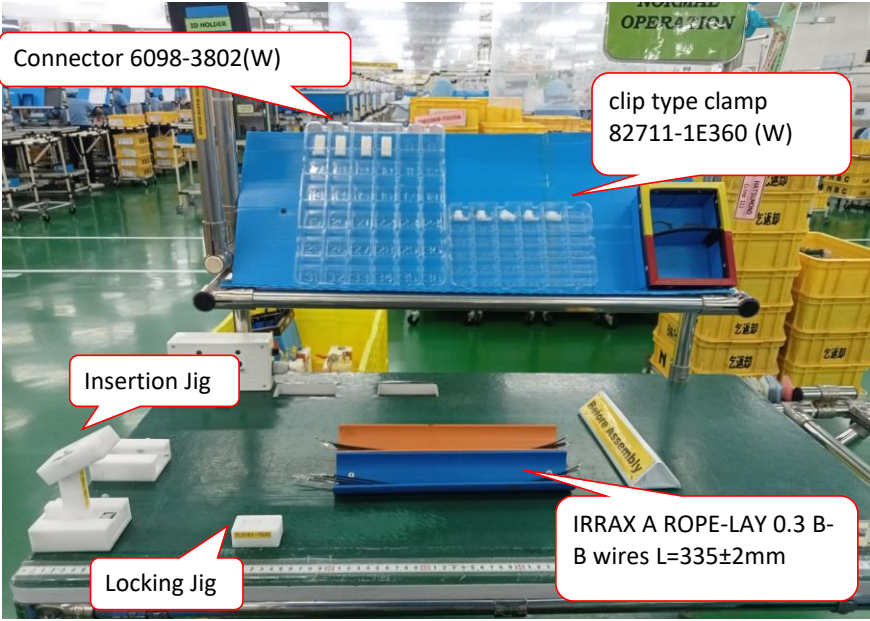
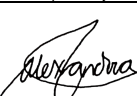
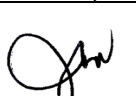
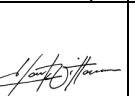
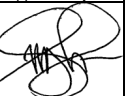
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	OFFLINE ASSEMBLY PROCESS						Validity Date:		n/a	
	Process Name/Title:			Model code/Part number: 400D / 7L0161-7020			Customer: TRQSS		Car Model: TOYOTA-bZ4X(BEV)	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Document No.: WI-ENG-PDE-1262			Revision No.: 0		Page No.: 1 of 7	

PARTS:		1. Connector 6098-3802 3.Clip type clamp 82711-1E360 (W) 2. IRRAX A ROPE-LAY 0.3 B-B wires L=322±2mm [2pcs.]				JIG:		1.Insertion Jig 2.Locking Jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	OFFLINE Table Lay out	<div>TABLE LAY-OUT</div> 				<div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>		<div>Document reference/s:</div> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1.No missing parts 2.No excess parts tools</p>	

Revision History								Prepared by	Checked by	Reviewed by	Approved by		
05/15/25	0	Initial issue				A.Buban	J.Loterte	C.Villanueva	A.Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Checked by	Reviewed by	Approved by	Est. Date:	May 15, 2025		

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# WORK INSTRUCTION

## OFFLINE ASSEMBLY PROCESS

Effectivity Date:

May 15, 2025

Process Name/Title:

Model code/Part number:

400D / 7L0161-7020

Customer:

TRQSS

Car Model:

TOYOTA-bZ4X(BEV)

Validity Date:

n/a

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WI-ENG-PDE-1262

Purpose:



PROTOTYPE



PRE-LAUNCH



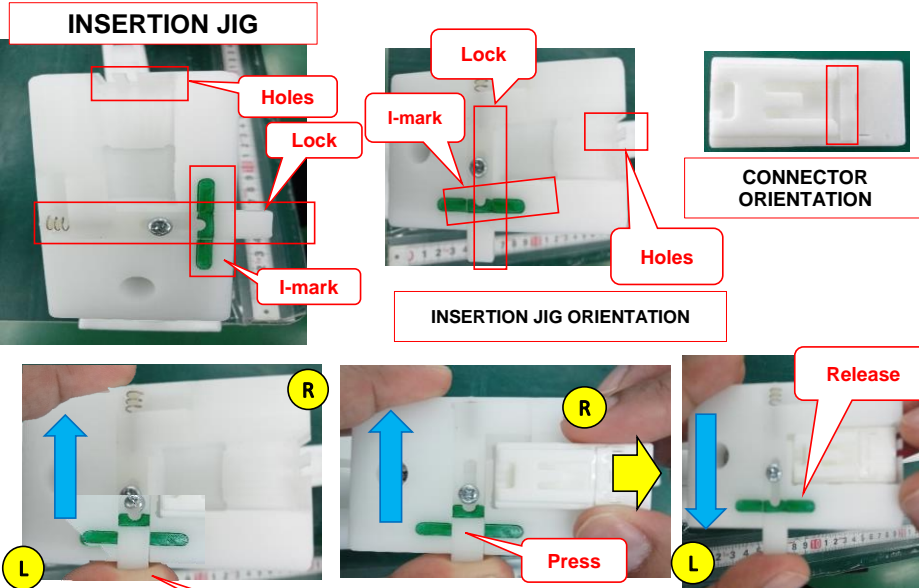

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PARTS:		1.connector 6098-3802 (W)		JIG:	1.Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	OFFLINE  Connector setting to insertion jig 6098-3802 (W)	<div><div>INSERTION JIG</div><div></div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector <b>6098-3802 (W)</b> into jig using right hand then release the lock.</div><div></div><div>3. Check the holes/terminal slot for <b>B-B wires.</b></div></div> <td>n/a</td> <td><div>Connector Orientation Illustration</div><div><div>I-mark is align</div><div>2 Holes are open</div><div>GOOD</div><div>I-mark is not align</div><div>All holes are open</div><div>NG</div></div><div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div></td>		n/a	<div>Connector Orientation Illustration</div> <div><div>I-mark is align</div><div>2 Holes are open</div><div>GOOD</div><div>I-mark is not align</div><div>All holes are open</div><div>NG</div></div> <div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div>

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## WORK INSTRUCTION

## OFFLINE ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

400D / 7L0161-7020

Customer:

TRQSS

Car Model:

TOYOTA-bZ4X(BEV)

Purpose:



PROTOTYPE



PRE-LAUNCH



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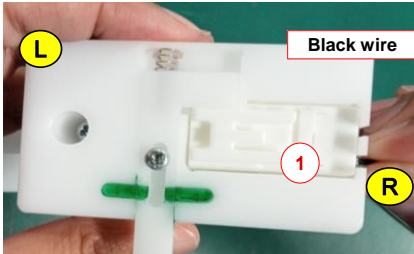
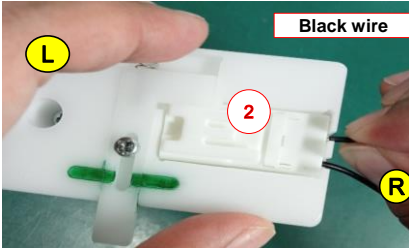
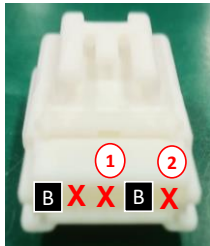

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PARTS:		1.Connector 6098-3802 (W) 2.IRRAX A ROPE-LAY 0.3 B-B wires L=322±2mm [2pcs.]		JIG:	1.Insertion Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	OFFLINE	<div><div>TERMINAL FACING</div><div></div><div><div><div>Black wire</div><div></div></div><div><div>1. Hold the connector <b>6098-3802 (W)</b> then get the <b>1st Black wire</b> and insert to terminal <b>slot 1</b> using right hand. Conduct <b>2x</b> push-pull after wire insertion.</div></div><div><div><div>2. Get the <b>2nd Black wire</b> and insert to terminal <b>slot 2</b> using right hand. Conduct <b>2x</b> push-pull after wire insertion.</div></div><div><div></div><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></div></div></div><div><div>VISUAL REFERENCE</div><div></div><div></div></div></div><td>n/a</td><td><p><b>Document reference/s:</b></p><p><b>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b></p><p>Important reminders and note/s;</p><p><b>1.Make sure wires are properly inserted.</b> <b>Conduct <u>Pull-Push-Pull-Push</u> after insertion.</b> <b>Do not exert extra force.</b></p><p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p></td></div>		n/a	<p><b>Document reference/s:</b></p> <p><b>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b></p> <p>Important reminders and note/s;</p> <p><b>1.Make sure wires are properly inserted.</b> <b>Conduct <u>Pull-Push-Pull-Push</u> after insertion.</b> <b>Do not exert extra force.</b></p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p>

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**WORK INSTRUCTION**  
**OFFLINE ASSEMBLY PROCESS**

Process Name/Title:

Model code/Part number: **400D / 7L0161-7020**

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

Customer: **TRQSS** Car Model: **TOYOTA-bZ4X(BEV)**

Effectivity Date:

**May 15, 2025**

Validity Date:

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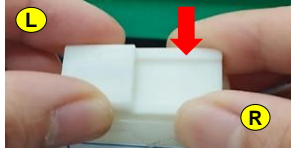



