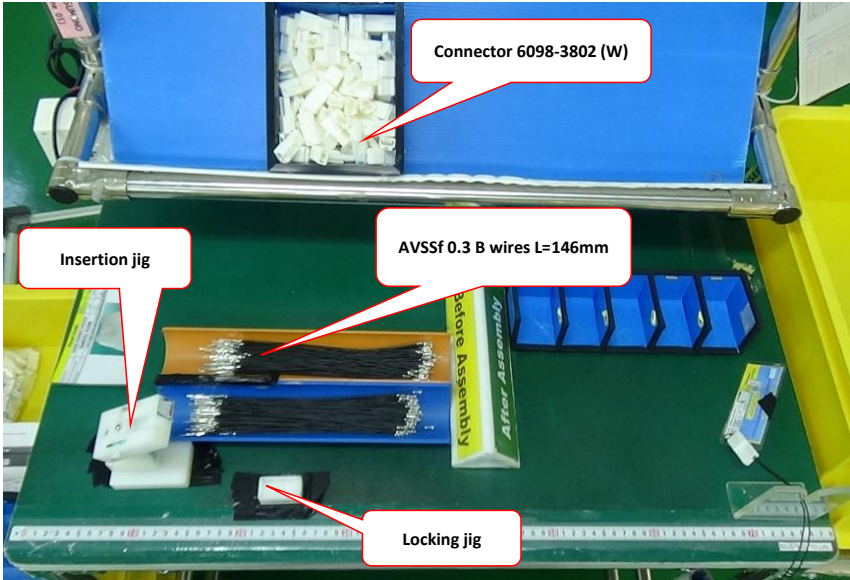
	WORK INSTRUCTION				Effectivity Date:	May 22, 2024		
	OFFLINE ASSEMBLY PROCESS				Validity Date:	n/a		
	Process Name/Title:		Model code/Part number: 150B / 7N0002-7020A	Customer: TRMX	Car Model: TOYOTA-COROLLA	Document No.:	WI-ENG-PDE-280	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	1 of 6


PARTS:		1. Connector 6098-3802 (W); AVSSf 0.3 B wires L=146mm			JIG:	1. Insertion jig 2. Locking jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
1	Offline 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 references:</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>		

