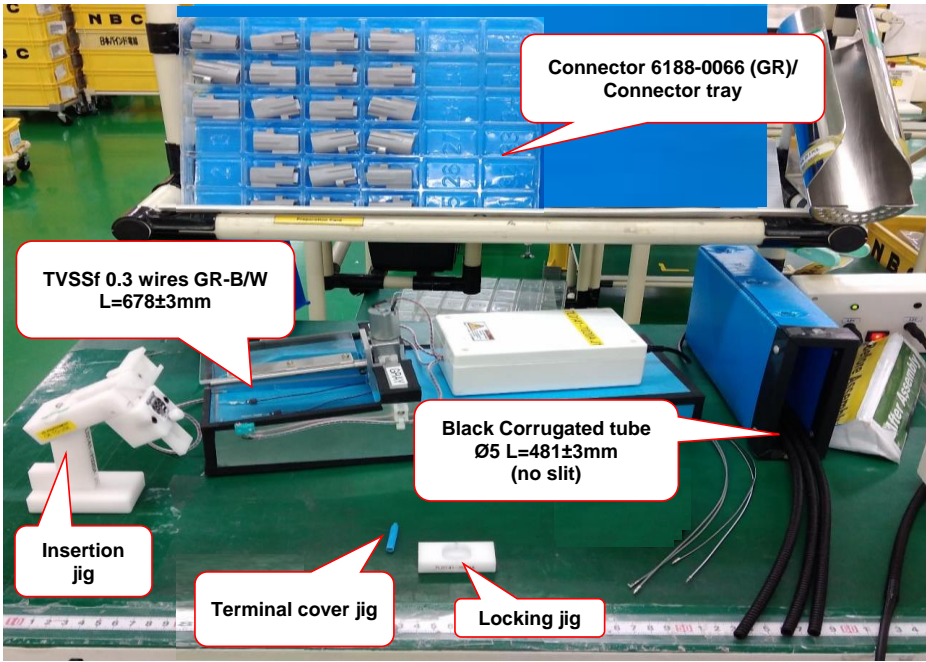
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	OFFLINE ASSEMBLY PROCESS				Validity Date:	n/a	
	Process Name/Title:		Model code/Part number: 380D / 7L0141-7020B	Customer: TRQSS	Car Model: TOYOTA CAMRY	Document No.: WI-ENG-PDE-1051	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.: 1	
		Page No.:		1 of 6			

PARTS:			1.Connector 6188-0066 (GR); TVSSf 0.3 wires GR-B/W L=678±3mm; Black Corrugated tube Ø5 L=481±3mm (no slit)				JIG:		1. Insertion jig with switch cover 2. Locking jig 3. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS		
1	Offline	<div> <div>TABLE LAY-OUT</div>  </div>				<div> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>		Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.		
Revision History										
						Prepared by	Reviewed by	Approved by	Noted by	
09/13/24	1	Change from Pre-launch to Masspro.				A. Hernandez	C. Villanueva	A. Arañes	n/a	
09/11/24	0	Initial issue				A. Hernandez	C. Villanueva	A. Arañes	n/a	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date: September 11, 2024



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PARTS:		1. Connector 6188-0066 (GR)		JIG:	1.Insertion jig with flip cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Offline	<div>Connector setting to Insertion jig 6188-0066 (GR)</div> <div><div><div>INSERTION JIG WITH FLIP COVER</div><div><div><div>Visual reference</div><div>Switch cover</div><div>Insertion jig</div></div><div><div>Lock</div><div>I-mark</div></div><div><div>Holes</div><div>CONNECTOR ORIENTATION</div></div></div></div><div><div><div>L</div><div>Press</div></div><div><div>L</div><div>Press</div><div>R</div></div><div><div>L</div><div>R</div><div>Release</div></div></div><div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6188-0066 (GR) into jig using right hand and release the lock. Note: Refer to above illustration for correct setting.</div><div>3. Check the holes/terminal slot for B/W wire.</div></div></div> <div>N/A</div> <td><div><div>Connector Orientation Illustration</div><div><div><div>I-mark is align</div><div>1 hole is open</div></div><div>GOOD</div><div><div><div>I-mark is not align</div><div>1 hole is open</div></div><div>NG</div></div></div><div><div>1. Use the provided jig per model</div><div>2. No wrong orientation of connector</div><div>3. No wrong use of connector</div><div>4. No damaged connector</div></div></div></td>		<div><div>Connector Orientation Illustration</div><div><div><div>I-mark is align</div><div>1 hole is open</div></div><div>GOOD</div><div><div><div>I-mark is not align</div><div>1 hole is open</div></div><div>NG</div></div></div><div><div>1. Use the provided jig per model</div><div>2. No wrong orientation of connector</div><div>3. No wrong use of connector</div><div>4. No damaged connector</div></div></div>	

