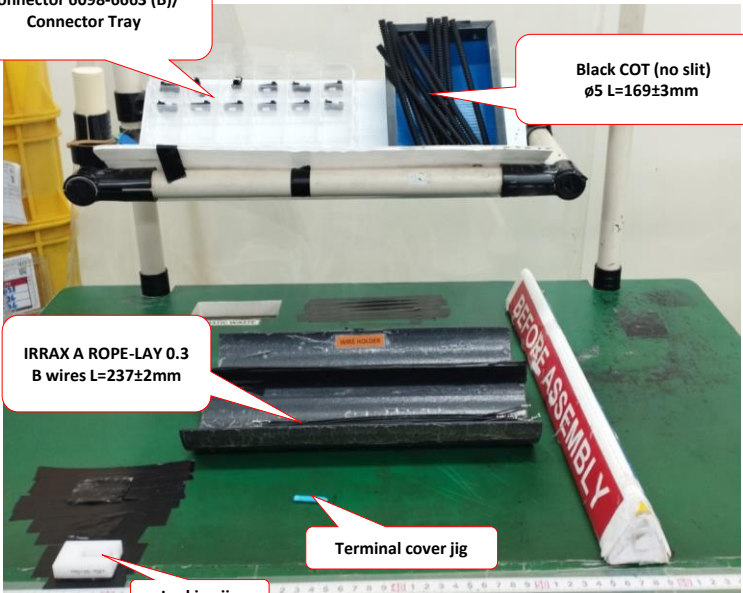
	<b>WORK INSTRUCTION</b>				Effectivity Date:		December 21, 2023	
	Process Name/Title: <b>OFFLINE ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Model code/Part number: <b>200D/220D/7R0125-7022</b>		Customer: <b>TRMX</b>		Car Model: <b>TOYOTA-SEQUOIA</b>		Document No.: <b>WI-ENG-PDE-744</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		0	Page No.:


<b>PARTS:</b>		1. All parts: Connector 6098-6663 (B); IRRAX A ROPE-LAY 0.3 B wires L=237±2mm; Black COT (no slit) ø5 L=169±3mm				<b>JIG:</b>		1. Terminal cover 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	n/a	<div style="text-align: center;"> <b>Table Lay-out</b> </div> 				<div style="border: 1px dashed red; padding: 5px;"> <b>Safety Instruction</b>            Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div style="border: 1px dashed red; padding: 5px;"> <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 style="border: 1px dashed red; padding: 5px;"> <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 WI-PRO-CNC-017 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
12/21/23	0	Initial issue.	D.Castillo	J. Loterte	C. Villanueva	A. Arañes	D. Castillo	J. Loterte	C. Villanueva	A. Arañes	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	December 21, 2023			

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	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>December 21, 2023</b>		
	Process Name/Title: <b>OFFLINE ASSEMBLY PROCESS</b>			Validity Date:	<b>n/a</b>		
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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	<b>0</b>	Page No.:	<b>2 of 4</b>


<b>PARTS:</b>	1. Connector 6098-6663 (B) 2. IRRAX A Rope-lay 0.3 B wires L=237±2mm [2pcs.]			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	n/a	Wire insertion to connector 6098-6663 (B)			<div>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</div> <div><b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal.</b> <b>2. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b></div> <div><b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b> <b>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b></div>

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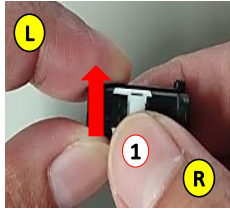
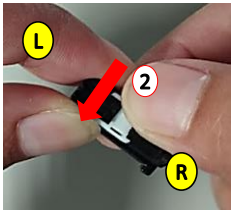







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	Model code/Part number: <b>200D/220D/7R0125-7022</b>		Customer: <b>TRMX</b>	Car Model: <b>TOYOTA-SEQUOIA</b>	Document No.:	<b>WI-ENG-PDE-744</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	3 of 4

<b>PARTS:</b> 1. Assy parts 2. Black Corrugated tube ø5 L=169±3mm (no slit)		JIG: 1. Terminal cover jig 2. Locking jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>
3	Connector lock	 <div> <p>1. Put the connector into locking jig using right hand then press to lock <b>2x</b> using both hands. Touch the connector lock if properly locked.</p> </div>   <div> <p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p> </div>  <div> <p>BEFORE PRESSING</p> </div>  <div> <p>AFTER PRESSING</p> </div>	<b>LOCKING JIG</b> 
<i><b>Important reminders/Note/s:</b></i> <b>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b>  1. Use the provided jig per connector 2. No unlock/half-locked connector			
4	Wire insertion to black corrugated tube ø5 L=169±3mm (no slit)	 <div> <p>1. Get the terminal cover jig using right hand then insert the <b>B-B wires</b>.</p> </div>  <div> <p>2. Get the Corrugated tube ø5 L=169±3mm (no slit) using right hand then insert the <b>B-B wires</b>.</p> </div>  <div> <p>3. After insertion, remove the terminal cover jig using right hand.</p> </div>	<b>TERMINAL COVER JIG</b> 
1. No deformed terminal 2. No wrong usage of parts			

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**WORK INSTRUCTION**

Process Name/Title:

**OFFLINE ASSEMBLY PROCESS**

Effectivity Date:

December 21, 2023

Model code/Part number:

**200D/220D /7R0125-7022**

Customer:

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Car Model:

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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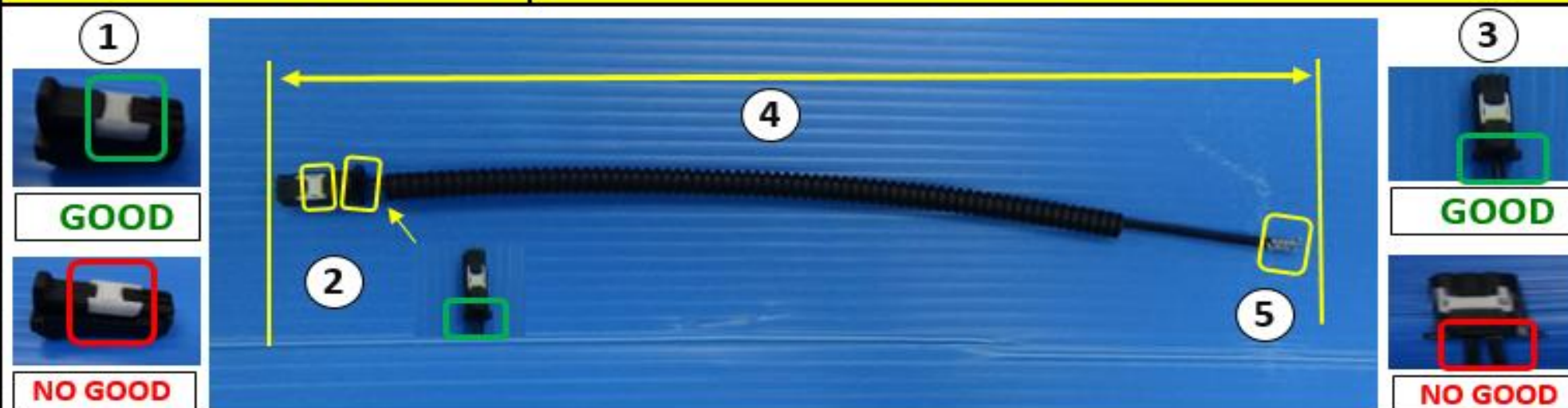
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**PARTS:**

Assy parts

JIG:

n/a

**QUALITY CHECKPOINTS****OFFLINE INSERTION****7R0125-7022****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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