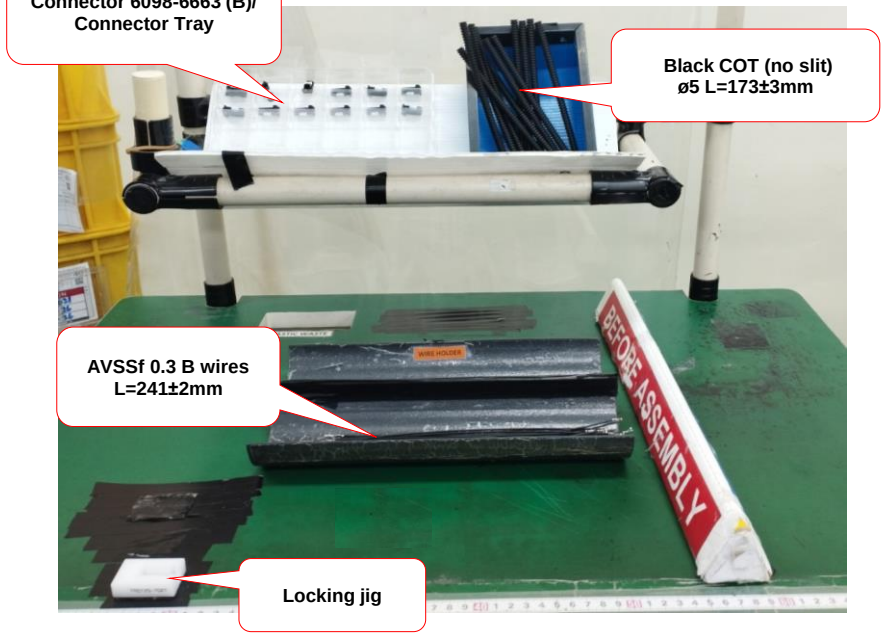
	WORK INSTRUCTION			Effectivity Date:	December 21, 2023		
	Process Name/Title:	OFFLINE ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 220D / 7R0127-7022	Customer: TRMX	Car Model: LEXUS-LM	Document No.:	WI-ENG-PDE-595		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	2	Page No.:	1 of 4

PARTS:	1. All parts: Connector 6098-6663 (B); AVSSf 0.3 B wires L=241±2mm; Black COT (no slit) ø5 L=173±3mm	JIG:	1. Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	n/a	2 Table Lay-out	**Table Lay-out**  	**Safety Instruction** Be sure to wear required 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
10/26/22	1	Change document purpose from Pre-launch to masspro.	M.Catapang	J.Loterte	C.Villanueva	A. Arañes
10/04/22	0	Initial issue. Reduced 15mm measurement in COT from ø5 L=188±3mm to ø5 L=173±3mm and wires from L=256±2mm to L=241±2mm.	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:	October 4, 2022		

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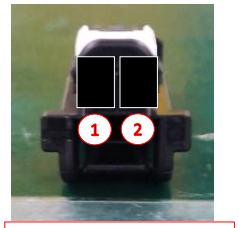
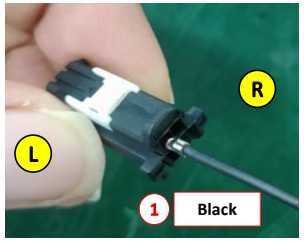
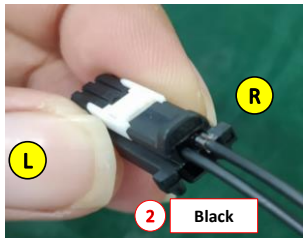
PARTS:	1. Connector 6098-6663 (B) 2. AVSSf 0.3 B wires L=241±2mm [2pcs.]	3. Black corrugated tube ø5 L=173±3mm	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	2	Wire insertion to Black corrugated tube ø5 L=173±3mm (no slit)	 1. Get the **Black corrugated tube ø5 L=173±3mm (no slit)** uisng left had and get **B-B wires** using right hand then insert.	n/a	1. No deformed terminal 2. No wrong usage of parts
3	2 P1	Wire insertion to connector 6098-6663 (B)	 **CONNECTOR ORIENTATION**  **VISUAL REFERENCE** **WIRE FACING**  1. Hold the connector **6098-6663 (B)** then get the **first Black wire** and insert to terminal **slot 1** using right hand. Conduct **2x** push pull after wire insertion. ***Note: Insertion of wire must be from left to right.***  2. Hold the connector **6098-6663 (B)** then get the **second Black wire** and insert to terminal **slot 2** using right hand. Conduct **2x** push pull after wire insertion.	n/a	1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing ***Important reminders/Note/s:*** ***1. Make sure wires are properly inserted.*** ***Conduct Pull-Push-Pull-Push after insertion.*** ***Do not exert extra force.*** ***Document references:*** ***1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.*** ***2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.***