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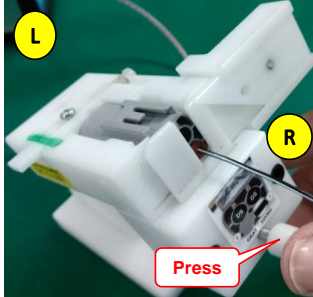

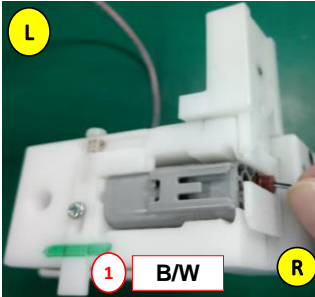
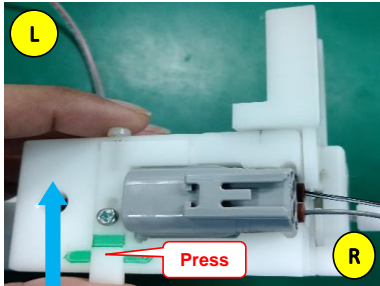
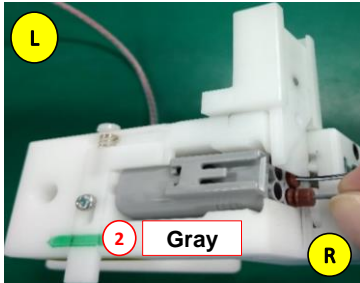
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PARTS:	1. TVSSf 0.3 wires GR-B/W L=678±3mm 2. Connector 6188-0066 (GR)			JIG:	1. Insertion jig with flip cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Offline Wire Insetion to Connector 6188-0066 (GR)	<div><div></div><div><p>1. Hold the Insertion jig using left hand. Get Black /White wire then insert to terminal slot 1 using right hand.</p><p>2. Push the button using right hand. The slot for Gray wire will be opened.</p></div><div><div></div><div><p>3. Get Gray 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></div></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: <i>1. Please hold the wire near terminal.</i> <i>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</i> <i>3. Insertion of wires must be from left to right</i></div> <div>Document references: <i>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i> <i>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></div>

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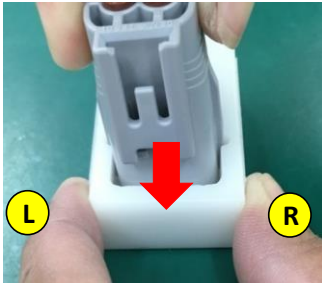








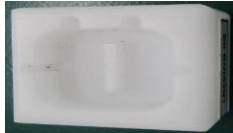



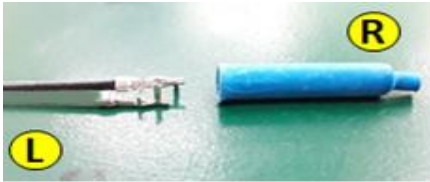

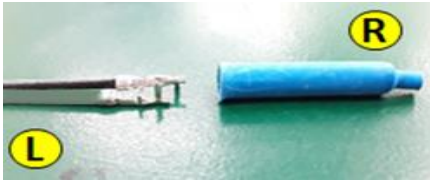

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PARTS:		1. Assy parts 2. Black Corrugated tube Ø5 L=481±3mm (no slit)		JIG:	1. Locking jig 2. Terminal cover jig									
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS									
4	Connector Lock	<div><div><p>L R</p></div><div><p>Before pressing</p></div><div><p>After pressing</p></div><div><p>Connector Cross Sectional View</p><table><tr><td>NG</td><td>NG</td><td>GOOD</td></tr><tr><td></td><td></td><td></td></tr><tr><td>Unlock Condition</td><td>Half Lock Condition</td><td>Full Lock Condition</td></tr></table></div></div> <div><p>1. Put the connector into locking jig using right hand then press 2x. Check if properly locked.</p></div>		NG	NG	GOOD				Unlock Condition	Half Lock Condition	Full Lock Condition	<div>LOCKING JIG</div> 	1. Use the provided locking jig per model 2. No unlock/half-locked connector
NG	NG	GOOD												
														
