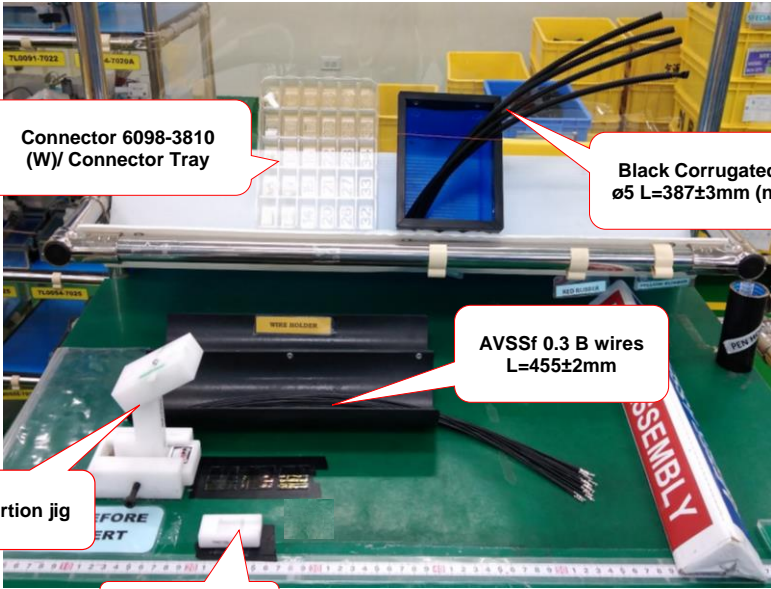
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	Process Name/Title:			Validity Date:	n/a		
	Model code/Part number:	200D / 7R0129-7020	Customer: TRMX	Car Model: Lexus (TOYOTA) LM	Document No.:	WI-ENG-PDE-545	
	Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	3	Page No.: 1 of 6

PARTS:	1. All parts: Connector 6098-3810 (W); AVSSf 0.3 B wires L=455±3mm; Black Corrugated tube ø5 L=387±3mm (no slit)			JIG:	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	Offline 3 Table Lay-out	<div>Table Lay-out</div> 		<div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<div>Document reference/s:</div> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>

Revision History						Prepared by	Reviewed by	Approved by	Noted by
06/11/24	3	Remove terminal cover jig and update process sequence due to process improvement. Update table lay-out. Inclusion of Quality checkpoints. Inclusion of car model "Lexus (TOYOTA) LM".	D. Castillo	C.Villanueva	A. Arañes	n/a			
09/30/22	2	Improve quality pointers: Reminders/notes and references in process no.1,2,3 and 4 due to document improvement. Work procedure/illustration in process no.4 - connector lock.	M. Catapang	J. Loterte	C.Villanueva	A. Arañes			
06/16/22	1	Change document purpose from pre-launch to masspro	M. Catapang	J. Loterte	C.Villanueva	A. Arañes			
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	June 10, 2022	n/a

**WORK INSTRUCTION**

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June 11, 2024

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OFFLINE ASSEMBLY PROCESS

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200D / 7R0129-7020

Customer:

TRMX

Car Model:

Lexus (TOYOTA) LM

Document No.:

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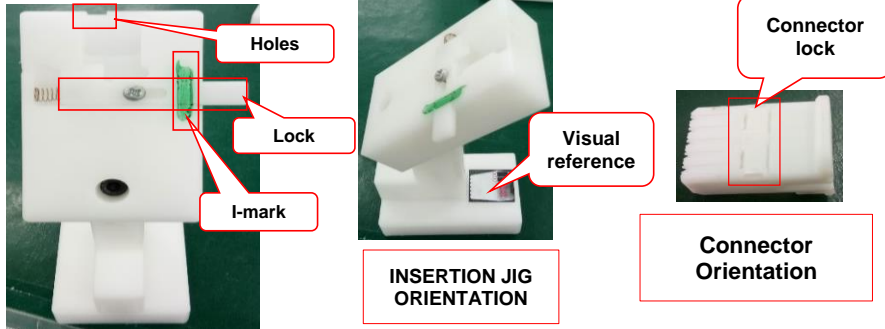
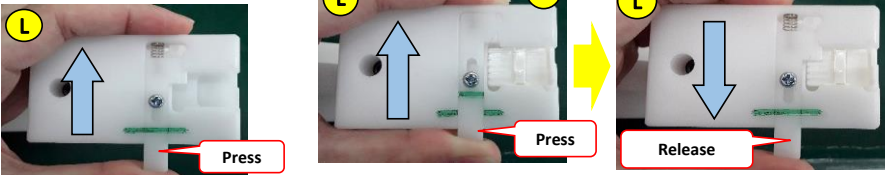
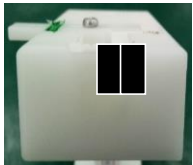
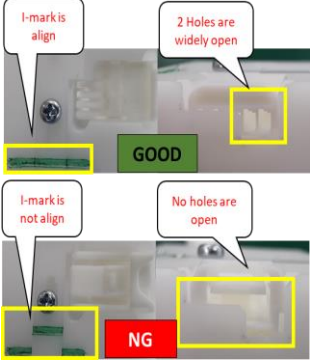
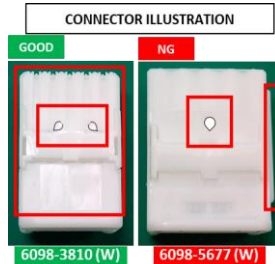
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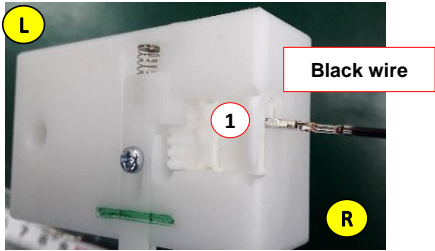

