



WORK INSTRUCTION

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

June 27, 2024

Validity Date:

n/a

Model code/Part number:

241B / 7L0050-7023

Customer:

TRQSS

Car Model:

LEXUS ES

Document No.:

WI-ENG-PDE-190

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1. Connector 6098-3810(W); AVSSf 0.3 B L=358mm; Black corrugated tube Ø5, L=267+3mm

JIG:

1. Insertion jig
2. Locking jig

NO.

PROCESS NAME

1

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

TABLE LAY-OUT



Safety Instruction

Be sure to wear prescribed 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.

1. No missing parts/tools
2. No excess parts/tools

Revision History

Prepared by

Reviewed by

Approved by

Noted by

06/27/24

1

Change Process name from Kitting to Offline Assembly Process. Removal of terminal cover jig and Improve measurement and visual inspection/quality checkpoint.

A. Hernandez

C. Villanueva

A. Arañes

n/a

02/11/21

0

Transfer process owner from Production (WI-PRO-ASY-091) to Engineering (WI-ENG-PDE-190). Exclude wire insertion to connector process from Taping assembly to Kitting assembly process due to balancing concern.

J. Loterte

R. Peñaloza

Shimamura

A. Arañes

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

February 11, 2021

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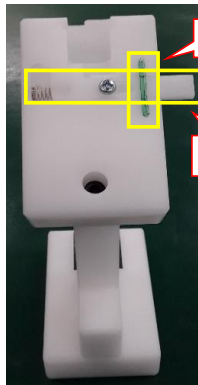

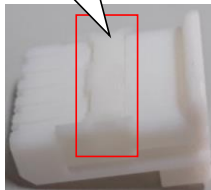
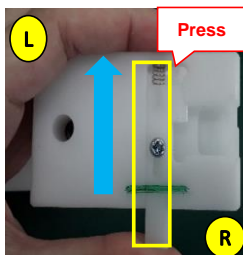
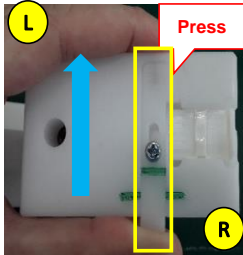
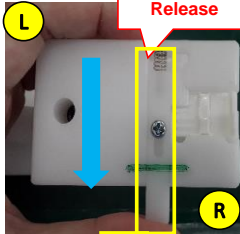
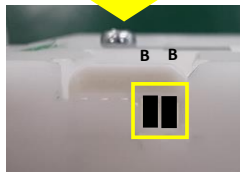


☒ MASSPRO

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PARTS:	1. Connector 6098-3810 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	n/a Connector setting to Insertion jig 6098-3810 (W)	<div><div><div>Insertion Jig</div><div></div><div></div><div></div><div>Connector orientation</div></div><div><div><div><div>L</div><div>Press</div></div><div></div><div><div><div>L</div><div>Release</div></div><div></div></div><div>1. Press the button using left thumb and insert the connector 6098-3810 (W) using right hand, release after insertion.</div></div></div><div>n/a</div><div><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><div>Connector Orientation Illustration</div><div><div><div>I-mark is align</div><div>2 Holes are widely open</div></div><div><div>I-mark is not align</div><div>No holes are open</div></div></div></div></div></div>		

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PARTS:		1. Black Corrugated tube Ø5, L=267±3mm (no slit) 2. Black wire L=358mm		JIG:	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a	<div></div> <div>1. Get black corrugated tube Ø5 L=267±3mm using left hand and insert Black wires L=358mm using right hand.</div>		n/a	1. No wrong use of parts 2. No deformed terminal

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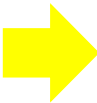

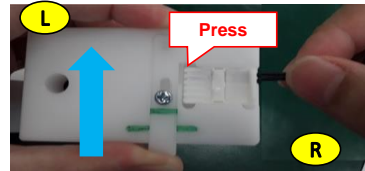




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PARTS:		1. AVSSf 0.3 wires B L=358mm [2pcs] 2.Connector 6098-3810 (W)		3.Assy parts		JIG:	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	Wire insertion to connector 6098-3810 (W) n/a		<div><div>Wire facing</div></div> <div><div><div>1. Black</div></div><div></div><div><div>2. Black</div></div></div> <div>1. Get Black wires and insert to terminal slot using right hand. Conduct one by one insertion from left to right.</div> <div><div><div>Press</div></div><div>2. Press the button using left hand, remove the harness using right hand.</div></div>			n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing.</div> Important reminders/note/s: <div>1. Please hold the wire near terminal during insertion.</div> <div>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div>
5	Connector Lock		<div><div></div></div> <div>1. Press the connector into locking jig using right thumb. Touch the connector to confirm if properly locked.</div> <div><div><div>Before pressing</div></div><div><div>After pressing</div></div></div>			<div><div>Locking jig</div></div>	<div>1. No Unlock/ No Half-locked connector</div> Important reminders/note/s: <div>1. Use provided jig tool per model to avoid damaged lock.</div> Document reference/s: <div>1. Please refer to GL-PRO-ASY-017 for the verification of connector lock.</div>

