				WORK INS	STRUCTION				Effecti	ivity Date:		October 21, 2024						
			Process Name/Title:	OFFLI	NE ASSEMBLY PRO	CESS			Validit	ty Date:		n/a						
			Model code/Part number:	900B.910B / 7N0104-70200	C Customer: TRJ	Car Model:	LEXU	JS-NX/RX	Docun	ment No.:		WI-ENG-PDE-1	136					
			Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPF	RO		Revisi	ion No.:	1	Page No.:	1 of 10					
PARTS:			arts (Connector 6098-3810 mm and Ø7 L=78±3mm; A	(W); Connector 6188-0407(W); MR SW VSSf 0.3 B L=666±3mm;	CP(G,B/W L=608±3mm); Bla	ack Corrugate	ed tube (n	o slit) Ø5	JIG: 1. Insertion jig 2. Locking jig 3. Terminal cover jig			ig						
N	0.	Р	ROCESS NAME	WORK I	PROCEDURE/ ILLUSTR	ATION				TOOLS/PPE	(QUALITY POIN	TERS					
		OFFLI NE		TABLE LAY-OUT Connector 6098-3810 (W)/ Connector tray Connector 6188-0407 (W)/ Connector tray					pr	fety Instruction Be sure to wear rescribed person- stective equipment during operation ploves, finger cot- etc.)	s, Docum	Document reference/s: 1. Refer to WI-PRO-CNC-071 Wire and Strip Length Tolerance						
1							Table Lay-out	MRSW CP (TVSSf 0.3 G-B/W L=608±3mm)	Black Corrugate tube Ø7 L=78±3mm (N slit)				1. N 2.	dousekeeping Maintain and alwing practice 5's. Personal things the workplace is ohibited. Keep it your locker.	ays 1. No missi 2. No exces	1. No missing parts/tools 2. No excess parts/tools 3. No excess parts/tools		
				Insertion jig B	Locking jig	Ter	minal co	ver jig	the S Le	Alert level any trouble, info Assembly Assist Supervisor or Line ader for immedia corrective action.	ant e ate							
				Revision History			Prepared by	Reviewed by	Approved by	Noted by								
10/21/24	1	Change from Pre-launch to Masspro. Update Visual inspection/Quality checkpoints. D. Castillo C. Villanua a								0	1/bit	ALTO CONTRACTOR OF THE PARTY OF						
10/17/24	0	Initial issu	D. Castillo	C.Villanuev a	A. Arañes	n/a D. Castillo C. Villanueva			A. Aranes	n/a								
Eff. Date	Rev. No			Details of Change		Revised	Reviewed	Approved N	loted Est. Date: October 17, 2024									

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				RK INSTRUCTION				Effectivity Date:	T	October 21, 20	24
JB(Process Name/Title:		OFFLINE ASSEMB				Validity Date:		n/a	
		Model code/Part number:	900B.910B / 7N0104	-7020C Customer:	TRJ Car M	odel:	LEXUS-NX/RX	Document No.:		WI-ENG-PDE-1	136
		Purpose:	PROTOTYPE	☐ PRE-LAUNCH		MASSPRO)	Revision No.:	1	Page No.:	2 of 10
PARTS:	1. Conn	ector 6098-3810 (W)		JIG:	ig						
NO.	F	ROCESS NAME	W	VORK PROCEDURE/	ILLUSTRATION	1		TOOLS/PPE		TERS	
2	OFFLI NE	Connector setting to insertion jig 6098-3810 (W)	INSERTION JIG Press 1. Press the lock of insertion jig using left thumb.	Lock Press 2. Insert the connector of release the lock. Note: Follow the conn	• • •	g using r		n/a	1. Use the 2. No wron 3. No wron	is NOT gn	nnector



