



WORK INSTRUCTION

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

July 10, 2024

Validity Date:

n/a

Model code/Part number:

200D

/

7R0124-7020

Customer:

TRMX

Car Model:

TOYOTA SEQUOIA

Document No.:

WI-ENG-PDE-705

Purpose:

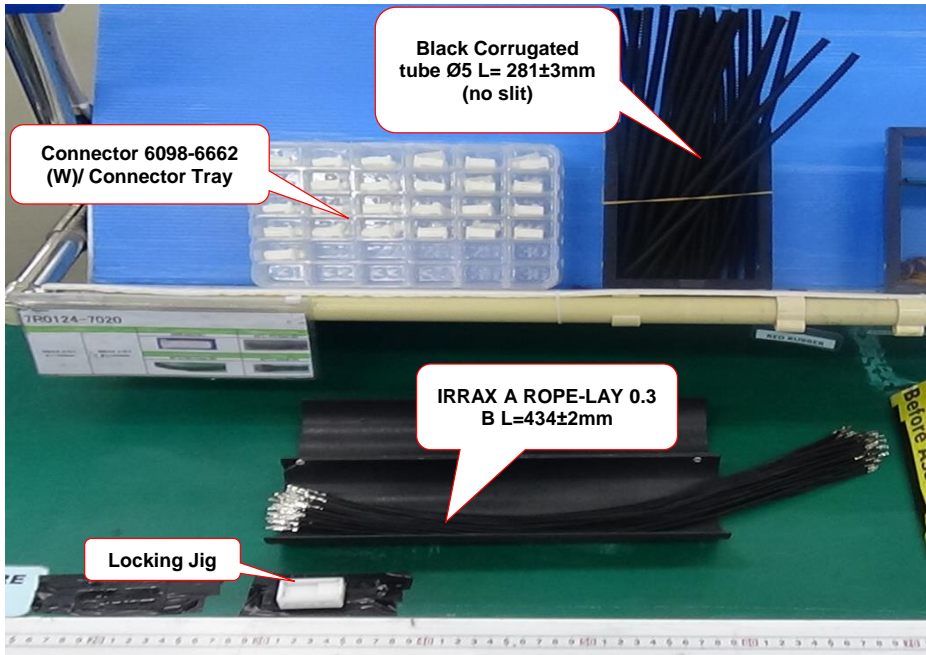
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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PARTS:	1. Connector 6098-6662 (W); IRRAX A ROPE-LAY 0.3 B L=434±2mm; Black Corrugated tube Ø5 L= 281±3mm (no slit)				JIG:	1.Locking jig							
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS						
1	n/a	<div>TABLE LAY-OUT</div>  <div>Connector 6098-6662 (W) Connector Tray</div> <div>Black Corrugated tube Ø5 L= 281±3mm (no slit)</div> <div>IRRAX A ROPE-LAY 0.3 B L=434±2mm</div> <div>Locking Jig</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>	<div>Document reference/s: 1. Please refer to WI-PRO-CNC-017 for Wire and Stip length procedure</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>						
Revision History													
07/10/24	1	Improve measurement and visual inspection. Removal of terminal cover jig				A.Hernandez	C. Villanueva	A. Arañes	n/a	Prepared by	Reviewed by	Approved by	Noted by
07/29/23	0	Initial Issue. Excluded process from WI-ENG-PDE-449; Change MP from 1MP to 2MP with Offline Assembly process due to new process distribution; Updated template; inclusion of CAR MODEL "TOYOTA SEQUOIA" (Please refer to ENGDRR-132 for Document revision request)				M. Ariola	J. Loterte	C. Villanueva	A. Arañes	A.Hernandez	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	July 29, 2023		

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PARTS:		1.IRRAX A ROPE-LAY 0.3 B L=434±2mm 2. Black Corrugated tube ø5 L=281±3mm (No slit)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	n/a	<div></div> <div>1.Get black corrugated tube ø5 L=281±3mm (no slit) using left hand and insert IRRAX A ROPE-LAY 0.3 B L=434±2mm using right hand.</div>		n/a	1. No wrong usage of parts 2. No deformed terminal

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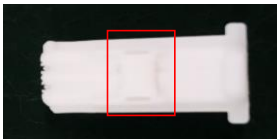

