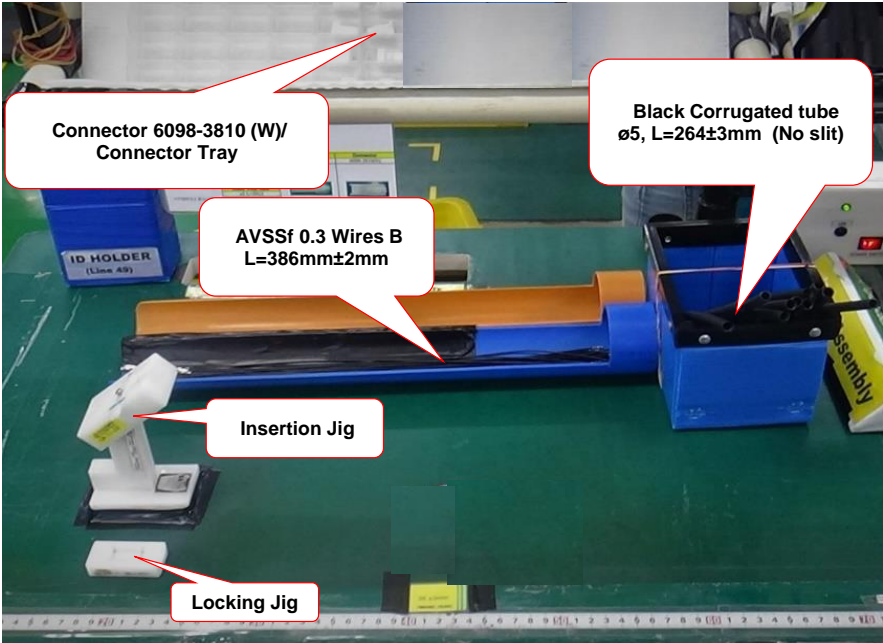
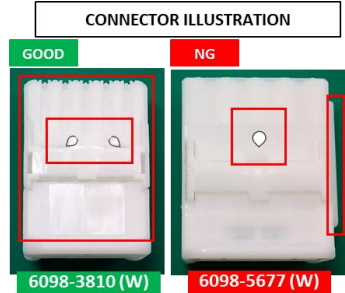


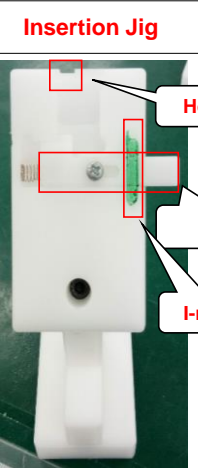


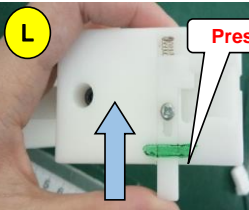
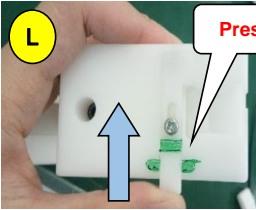
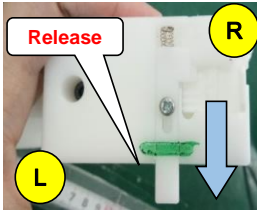

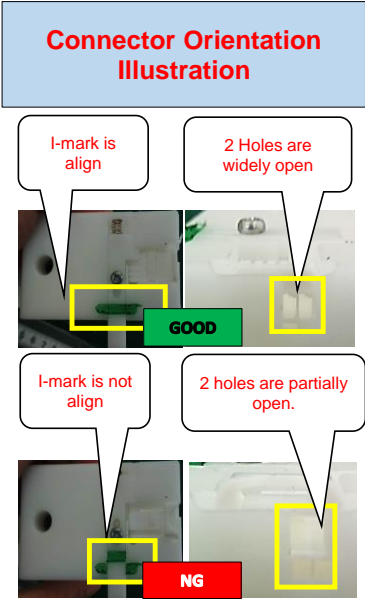
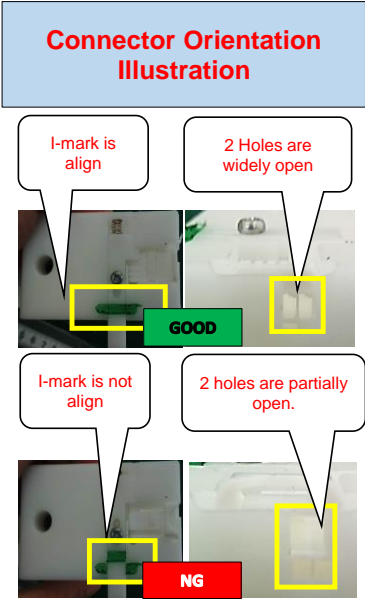
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	Process Name/Title:				Validity Date:	n/a		
	Model code/Part number: 240B / 7M0487-7020C		Customer: TRJ	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-821		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	1 of 7