PARTS: 1. AVSSI 0.3 B L=666±3mm [2pcs.] NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS Important reminders/Note/s: 1. Please hold the wire near terminders in sertion. 2. Insertion of wire must be insert of connector inserted. Conduct Pull-yush-Pull-Push after insertion. Do not exert extra force. 1. No loose insertion. 2. No wrong insertion. 3. One by one insertion. 3. One by one insertion. 4. No deformed terminal 5. No wrong wire facing. Document reference/s: 1. Refer to Wi-PROC-NC-017 for Ward and Strip length Tolorachy length Tolorachy. Document reference/s: 1. Refer to Wi-PROC-NC-017 for Ward Strip length Tolorachy length Tolorachy length Tolorachy length Tolorachy length Tolorachy. Document reference/s: 1. Refer to Wi-PROC-NC-017 for Ward Strip length Tolorachy length Tolorachy length Tolorachy. Please refer to GL-PRO-ASSY-03 for Pull-Push procedure.				WORK INSTRUCTION	N		Effectivity Date:		October 21, 20	24
PARTS: 1. AVSST 0.3 B L=666±3mm [2pcs.] NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS Important reminders/Note/s: 1. Page No.: 3 of: NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS Important reminders/Note/s: 1. Please hold the wire near terminding insertion. 2. Insertion to wire must be insert induring insertion. 3. Make sure wires are properly inserted. Conduct Pull-Push after insertion. Do not exert extra force. 1. No loose insertion. 2. No wrong insertion. 3. One by one insertion. 2. No wrong wire facing Document reference/s: 1. Refer to Wi-PROCENCE/IT for Willing length Tolerance. Document reference/s: 1. Refer to Wi-PROCENCE/IT for Willing length Tolerance. To Pull-Push procedure. After insertion. push the lock using left thumb			Process Name/Title:	OFFLINE ASSE	MBLY PROCESS		Validity Date:		n/a	
PARTS: 1. AVSS10.3 B L=666a3mm [2pcs.] NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS Important reminders/Note/s: 1. Please hold the wire near termiduring insertion. 2. Insertion of wire must be insert of conduct Pull-Push-Pull-Push ande insertion. Do not exert extra force. 1. No loose insertion. 2. No wrong insertion. 2. No wrong insertion. 3. One by one insertion. 4. No deformed terminal. 5. No wrong wire facing. Document reference/s: 1. Refer to WI-PRO-CNC-017 for Warning and strip insertion. Do course treated. 1. Refer to WI-PRO-CNC-017 for Warning and strip insertion. Document reference/s: 2. Please refer to GL-PRO-ASSY-02 for Pull-Push procedure.			Model code/Part number:	900B.910B / 7N0104-7020C Custom	ner: TRJ Car Model:	LEXUS-NX/RX	Document No.:		WI-ENG-PDE-11	136
NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TERMINAL FACING Important reminders/Note/s: 1. Please hold the wire near termiduring insertion. 2. Insertion of wire must be insert of during insertion. 3. Make sure are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 1. No loose insertion. Do not exert extra force. 1. No loose insertion. 2. No wrong insertion. 2. No wrong insertion. 3. One by one insertion. 4. No deformed terminal. 5. No wrong wire facing Document reference/s: 1. Refer to Wi-PRO-CNC-017 for Ward Strip length Tolerance. 2. Please refer to GL-PRO-ASSY-07. 4. Refer to Wi-PRO-CNC-017 for Ward Strip length Tolerance. 2. Please refer to GL-PRO-ASSY-07. 4. Pull-Push Procedure. 2. Please refer to GL-PRO-ASSY-07. 4. Pull-Push Procedure. 2. Please refer to GL-PRO-ASSY-07. 4. Pull-Push Procedure. 3. After insertion, push the lock using left thumb			Purpose:	PROTOTYPE PRE-LAL	JNCH MASSP	RO	Revision No.:	1	Page No.:	3 of 10
TERMINAL FACING Important reminders/Note/s: 1. Please hold the wire near terminduring insertion. 2. Insertion of wire must be insert 3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push afte insertion. Do not exert extra force. 1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire lacing Connector slot 1 using right hand. Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wand Strip length Tolerance 3. After insertion, push the lock using left thumb	PARTS:	1. AVS	Sf 0.3 B L=666±3mm [2pc	:s.]			JIG:	1. Insertior	n jig	
Important reminders/Note/s: Impo	NO.	F	ROCESS NAME	WORK PROCEDU	RE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
then hold the wires and gently pull out the connector from jig using right hand.		OFFLI	Wire insertion to connector	1. Get the 1st Black wire then insert to connector slot 1 using right hand. 3. After ithen hold	2. Get the 2nd Black connector slot 2 using the wires and gently pull out the wires are with the wires are with the wires are wires.	2 Black R wire then insert to right hand.	n/a	1. Pleas during i 2. Inser 3. Make inserted Conductinsertio Do not 0. 1. No loose 2. No wron 3. One by 4. No defo 5. No wron Docum 1. Refer and Strip 2. Please	ant reminders/inserblook the wire no insertion. It is a sure wires are policited by the policy of the pull-Push-Pull-Insertion one insertion one insertion remed terminal ing wire facing to WI-PRO-CNC-Coolength Tolerance of the pull-PRO GL-PRO GL-P	Note/s: ear terminal be inserted. properly Push after 3:



	_		WORK INSTRUCTION		Effectivity Date:	October 21, 2024			
		Process Name/Title:	OFFLINE ASSEMBLY	PROCESS		Validity Date:		n/a	
		Model code/Part number:	900B.910B / 7N0104-7020C Customer: Ti		LEXUS-NX/RX	Document No.:		WI-ENG-PDE-11	136
		Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH	MASSPI		Revision No.:	1	Page No.:	4 of 10
PARTS:	1. Assy	parts		JIG: 1. Loc		Locking jig			
NO.	F	ROCESS NAME	WORK PROCEDURE/ ILL	TOOLS/PPE	(QUALITY POINTERS			
4	OFFLI NE	Connector lock	1. Put the connector into locking jig using right hand then press to lock 2x. 2. Ensure that connector is in locked condition connector lock based on the sequence illustrate.	by slide touching the ed.	After Pressing	LOCKING JIG	1. Manua damaged	ant reminders/N al locking may can d connector lock vided jig tools per i ock/ half-locked co	use model



			WORK INSTRUCTION	ON			Effectivity Date:		October 21, 20	24
		Process Name/Title:	OFFLINE ASS		CESS		Validity Date:		n/a	
		Model code/Part number:	900B.910B / 7N0104-7020C Custo		Car Model:	LEXUS-NX/RX	Document No.:		WI-ENG-PDE-11	136
		Purpose:	PROTOTYPE PRE-L		MASSPR		Revision No.:	1	Page No.:	5 of 10
PARTS:		W CP TVSSf 0.3 G-B/W L=60 Corrugated tube Ø7 L=78±3					JIG:	1. Termina	I cover jig	
NO.	F	ROCESS NAME	WORK PROCED	URE/ ILLUSTR	RATION		TOOLS/PPE	(QUALITY POIN	TERS
5	OFFLI NE	Wire insertion to Black Corrugated tube Ø7 L=78±3mm (no slit)	1. Get the terminal cover jig using right hand then insert the G and B/W wires.	2. Get the Co using right ha	nd and insert the	R. 278±3mm (no slit) ne G and B/W wires derminal cover	TERMINAL COVER JIG	1. Refe Wire au	r to WI-PRO-CNC nd Strip length to use of parts ned terminal	C-017 for



NICO			WORK II		Effectivity Date:	October 21, 2024					
		Process Name/Title:	OFF	LINE ASSEMBLY PRO	CESS		Validity Date:		n/a		
		Model code/Part number:	900B.910B / 7N0104-70		Car Model:	LEXUS-NX/RX	Document No.:		WI-ENG-PDE-1	136	
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	MASSPR	0	Revision No.:	1	Page No.:	6 of 10	
PARTS:	1. Conn	ector 6188-0407 (W)					JIG:	, 6			
NO.	P	ROCESS NAME	WORI	K PROCEDURE/ ILLUSTR	RATION		TOOLS/PPE	(QUALITY POIN	TERS	
6	OFFLI NE	Connector setting to Insertion jig 6188-0407 (W)		Lock I-mark Press R 2. Insert the connector 6188-0 release the lock. Note: Refer to above illustra 3. Press the lower wire guide us thumb. Terminal slot for B/W will open.	0407 (W) into jig ation for correct			I-mark is I-mark align 1. Use the 2. No wror 3. No wror	GOOD	1 hole is open 1 hole is open oodel connector	

