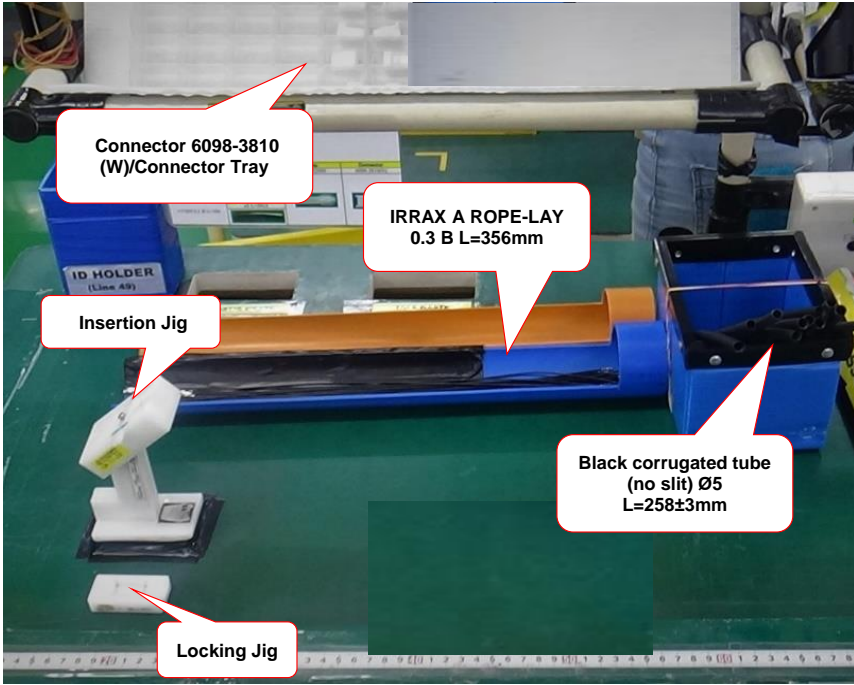


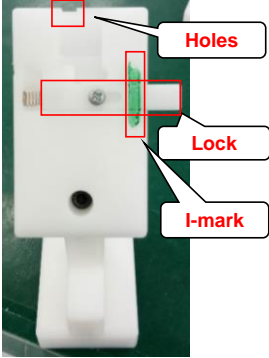
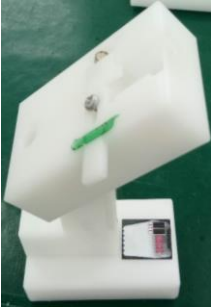

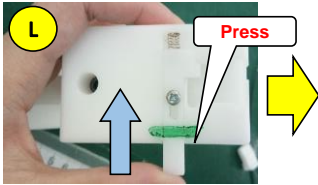
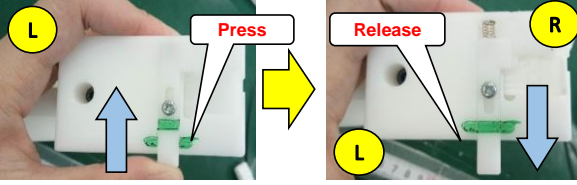


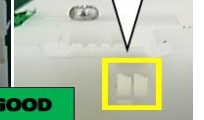
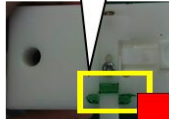
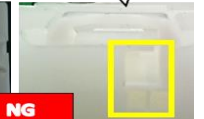
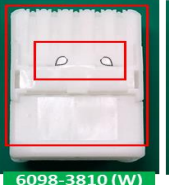

	WORK INSTRUCTION OFFLINE ASSEMBLY PROCESS				Effectivity Date:	April 25, 2024	
	Process Name/Title:				Validity Date:	n/a	
	Model code/Part number: 100B / 7M0583-7020A		Customer: TRJ	Car Model: LEXUS-UX	Document No.:	WI-ENG-PDE-221	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.: 1 of 7

PARTS:	1. Connector 6098-3810 (W) ; IRRAX A ROPE-LAY0.3 B L=356mm(2pcs) ; Black corrugated tube (no slit) Ø5 L=258±3mm			JIG:	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
1	Offline Table Lay-out	<div style="text-align: center;"> TABLE LAY-OUT  </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.	
			<div style="text-align: center;"> CONNECTOR ILLUSTRATION </div> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  6098-3810 (W) </div> <div style="text-align: center;">  6098-5677 (W) </div> </div>		

Revision History						Prepared by	Reviewed by	Approved by	Noted by
04/25/24	2	Inclusion of all improvements (Table lay-out; important reminders and note/s; Document references; Measurements, Visual inspection and Car model"LEXUS-UX"). Change assembly process name from kitting assembly to offline assembly and improve work procedure/illustration on process 1 connector lock. Transfer Wire insertion to corrugated tube process form Taping assembly process (WI-ENG-PDE-222). Transfer to new format.	D.Castillo	C.Villanueva	A. Arañes	n/a			
01/29/21	1	Transfer process owner from Production (WI-PRO-ASY-172) to Engineering (WI-ENG-PDE-221). Apply some improvements and improve pictures in every process.	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes			n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 29, 2019	

