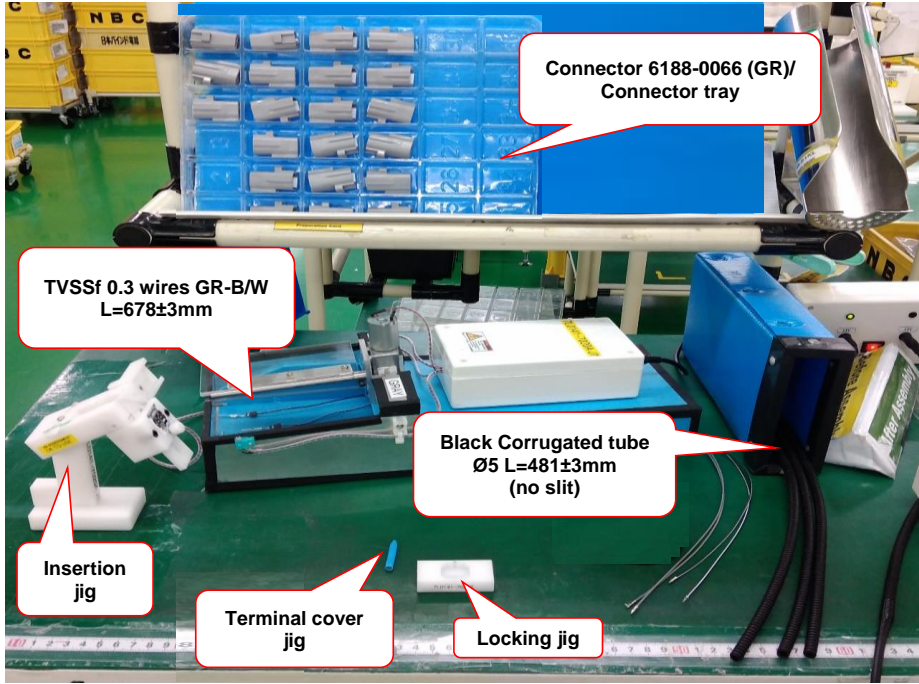



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	Process Name/Title: OFFLINE ASSEMBLY PROCESS						Validity Date:		n/a	
	Model code/Part number: 380D / 7L0141-7020A			Customer: TRQSS		Car Model: TOYOTA CAMRY		Document No.: WI-ENG-PDE-970		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.:		0	Page No.: 1 of 6

PARTS:		1.Connector 6188-0066 (GR); TVSSf 0.3 wires GR-B/W L=678±3mm; Black Corrugated tube Ø5 L=481±3mm (no slit)				JIG:		1. Insertion jig with switch cover 2. Locking jig 3. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	Offline Table Lay-out	<div>TABLE LAY-OUT</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>		<div><b>Document reference/s:</b> 1. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length Tolerance.</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>	


Revision History						Prepared by		Reviewed by		Approved by		Noted by	
09/04/24	0	Initial issue. Transfer process from Taping assembly process.				D.Castillo	C. Villanueva	A. Arañes	n/a				n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	September 4, 2024		

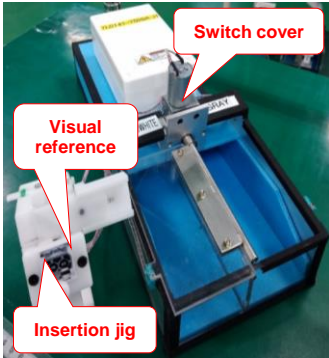
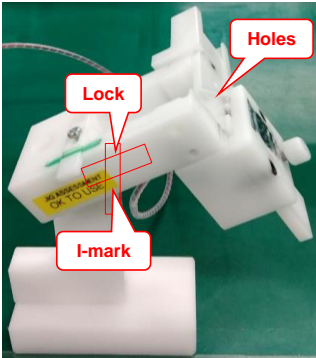

