


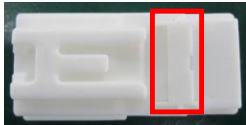
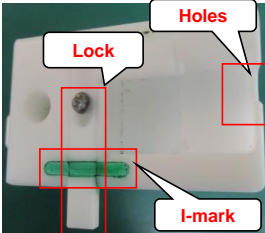
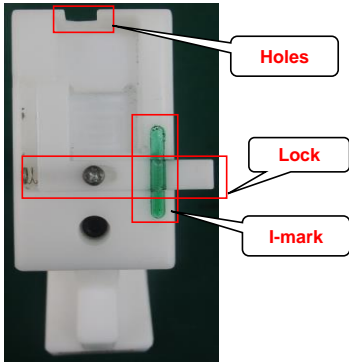
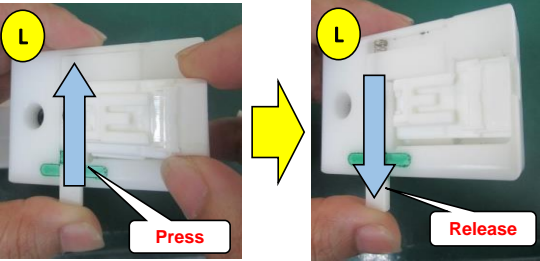
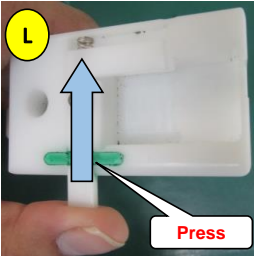

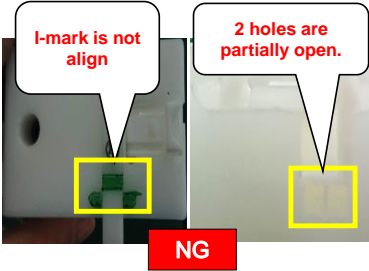
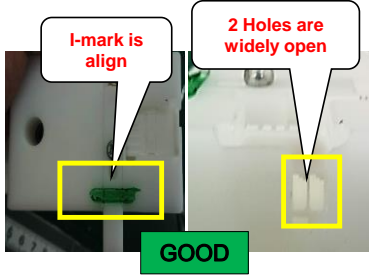
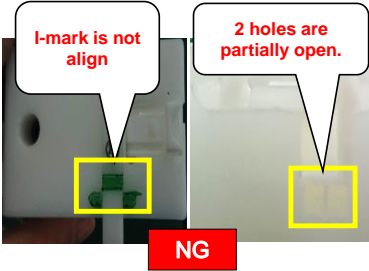
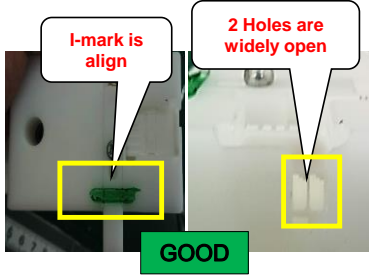
	WORK INSTRUCTION				Effectivity Date:	May 22, 2024		
	OFFLINE ASSEMBLY PROCESS				Validity Date:	n/a		
	Process Name/Title:				Document No.:	WI-ENG-PDE-066		
	Model code/Part number: 927B / 7R0101-7020		Customer: TRMX	Car Model: TOYOTA COROLLA	Revision No.:	3	Page No.:	1 of 7
Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						

PARTS:	1. Black Corrugated tube (no slit) Ø5, L=39+3mm; Connector 6098-5668 (W); AVVSf 0.3 Wires B L=216+2mm			JIG:	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
1	Offline Table Lay-out	<div style="text-align: center; border: 1px solid red; padding: 5px; margin-bottom: 10px;">TABLE LAY-OUT</div>	<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px solid red; padding: 5px;"> 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 1. No missing parts/tools. 2. No excess parts/tools.	