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Model code/Part number:		100B / 7M0583-7020A	Customer:	TRJ	Car Model:	LEXUS-UX	Document No.:	WI-ENG-PDE-221
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 6098-3810 (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>Insertion Jig</div><div>Insertion Jig Orientation</div><div>Connector Orientation</div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6098-3810 (W) into jig using right hand and release the lock.</div><div>3. Check the holes/terminal slot for B-B wires.</div></div>			n/a	<div>Connector Orientation Illustration</div> <div>I-mark is align</div>  <div>2 Holes are widely open</div>  <div>I-mark is not align</div>  <div>2 holes are partially open.</div>  <div>GOOD</div> <div>NG</div> <div>CONNECTOR ILLUSTRATION</div> <div>GOOD</div>  <div>6098-3810 (W)</div> <div>NG</div>  <div>6098-5677 (W)</div> <div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</div>		

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Car Model:

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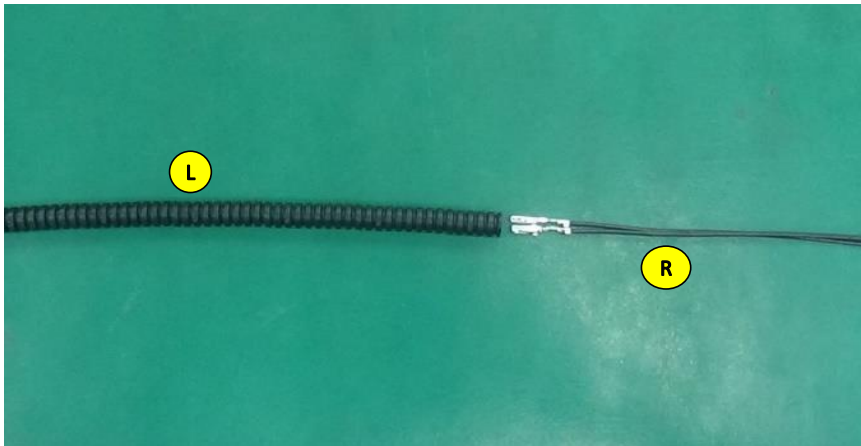
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PARTS:		1. Black corrugated tube (no slit) Ø5 L=258±3mm 2. IRRAX A ROPE-LAY0.3 B L=356mm [2pcs]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Offline Wire insertion to Black corrugated tube (no slit) Ø5 L=258±3mm	 <div>1.Get Black corrugated tube (no slit) Ø5 L=258±3mm using left hand and insert IRRAX A ROPE-LAY0.3 B L=356mm(2pcs) using right hand.</div>		n/a	1. No wrong use of parts 2. No deformed terminal

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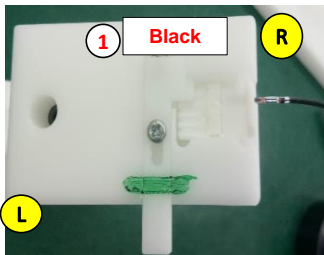
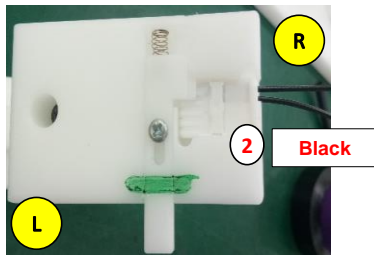

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PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Offline Wire Insertion to Connector 6098-3810 (W)	<div><div>Wire facing</div></div> <div><div>1. Get the First Black wire and insert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

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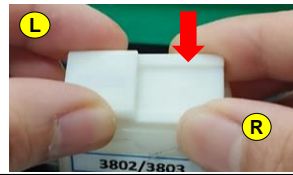



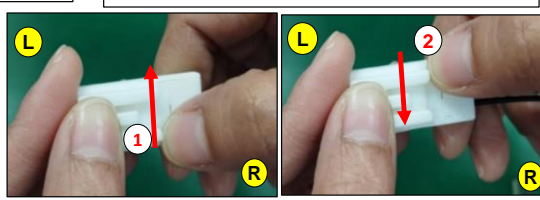


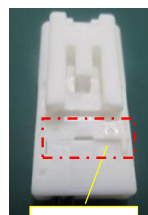
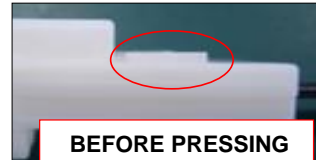
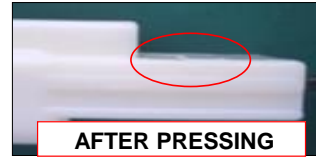
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PARTS:	1. Assy Parts			JIG:	1. Locking jig
NO.	PROCESS NAME	2 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Offline Connector Lock	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div> <div><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> 	<p>1. Use the provided jig per connector 2. No unlock/half-locked of connector lock</p> <p>Important reminders/note/s: 1.MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</p> <p>Document reference/s: 1.Please refer to GL-PRO-ASY-017 for the verification of connector lock.</p> <div><div>GOOD</div><p>Full Lock</p><div>NG</div><p>Half Lock</p></div> <div><p>BEFORE PRESSING</p><p>AFTER PRESSING</p></div>

