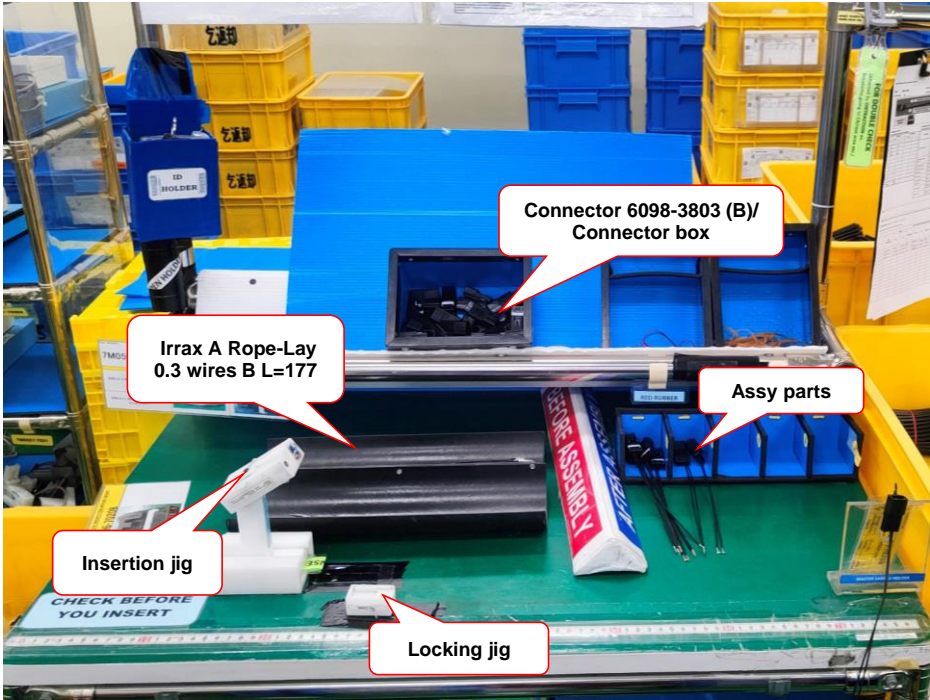
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	Process Name/Title: <b>OFFLINE ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Model code/Part number: <b>400B / 7M0596-7020B</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-VITZ</b>	Document No.:		<b>WI-ENG-PDE-124</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		4	Page No.: 1 of 6

<b>PARTS:</b>	1. Assy parts (IRRAX A Rope-Lay 0.3 wires B L=177); Connector 6098-3803 (B)			JIG:	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><div>TABLE LAY-OUT</div></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 work place 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 WI-PRO-CNC-017 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
06/06/24	4	Inclusion of Measurement and improved Visual Inspection.				L. Ariola	C. Villanueva	A. Arañes	n/a
06/27/23	3	Inclusion of Table lay-out and Quality checkpoints; improvement of important reminders/note/s and document references; Change process name from Kitting assembly to Offline assembly.				J. Loterte	C. Villanueva	A. Arañes	n/a
06/12/21	2	Remove validity date; Change the insertion jig illustration from combined insertion and locking to manual				J. Loterte	Villanueva	Shimamura	A. Arañes
12/12/20	1	Remove cycle time, change 2x pulling to pull-push-pull-push in insertion process				J. Loterte	Peñaloza	Shimamura	A. Arañes
Eff. Date	Rev. No.	Details of Change				Revised	Reviewed	Approved	Noted


Est. Date:	May 15, 2020
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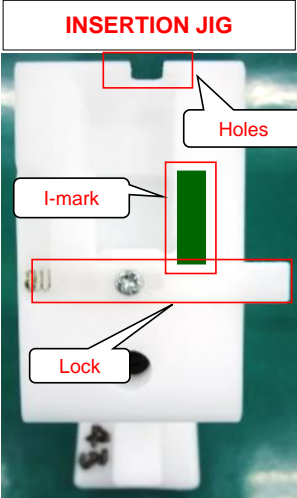
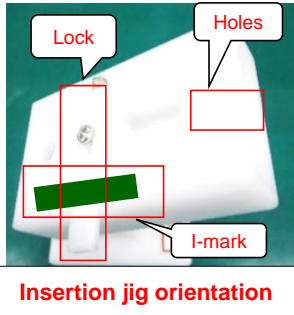