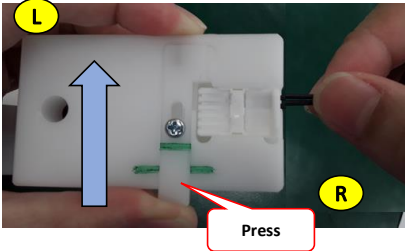
PARTS:		1. Connector 6098-3810 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Offline Connector setting to Insertion jig 6098-3810 (W)	<div><div><div>INSERTION JIG</div><div></div></div><div><div></div><div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Get the connector 6098-3810 (W) using right hand then insert to jig using right hand and release the lock using left thumb. Note: Follow the connector orientation.</div><div><div></div><div>3. Check the holes/terminal slot for B-B wires.</div></div></div></div></div>		n/a	<div><div>Connector Orientation Illustration</div><div></div><div><div>CONNECTOR ILLUSTRATION</div><div></div></div></div>

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	Model code/Part number: 200D / 7R0129-7020		Customer: TRMX	Car Model: Lexus (TOYOTA) LM	Document No.: WI-ENG-PDE-545		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	3	Page No.:	3 of 6



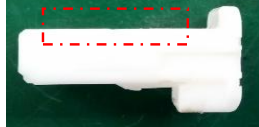
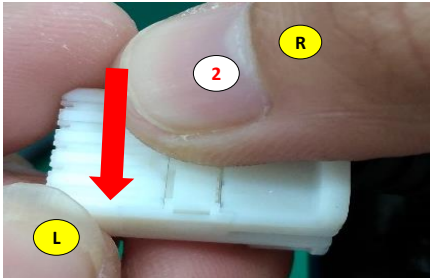
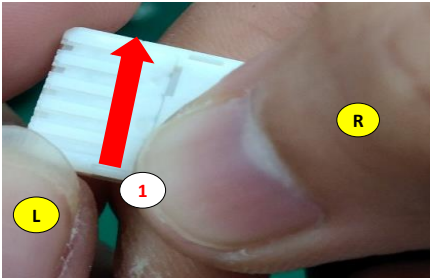
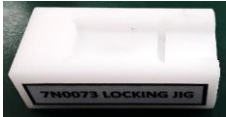
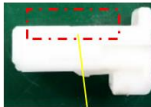
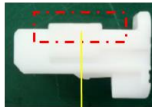
PARTS:	1. AVSSf 0.3 B wires L=455±2mm [2pcs.] 2. Black Corrugated tube ø5 L=387±3mm (no slit)			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	<div>3</div> Wire insertion to Black Corrugated tube ø5 L=387±3mm (no slit)	<div></div> <div>1. Get black Corrugated tube ø5 L=387±3mm using left hand and insert Black wires L=455±3mm using right hand.</div>		n/a	1. No wrong use of parts 2. No deformed terminal
4	Offline Wire insertion to connector 6098-3810 (W)	<div></div> <div>Wire facing</div> <div></div> <div>1. Get 1st black wire then insert to terminal slot 1 using right hand.</div> <div></div> <div>2. Get 2nd Black wire then insert to terminal slot 2 using right hand.</div> <div></div> <div>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.</div>		n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform 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. 3. Insertion of wires must be from left to right 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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	Process Name/Title:		Model code/Part number: 200D / 7R0129-7020		Customer: TRMX	Car Model: Lexus (TOYOTA) LM	Document No.:	WI-ENG-PDE-545	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	3	Page No.:	4 of 6	

