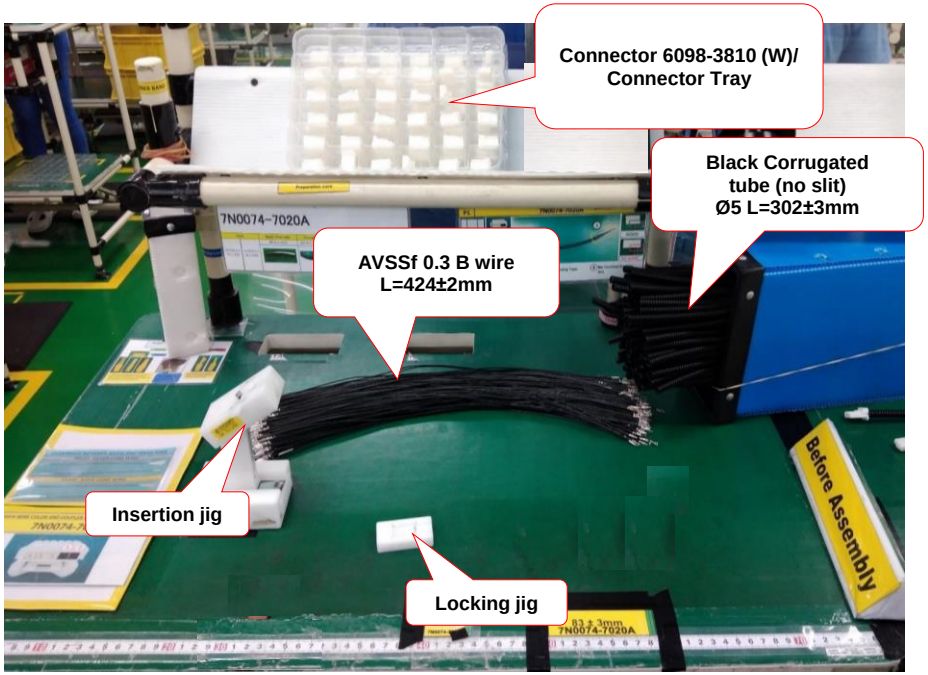
	WORK INSTRUCTION			Effectivity Date:	May 24, 2024		
	Process Name/Title:	OFFLINE ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number:	946B / 7N0073-7020	Customer: TRJ	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-840	
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.: 1 of 6

PARTS:	1. Connector 6098-3810 (W); Black corrugated tube (no slit) ø5 L=302±3mm; AVSSf 0.3 B wires L=424±2mm	JIG:	1. Insertion jig 2. Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	n/a	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 references:*** ***1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance*** 1. No missing parts/tools 2. No excess parts/tools

Revision History							Prepared by	Reviewed by	Approved by	Noted by
05/24/24	0	Initial issue.	D.Castillo	C.Villanueva	A. Arañes	n/a	D. Castillo	C.Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	May 24, 2024		

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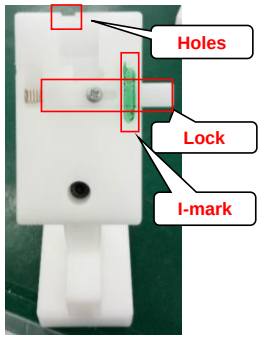
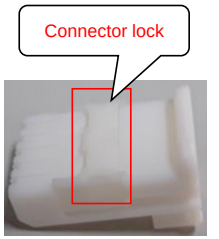
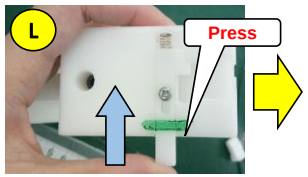
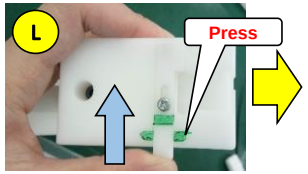
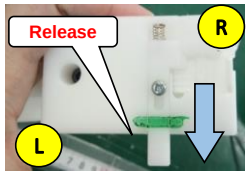
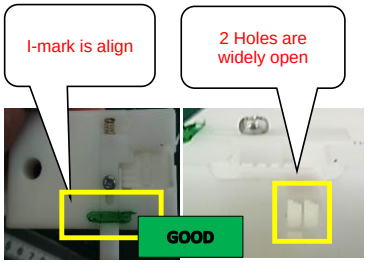
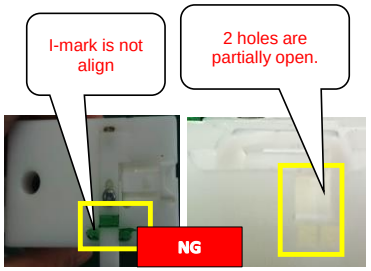
	Model code/Part number:	946B / 7N0073-7020	Customer: TRJ	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-840	
	Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	0	Page No.: 2 of 6