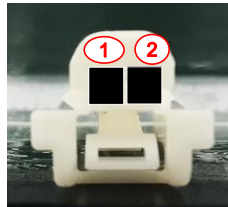
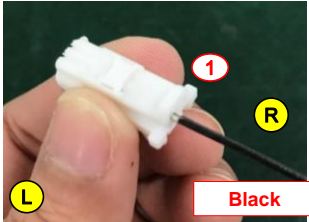
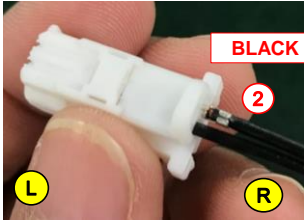
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PARTS:		1. Connector 6098-6662 (W) 2. IRRAX A ROPE-LAY 0.3 B L=434±2mm [2pcs]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a Wire insertion to Connector 6098-6662 (W)	<div><p>CONNECTOR ORIENTATION</p></div> <div><p>WIRE FACING</p></div> <div><p>VISUAL REFERENCE</p></div> <div><p>Black</p></div> <div><p>BLACK</p></div> <div><p>1. Hold the connector using left hand. Get the first Black wire then insert to terminal slot 1 using right hand. Note: Conduct Pull-Push-Pull-Push after insertion NOTE: Insertion of wire must be from left to right.</p></div> <div><p>2. Get the second Black wire and insert to terminal slot 2 using right hand. Note: Conduct Pull-Push-Pull-Push after insertion</p></div>		n/a	<p>1. No wrong insertion 2. No loose insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p>Important reminders/Note/s:</p> <p>1. Insertion of wire must be from left to right. 2. Please hold the wire near terminal during insertion 3. Make sure wires are properly inserted . Conduct Pull-Push-Pull-Push after insertion Do not exert extra force. 4. This connector has NO DOUBE LOCK, proper insertion method must be followed.</p> <p>Document reference/s:</p> <p>1. Please refer to WI-PRO-CNC-017 for Wire and Stip length procedure</p> <p>2. Please refer to GL-PRO-ASY-029 for Push-Pull procedure.</p>

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200D**/****7R0124-7020**

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TRMX

Car Model:

TOYOTA SEQUOIA

Purpose:

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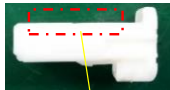
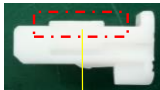
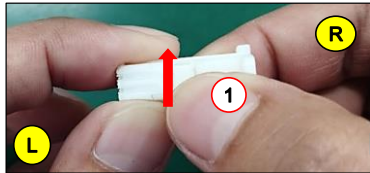
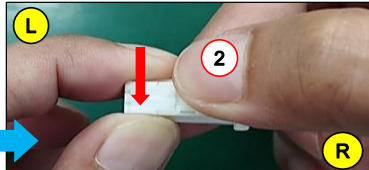
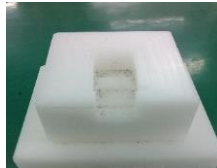
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PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	n/a	<div><div></div><div><p>1. Put the connector into locking jig using both hands then press 2x to lock using both hands.</p></div><div><div><div></div><div></div></div><div><div><div></div><div></div></div><div><div>Fully Locked</div><div>Unlocked</div></div></div></div></div> <div><div><div></div><div></div></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>	<div><div>Locking jig</div></div>	<p>Important reminders/Note/s:</p> <p>1. Manual locking may cause damaged connector lock.</p> <p>1. Use the provided jig per connector 2. No unlock/half-locked connector</p>

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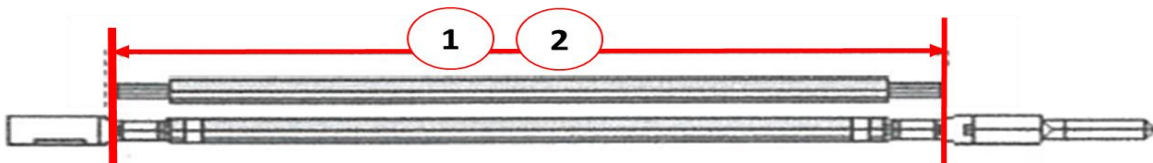
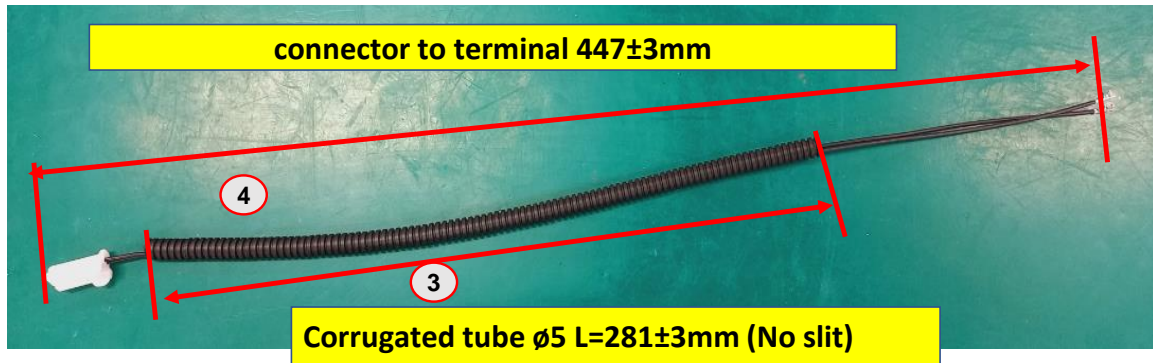
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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

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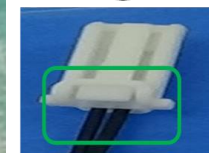
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL/QUALITY POINTERS****OFFLINE****7R0124-7020****1****GOOD****NO GOOD****2****3****GOOD****NO GOOD****1****No Unlock Connector****2****No Terminal Backing Out****3****No Deformed terminal****4****Check the Alignment**

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