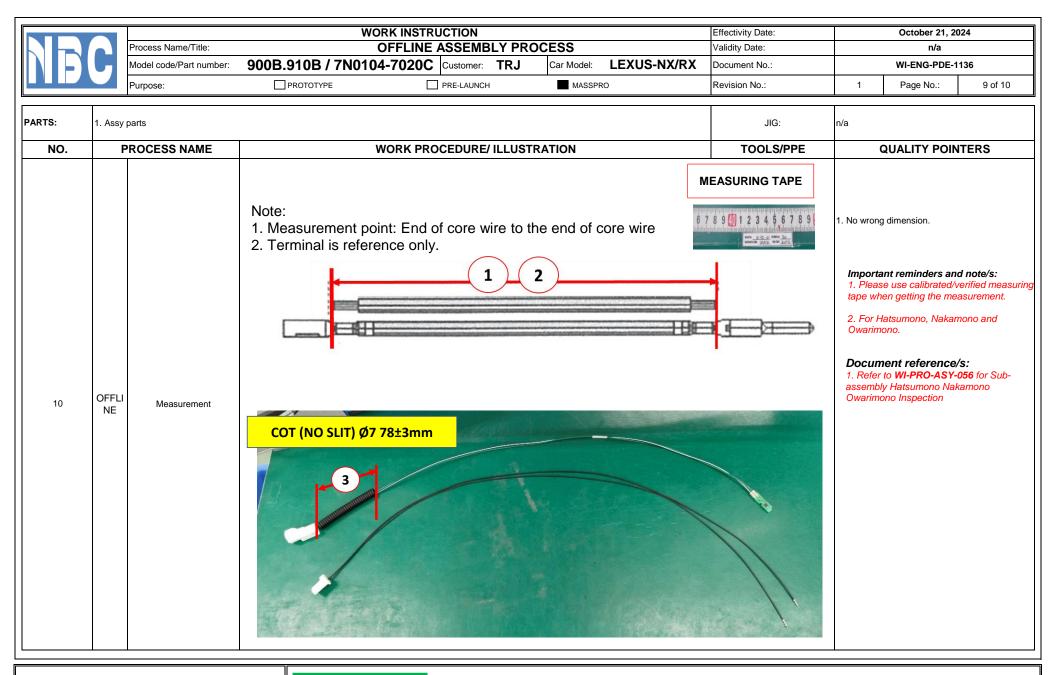


			WORK INST	Effectivity Date:	October 21, 2024						
		Process Name/Title:		ASSEMBLY	Y PROCESS		Validity Date:	n/a			
		Model code/Part number:	900B.910B / 7N0104-70200	Customer: T	'RJ Car Model:	LEXUS-NX/RX	Document No.:		WI-ENG-PDE-11	36	
		Purpose:	☐ PROTOTYPE [PRE-LAUNCH	MASSPR	0	Revision No.:	1	Page No.:	7 of 10	
PARTS:	1. MRS	W CP (TVSSf 0.3 G-B/W L=6	608±3mm)				JIG:	1. Insertion jig			
NO.	F	PROCESS NAME	WORK PR	OCEDURE/ ILI	LUSTRATION		TOOLS/PPE		QUALITY POIN	TERS	
7	OFFLI NE	Wire Insetion to Connector 6188-0407 (W)	1.Hold the Insertion jig using left hand. Get Black/White wire then insert to terminal slot 1 using right hand. 2 Green R 3. Get Green wire then insert to terminal ske 2 using right hand.	ot	Press 2. Push the button using for Green wire will be op	ress R	n/a	1. Please during in 2. Inserti 3. Make inserted. Conduct insertion Do not e. 1. No loose 2. No wron 3. One by 4. No defo 5. No wron Docum 1. Refer and Strip 2. Please	ion of wire must be sure wires are property in the property in	ar terminal be inserted. operly ush after 17 for Wire	



			WC	ORK INSTRUCTION			Effectivity Date:		October 21, 20	024
	Model o	Process Name/Title:		OFFLINE ASSEMBLY PR	OCESS		Validity Date:		n/a	
		Model code/Part number:		04-7020C Customer: TRJ		LEXUS-NX/RX	Document No.:		WI-ENG-PDE-1	136
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO		Revision No.:	1	Page No.:	8 of 10
PARTS:	1.Assy	parts					JIG:	1. Locking jig		
NO.	I	PROCESS NAME		WORK PROCEDURE/ ILLUST	RATION		TOOLS/PPE	(QUALITY POIN	ITERS
8	OFFLI NE		7L0124 R	1. Put the connector into locking j 2x. Check the connector lock if pr lock after pressing. Before lock ONNECTOR CROSS NG Double Double	After loc	ck	LOCKING JIG	Importa 1. Manua connecte 1. Use the	ant reminders/i	/Note/s: ause damaged
			U	Inlock Condition Half Lock Co	Lock Condition					





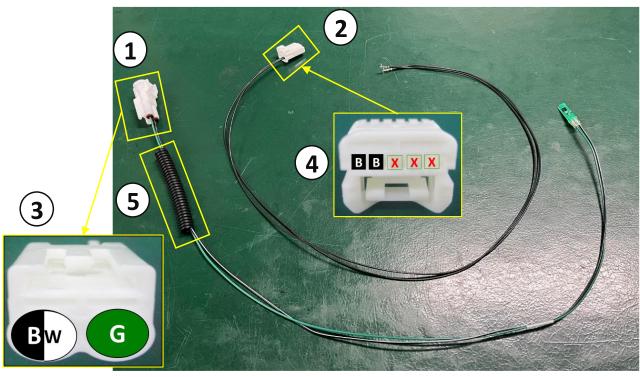


			WORK INSTRUCTION						Effectivity Date:	October 21, 2024		24		
		Process Name/Title:		OFFLINE A	ASSEME	3LY PRO	CESS		Validity Date:		October 21, 2024 n/a WI-ENG-PDE-1136 1 Page No.: 10 of 10			
		Model code/Part number:	900B.910B / 7N010	4-7020C	Customer:	TRJ	Car Model:	LEXUS-NX/RX	Document No.:		WI-ENG-PDE-1	136		
		Purpose:	PROTOTYPE		PRE-LAUNCH	1	MASSPR	0	Revision No.:	1	Page No.:	10 of 10		
PARTS:	1. Assy	/ parts							JIG:	n/a				

VISUAL INSPECTION/ QUALITY CHECKPOINTS

OFFLINE INSERTION

7N0104-7020C



- 1 2 No Unlocked/ Half-locked connector
- (3) (4) No Wrong Insert
 - **5** No Missing COT
 - 6 No Deformed terminal
 - 7 No Terminal backing out

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