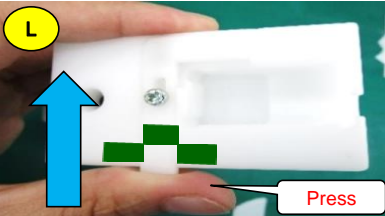
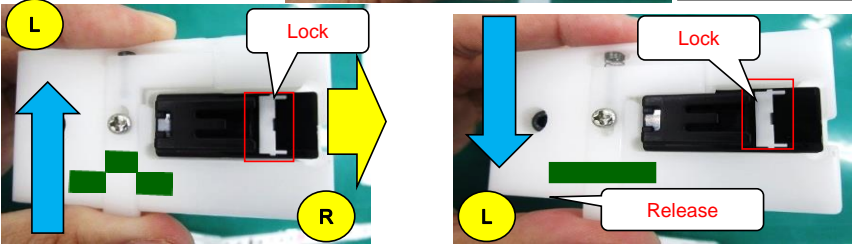

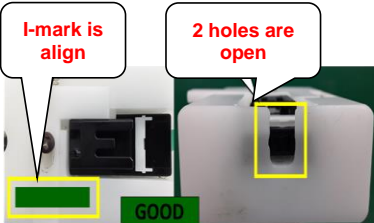
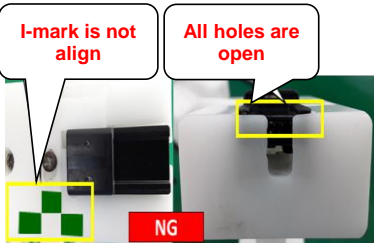
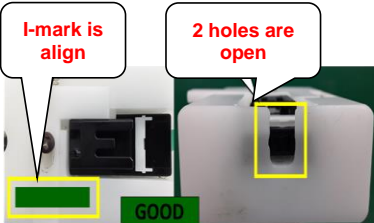
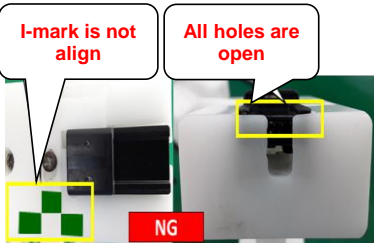
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	<b>OFFLINE ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Process Name/Title:		Model code/Part number: <b>400B / 7M0596-7020B</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-VITZ</b>		Document No.: <b>WI-ENG-PDE-124</b>
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		4	Page No.:


<b>PARTS:</b>		1. Connector 6098-3803 (B)		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 Setting to Insertion jig 6098-3803 (B)	<div><div><p><b>INSERTION JIG</b></p><p>Holes</p><p>I-mark</p><p>Lock</p></div><div><p>Lock</p><p>Holes</p><p>I-mark</p><p><b>Insertion jig orientation</b></p></div><div><p><b>Connector orientation</b></p></div><div><p>1. Press the lock of insertion jig using left thumb.</p><p>Press</p></div><div><p>2. Insert the connector <b>6098-3803 B</b> into jig using right hand and release the lock.</p><p>Lock</p><p>Release</p></div><div><p>3. Check the holes/terminal slot for 2 Black wires.</p></div></div> <td>n/a</td> <td colspan="2"><div><p><b>Connector Orientation Illustration</b></p><div><p>I-mark is align</p><p>2 holes are open</p><p>GOOD</p></div><div><p>I-mark is not align</p><p>All holes are open</p><p>NG</p></div></div><p>1. Use the provided jig per model 2. No wrong orientation of connector</p></td>		n/a	<div><p><b>Connector Orientation Illustration</b></p><div><p>I-mark is align</p><p>2 holes are open</p><p>GOOD</p></div><div><p>I-mark is not align</p><p>All holes are open</p><p>NG</p></div></div> <p>1. Use the provided jig per model 2. No wrong orientation of connector</p>	