PARTS:	1. All parts: Connector 6098-3810 (W); AVSSf 0.3 Wires B L=386mm±2mm; Black Corrugated tube ø5, L=264±3mm (No slit)				JIG:	1. Insertion jig 2. Locking jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS	
1	Offline	<div> <div>Table Lay-out</div>  </div>				<div> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	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 <div> CONNECTOR ILLUSTRATION  </div>	

Revision History								Prepared by	Reviewed by	Approved by	Noted by
05/24/14	0	Initial issue.				D. Castillo	C. Villanueva	A. Arañes	n/a		
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	May 24, 2024

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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	Offline Connector Setting to Insertion jig 6098-3810 (W)	<div><div><p>Insertion Jig</p><p>Holes</p><p>Lock</p><p>I-mark</p></div><div><p>Insertion Jig Orientation</p></div><div><p>Connector Orientation</p></div><div><p>L Press</p><p>1. Press the lock of insertion jig using left thumb.</p></div><div><p>L Press</p><p>2. Insert the connector 6098-3810 (W) into jig using right hand and release the lock.</p></div><div><p>R Release</p><p>L</p><p>3. Check the holes/terminal slot for B-B wires.</p></div><div></div></div> <td>n/a</td> <td colspan="3"><div><p>Connector Orientation Illustration</p><p>I-mark is align</p><p>2 Holes are widely open</p><p>GOOD</p><p>I-mark is not align</p><p>2 holes are partially open.</p><p>NG</p></div><p>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p></td>			n/a	<div><p>Connector Orientation Illustration</p><p>I-mark is align</p><p>2 Holes are widely open</p><p>GOOD</p><p>I-mark is not align</p><p>2 holes are partially open.</p><p>NG</p></div> <p>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p>		


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	Model code/Part number: 240B / 7M0487-7020C		Customer: TRJ	Car Model: LEXUS-ES	Document No.:		WI-ENG-PDE-821	
	Purpose: <input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:		0	Page No.:


PARTS:		1. Black Corrugated tube ø5, L=264±3mm (No slit) 2. AVSSf 0.3 Wires B L=386mm±2mm [2pcs]			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	Offline	<div></div> <div>1. Get black corrugated tube ø5 L=264±3mm using left hand and insert Black wires L=386±2mm using right hand.</div>			n/a	1. No wrong use of parts 2. No deformed terminal


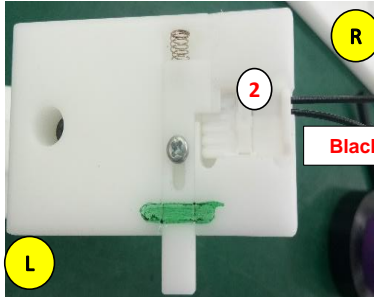
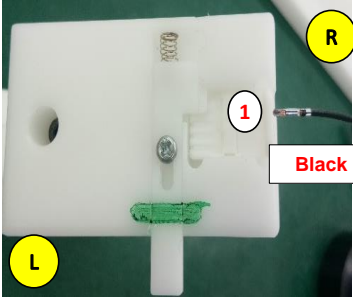
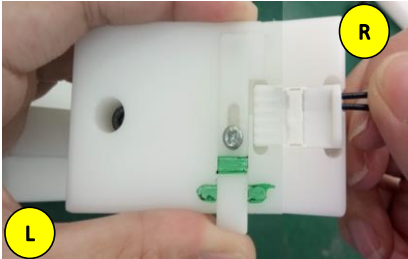
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PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Offline Wire Insertion to Connector 6098-3810 (W)	<div><div>Wire facing</div></div> <div></div> <div></div> <div>1. Get the first Black wire and insert to Slot 1 of connector using right hand.</div> <div>2. Get the 2nd Black wire and insert to Slot 2 of connector using right hand.</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>		n/a	<div>1. No loose insertion 2. No wrong dimension 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>Important reminders/Note/s: 1. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force. 2. Please hold the wire near terminal during insertion. 3. Insertion of wire must be from left to right</div> <div>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip lenght tolerance. 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>

