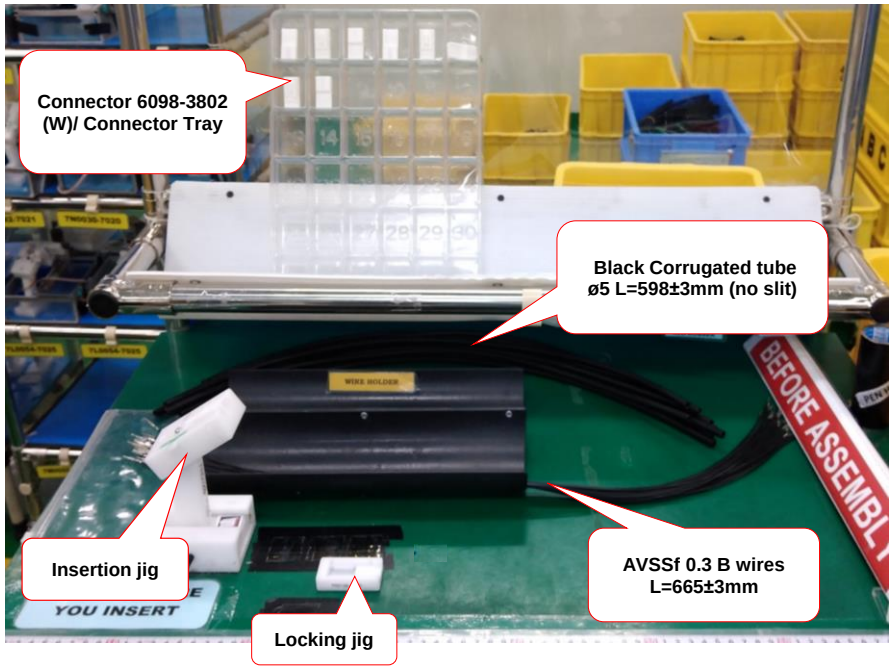
	WORK INSTRUCTION				Effectivity Date:	December 21, 2023		
	Process Name/Title:	OFFLINE ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number:	220D / 7R0128-7021	Customer: TRMX	Car Model: LEXUS-LM	Document No.:	WI-ENG-PDE-593		
	Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	2	Page No.:	1 of 6

PARTS:	1. All parts: Connector 6098-3802 (W); AVSSf 0.3 B wires L=665±3mm; Black COT (no slit) ø5 L=598±3mm	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 reference/s:*** ***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

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
12/21/23	2	Remove terminal cover jig and update process sequence due to process improvement. Update table lay-out. Inclusion of Quality pointers and Car Model "LEXUS-LM"	D. Castillo	C.Villanueva	A. Arañes	n/a
10/21/22	1	Change document purpose from Pre-launch to masspro.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
10/03/22	0	Initial issue. Wire length from L=680±3mm to L=665±3mm;COT length from ø5 L=613±3mm to ø5 L=598±3mm.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes

Prepared by	Reviewed by	Approved by	Noted by
D. Castillo	C. Villanueva	A. Arañes	n/a
Est. Date:	June 9, 2022		

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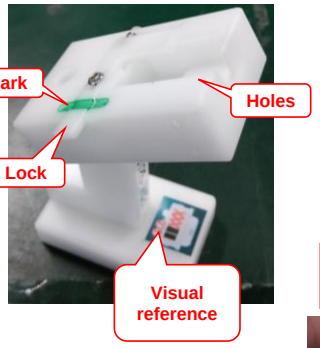
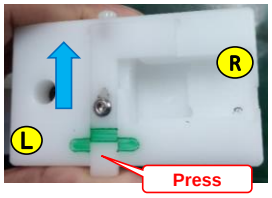
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	2	Page No.: 2 of 6

PARTS:	1. Connector 6098-3802 (W)	JIG:	1. Insertion jig

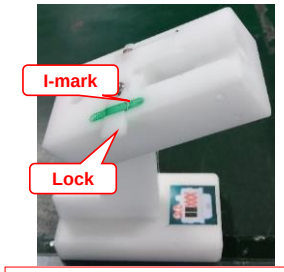
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	n/a	Connector Setting to Insertion jig 6098-3802 (W)		n/a	

INSERTION JIG

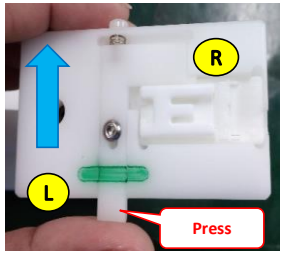


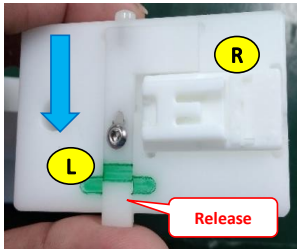


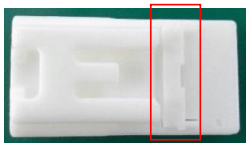
1. Press the lock of insertion jig using left thumb.



