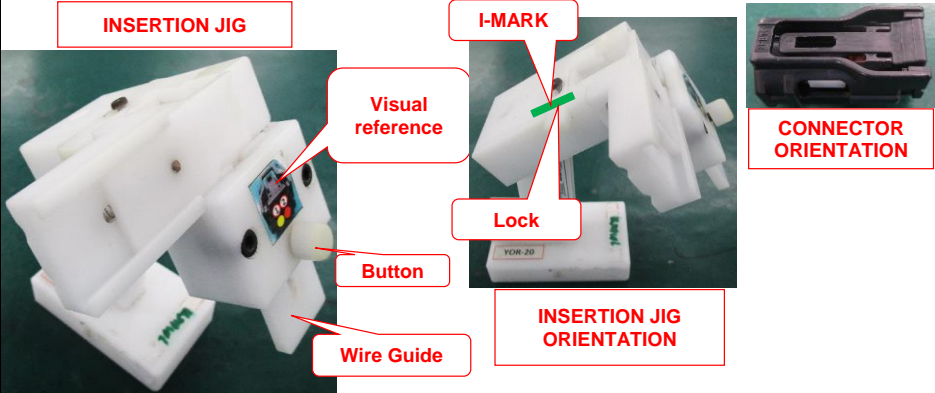
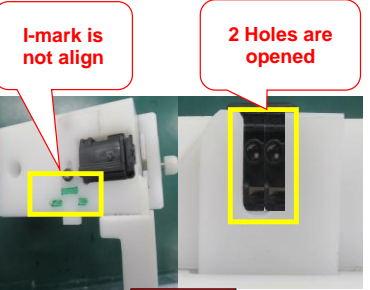
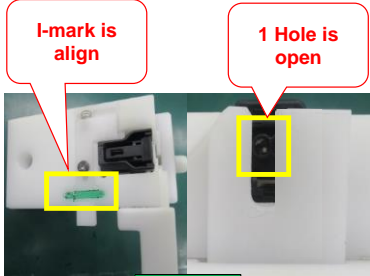
PARTS:	1. Assy parts 2. Black Corrugated tube (no slit) Ø7 L=92±3mm 3. Black Corrugated tube (no slit) Ø5 L=201±3mm			JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to connector 6188-0066 (GR)	<div><p>1. Get the Y wire then insert to terminal slot 1 using right hand.</p></div> <div><p>2. Press the button using right thumb. The slot for OR wire will be opened.</p></div> <div><p>3. Get the OR wire then insert to terminal slot 2 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> <div><p>WIRE FACING</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</div> <div>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.</div> <div>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</div>
4	Wire insertion to Black Corrugated tube (no slit) Ø7 L=92±3mm Ø5 L=201±3mm	<div><p>1. Get the corrugated tube (no slit) Ø7 L= 92±3mm using right hand then insert the yellow wire and orange wire by using left hand.</p></div> <div><p>2. Get the corrugated tube (no slit) Ø5 L= 201±3mm using right hand then insert the yellow wire and orange wire by using left hand.</p></div> <div><p>Ø7 L= 92±3mm Ø5 L= 201±3mm</p></div>		N/A	<div>1. No wrong use of parts 2. No deformed terminal</div>

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	Process Name/Title:			Model code/Part number:	100B / 7M0594-7021	Customer:	TRJ	Car Model:	LEXUS UX	Document No.:	WI-ENG-PDE-425A	
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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	<div>Connector setting to insertion jig 6189-1161 (B)</div> <div></div>			N/A	<div>Connector Orientation Illustration</div> <div></div> <div>GOOD</div> <div>NG</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>		