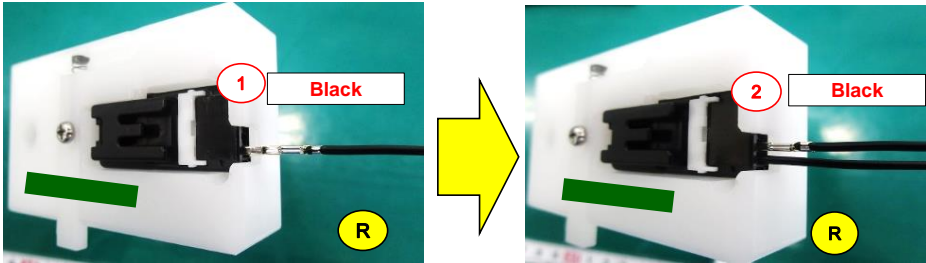
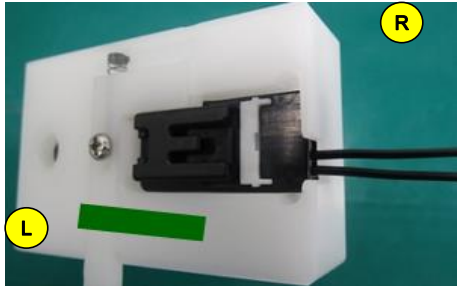
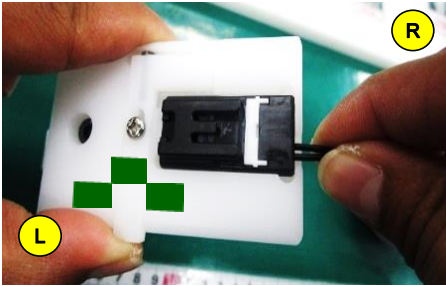
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	Process Name/Title: <b>OFFLINE ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>400B / 7M0596-7020B</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-VITZ</b>	Document No.:	<b>WI-ENG-PDE-124</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	4	Page No.:	3 of 6

<b>PARTS:</b>	1. IRRAX A Rope-Lay 0.3 wires B L=177 [2pcs]			JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
3	Offline  Wire insertion to connector 6098-3803 (B)	<div><div>WIRE FACING</div></div> <div><div>1. Get the first black wire and insert to connector using right hand. Conduct one by one insertion from left to right.</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> <div><div>2. Get the 2nd black wire and insert to connector using right hand.</div></div>		n/a	<p><b>Important reminders and Note/s;</b></p> <p>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>2. Please hold the wire near terminal during insertion.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to GL-PRO-ASY-029 for Pull-push procedure.</p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p>

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**WORK INSTRUCTION**

Process Name/Title:

**OFFLINE ASSEMBLY PROCESS**

Effectivity Date:

June 6, 2024

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**400B / 7M0596-7020B**

Customer:

**TRJ**

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**WI-ENG-PDE-124**

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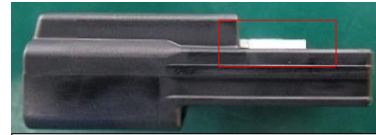
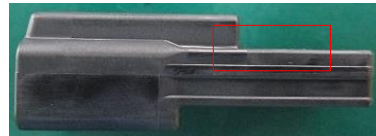


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<b>PARTS:</b>	1. Assy parts			JIG:	1. Locking jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
4	Offline Connector lock	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div> <div><p>3. Press the lower parts of connector using right hand while left hand holding the middle.</p><p>4. Press the upper part of connector using right hand while left hand holding the middle.</p></div> <div><p>5. Lift then press the connector in the middle using left and right hand.</p><p>6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div>		<div><b>LOCKING JIG</b></div> 	<p>1. Use the provided jig per connector 2. No unlock/half-locked connector</p> <p><b>Important reminders and Note/s;</b> <b>1. Manual locking may cause damaged lock.</b></p> <p><b>Document reference/s:</b> <b>1. Refer to GL-PRO-ASY-017 for locking verification.</b></p> <div><p><b>BEFORE PRESSING</b></p><p><b>AFTER PRESSING</b></p><div><p><b>GOOD</b></p><p>Full Lock</p><p><b>NG</b></p><p>Half Lock</p></div></div>

