

	<b>WORK INSTRUCTION</b>						Effectivity Date:		September 4, 2024	
	Process Name/Title: <b>OFFLINE ASSEMBLY PROCESS</b>						Validity Date:		n/a	
	Model code/Part number: <b>220D / 7R0130-7022</b>		Customer: <b>TRMX</b>		Car Model: <b>LEXUS LM</b>		Document No.: <b>WI-ENG-PDE-566</b>			
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.: <b>2</b>		Page No.: <b>1 of 7</b>	

<b>PARTS:</b>		1. Connector 6098-3802 (W); AVSSf 0.3 G-V wires L=719±3mm; Black corrugated tube (No slit) Ø5 L=88±3mm				JIG:		1. Insertion jig 2. Locking jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<div style="border: 1px solid black; padding: 5px; display: inline-block;">2</div> <b>WORK PROCEDURE/ ILLUSTRATION</b>				<b>TOOLS/PPE</b>		<b>QUALITY POINTERS</b>	
1	Offline  Table Lay-out	<div style="border: 1px solid black; padding: 10px; margin-bottom: 10px;"> <b>TABLE LAY-OUT</b> </div>				<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <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. Please refer to <b>WI-PRO-CNC-017</b> for Wire and Strip length tolerance.	
						<div style="border: 1px solid black; padding: 2px;">CONNECTOR ILLUSTRATION</div>		<div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <div style="background-color: green; color: white; padding: 2px; font-weight: bold;">GOOD</div> <div style="background-color: green; color: white; padding: 2px; font-weight: bold;">6098-3802 (W)</div> </div> <div style="text-align: center;"> <div style="background-color: red; color: white; padding: 2px; font-weight: bold;">NG</div> <div style="background-color: red; color: white; padding: 2px; font-weight: bold;">6098-5668 (W)</div> </div> </div>	

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
09/04/24	2	Installation of switch cover to insertion jig. Inclusion of car model "LEXUS-LM" and Measurement. Improved Visual Inspection/Quality checkpoints.	D.Castillo	C. Villanueva	A.Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a					
09/23/22	1	Improve: Work procedure/Illustration on process no. 4 and 5; Quality pointers and notes on pg. no. 1, 2,3,4, and 5	M.Ariola	J. Loterte	C. Villanueva	A.Arañes									
07/26/22	0	Initial Issue. Exluded from (WI-ENG-PDE-563) due to process improvement. Additional Table Lay-out	M.Ariola	J. Loterte	C. Villanueva	A.Arañes									
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	July 24, 2022							


  

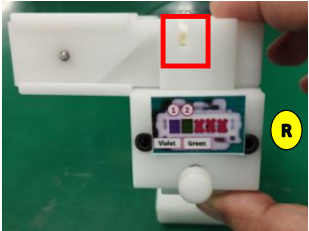
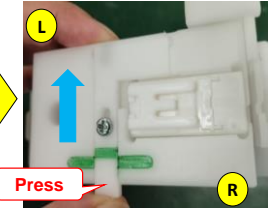
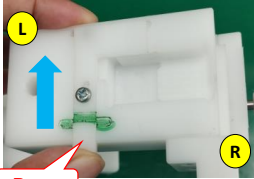
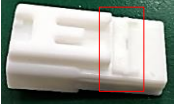
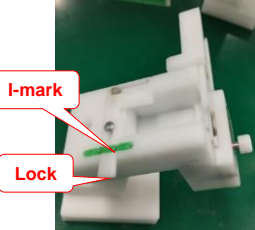
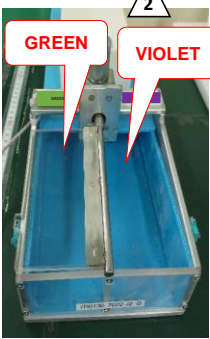

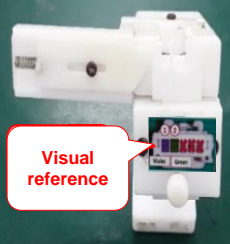
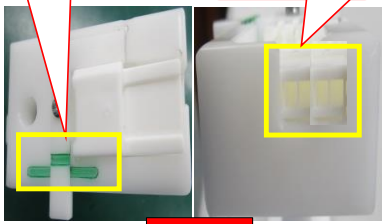
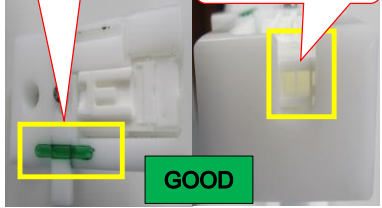
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	WORK INSTRUCTION			Effectivity Date:	September 4, 2024		
	Process Name/Title: OFFLINE ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 220D / 7R0130-7022		Customer: TRMX	Car Model: LEXUS LM	Document No.: WI-ENG-PDE-566		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	2	Page No.:	2 of 7