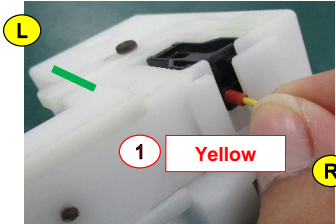

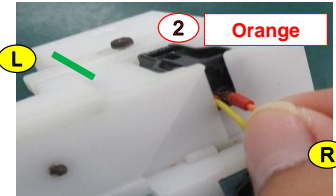

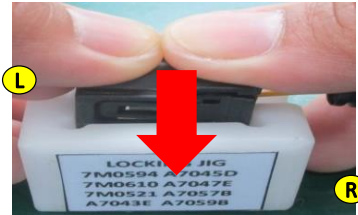




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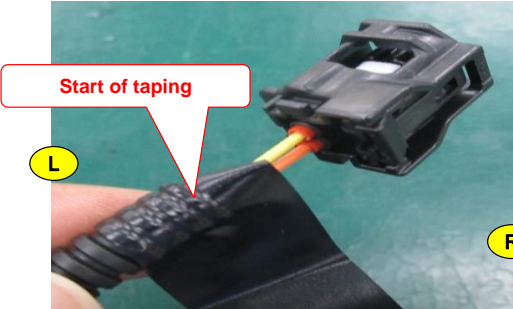
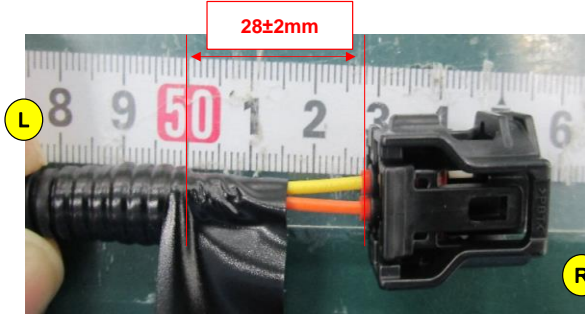
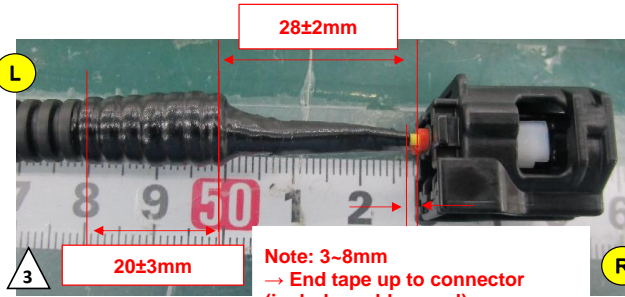

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		Process Name/Title:				Document No.:	WI-ENG-PDE-425A	
		Model code/Part number:	100B / 7M0594-7021	Customer:	TRJ	Car Model:	LEXUS UX	
Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	3	Page No.:	5 of 13

PARTS:	1. Assy parts				JIG:	1. Insertion jig 2. Locking jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
6	P1	<div>     </div> <div> <p>1. Hold the Y wire then insert to terminal slot 1 using right hand.</p> <p>2. Press the button using right thumb. The slot for OR wire will be opened.</p> <p>3. Hold the OR wire then insert to terminal slot 2 using right hand.</p> <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 deformed terminal 5. No wrong wire facing</p> <p>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.</p> <p>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>		
7		<div>     </div> <div> <p>1. Put the connector into locking jig using both hands and then press 2x. Check the connector if properly locked.</p> </div>			<div> <p>LOCKING JIG</p>  </div>	<p>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <p>1. Use the provided locking jig per model 2. No unlock/half-locked connector</p>		

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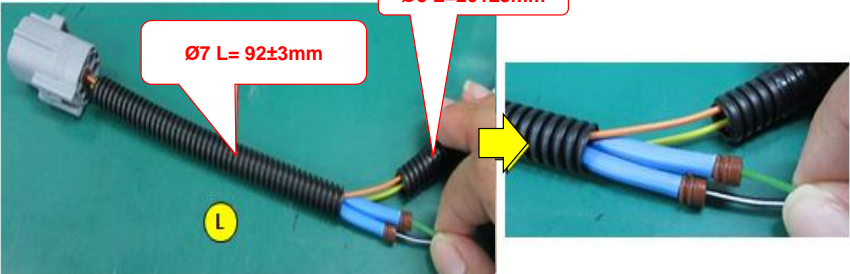


PARTS:		1. Assy parts 2. Black tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
8	P1 Taping 1 Black Corrugated tube to wire near connector	<div><div>1. Hold the corrugated tube using left hand then start taping using both hands.</div></div> <div><div>2. Measure from end of the corrugated tube up to connector 28±2mm using both hands.</div></div> <div><div>3. After taping, check the measurement and tape condition.</div></div>		<div>MEASURING TAPE</div> 	<div>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</div> <div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</div>	

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	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		3	Page No.: 7 of 13

PARTS:		1. MRSW CP TVSSf 0.3 G-B/W wires L=685±3mm 2. Assy parts		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1 Wire insertion to assy parts	<div><div>1. Get the MRSW CP TVSSf 0.3 G-B/W wires L=685±3mm using both hands then insert the terminal cover jig using right hand.</div></div> <div><div>Ø7 L=92±3mm</div><div>Ø5 L=201±3mm</div><div>2. Hold the COT (no slit) Ø7 L=92±3mm using left hand then insert the MRSW CP TVSSf 0.3 G-B/W wires L=685±3mm using right hand.</div></div> <div><div>3. After insertion, remove the cover jig using right hand.</div></div>		<div><div>TERMINAL COVER JIG</div></div>	1. No wrong usage of parts 2. No damaged rubber seal 3. No exposed rubber seal during insertion