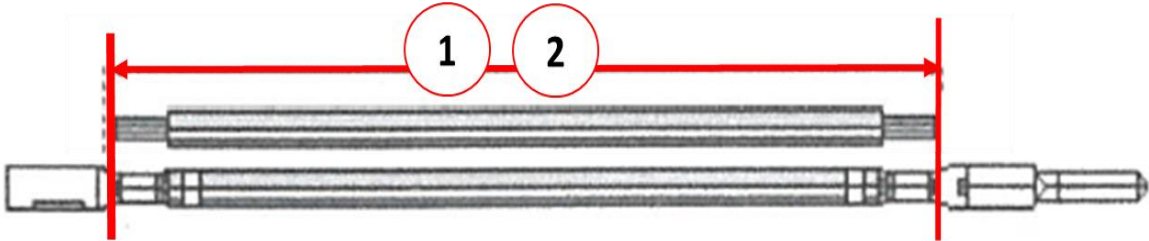
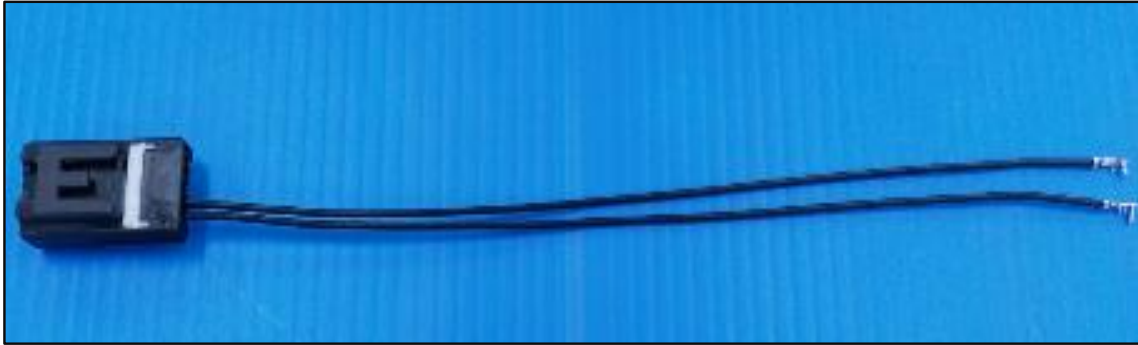

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	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	4	Page No.:	5 of 6

<b>PARTS:</b>		1. Assy parts		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>4</b> <b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
5	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> 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.</div> <div><b>Document reference/s:</b> 1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension</div>		

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**WORK INSTRUCTION**

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Car Model:

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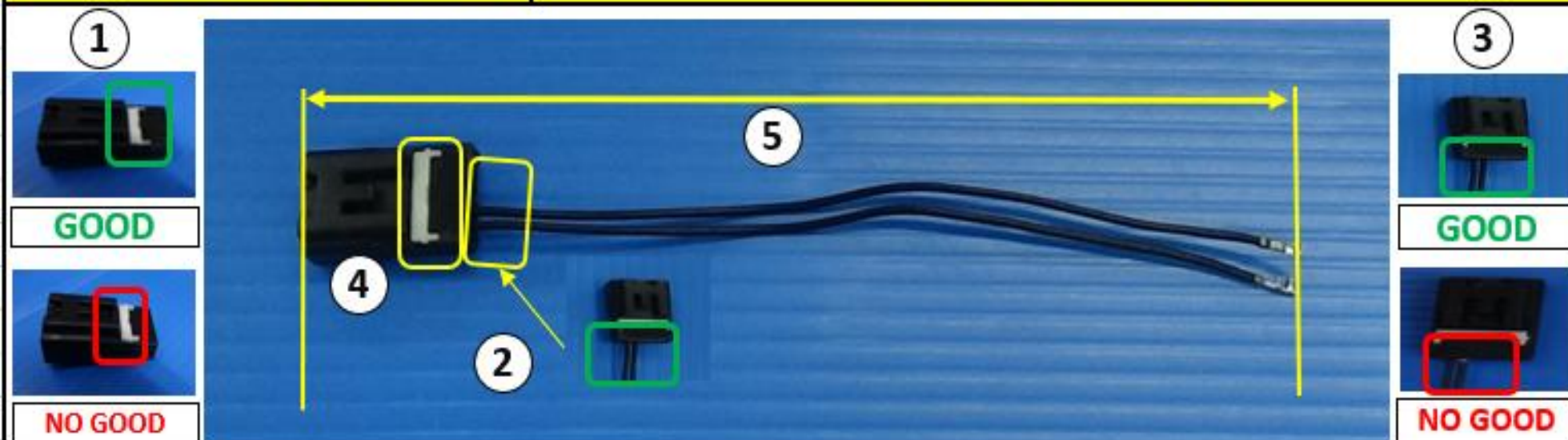
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7M0596-7020B****1 No Unlock connector****3 No Terminal Backing Out****2 No Wrong insert****4 No Deform terminal****5 Check the Alignment**

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