PARTS:	1. Connector 6098-3802 (W)			JIG:	1. Insertion jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
2	Offline	<div>Connector setting to insertion jig 6098-3802 (W)</div> <div><p>1. Press the lock of insertion using left hand.</p><p>2. Get the connector 6098-3802 (W) using right hand then insert to insertion jig. Release the lock after insertion. <i>Note: Follow the connector orientation.</i></p><p>3. Push the lower wire guide upward using right hand. Slot for <b>Violet wire</b> will be opened.</p></div>		N/A	<div>Connector Orientation Illustration</div> <div><p>1. Use the provided jig per model</p><p>2. No wrong orientation of connector</p><p>3. No wrong use of connector</p><p>4. No damaged connector</p></div>		

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## OFFLINE ASSEMBLY PROCESS

Effectivity Date:

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Model code/Part number:

220D / 7R0130-7022

Customer:

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Car Model:

LEXUS LM

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☐ PROTOTYPE

☐ PRE-LAUNCH


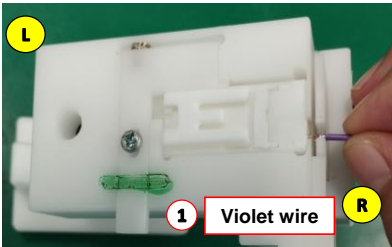
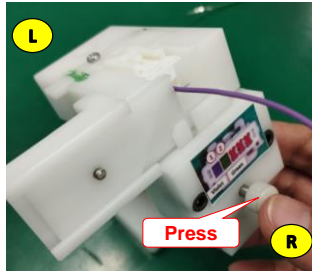
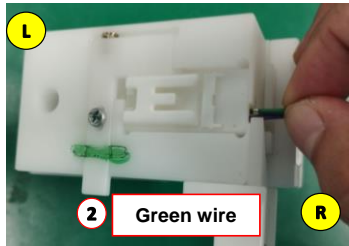
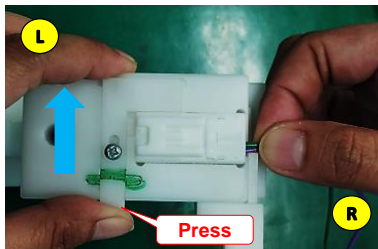
☒ MASSPRO

Revision No.:

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Page No.:

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PARTS:	1. AVSSf 0.3 V-G wires L=719±3mm		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Offline	<div><div><div><p>Wire facing</p></div></div><div><div><div><p>1. Hold the insertion jig using left hand. Get the <b>Violet</b> then insert to terminal slot <b>1</b> using right hand.</p></div><div><div><p>2. Press the button using right thumb. The slot for <b>Green wire</b> will be opened.</p></div></div><div><div><div><p>3. Get the <b>Green wire</b> then insert to terminal slot <b>2</b> using right hand.</p></div><div><div><p>4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div></div></div></div></div></div></div>	N/A	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div><b>Important reminders/note/s:</b> 1. <i>Make sure wires are properly inserted.</i>  <i>Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</i></div> <div><b>Document reference/s:</b> 1. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length Tolerance  2. Refer to <b>GL-PRO-ASY-029</b> for Pull-Push procedure.</div>

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Effectivity Date:

**September 4, 2024**

Model code/Part number:

**220D / 7R0130-7022**

Customer:

**TRMX**

Car Model:

**LEXUS LM**

Document No.:

**WI-ENG-PDE-566**

Purpose:




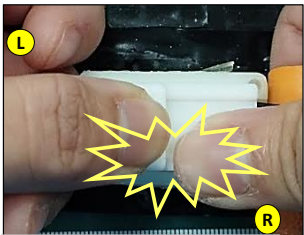

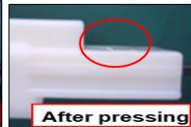
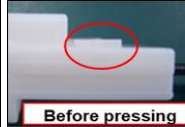

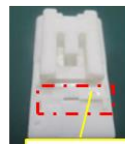

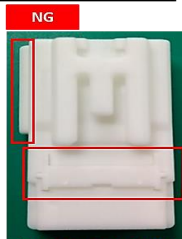
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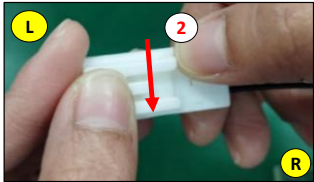
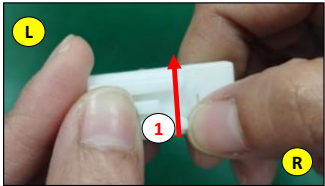