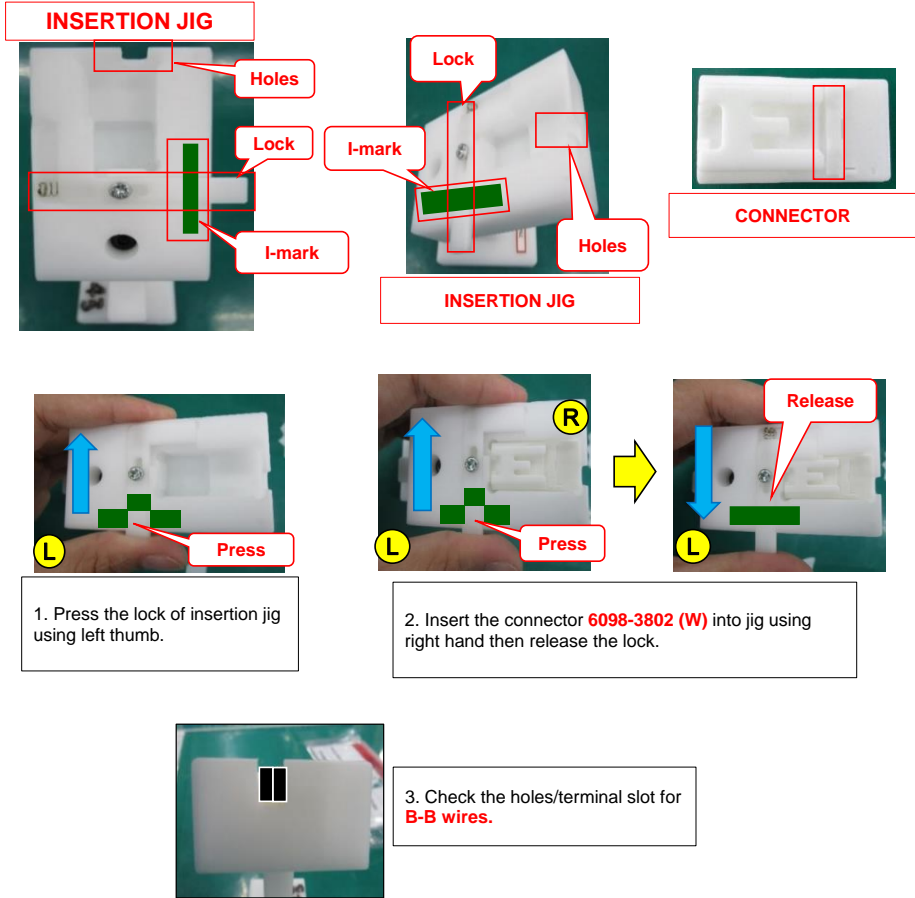
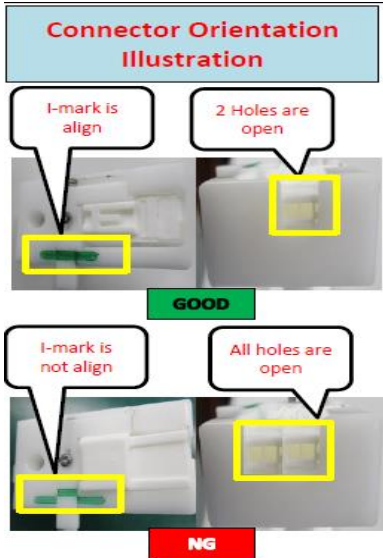
Revision History				Prepared by	Reviewed by	Approved by	Noted by
05/22/24	1	Transfer to new format. Change from Kitting to Offline assembly process. Inclusion of Table lay-out, Measurement and Visual inspection. Update Work procedure of Connector lock process. Update Quality pointers, Important reminders /Note/s. Inclusion of car model "TOYOTA-COROLLA".		D. Castillo	C.Villanueva	A. Arañes	n/a
06/11/21	0	Excluded from Production WI (WI-PRO-ASY-147) to have separate Work instruction. Improve all process illustration and quality pointers.		J. Loterte	C.Villanueva	A.Shimamura	A. Arañes
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted
				Est. Date:	June 11, 2021		

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	WORK INSTRUCTION			Effectivity Date:	May 22, 2024		
	Process Name/Title: OFFLINE ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 150B / 7N0002-7020A		Customer: TRMX	Car Model: TOYOTA-COROLLA	Document No.: WI-ENG-PDE-280		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	2 of 6

PARTS:		1. Connector 6098-3802 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
2	Offline Connector Setting to Insertion jig 6098-3802 (W)	<div></div>	n/a	<div></div> <div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div>	

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PARTS:		1. AVSSf 0.3 wires B L=146mm [2pcs.]		JIG:	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Offline	Wire insertion to connector 6098-3802 (W)		n/a	<div><div><div>1</div><div>Important reminders /Note/s; 1. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force. 2. Insertion must be from left to right.</div></div><div><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></div>

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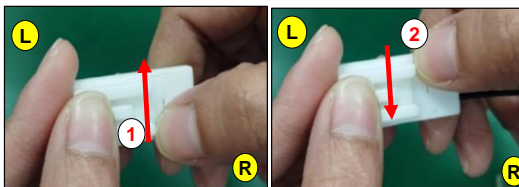


