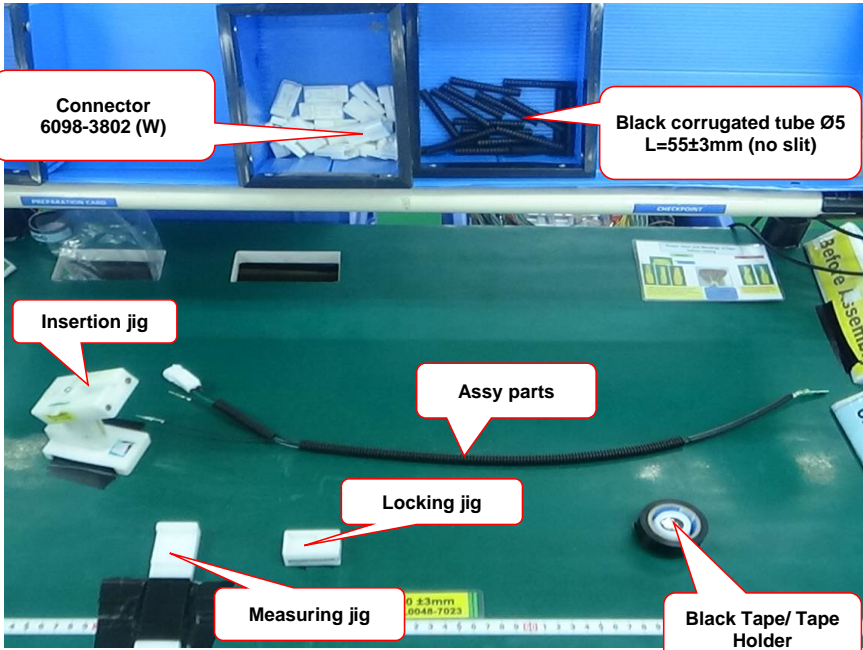




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	Model code/Part number: 241B / 7L0048-7023A	Customer: TRQSS	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-1069B		
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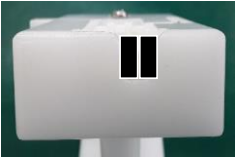
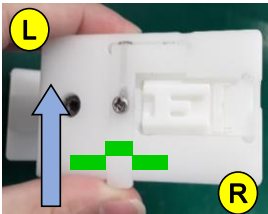
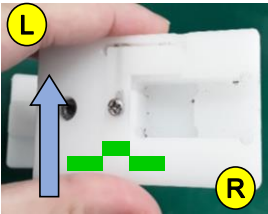
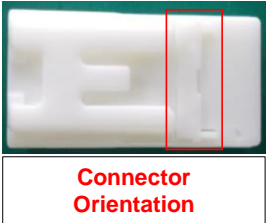
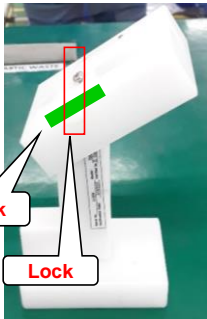
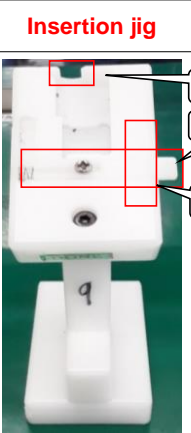
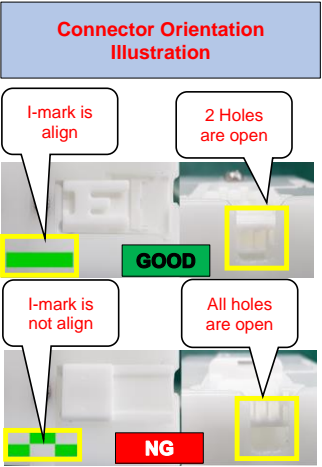
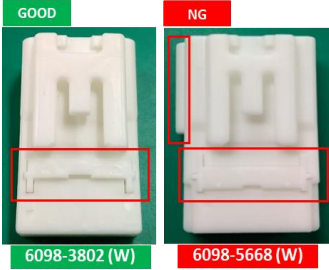
PARTS:		1. Assy parts; Black corrugated tube Ø5 L=55±3mm(no slit); Black Tape; Connector 6098-3802 (W)		JIG:	1. Insertion jig 2. Locking jig 3. Measuring jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
1	P2	<div>Table Lay-out</div> <div></div>			<div><u>Safety Instruction</u> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><u>Housekeeping</u> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><u>Alert level</u> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	1. No missing parts/tools 2. No excess parts/tools

Revision History							Prepared by	Reviewed by	Approved by	Noted by	
							 D. Castillo	 C. Villanueva	 A. Arañes	n/a	
10/01/24	1	Change from pre-launch to masspro. Update work procedure of Taping 1.		D.Castillo	C. Villanueva	A. Arañes					n/a
09/24/24	0	Initial issue. Transfer process due to process improvement.		D.Castillo	C. Villanueva	A. Arañes					n/a
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved					Noted
							Est. Date:	September 24, 2024			

