



WORK INSTRUCTION
OFFLINE ASSEMBLY PROCESS

| | | | |
|-------------------|----------------|-----------|--------|
| Effectivity Date: | July 26, 2024 | | |
| Validity Date: | n/a | | |
| Document No.: | WI-ENG-PDE-987 | | |
| Revision No.: | 0 | Page No.: | 1 of 5 |

| | | | |
|-------------------------|--|------------|----------------|
| Process Name/Title: | | | |
| Model code/Part number: | 491D/564D / 7R0150-7020 | Customer: | TRMX |
| | | Car Model: | TOYOTA-SEQUOIA |
| Purpose: | <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO | | |

| | | | | | |
|--------|--|------------------------------|---|--|--|
| PARTS: | 1. Connector 6098-6663 (B): IRRAX A Rope-lay 0.3 B wires L=255±2mm [2pcs.]; Black Corrugated tube ø5 L=187±3mm (no slit) | | | JIG: | 1. Locking jig |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 1 | Offline | Table lay-out | <div><p>Table Lay-out</p><p>Connector 6098-6663 (B)/ Connector Tray</p><p>Black COT (no slit) ø5 L=187±3mm</p><p>IRRAX A ROPE-LAY 0.3 B wires L=225±2mm</p><p>Locking jig</p></div> | <div><p>Safety Instruction</p><p>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p><p>Housekeeping</p><p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p><p>Alert level</p><p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p></div> | <p>1. No missing parts/tools 2. No excess parts/tools</p> <p>Document references:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> |

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|------------------|---------|---|--|--|--|-------------|---------------|-------------|----------|
| Revision History | | | | | | Prepared by | Reviewed by | Approved by | Noted by |
| | | | | | | | | | |
| 07/26/24 | 0 | Initial issue. Separate process from Taping assembly process. | | | | A.Hernandez | C. Villanueva | A. Arañes | n/a |
| Eff. Date | Rev. No | Details of Change | | | | Revised | Reviewed | Approved | Noted |

Est. Date: July 26, 2024

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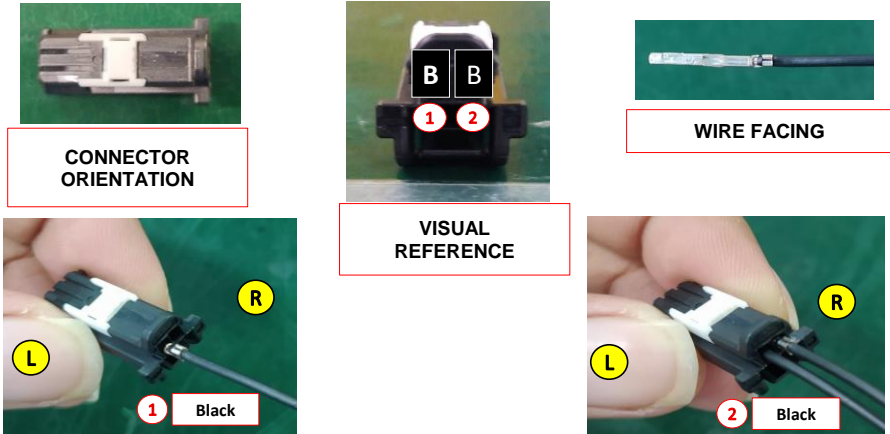
DCC Stamp



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| PARTS: | 1. Connector 6098-6663 (B); 2. IRRAX A Rope-lay 0.3 B wires L=255±2mm [2pcs. 3. Black Corrugated tube ø5 L=187±3mm (no slit) | | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 2 | Wire insertion to Black Corrugated tube ø5 L=187±3mm (no slit) |  <div>1. Get the Black corrugated tube ø5 L=187±3mm (no slit) using left hand and get B-B wires using right hand then insert.</div> | | n/a | 1. No deformed terminal 2. No wrong usage of parts |
| 3 | Wire insertion to connector 6098-6663 (B) |  <div>1. Hold the connector 6098-6663 (B) then get the first Black wire and insert to terminal slot 1 using right hand. Conduct 2x push pull after wire insertion. Note: Make sure to hold the COT using right hand while insertion to prevent deformed in 7D0349 Terminal.</div> <div>2. Hold the connector 6098-6663 (B) then get the second Black wire and insert to terminal slot 2 using right hand. Conduct 2x push pull after wire insertion.</div> | | n/a | 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 Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance |

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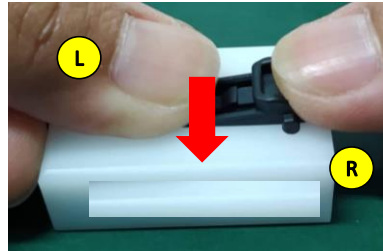
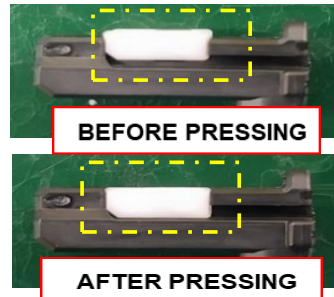
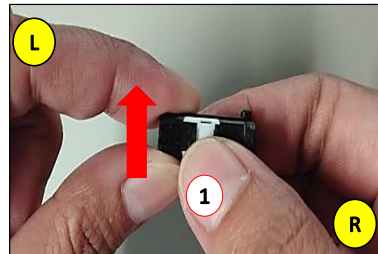
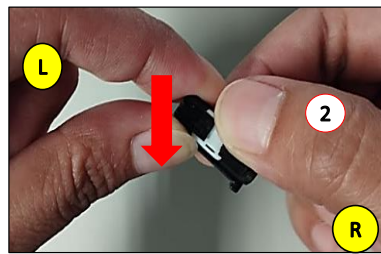

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|--------|---------------------------|---|--|--|--|
| PARTS: | | 1. Assy parts 2. Black tape | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 4 | Offline Connector lock | <div></div> <div>1. Put the connector into locking jig using right hand then press to lock 2x using both hands.</div> <div></div> <div></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>  | <p>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <p>1. Use the provided jig per connector 2. No unlock/half-locked connector</p> |

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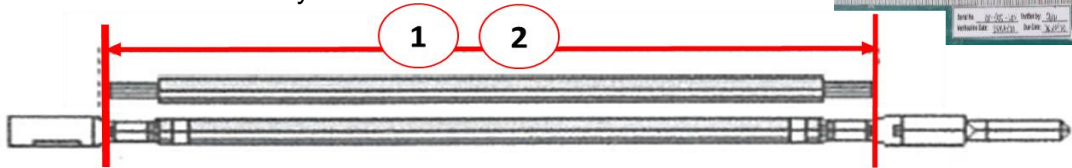

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|--------|---------------|------------------------------|---|------|-----------|--|--|
| PARTS: | 1. Assy parts | | | JIG: | n/a | | |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | | TOOLS/PPE | QUALITY POINTERS | |
| 5 | n/a | Measurement | <p>Note:</p> <ol style="list-style-type: none">1. Measurement point: End of core wire to the end of core wire2. Terminal is reference only.   <p>COT Ø5 L=187±3</p> | | | <p>1. No wrong dimension</p> <p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> | |

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|--------|-----|------|-----|
| PARTS: | n/a | JIG: | n/a |
|--------|-----|------|-----|

VISUAL INSPECTION/ QUALITY CHECKPOINTS

OFFLINE INSERTION

7R0150-7020



1 No Unlocked/Half-locked connector

2 No Terminal Backing Out

3 No Missing COT

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