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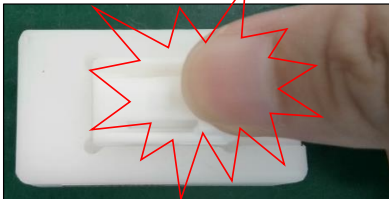


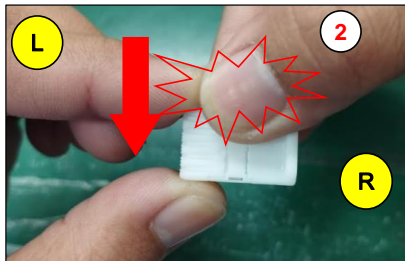
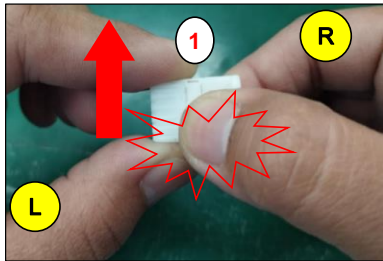

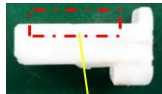
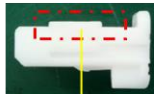
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PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Offline Connector lock	<div></div> <div> Before Pressing</div> <div> After Pressing</div> <div>1. Put the connector into locking jig using right hand then press to lock 2x.</div> <div></div> <div>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</div>	<div>Locking jig</div> <div></div>	<p>Important reminders/Note/s:</p> <p>1. Manual locking may cause damaged connector lock.</p> <p>1. Use provided jig tool per model to avoid damaged lock. 2. No Unlock and half-locked connector 3. No damaged lock</p> <div>LOCK CONDITION</div> <div> GOOD Fully Locked</div> <div> NG UnLocked</div>

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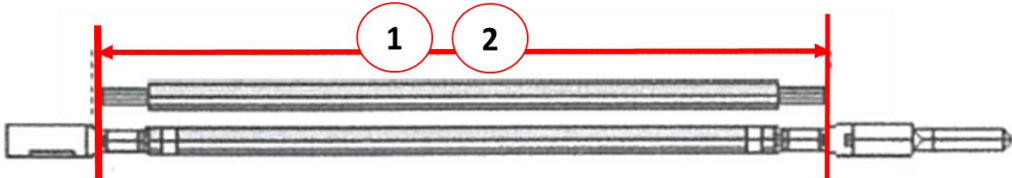

