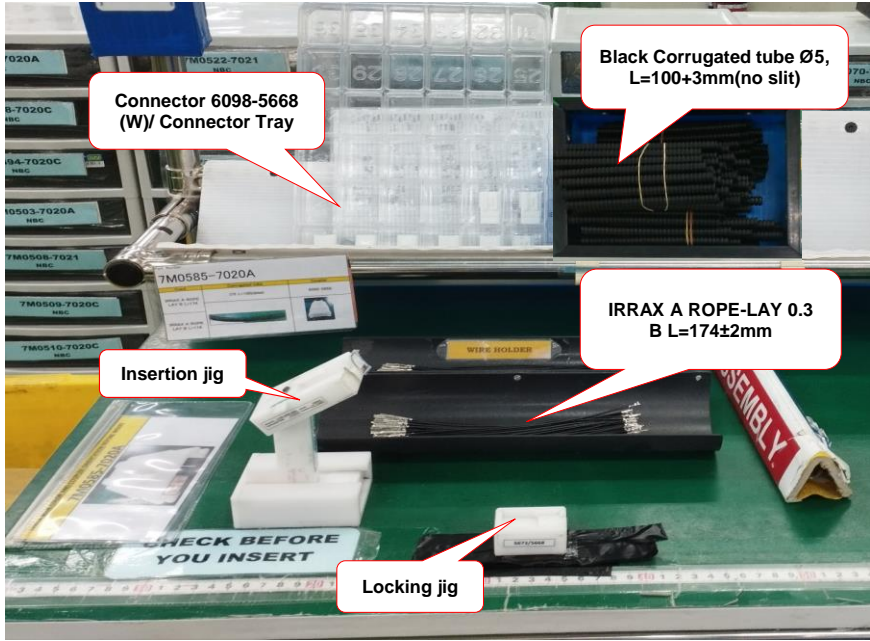
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	Process Name/Title:				Validity Date: <b>n/a</b>	
	Model code/Part number: <b>100B / 7M0585-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS UX</b>	Document No.: <b>WI-ENG-PDE-219</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.: <b>3</b> Page No.: <b>1</b> of <b>7</b>	


<b>PARTS:</b> 1.Connector 6098-5668 (W); IRRAX A ROPE-LAY 0.3 B L=174±2mm; Black Corrugated tube Ø5, L=100+3mm(no slit)		<b>JIG:</b> 1. Insertion jig 2. Locking jig		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
1	Offline Table Lay-out	<div style="text-align: center;"> <b>TABLE LAY-OUT</b> </div> 	<div> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div> <b>Housekeeping</b>            1. Maintain and always practice 5's.            2. Personal things on the workplace is prohibited. Keep it in your locker.         </div> <div> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>	<b>Document reference/s:</b> 1. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length Tolerance.  1. No missing parts/tools 2. No excess parts/tools

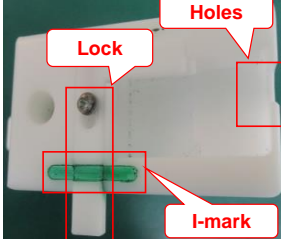
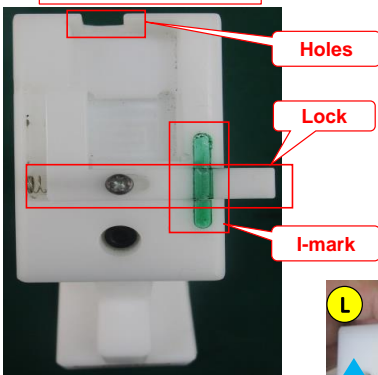

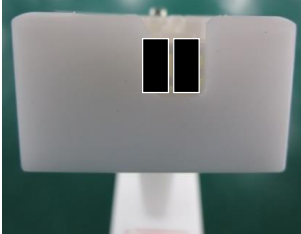
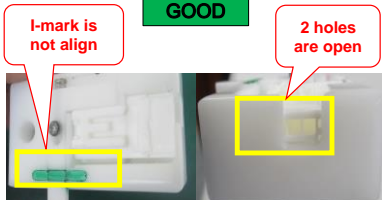
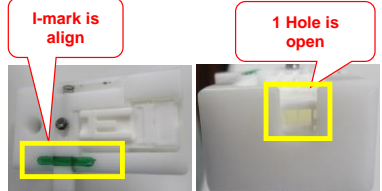


  

Revision History						Prepared by	Reviewed by	Approved by	Noted by
05/22/24	3	Inclusion of Measurement and car model "LEXUS UX". Improved visual Inspection				L. Ariola	C. Villanueva	A. Arañes	n/a
09/08/22	2	Additional table lay-out. Change document title from 'Kitting assembly process' to 'Offline assembly process'. Improve work procedure and illustration in process no.4 - locking method. Improve quality pointers and notes in process no.1,2,3 and 4.				M. Catapang	C. Villanueva	A. Shimamura	A. Arañes
07/10/21	1	Removal of validity date. Additional note in insertion process and in quality pointers.				M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted
						Est. Date:	January 09, 2021		