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	TAPING ASSEMBLY PROCESS			Validity Date:	n/a							
	Process Name/Title:			Model code/Part number:	241B / 7L0048-7023A	Customer:	TRQSS	Car Model:	LEXUS-ES	Document No.:	WI-ENG-PDE-1069B	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:		1	Page No.:	2 of 7		


PARTS:		1. Connector 6098-3802 (W)		JIG:	1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS		
2	P2 Connector setting to insertion jig 6098-3802 (W)	<div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the connector 6098-3802 (W) into jig using right hand and release the lock. <i>Note: Refer to above illustration for correct setting.</i></p><p>3. Check the holes/terminal slot for 2 Black wires.</p></div>	n/a	<div><p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p><p>Connector Orientation Illustration</p><p>I-mark is align</p><p>2 Holes are open</p><p>I-mark is not align</p><p>All holes are open</p><p>GOOD</p><p>NG</p><p>CONNECTOR ILLUSTRATION</p><p>GOOD</p><p>NG</p><p>6098-3802 (W)</p><p>6098-5668 (W)</p></div>		

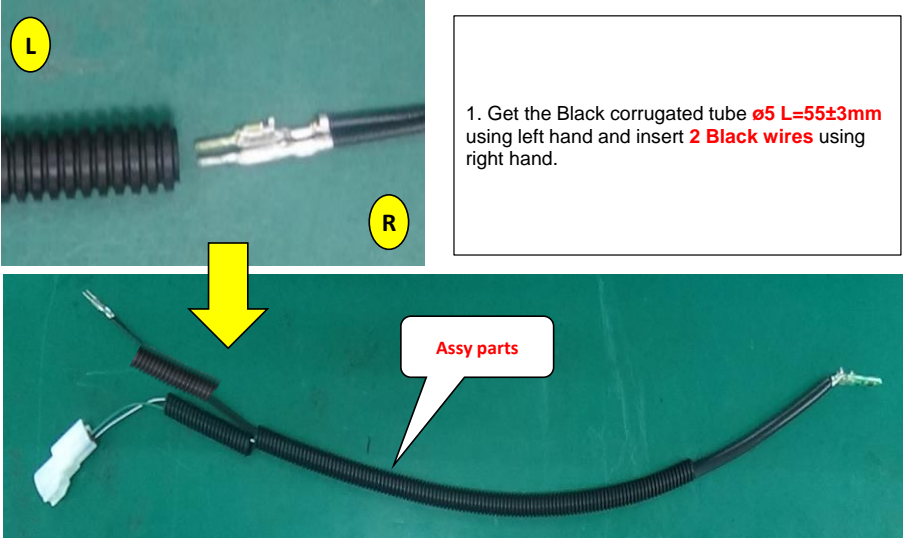
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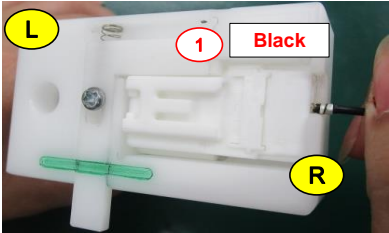
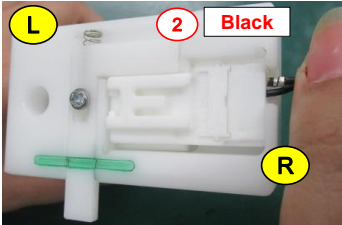
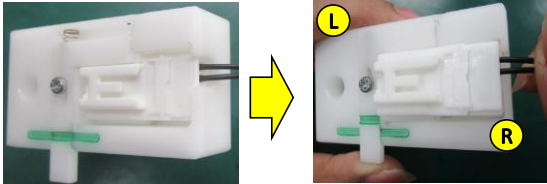


PARTS:		1. Assy parts 2. Black Corrugated tube ø5 L=55±3mm (no slit)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	P2	<div>Wire insertion to Black Corrugated tube ø5 L=55±3mm (no slit)</div> <div></div>	n/a	1. No wrong use of parts 2. No deformed terminal	

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	Model code/Part number: 241B / 7L0048-7023A		Customer: TRQSS	Car Model: LEXUS-ES	Revision No.: 1		
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PARTS:	1. Assy parts			JIG:	1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS		
4	P2 Wire insertion to connector 6098-3802 (W)	<div><p>TERMINAL FACING</p></div> <div><p>1. Get the 1st Black wire then insert to terminal slot 1 of connector using right hand.</p></div> <div><p>2. Get the 2nd Black wire then insert to terminal slot 2 of connector using right hand.</p></div> <div><p>3. 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>NO DEFORMATION ON TERMINAL GOOD</p></div> <div><p>DEFORMED TERMINAL NO GOOD</p></div>				

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. **Insertion of wires must be from left to right.**
2. **Please hold the wire near terminal.**
3. **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.
2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