PARTS:	1. Assy parts			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Offline Connector Lock	<div><p>LOCKING JIG</p></div> <div>1. Put the connector into locking jig using right hand then press 2x using both hands. Touch the connector lock to confirm if properly locked.</div> <div><p>Before Pressing</p><p>After Pressing</p></div> <div></div> <div>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</div>		<div>LOCKING JIG</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> <div>CONNECTOR LOCK CONDITION</div> <div><div>GOOD</div><p>Fully Locked</p><div>NG</div><p>UnLocked</p></div>

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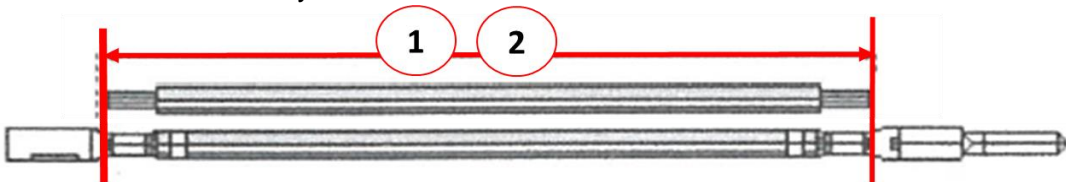


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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	Offline	Measurement	<div>Note: 1. Measurement point: End of core wire to the end of core wire 2. Terminal is reference only.</div> <div></div> <div></div> <div>MEASURING TAPE</div>	<div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div>
			<div>COT (NO SLIT) Ø5 387±3mm</div> <div></div>	1. No wrong dimension

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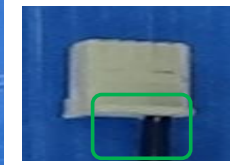
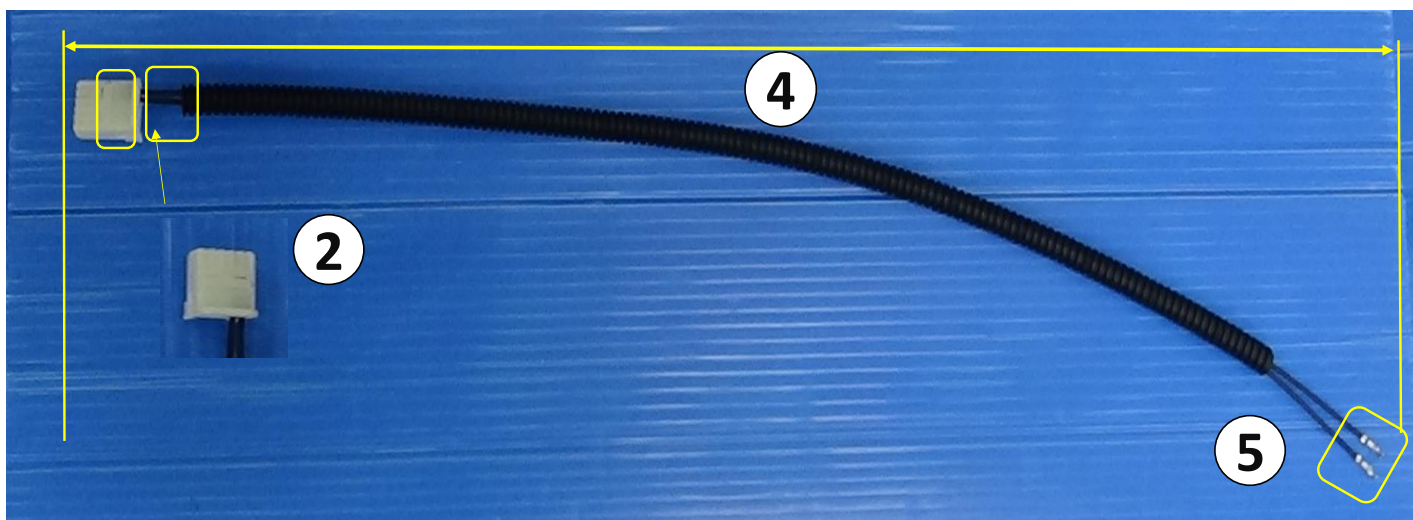
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7R0129-7020****GOOD****NO GOOD****GOOD****NO GOOD****1****No Unlock connector****3****No Terminal Backing Out****5****No Deform terminal****2****No Wrong insert****4****Check the Alignment**

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