PARTS:	1. Connector 6098-3810 (W)			JIG:	1. Insertion jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
2	n/a	Connector Setting to Insertion jig 6098-3810 (W)	     1. Press the lock of insertion jig using left thumb. 2. Insert the connector 6098-3810 (W) using right hand and release the lock. 3. Check the holes/terminal slot for B-B wires.	n/a	**Connector Orientation Illustration**   1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector

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	WORK INSTRUCTION			Effectivity Date:	May 24, 2024		
	Process Name/Title:	OFFLINE ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number:	946B / 7N0073-7020	Customer: TRJ	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-840	
	Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	0	Page No.: 3 of 6

PARTS:	1. Black corrugated tube (no slit) ø5 L=302±3mm 2. AVSSf 0.3 B wires L=424±2mm [2pcs]			JIG:	n/a
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
3	n/a	Wire insertion to Black corrugated tube (no slit) ø5 L=302±3mm	 1. Get black corrugated tube **ø5 L=302±3mm** using left hand and insert Black wires **L=424±2mm** using right hand.	n/a	1. No wrong use of parts 2. No deformed terminal

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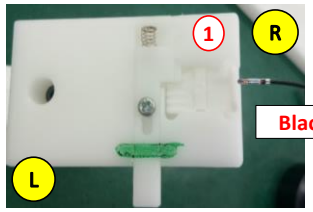
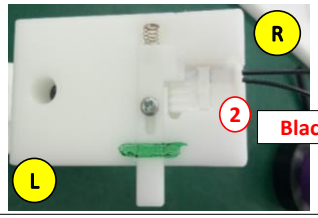
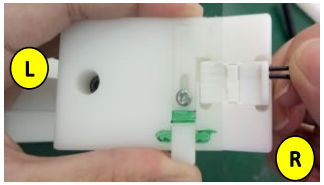
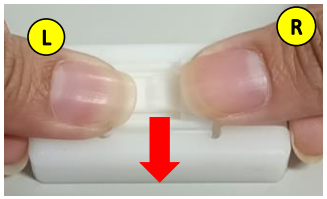
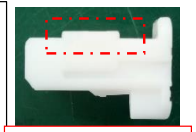
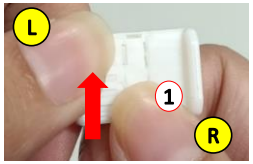
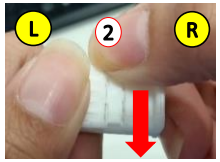
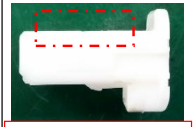
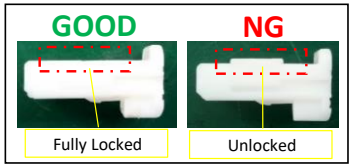
	Process Name/Title:	OFFLINE ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number:	946B / 7N0073-7020	Customer: TRJ / Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-840		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	0	Page No.:	4 of 6

PARTS:	1. Assy parts	JIG:	1. Insertion jig 2. Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	n/a	Wire Insertion to Connector 6098-3810 (W)	 Black Wire facing  Black 1. Get the 1st Black wire and insert to Slot 1 of connector using right hand. Note: Insertion should be from left to right. 2. Get the 2nd Black wire and insert to Slot 2 of connector 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 dimension 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.*** ***2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance***
5		Connector lock	 1. Put the connector into locking jig using right hand then press to lock **2x** using both hands. Touch the connector lock if properly locked.  Before Pressing   2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.  After Pressing	LOCKING JIG 	1. Use the provided locking jig per model 2. No unlocked/half-locked connector  ***Important reminders/Note/s:*** ***1. Manual locking may cause damaged connector*** ***Document references:*** ***1. Refer to GL-PRO-ASY-017 for the verification of lock***