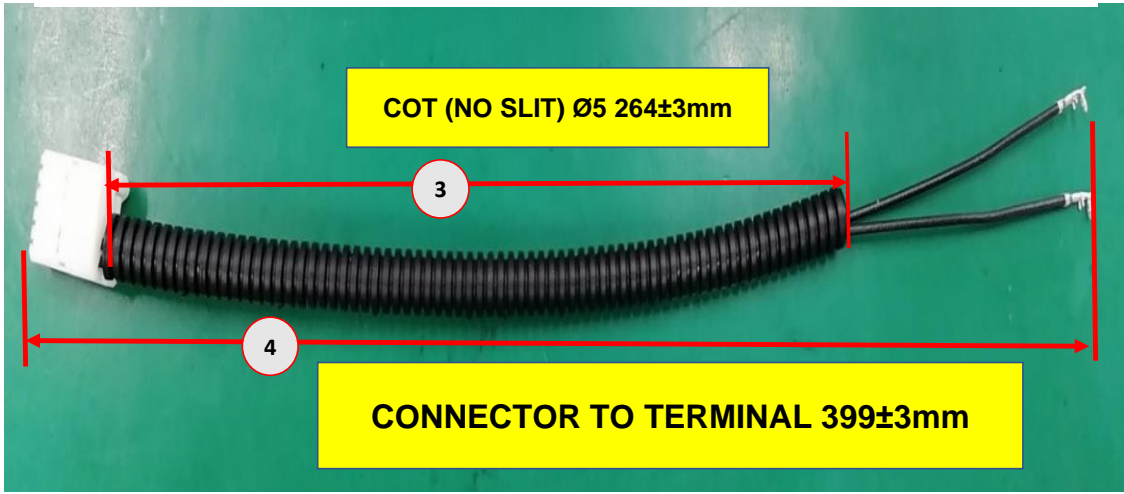
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PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	Offline	Measurement	<div>Note: 1. Measurement point: End of core wire to the end of core wire 2. Terminal is reference only.</div> <div></div>	<div><div>MEASURING TAPE</div><div></div></div> <div><div>Important reminders and note/s:</div><div>1. Please use calibrated /verified measuring tape when getting the measurement.</div><div>2. For Hatsumono, Nakamono and Owarimono.</div></div> <div><div>Document reference/s:</div><div>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection.</div></div>
			<div></div> <div><div>COT (NO SLIT) Ø5 264±3mm</div><div>3</div><div>4</div><div>CONNECTOR TO TERMINAL 399±3mm</div></div>	<div>1.No wrong dimension</div>

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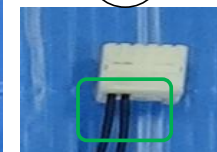
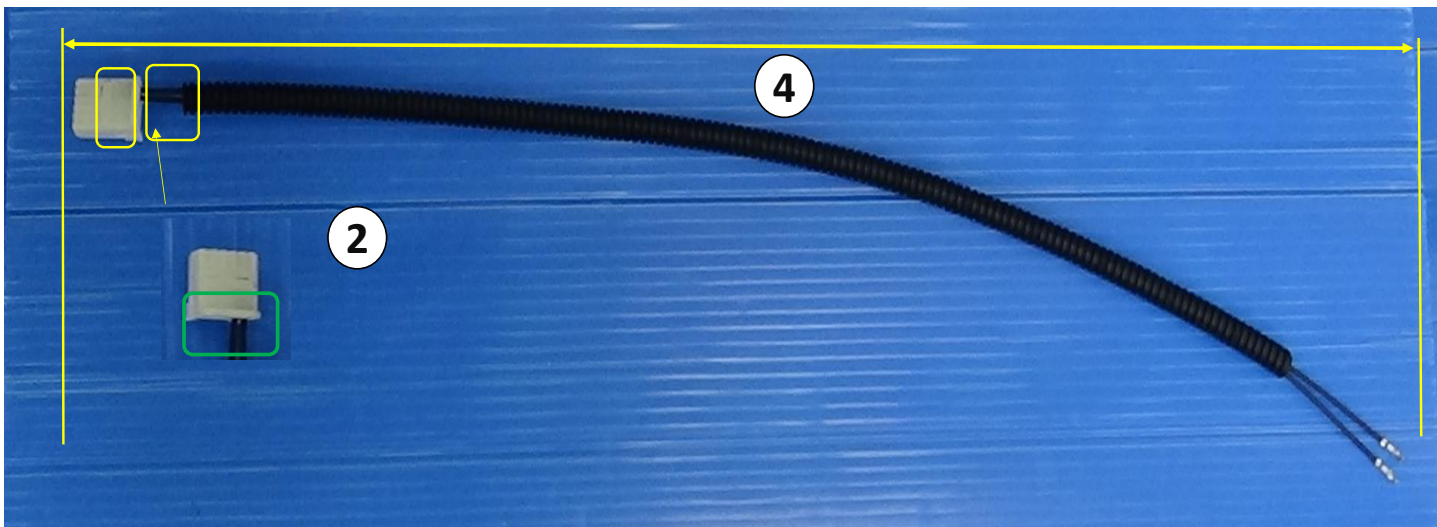
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION**OFFLINE INSERTION****7M0487-7020C****1****GOOD****NO GOOD****2****3****GOOD****NO GOOD****4****1****No Unlock/Halflocked connector****2****No Wrong insert****3****No Terminal Backing Out****4****Check the Alignment**

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