Revision History						Prepared by	Reviewed by	Approved by	Noted by
05/22/24	3	Inclusion of Car model "TOYOTA-COROLLA", Table lay-out, Measurement and Visual inspection. Update Connector lock process. Change from Kitting assembly process to Offline assembly process. Transfer Wire insertion to COT from Taping assembly process.	D. Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes
02/20/21	2	Change connector color in accordance with color standardization for plastic parts (Please refer to GL-COM-003 for Color Standardization for Plastic Parts). Change from 2x pulling to Pull-Push-Pull-Push insertion quality pointers.	D. Castillo	C. Villanueva	A. Shimamura	A. Arañes			
7/27/20	1	Added guidelines to Connector lock. Changed effective and validity date. Updated cycle time.	D. Castillo	R. Peñaloza	A. Shimamura	A. Arañes			
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	January 17, 2020	

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	3	Page No.:	2 of 7

PARTS:	1. Connector 6098-5668 (W)			JIG:	1. Insertion jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
2	Offline Connector setting to insertion jig 6098-5668 (W)	<div><div>INSERTION JIG</div><div><div>CONNECTOR ORIENTATION</div></div><div><div>2. Insert the connector (6098-5668) into jig using right hand and release the lock.</div></div><div><div>3. Check the holes/terminal slot for B-B wires.</div></div></div> <div>n/a</div> <td colspan="3"><div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</div><div>Connector Orientation Illustration</div><div></div></td>			<div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</div> <div>Connector Orientation Illustration</div> <div></div>			

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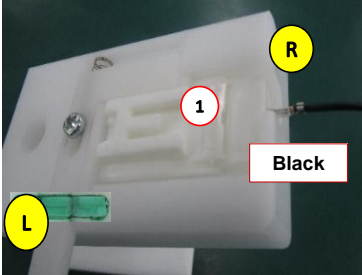
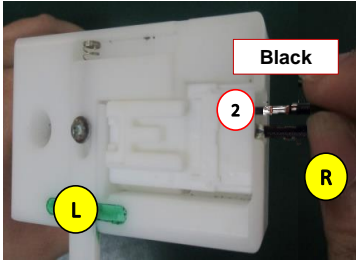
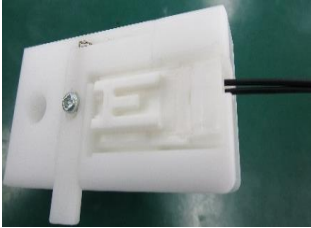
PARTS:		1.Black Corrugated tube (no slit) Ø5 L=39+3mm 2. AVSSf 0.3 B L=216±2mm [2pcs]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Offline <div>3</div> Wire insertion to corrugated tube (no slit) Ø5 L=39+3mm	 <div>1.Get black corrugated tube Ø5 L=39+2mm using left hand and insert AVSSf 0.3 B L=216±2mm using right hand.</div>		n/a	1. No wrong usage of parts 2. No deformed terminal

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	3	Page No.:	4 of 7

PARTS:	1.Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Offline Wire insertion to Connector 6098-5668 (W)	<div><p>Wire facing</p></div> <div><p>1. Get the Black wire and insert to Slot 1 of connector using right hand.</p></div> <div><p>2. Get the Black wire and insert to Slot 2 of connector using right hand.</p></div> <div><p>3. After insertion, push the lock button using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div>		n/a	<p>Impoprtant reminders and note/s:</p> <p>1. <i>Insertion should be from left to right.</i></p> <p>2. <i>Please hold the wire near terminal during insertion.</i></p> <p>3. <i>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</i></p> <p>1. No loose insertion 2. No wrong dimension 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p>

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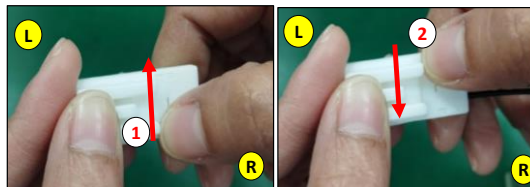

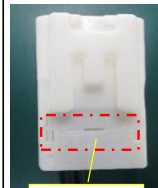
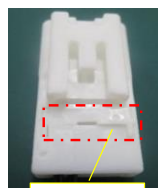


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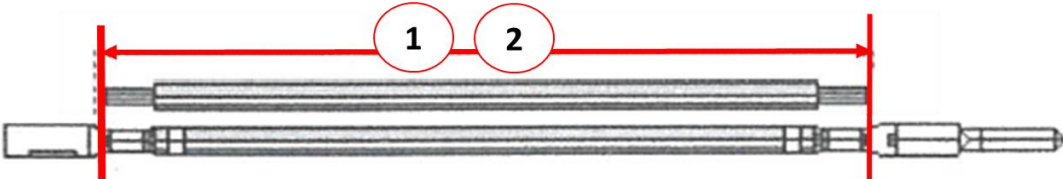