Unlock Condition	Half Lock Condition	Full Lock Condition												
5	Offline Wire Insertion to Black Corrugated tube Ø5 L=481±3mm (no slit)	<div><div><p>L R</p></div><div><p>1. Get the terminal cover jig using right hand then insert the GR-B/W wires using left hand.</p></div><div><p>L R</p></div><div><p>2. Get the corrugated tube (no slit) Ø5 L=481±3mm using right hand and then insert the GR-B/W wires using left hand.</p></div><div><p>L R</p></div><div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div></div>		<div>TERMINAL COVER JIG</div> 	1. No wrong use of parts 2. No deformed terminal									

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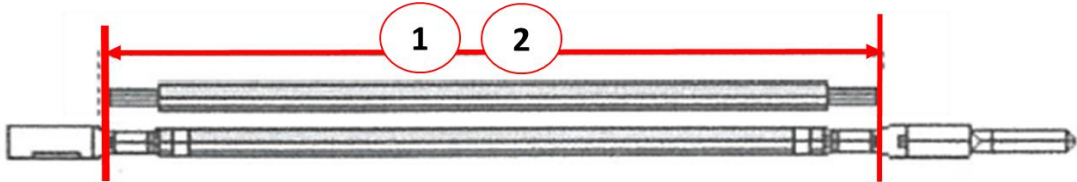
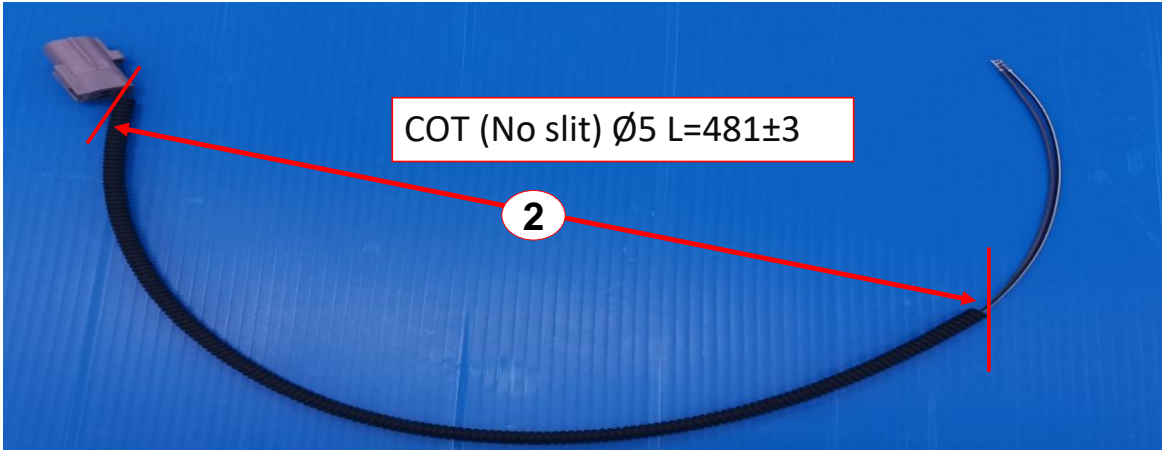
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	Offline	Measurement	<div>MEASURING TAPE</div> 	<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p>
			 	<p>1. No wrong dimension</p>

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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**OFFLINE INSERTION****7L0141-7020B**

①

**GOOD****NO GOOD**

④



②



③

**GOOD****NO GOOD****① No Unlocked/ Half-locked connector****③ No Terminal Backing Out****② No Wrong insert****④ No Deformed terminal**

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