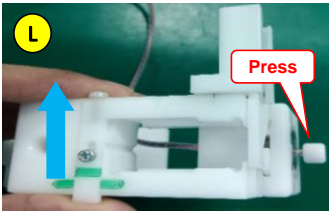
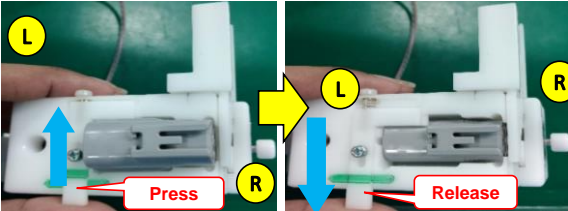
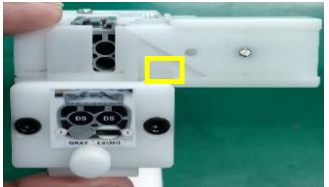
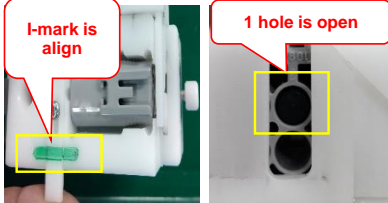
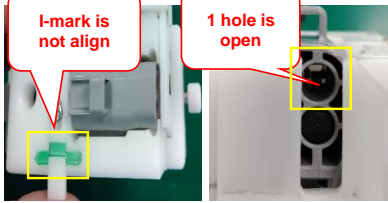
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		Process Name/Title: <b>OFFLINE ASSEMBLY PROCESS</b>			Validity Date:		n/a		
		Model code/Part number: <b>380D / 7L0141-7020A</b>		Customer: <b>TRQSS</b>		Car Model: <b>TOYOTA CAMRY</b>		Document No.: <b>WI-ENG-PDE-970</b>	
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<b>PARTS:</b>		1. Connector 6188-0066 (GR)			<b>JIG:</b>		1.Insertion jig with flip cover		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>		<b>QUALITY POINTERS</b>		
2	Offline Connector setting to Insertion jig 6188-0066 (GR)	<div><div><b>INSERTION JIG WITH FLIP COVER</b></div><div></div><div></div><div></div><div><b>CONNECTOR ORIENTATION</b></div></div> <div><div></div><div></div><div></div><div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the connector <b>6188-0066 (GR)</b> into jig using right hand and release the lock. <i>Note: Refer to above illustration for correct setting.</i></p><p>3. Check the holes/terminal slot for <b>B/W wire.</b></p></div></div> <div><p>N/A</p></div> <div><div><b>Connector Orientation Illustration</b></div><div></div><div><b>GOOD</b></div><div></div><div><b>NG</b></div><div><p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p></div></div>							


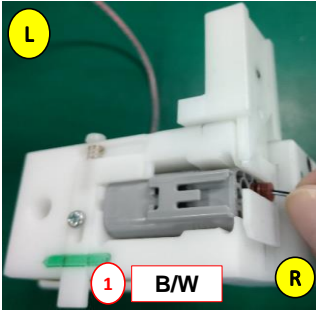
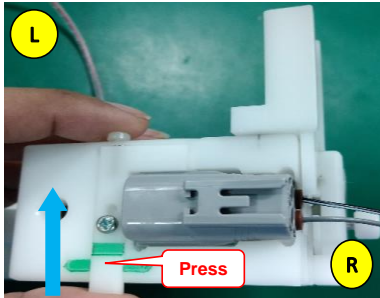
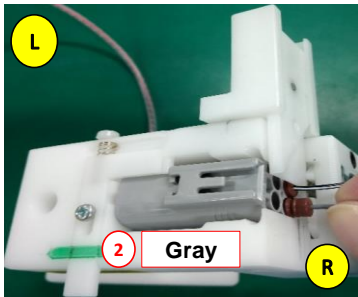
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	Model code/Part number: <b>380D / 7L0141-7020A</b>		Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA CAMRY</b>	Document No.: <b>WI-ENG-PDE-970</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	3 of 6

<b>PARTS:</b>	1. TVSSf 0.3 wires GR-B/W L=678±3mm 2. Connector 6188-0066 (GR)			JIG:	1. Insertion jig with flip cover
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
3	Offline  Wire Insetion to Connector 6188-0066 (GR)	<div><p>Wire facing</p></div> <div><p>Press</p></div> <div><p>1. Hold the Insertion jig using left hand. Get <b>Black /White wire</b> then insert to terminal <b>slot 1</b> using right hand.</p><p>2. Push the button using right hand. The slot for <b>Gray wire</b> will be opened.</p><p>3. Get <b>Gray wire</b> then insert to terminal <b>slot 2</b> using right hand.</p><p>4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div>		N/A	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p><b>Important reminders/Note/s:</b></p> <p>1. <i>Please hold the wire near terminal.</i></p> <p>2. <i>Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</i></p> <p>3. <i>Insertion of wires must be from left to right</i></p> <p><b>Document references:</b></p> <p>1. <i>Refer to <b>GL-PRO-ASY-029</b> for Pull-Push procedure.</i></p> <p>2. <i>Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length Tolerance</i></p>

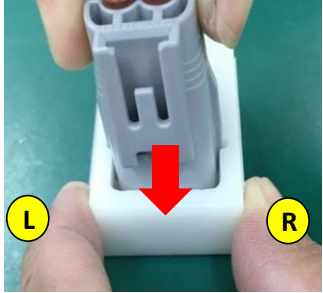


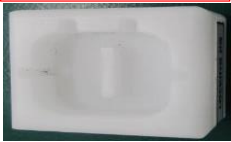



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	Model code/Part number: <b>380D / 7L0141-7020A</b>		Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA CAMRY</b>	Document No.:	WI-ENG-PDE-970	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	4 of 6


  