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100B / 7M0594-7021

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TRJ

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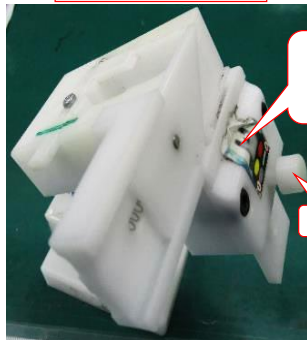


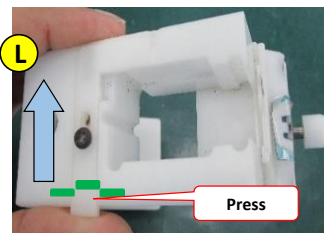


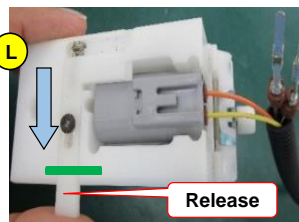
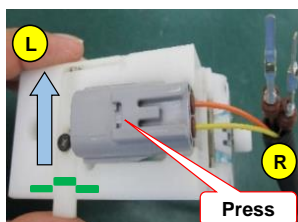
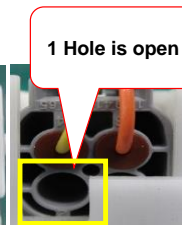



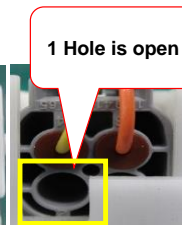



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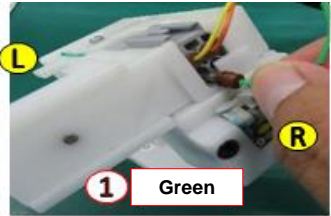

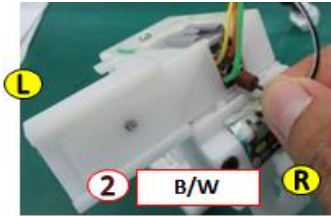
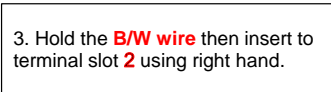
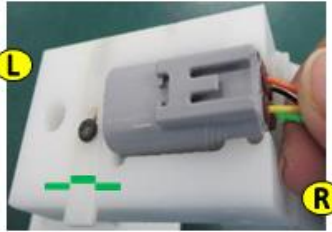