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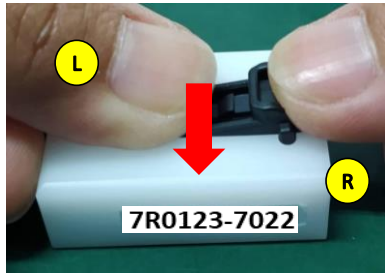
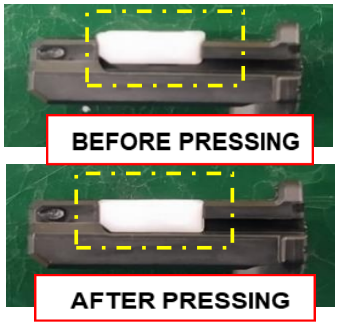
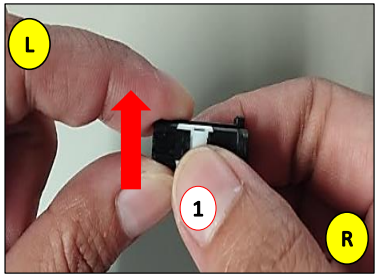
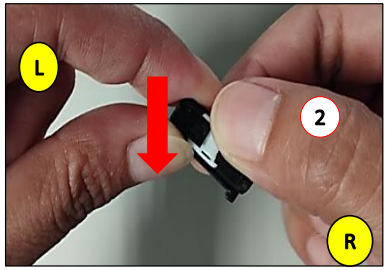
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	2	Page No.:	3 of 4

PARTS:	1. Assy parts			JIG:	1. Locking jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
4	2 n/a	Connector lock	  1. Put the connector into locking jig using right hand then press to lock **2x** using both hands.   2. 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 lock.*** 1. Use provided jig tool per model 2. No unlock/half-locked connector

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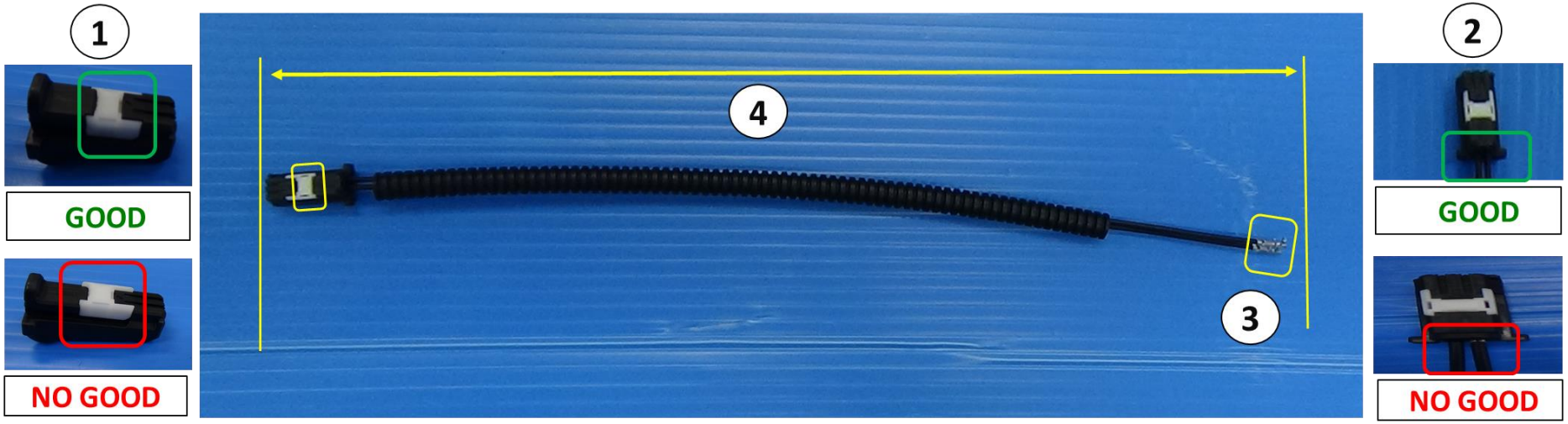
PARTS:	n/a	JIG:	n/a

QUALITY CHECKPOINTS

OFFLINE INSERTION 7R0127-7022



1 No Unlock connector

2 No Terminal Backing Out

3 No Deform terminal

4 Check the Alignment

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