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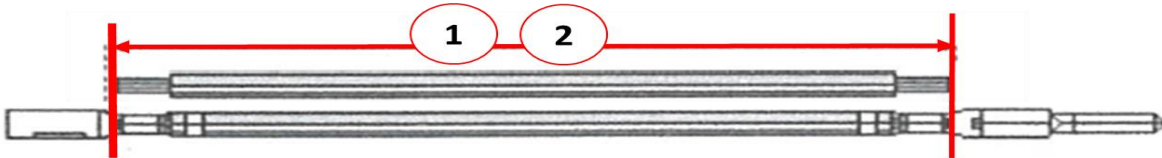

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PARTS:		1. Black Corrugated tube Ø5, L=267±3mm (no slit) 2. Black wire L=358mm		JIG:	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	1 QUALITY POINTERS
6	n/a	Note: 1. Measurement point: End of core wire to the end of core wire 2. Terminal is reference only.		<div>MEASURING TAPE</div> 	Important reminders and note/s: 1. Please use calibrated /verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono. Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection.
		<div>1</div>  			
	Measurement				1.No wrong dimension

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PARTS:

n/a

JIG:

n/a



VISUAL INSPECTION/QUALITY CHECKPOINTS

OFFLINE INSERTION

7L0050-7023

1



GOOD

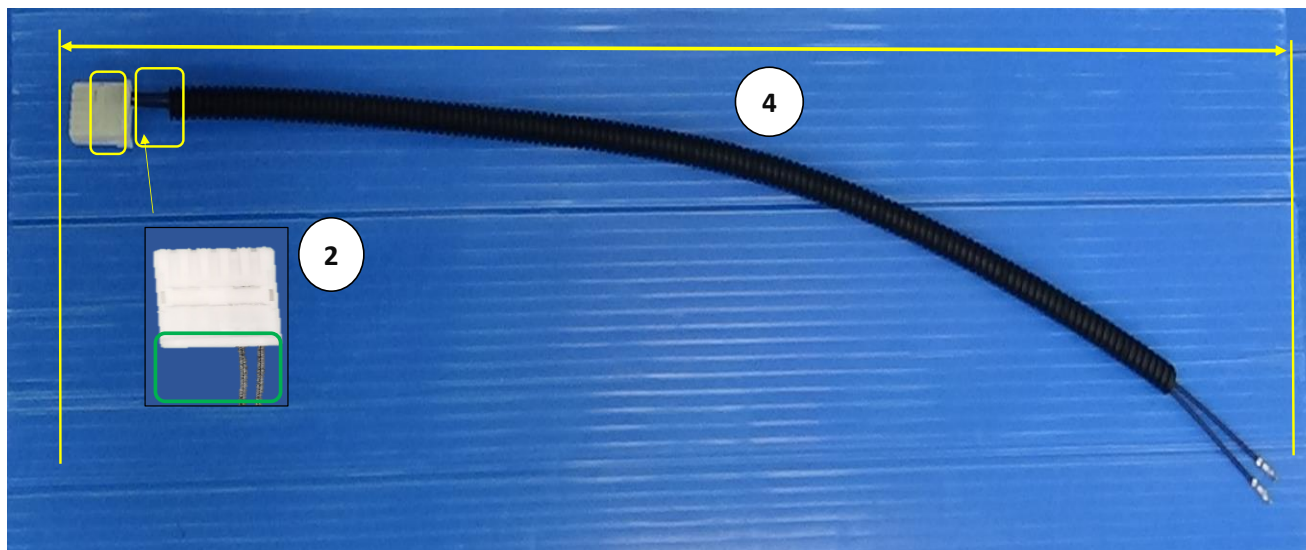


NO GOOD

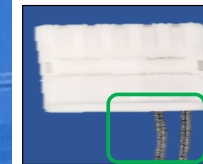
2



4



3



GOOD



NO GOOD

1

No **Unlock** connector

3

No **Terminal Backing Out**

2

No **Wrong insert**

4

Check the **Alignment**

5

No **Deform terminal**

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