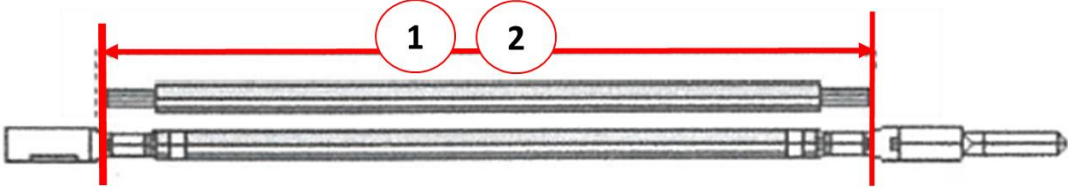
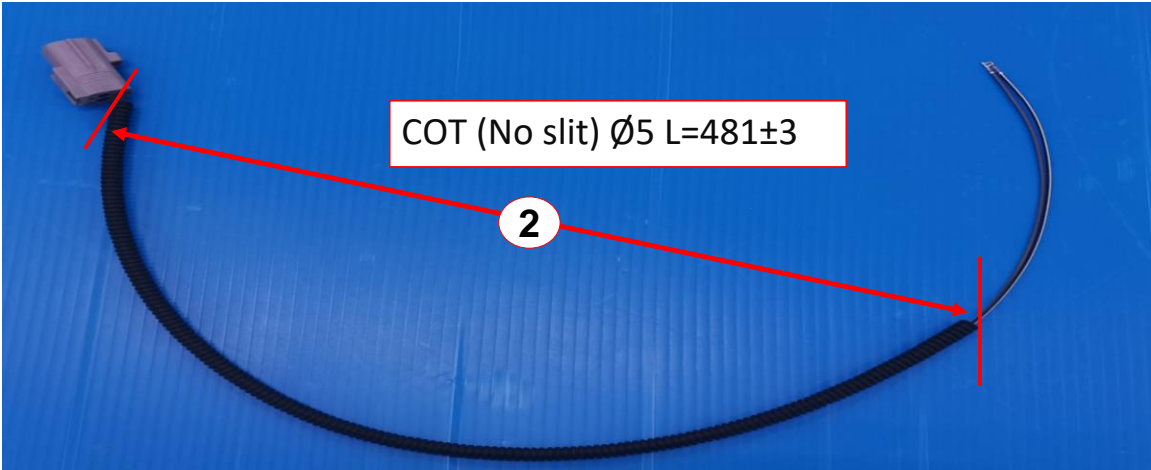

<b>PARTS:</b> 1. Assy parts 2. Black Corrugated tube Ø5 L=481±3mm (no slit)		JIG: 1. Locking jig 2. Terminal cover jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>
4	Connector Lock	  <div> <p><b>Connector Cross Sectional View</b></p> <p><b>NG NG GOOD</b></p>  <p>Unlock Condition    Half Lock Condition    Full Lock Condition</p> </div> <p>1. Put the connector into locking jig using right hand then press  <b>2x</b>. Check if properly locked.</p>	<div>LOCKING JIG</div> 
5	Offline Wire Insertion to Black Corrugated tube Ø5 L=481±3mm (no slit)	  <p>1. Get the terminal cover jig using right hand then insert the <b>GR-B/W wires</b> using left hand.</p> <p>2. Get the corrugated tube (no slit) <b>Ø5 L=481±3mm</b> using right hand and then insert the <b>GR-B/W wires</b> using left hand.</p> <p>3. After insertion, remove the terminal cover jig using right hand.</p>	<div>TERMINAL COVER JIG</div> 
			1. Use the provided locking jig per model 2. No unlock/half-locked connector
			1. No wrong use of parts 2. No deformed terminal

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	Process Name/Title:		Model code/Part number: <b>380D / 7L0141-7020A</b>		Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA CAMRY</b>	Document No.: <b>WI-ENG-PDE-970</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: <b>0</b>		Page No.:	5 of 6

<b>PARTS:</b>	1. Assy parts			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
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>MEASURING TAPE</div> <div></div>	<div><b>Important reminders and note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b>  <b>2. For Hatsumono, Nakamono and Owarimono.</b>  <b>Document reference/s:</b> <b>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</b></div> <div>1. No wrong dimension</div>

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**WORK INSTRUCTION**

Process Name/Title:

**OFFLINE ASSEMBLY PROCESS**

Effectivity Date:

**September 4, 2024**

Model code/Part number:

**380D / 7L0141-7020A**

Customer:

**TRQSS**

Car Model:

**TOYOTA CAMRY**

Document No.:

**WI-ENG-PDE-970**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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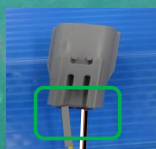
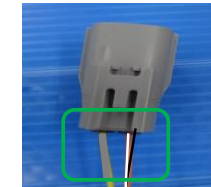
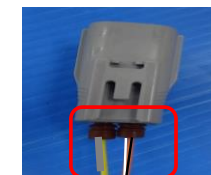
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**PARTS:**

1. Assy parts

JIG:

N/A

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7L0141-7020A****1****GOOD****4****2****NO GOOD****3****GOOD****NO GOOD****1 No Unlocked/ Half-locked connector****3 No Terminal Backing Out****2 No Wrong insert****4 No Deformed terminal**

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