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	<b>OFFLINE ASSEMBLY PROCESS</b>				Validity Date:	n/a			
	Process Name/Title:		Model code/Part number: <b>100B / 7M0585-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS UX</b>	Document No.:	<b>WI-ENG-PDE-219</b>	
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<b>PARTS:</b>	1. Connector 6098-5668 (W)			JIG:	1. Insertion jig			
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
2	Offline Connector 6098-5668 (W) setting to insertion jig	<div><div><b>INSERTION JIG</b></div><div><div><b>CONNECTOR ORIENTATION</b></div><div>2. Insert the connector <b>6098-5668 (W)</b> into jig using right hand and release the lock. <i>Note: Please follow the connector orientation.</i></div><div>3. Check the holes/terminal slot for <b>B-B wires</b>.</div></div></div>			n/a	<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> <div><b>Connector Orientation Illustration</b></div> <div><div><b>GOOD</b>    <b>NG</b></div><div><b>CONNECTOR ILLUSTRATION</b></div><div><div><b>GOOD</b>    <b>NG</b> <b>6098-5668 (W)</b>    <b>6098-3802 (W)</b></div></div></div>		

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Revision No.:

**3**

Page No.:

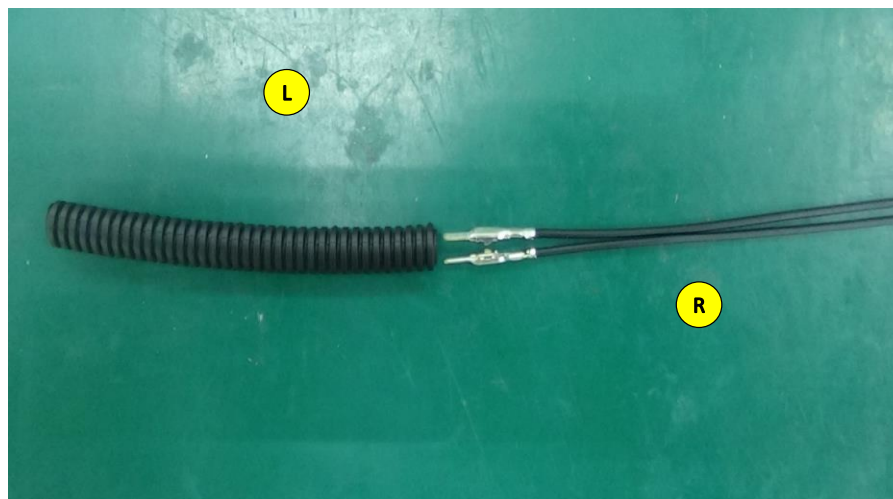
**3 of 7****PARTS:**

1. Black Corrugated tube Ø5, L=100+3mm(no slit)
2. IRRAX A Rope-lay 0.3 B L=174mm

JIG:

**n/a****NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****3**

Offline

Wire insertion to  
corrugated tube Ø5,  
L=100+3mm(no slit)

1. Get black corrugated tube **Ø5 L=100+3mm** using left hand and insert **IRRAX A 0.3 BL=174mm** using right hand.


**n/a**


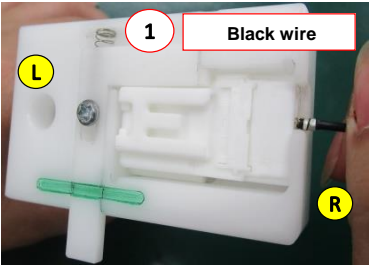
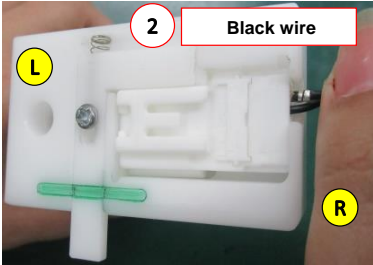
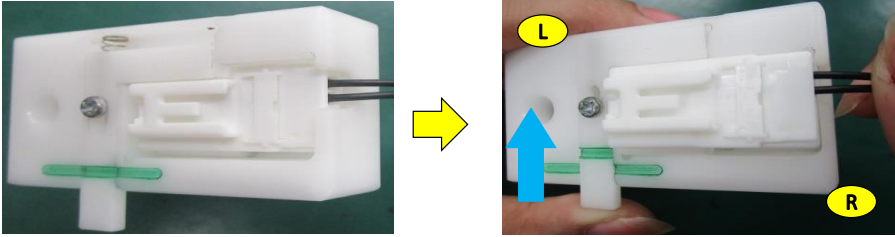
1. No wrong usage of parts
2. No deformed terminal