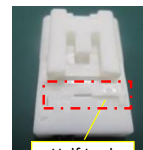



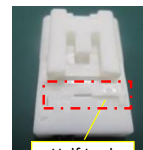


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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Offline Connector Lock	<div><div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div><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> <div><p>LOCKING JIG</p></div> <td><div><p>1. Use the provided jig per connector 2. No unlock/half-locked of connector lock</p><p>1</p><p>Important reminders /Note/s;</p><p>1.MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</p><p>Document reference/s;</p><p>1.Please refer to GL-PRO-ASY-017 for the verification of connector lock.</p><div><div><p>GOOD</p><p>Full Lock</p></div><div><p>NG</p><p>Half Lock</p></div></div><div><p>Before pressing</p><p>After pressing</p></div></div></td>		<div><p>1. Use the provided jig per connector 2. No unlock/half-locked of connector lock</p><p>1</p><p>Important reminders /Note/s;</p><p>1.MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</p><p>Document reference/s;</p><p>1.Please refer to GL-PRO-ASY-017 for the verification of connector lock.</p><div><div><p>GOOD</p><p>Full Lock</p></div><div><p>NG</p><p>Half Lock</p></div></div><div><p>Before pressing</p><p>After pressing</p></div></div>	

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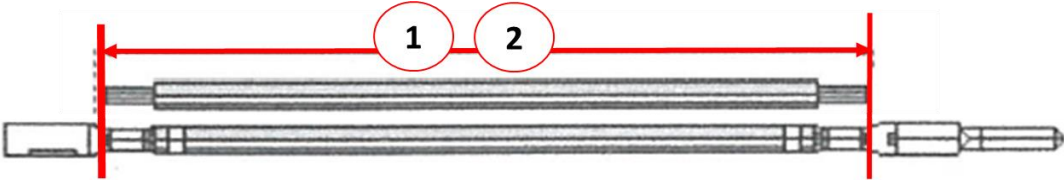


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PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
5	Offline Measurement	<p>Note:</p> <ol style="list-style-type: none">1. Measurement point: End of core wire to the end of core wire2. Terminal is reference only.  	<div>Measuring tape</div> 	<p>Important reminders and note/s:</p> <ol style="list-style-type: none">1. Please use calibrated/verified measuring tape when getting the measurement.2. For Hatsumono, Nakamono and Owarimono. <p>Document reference/s:</p> <ol style="list-style-type: none">1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection	

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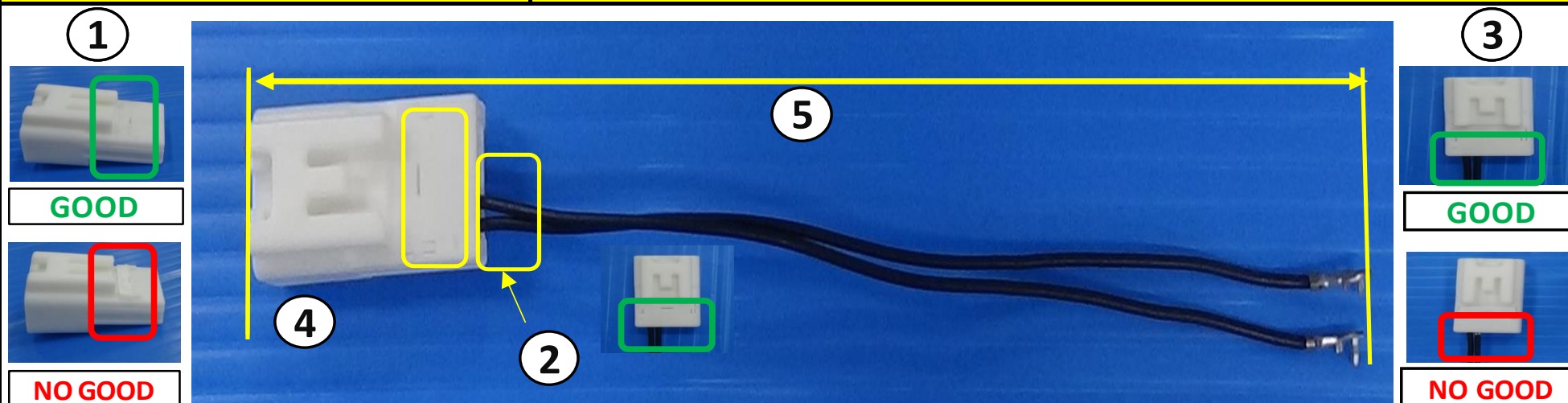
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7N0002-7020A****1 No Unlock connector****3 No Terminal Backing Out****2 No Wrong insert****4 No Deformed terminal****5 Check the Alignment**

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