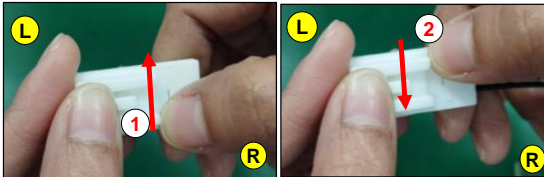





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PARTS:	1.Assy parts		JIG:	1.Locking Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	OFFLINE  Connector Lock	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div> <div><p>2. 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>3. Press the lower parts of connector using right hand while left hand holding the middle.</p></div> <div><p>Right thumb-upper Left thumb-middle</p><p>4. Press the upper part of connector using right hand while left hand holding the middle.</p></div> <div><p>Right thumb-middle Left thumb-middle</p><p>5. Lift then press the connector in the middle using left and right hand.</p></div> <div><p>6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div>	<div>LOCKING JIG</div> 	<div>1. No Unlock and half-locked 2. Use provided jig tools per model to avoid damaged lock.</div> <div><b>Important reminders/note/s:</b> <b>1.MANUAL LOCKING MAY CAUSED DAMAGED LOCK</b> <b>2. Use provided jig tool per model to avoid damaged lock.</b></div> <div><b>Document references;</b> <b>1.Please refer to GL-PRO-ASY-017 for the verification of connector lock.</b></div> <div><p>Before pressing</p><p>After pressing</p></div> <div><div><b>GOOD</b> <p>Full Lock</p></div><div><b>NG</b> <p>Half Lock</p></div></div>

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**WORK INSTRUCTION****OFFLINE ASSEMBLY PROCESS**

Process Name/Title:

Model code/Part number:

**400D / 7L0161-7020**

Customer:

**TRQSS**

Car Model:

**TOYOTA-bZ4X(BEV)**

Purpose:



PROTOTYPE



PRE-LAUNCH



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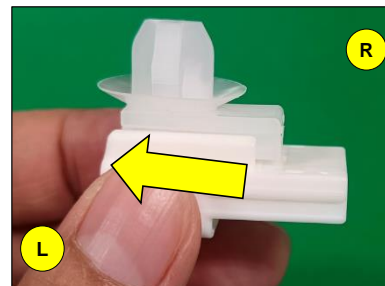
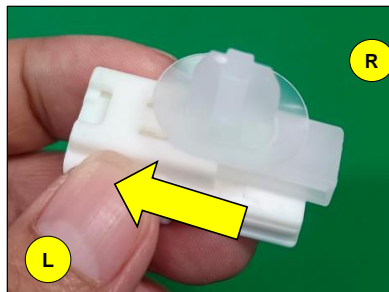
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**5 of 7****PARTS:**

1. Assy parts
2. Clip type clamp 82711-1E360 (W)

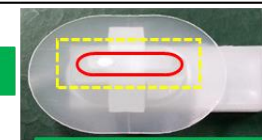
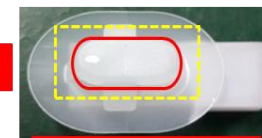
JIG:

**n/a****NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****5****OFFLINE**Clamp attachment  
(Clip type clamp)**CLAMP  
ORIENTATION**

1. Hold the Connector using left hand, get the clip type clamp **82711-1E360 (W)** then insert the clamp using right hand.

**Note: Follow the illustration. Sound will be heard if properly inserted.****Document reference/s:**

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

**CLIP CLAMP ILLUSTRATION****GOOD****82711-1E360 (W)****NG****82711-12B10 (W)**

- 1.No wrong used of Clip Type clamp

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**WORK INSTRUCTION****OFFLINE ASSEMBLY PROCESS**

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**400D / 7L0161-7020**

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**TRQSS**

Car Model:

**TOYOTA-bZ4X(BEV)**

Purpose:



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1. Assy parts

JIG:

n/a

**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

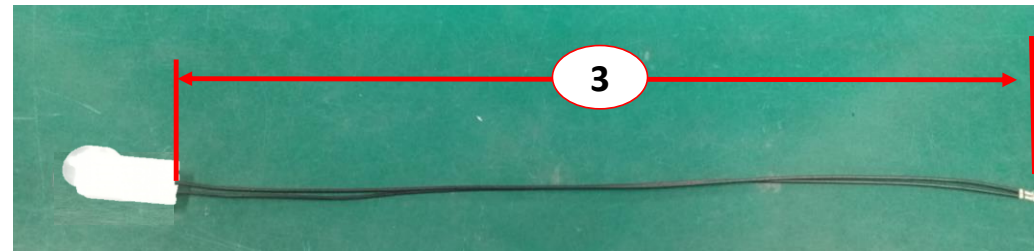
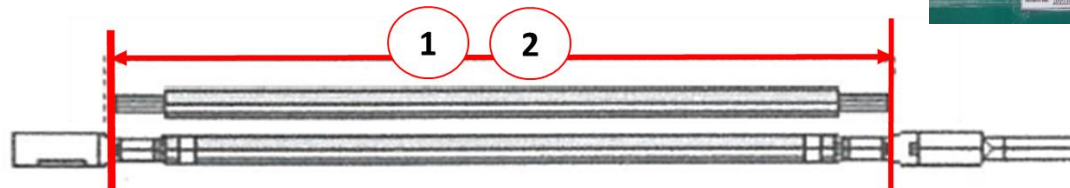
6