INSERTION JIG ORIENTATION





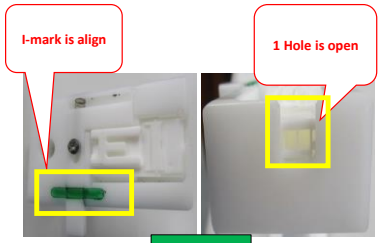


CONNECTOR ORIENTATION

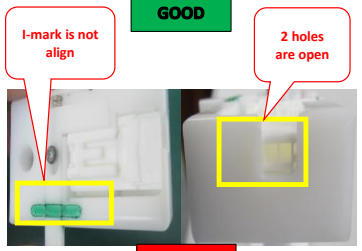
2. Insert the connector **6098-3802 (W)** into jig using right hand then release the lock.
Note: Follow the connector orientation

3. Check the holes/terminal slot for **B-B wires.**

Connector Orientation Illustration

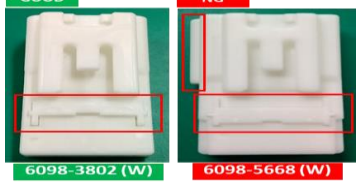


GOOD



NG

CONNECTOR 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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	Process Name/Title:	OFFLINE ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 220D / 7R0128-7021	Customer: TRMX	Car Model: LEXUS-LM	Document No.:	WI-ENG-PDE-593	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	2	Page No.: 3 of 6

PARTS:	1. AVSSf 0.3 B wires L=665±3mm [2pcs] 2. Black Corrugated tube ø5 L=598±3mm (no slit)	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	2 n/a	Wire insertion to black corrugated tube Ø5 L=598±3mm (no slit)	 1. Get the **Black corrugated tube ø5 L=598±3mm (no slit)** uisng left had and get **B-B wires** using right hand then insert.	n/a	1. No wrong usage of parts 2. No deformed terminal

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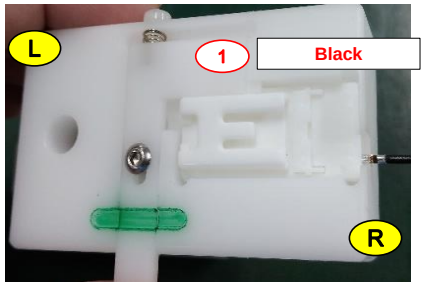
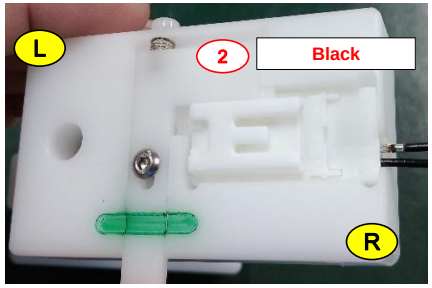
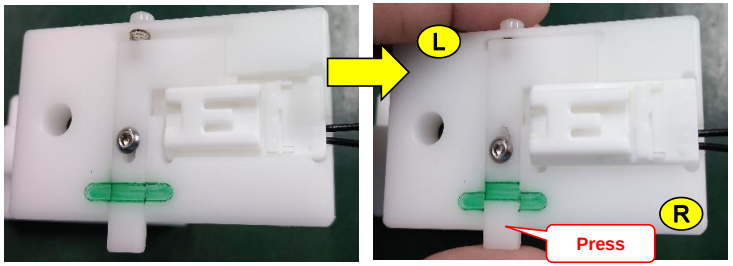
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	2	Page No.:	4 of 6

PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
4	2 n/a	Wire insertion to connector 6098-3802 (W)	 **WIRE FACING**  1. Get the **1st B wire** then insert to connector using right hand. ***Note: Insertion of wire must be from left to right.***  2. Get the **2nd B wire** then insert to 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 insertion 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***