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**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 01, 2024

Model code/Part number:

241B / 7L0048-7023A

Customer:

TRQSS

Car Model:

LEXUS-ES

Document No.:

WI-ENG-PDE-1069B

Purpose:



PROTOTYPE



PRE-LAUNCH







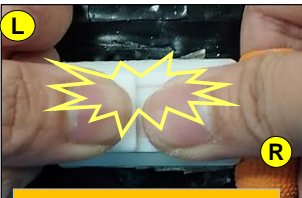
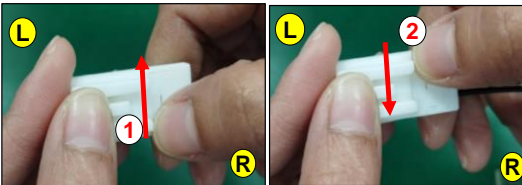

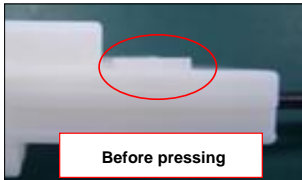


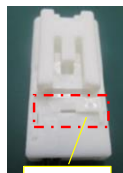
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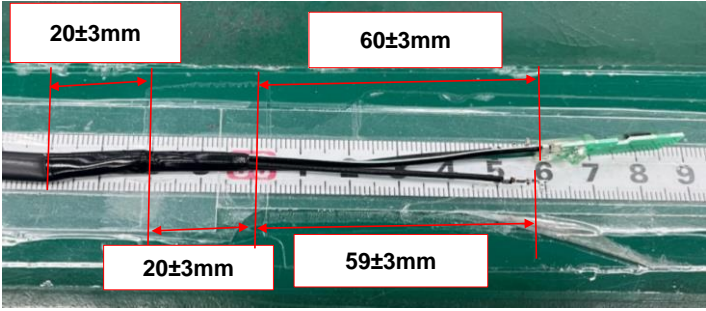
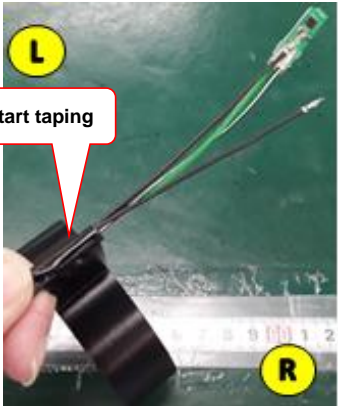



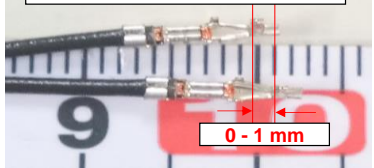
PARTS:		1. Assy parts 2. Black tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2 Connector lock	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div> <div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div> <div><p>Right thumb-Lower Left thumb-middle</p><p>3. Press the lower parts of connector using right hand while left hand holding the middle.</p></div> <div><p>Right thumb-upper Left thumb-middle</p><p>4. Press the upper part of connector using right hand while left hand holding the middle.</p></div> <div><p>Right thumb-middle Left thumb-middle</p><p>5. Lift then press the connector in the middle using left and right hand.</p></div> <div><p>6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</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 jig tool to lock the connector. 2. No unlock/half-locked connector</p> <div><p>Before pressing</p><p>After pressing</p></div> <div><div><p>GOOD</p><p>Full Lock</p></div><div><p>NG</p><p>Half Lock</p></div></div>

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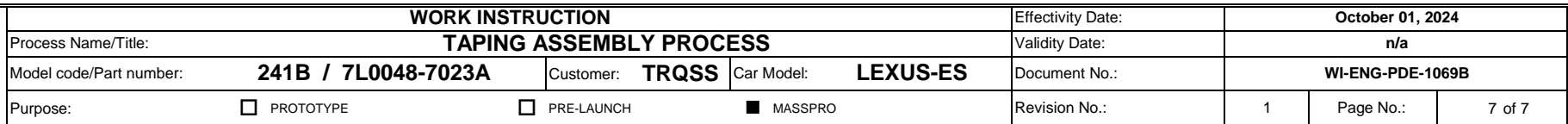
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PARTS:		1. Assy parts 2. Black tape			JIG:	1. Measuring jig	
NO.	PROCESS NAME	1	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
6	P2		<div></div> <div>1. Put assy parts to measuring jig. Position the hotmelt and terminal (must be no gap) then position the VM tube (sunprene) to end of measuring jig (must be no gap) using both hands. Measurement should be 80±3mm.</div> <div>2. Hold the SV tube (Vinyl) using left hand, get the Black tape then start taping using both hands.</div> <div>3. After taping, check the measurement, wire alignment & tape condition.</div>		<div>MEASURING JIG</div>  <div>MEASURING TAPE</div> 	<p>Important reminders and Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <p>1. No flip-out tape 2.No peel-off tape 3. No loose tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape</p> <div>Wire alignment tolerance</div> 	

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