OFFLINE

Measurement

Note:

1. Measurement point: End of core wire to the end of core wire
2. Terminal is reference only.

**MEASURING TAPE****Important reminders/Note/s:**

1. Please use calibrated/verified measuring tape when getting the measurement.

2. For Hatsumono, Nakamono, and Owarimono .

**Document reference/s:**

1. Refer to WI-PRO-ASY -056 for sub-assembly Hatsumono, Nakamono, and Owarimono

1. No wrong Dimension

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**WORK INSTRUCTION**

Process Name/Title:

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400D / 7L0161-7020

Customer:

TRQSS

Car Model:

TOYOTA-bZ4X(BEV)

Document No.:

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Purpose:

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PROTOTYPE

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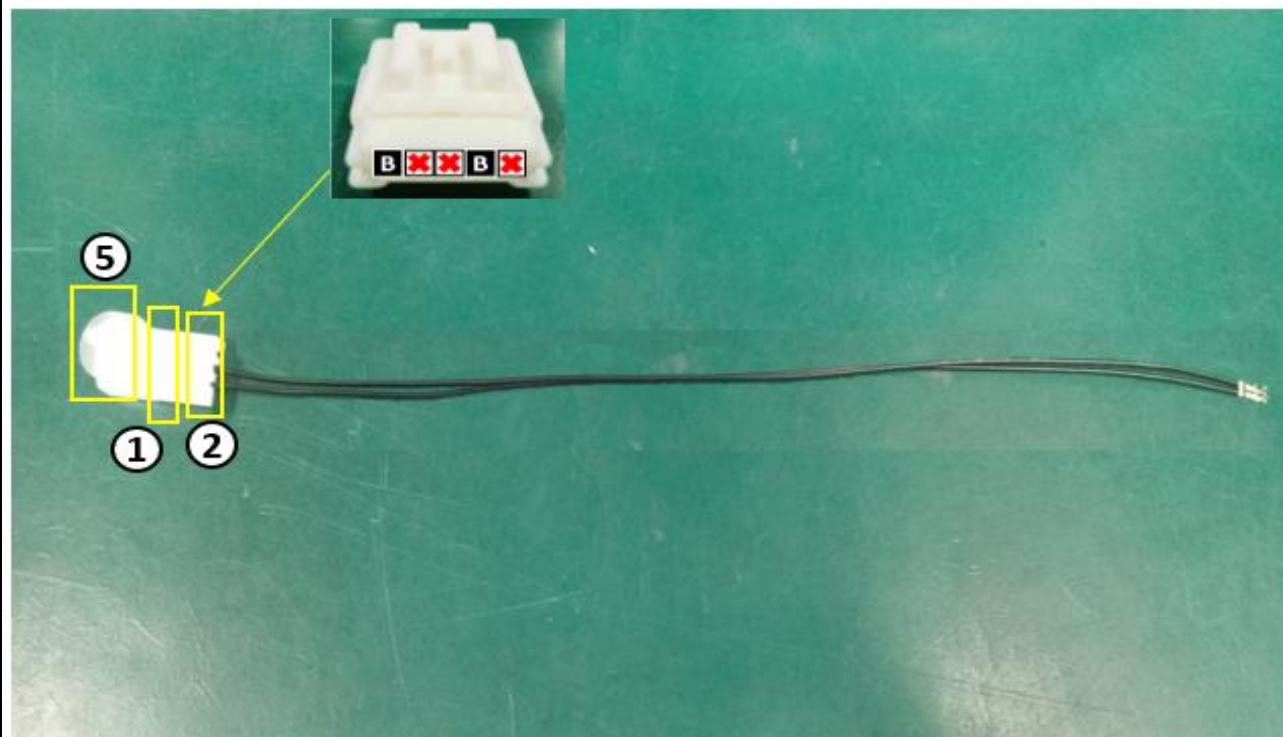
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7L0161-7020****① No Unlocked/Half-locked connector****② No Wrong Insert****③ No Deformed Terminal****④ No Terminal Backing Out****⑤ No MISSING /No Wrong Use of Clip type clamp**

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