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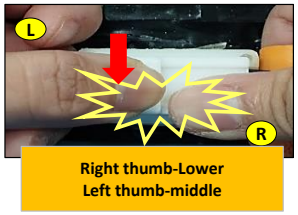
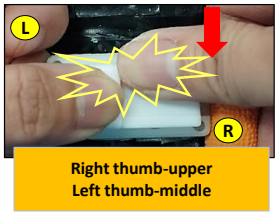
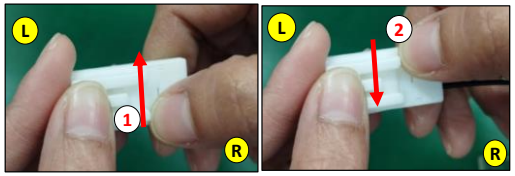
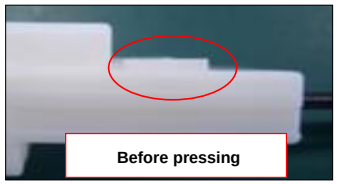
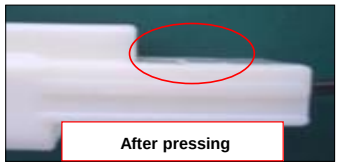
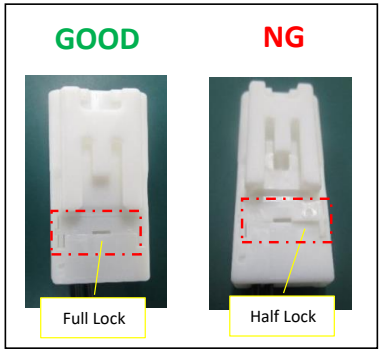
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	2	Page No.:	5 of 6

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

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	2 n/a	Connector lock	1. Load the connector into the jig holding both side of the connector, tip first. 2. Press the lower part of connector to fully insert into the locking jig.  3. Press the lower parts of connector using right hand while left hand holding the middle.  4. Press the upper part of connector using right hand while left hand holding the middle. 5. Lift then press the connector in the middle using left and right hand.  6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.	LOCKING JIG	   ***Important reminders/Note/s:*** ***1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR*** 1. Use the provided jig tool to lock the connector. 2. No unlock/half-locked connector

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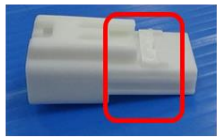
PARTS:	n/a	JIG:	n/a

2 QUALITY CHECKPOINTS

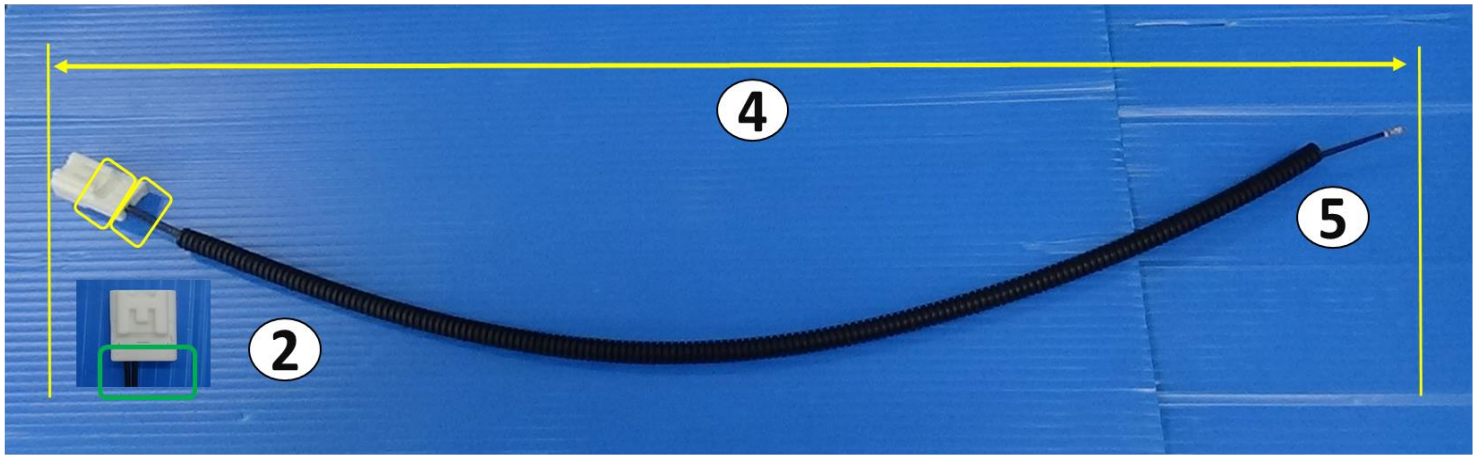
OFFLINE INSERTION 7R0128-7021

1

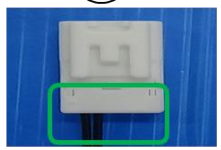
GOOD



NO GOOD



3



GOOD

NO GOOD

1 No Unlock connector

3 No Terminal Backing

2 No Wrong insert

4 Check the Alignment

5 No Deform terminal

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