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	<b>OFFLINE ASSEMBLY PROCESS</b>				Validity Date:	n/a			
	Process Name/Title:		Model code/Part number: <b>100B / 7M0585-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS UX</b>	Document No.:	<b>WI-ENG-PDE-219</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		3	Page No.:	4 of 7		

<b>PARTS:</b>	1. IRRAX A ROPE-LAY 0.3 B L=174±2mm [2pcs.] 2. Connector 6098-5668 (W)			JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
4	Offline  Wire insertion to connector 6098-5668 (W)	<div><div>WIRE FACING</div></div> <div><div>1. Get the <b>B-wire</b> then insert to terminal slot <b>1</b> using right hand. <b>Note: Make sure to hold the COT using right hand while insertion to prevent deformed in 7D0349 Terminal.</b></div></div> <div><div>2. Get the <b>B-wire</b> then insert to terminal slot <b>2</b> 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></div>		n/a	<p><b>Important reminders and note/s:</b></p> <ul style="list-style-type: none"><li>1. Insertion of wire must be from left to right.</li><li>2. Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</li><li>3. Please hold the wire near terminal.</li></ul> <p><b>Document references:</b></p> <ul style="list-style-type: none"><li>1. Refer to <b>GL-PRO-ASY-029</b> for Pull-Push procedure.</li><li>2. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length Tolerance.</li></ul> <ul style="list-style-type: none"><li>1. No loose insertion</li><li>2. No wrong insertion</li><li>3. One by one insertion</li><li>4. No deformed terminal</li><li>5. No wrong wire facing</li></ul>

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Document No.:

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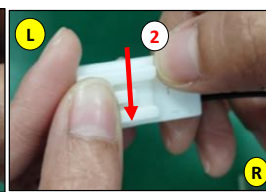





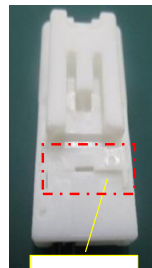
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Revision No.:

3

Page No.:

5 of 7


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><div><p>Right thumb-Lower Left thumb-middle</p></div><div><p>Right thumb-upper Left thumb-middle</p></div><div><div><p>Right thumb-middle Left thumb-middle</p></div><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></div><div><div><p>LOCKING JIG</p></div></div><div><p><b>Important reminders/Note/s:</b></p><p>1. <b>MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b></p><p>1. Use the provided jig tool to lock the connector. 2. No unlock/half-locked connector</p><div><div><p>Before pressing</p></div><div><p>After pressing</p></div><div><div><p>Full Lock</p></div><div><p>Half Lock</p></div></div></div></div></div>		

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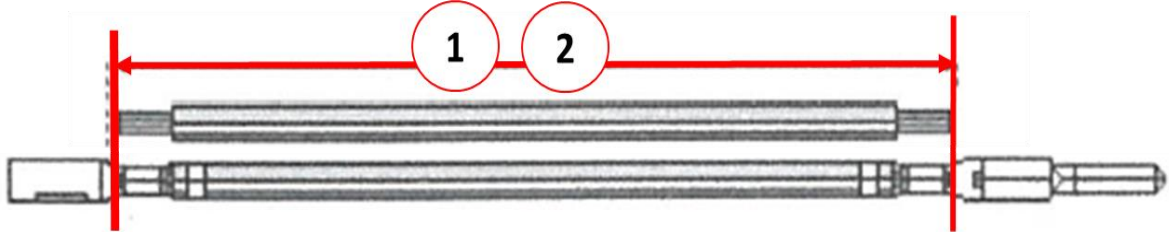