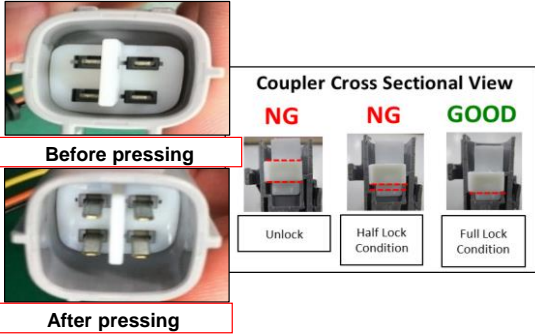

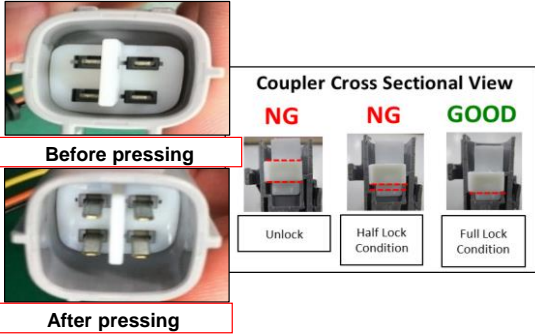

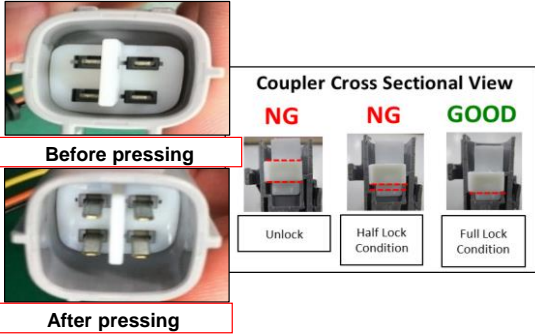
PARTS:	1. Assy parts		JIG:	1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	P1 Connector setting to insertion jig 6188-0066 (GR) (Assy parts)	<div><div>INSERTION JIG</div><div></div><div><div>I-MARK</div><div>Visual reference</div><div>Lock</div><div>Button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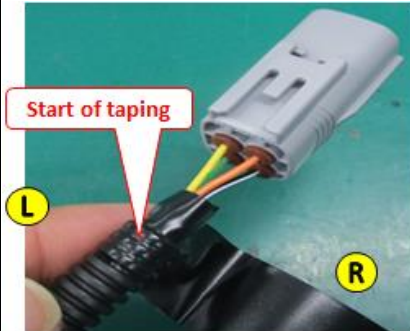
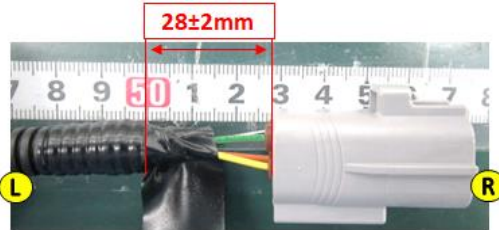
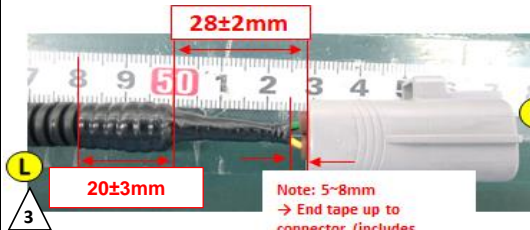


PARTS:	1. Assy parts			JIG:	1. Insertion jig 2. Locking jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
11	P1	<div><div><p>1 Green</p><p>1 Hold the G wire then insert to terminal slot 1 using right hand.</p></div><div><p>WIRE FACING</p></div><div><p>2 B/W</p><p>2. Press the button using right thumb. The slot for B/W wire will be opened.</p></div><div><p>3. Hold the B/W wire then insert to terminal slot 2 using right hand.</p></div><div><p>4. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</p></div></div> <div>N/A</div> <div>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. 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.</div> <tr><td>12</td><td></td><td colspan="2"><div><div><p>1. Put the connector into locking jig using both hands and then press 2x. Check the connector if properly locked.</p></div><div><p>Before pressing</p><p>After pressing</p><p>Coupler Cross Sectional View</p><p>NG NG GOOD</p><p>Unlock Half Lock Condition Full Lock Condition</p></div></div><div>LOCKING JIG</div><div>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR 1. Use the provided locking jig per model 2. No unlock/half-locked connector 3. No damage connector</div></td></tr>		12		<div><div><p>1. Put the connector into locking jig using both hands and then press 2x. Check the connector if properly locked.</p></div><div><p>Before pressing</p><p>After pressing</p><p>Coupler Cross Sectional View</p><p>NG NG GOOD</p><p>Unlock Half Lock Condition Full Lock Condition</p></div></div> <div>LOCKING JIG</div> <div>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR 1. Use the provided locking jig per model 2. No unlock/half-locked connector 3. No damage connector</div>	
12		<div><div><p>1. Put the connector into locking jig using both hands and then press 2x. Check the connector if properly locked.</p></div><div><p>Before pressing</p><p>After pressing</p><p>Coupler Cross Sectional View</p><p>NG NG GOOD</p><p>Unlock Half Lock Condition Full Lock Condition</p></div></div> <div>LOCKING JIG</div> <div>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR 1. Use the provided locking jig per model 2. No unlock/half-locked connector 3. No damage connector</div>					