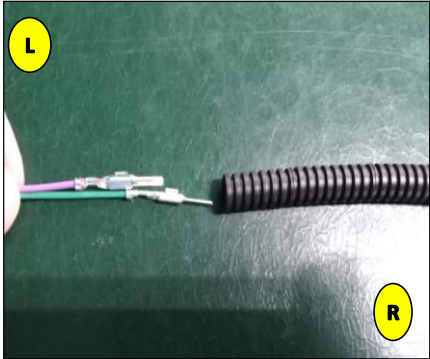
<b>PARTS:</b>		1. Assy parts		JIG:	1. Locking jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
4	Offline Connector lock	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div> <div><p>Right thumb-Lower Left thumb-middle</p><p>Right thumb-upper Left thumb-middle</p><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><b>LOCKING JIG</b> </div>	<div>1. No wrong use of parts 2. No deformed terminal</div> <div><b>Important reminders/note/s:</b> <i>1. Manual locking may cause damaged lock.</i></div> <div><p>Before pressing After pressing</p></div> <div><div><b>GOOD</b> <p>Full Lock</p></div><div><b>NG</b> <p>Half Lock</p></div></div> <div><b>CONNECTOR ILLUSTRATION</b> <div><b>GOOD</b> <p>6098-3802 (W)</p></div><div><b>NG</b> <p>6098-5668 (W)</p></div></div>

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		2	Page No.:


<b>PARTS:</b>		1. Assy parts 2. Black corrugated tube (No slit) Ø5 L=88±3mm		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	Connector lock (Continuation)  Offline	<div><p>5. Lift then press the connector in the middle using left and right hand.</p><p>Right thumb-middle Left thumb-middle</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> 	1. No wrong use of parts 2. No deformed terminal
5	Wire insertion to Black COT Ø5 L=88±3mm (No slit)	<div><p>1. Get the Black COT Ø5 L=88±3mm (No slit) using right hand and insert <b>G-V wires</b> using left hand.</p></div>		N/A	1. No wrong use of parts 2. No deformed terminal

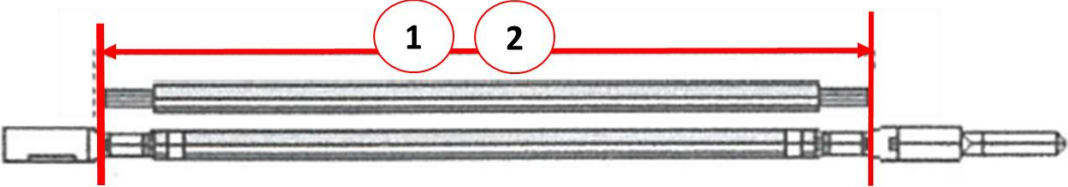


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PARTS:	1. Assy parts			JIG:	1. Locking jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
6	Offline Measurement	<p>Note:</p> <p>1. Measurement point: End of core wire to the end of core wire</p> <p>2. Terminal is reference only.</p>   <p>COT (No slit) Ø5 L=88±3</p> 		MEASURING TAPE	<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>		

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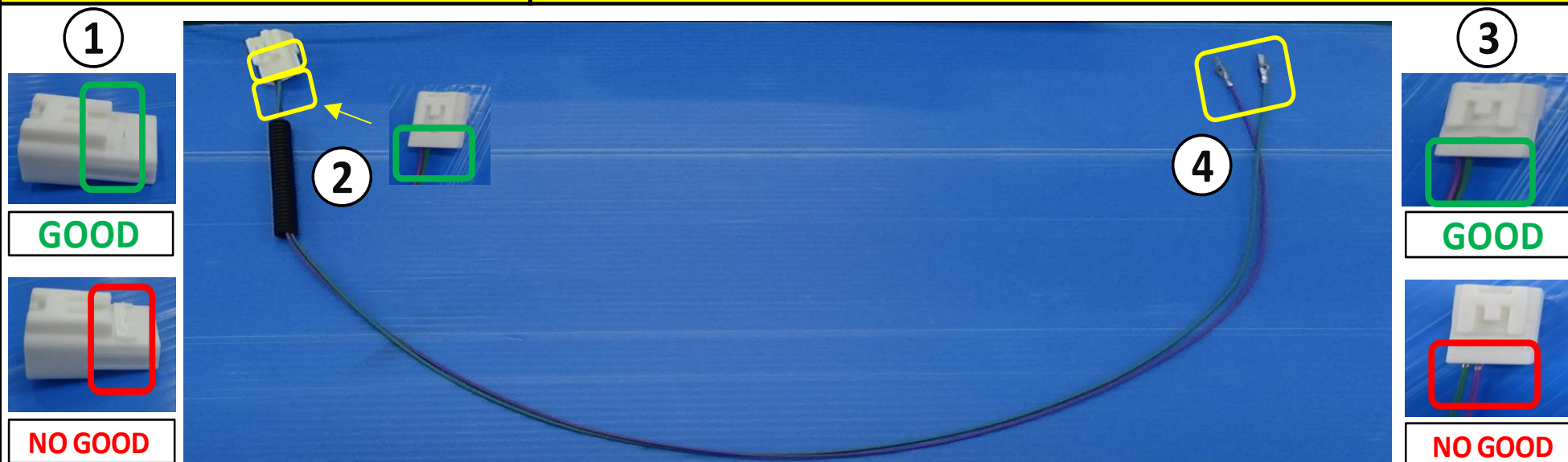
Page No.:

**7 of 7****PARTS:**

1. Assy parts

JIG:

N/A

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7R0130-7022****1****No Unlock connector****3****No Terminal Backing Out****2****No Wrong insert****4****No Deformed terminal**

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