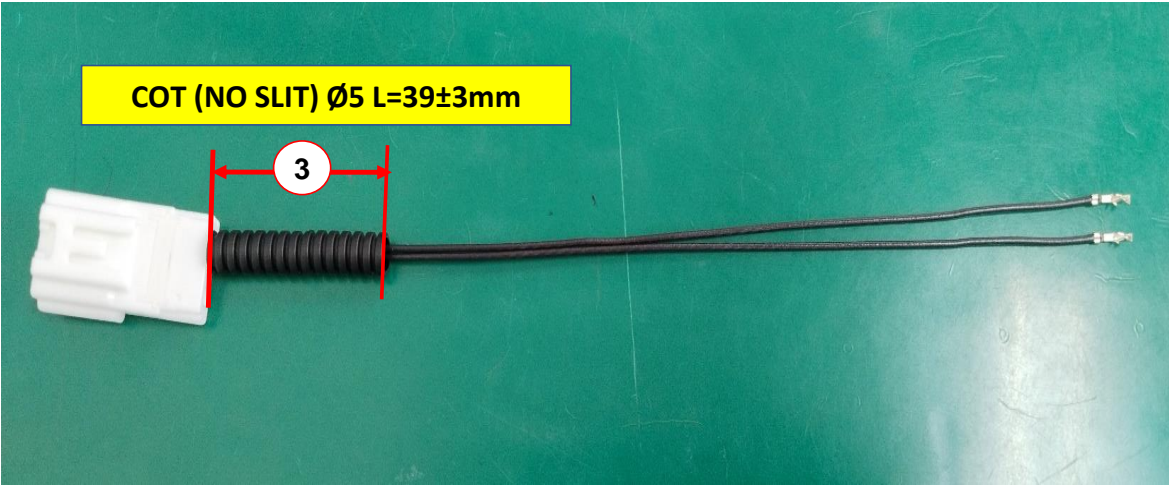
PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Offline Connector Lock	<div><div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div><div><p>2. Press the lower part of connector to fully insert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

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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></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>1. No wrong dimension</div>			

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PARTS:

1. Assy parts

JIG:

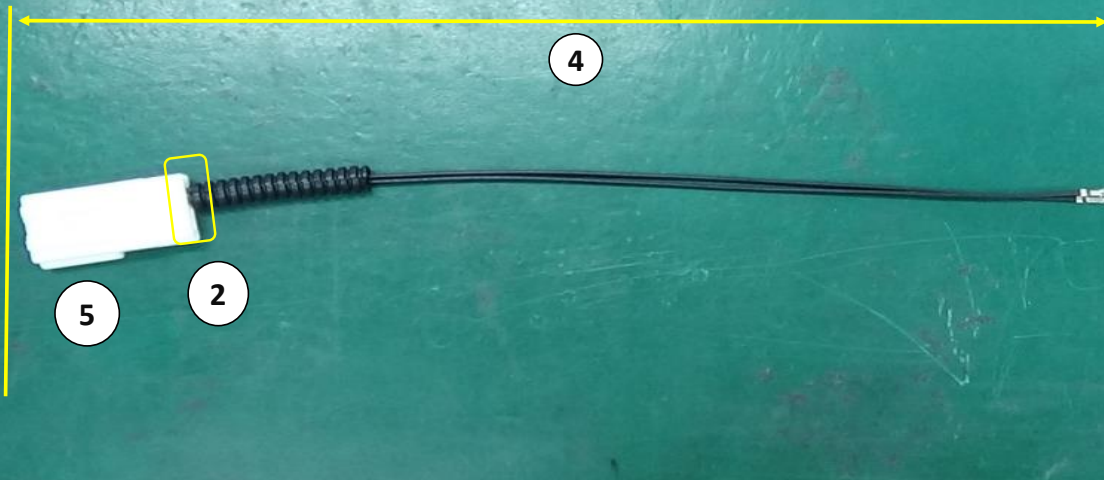
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**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7R0101-7020**

1

**GOOD****NO GOOD**

3

**GOOD****NO GOOD**

1

No Unlocked/Half-locked connector

3

No Terminal Backing Out

2

No Wrong insert

4

Check the Alignment

5

No Deformed terminal

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