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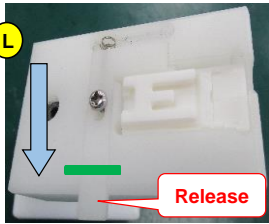
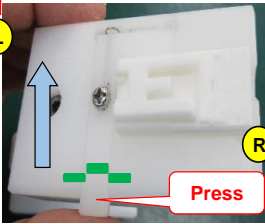
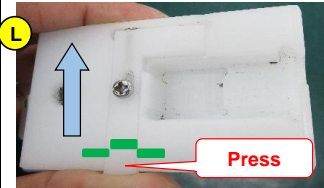
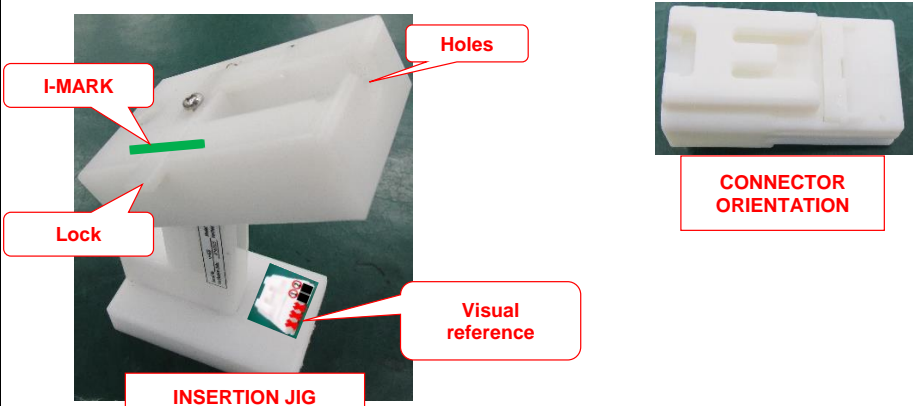
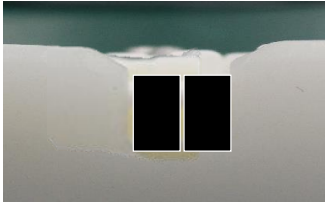
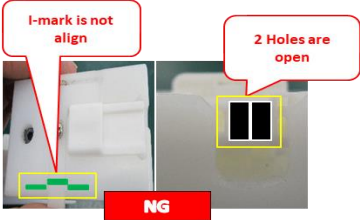
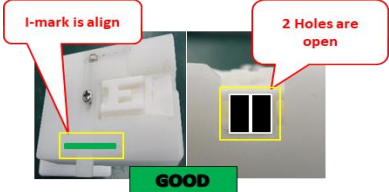
		WORK INSTRUCTION				Effectivity Date:		July 10, 2024		
		TAPING ASSEMBLY PROCESS				Validity Date:		n/a		
		Model code/Part number: 100B / 7M0594-7021		Customer: TRJ	Car Model: LEXUS UX		Document No.:		WI-ENG-PDE-425A	
		Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		3	Page No.:	10 of 13

PARTS:		1. Assy parts 2. Black tape		3. Black Corrugated tube (no slit) Ø5 L=163±3mm 4. AVSSf 0.3 B wires L=749±3mm [2pcs]		JIG:		n/a	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE		QUALITY POINTERS	
13	P1	Taping 2 Black Corrugated tube to wire near connector	<div><div></div><div></div><div>1. Hold the corrugated tube using left hand then start taping using right hand.</div><div>2. Measure from end of the corrugated tube up to connector 28±2mm using both hands.</div><div></div><div>3. After taping, check the measurement and tape condition.</div><div>Note: 5~8mm → End tape up to connector (includes rubber seal)</div><div>Note: Set aside the assy parts after assembly.</div></div> <div><div>MEASURING TAPE</div></div>			<div>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. Document reference/s: 1. 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 dimension 6. No wrong use of tape</div>			
14		Wire insertion to Black Corrugated tube (no slit) Ø5 L=163±3mm	<div><div></div><div>1. Get the COT (no slit) Ø5 L=163±3mm using right hand then insert the B-B wires L=749±3mm using left hand.</div></div>			N/A		<div>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 1. No wrong use of parts 2. No deformed terminal</div>	

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	WORK INSTRUCTION				Effectivity Date:	July 10, 2024		
	TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Process Name/Title:		Model code/Part number: 100B / 7M0594-7021		Customer: TRJ	Car Model: LEXUS UX		Document No.: WI-ENG-PDE-425A
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		3	Page No.: 11 of 13

PARTS:		1. Connector 6098-3802 (W)		JIG:	1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS		
14	P1 Connector setting to insertion jig 6098-3802 (W)	<div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6098-3802 (W) into jig using right hand then release the lock. Note: Follow the connector orientation.</div><div><div>3. Check the holes for B-B wires.</div></div></div> <div>N/A</div> <div><div>Connector Orientation Illustration</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

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

July 10, 2024

Model code/Part number:

100B / 7M0594-7021

Customer:

TRJ

Car Model:

LEXUS UX

Document No.:

WI-ENG-PDE-425A

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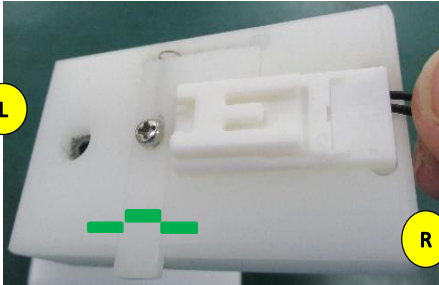
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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3

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PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
15	P1	<div><div>WIRE FACING</div></div> <div><div>1. Get the 1st B wire then insert to terminal slot 1 using right hand.</div></div> <div><div>2. Get the 2nd B wire then insert to terminal slot 2 using right hand.</div></div> <div><div>3. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</div></div>		N/A	<p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Please hold the wire near terminal.2. Insertion of wire must be from left to right3. Make sure wires are properly inserted. <p>Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>Document references:</p> <ol style="list-style-type: none">1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. <ol style="list-style-type: none">1. No loose insertion2. No wrong insertion3. One by one insertion4. No deformed terminal5. No wrong wire facing

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WORK INSTRUCTION

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Customer: TRJ

Car Model:

LEXUS UX

Document No.:

WI-ENG-PDE-425A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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3

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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

P1

7M0594-7021



NO GOOD



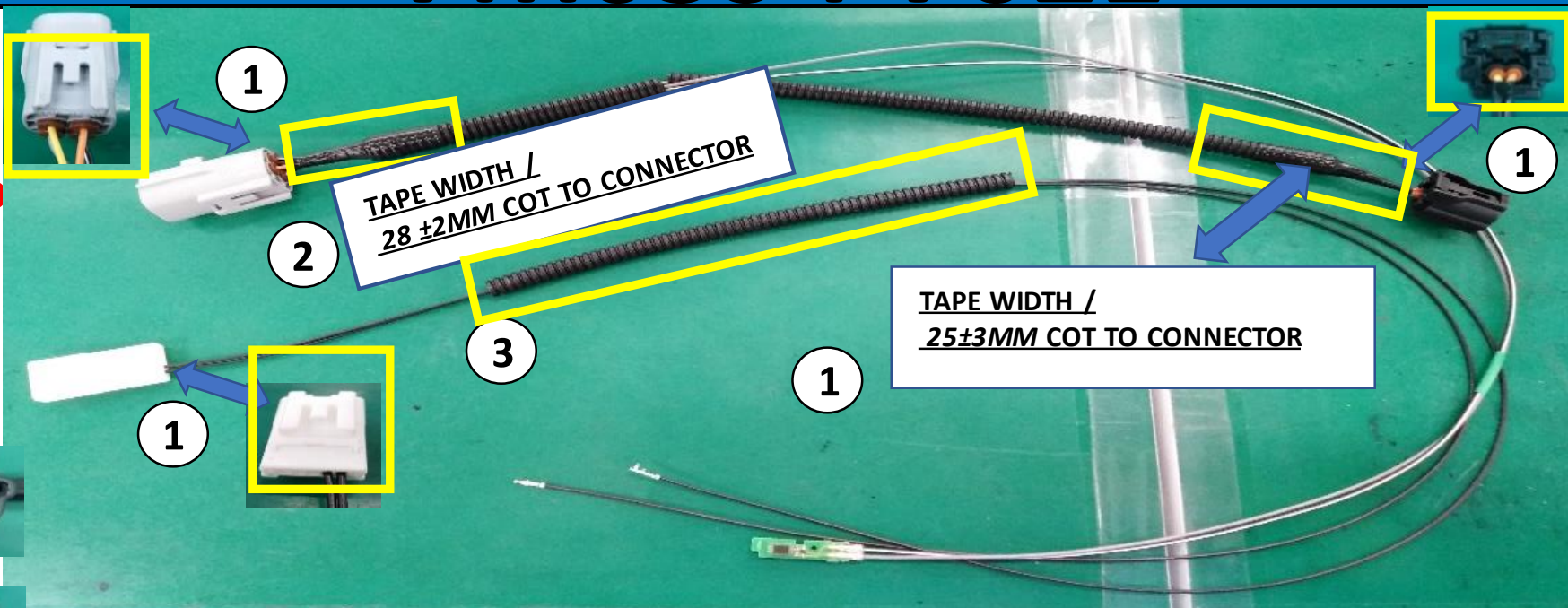
GOOD



GOOD



NO GOOD



1 No **WRONG INSERT**
No **UNLOCKED/HALFLOCKED**
No **TBO**

2 No **Missing Tape**
3 No **MISSING COT**

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