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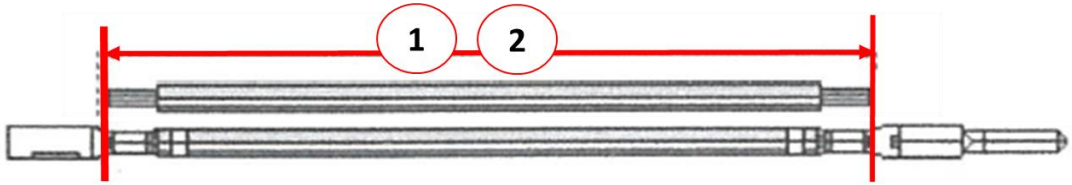
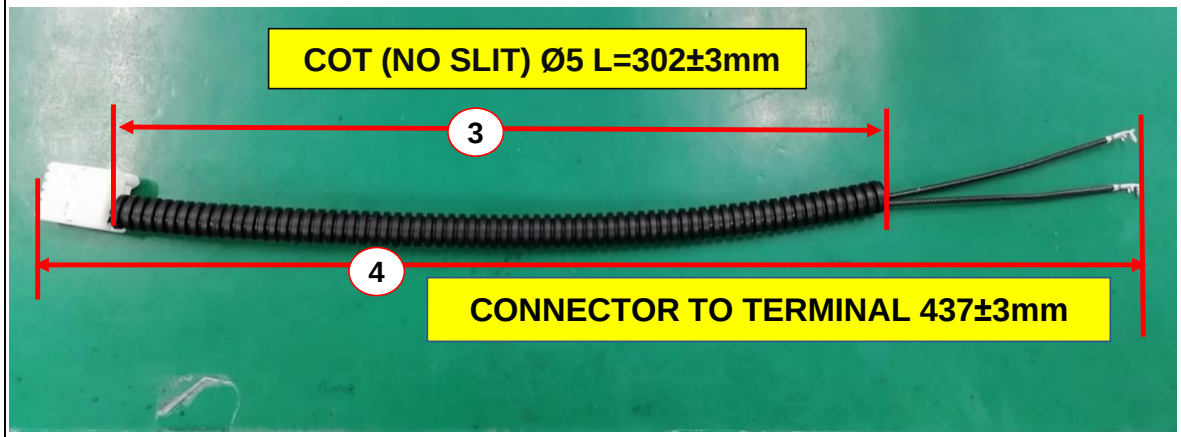
PARTS:	1. Assy parts	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	Offline	Measurement	Note: 1. Measurement point: End of core wire to the end of core wire 2. Terminal is reference only.   	MEASURING TAPE 	***Important reminders and note/s:*** ***1. Please use calibrated/verified measuring tape when getting the measurement.*** ***2. For Hatsumono, Nakamono and Owarimono.*** ***Document reference/s:*** *1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection* 1. No wrong dimension

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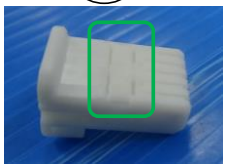
PARTS:	1.Assy Parts	JIG:	n/a

VISUAL INSPECTION

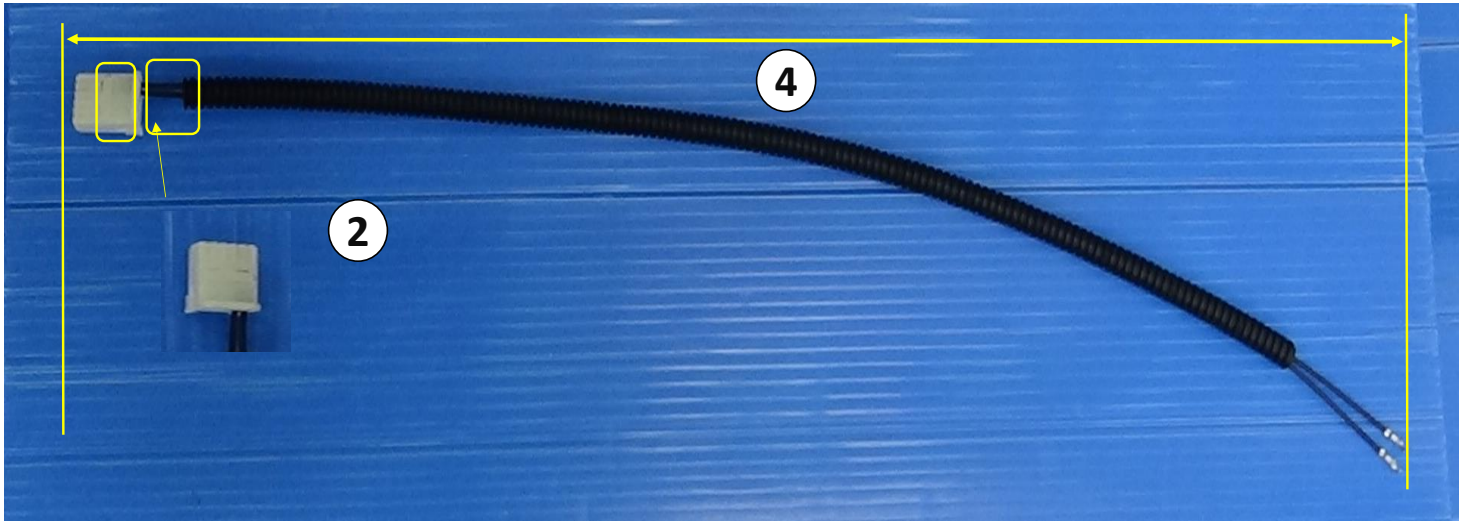
OFFLINE INSERTION 7N0073-7020

1

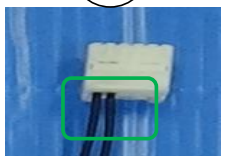


GOOD

NO GOOD



3



GOOD

NO GOOD

1 No **Unlock/Halflocked connector**

2 No **Wrong insert**

3 No **Terminal Backing Out**

4 Check the **Alignment**

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