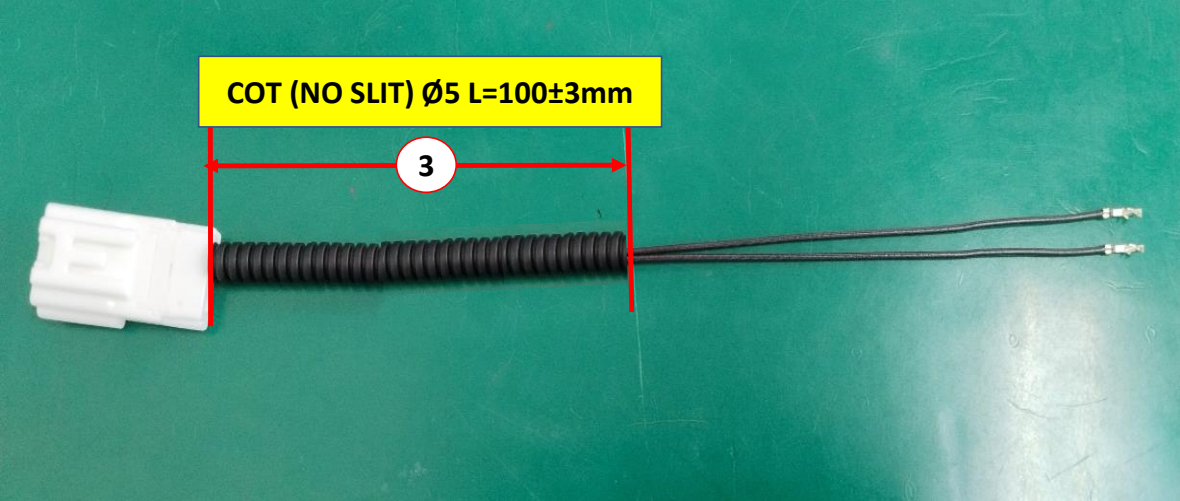
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<b>PARTS:</b>		1. Assy parts		JIG:	1. Locking jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>3 WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
6	Offline	Measurement	<div> <div> <p>Note:</p> <p>1. Measurement point: End of core wire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

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Revision No.:

3

Page No.:

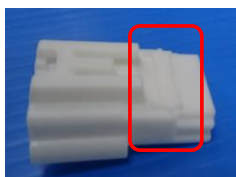
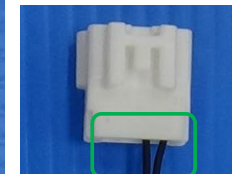
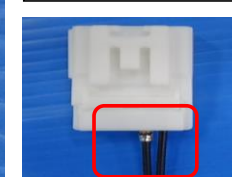
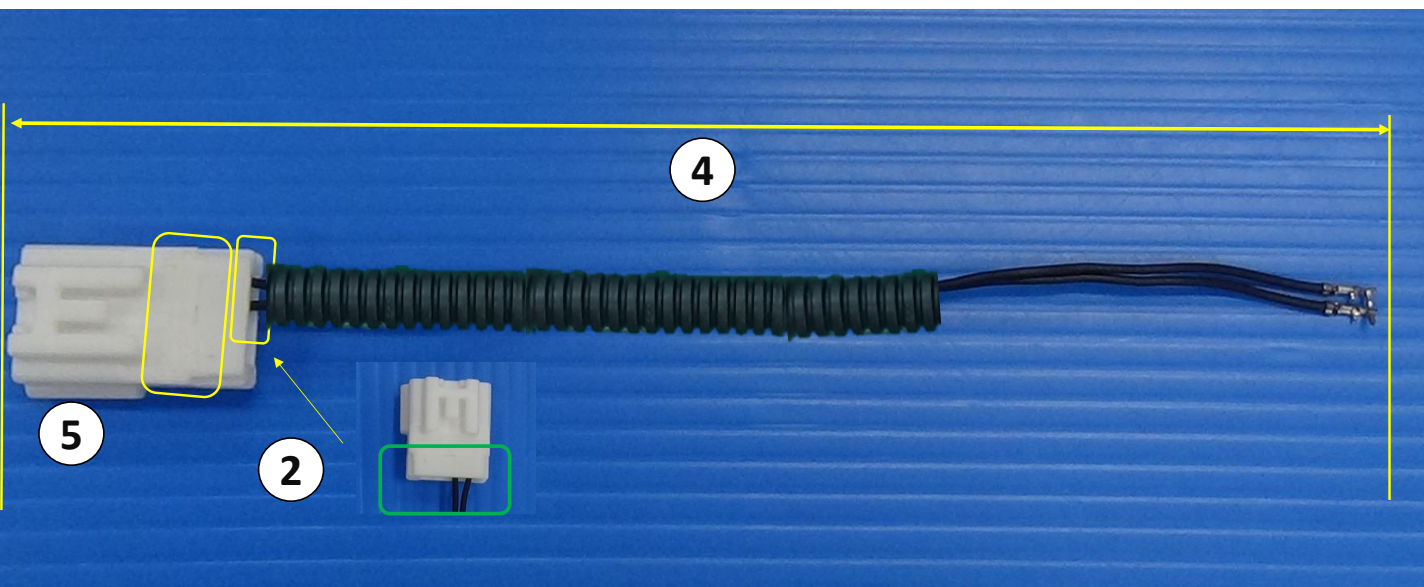
7 of 7

**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7M0585-7020A****1****GOOD****NO GOOD****3****GOOD****NO GOOD****4****5****2****1****No Unlocked/Half-locked connector****2****No Wrong insert****3****No Terminal Backing Out****4****Check the Alignment****5****No Deformed terminal**

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