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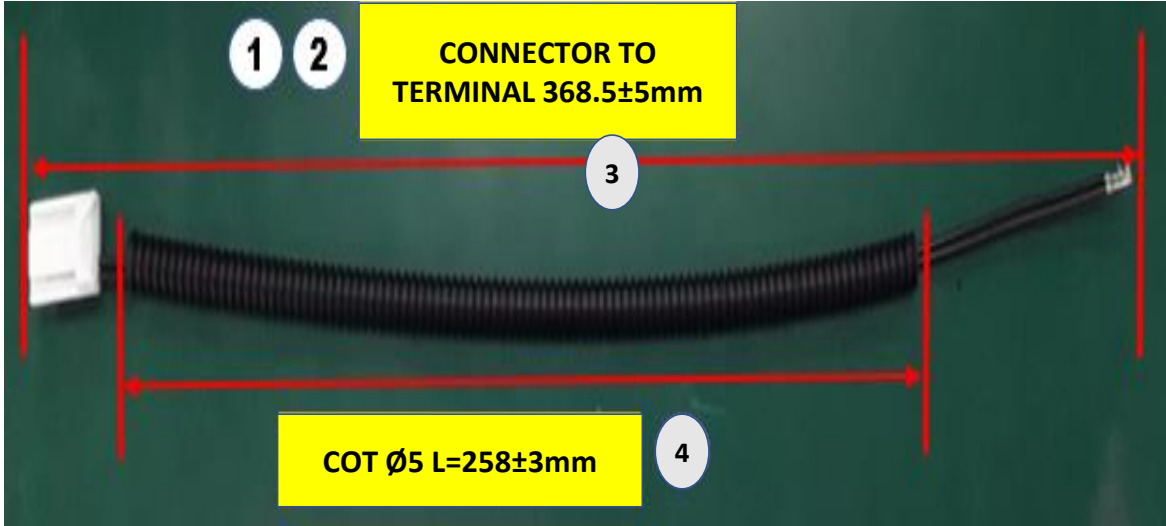

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PARTS:	1. Assy Parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	Offline Measurement	<div><div>Measuring tape</div></div>		<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</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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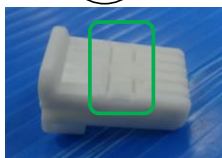
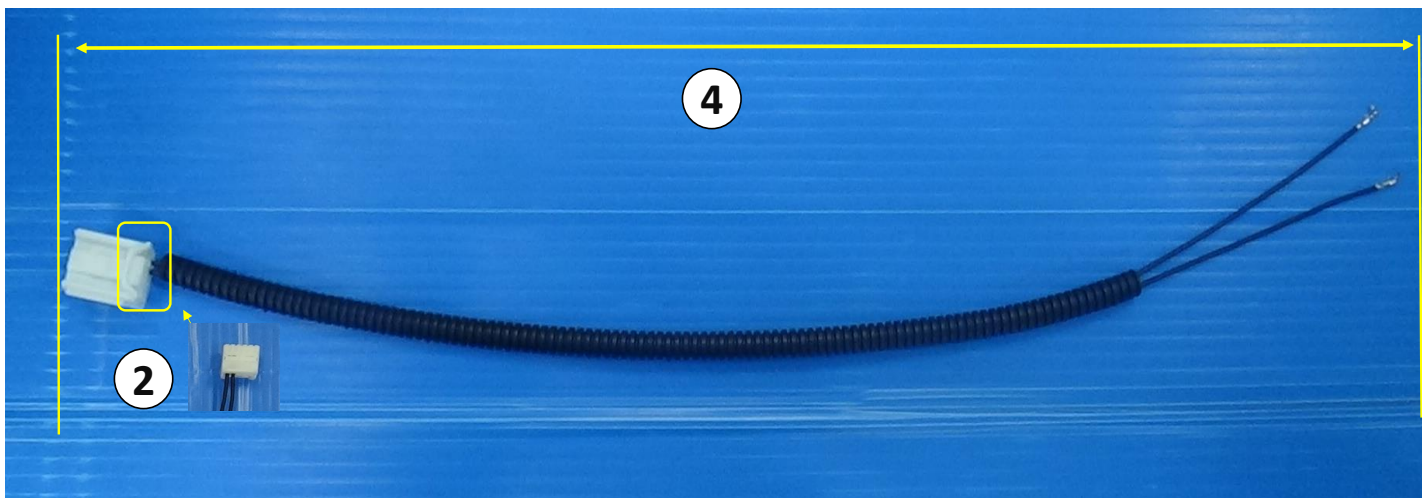
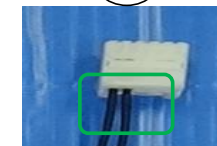
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1. Assy part

JIG:

n/a

**VISUAL INSPECTION****OFFLINE INSERTION****7M0583-7020A****1****GOOD****NO GOOD****2****1****No Unlock/Halflocked
connector****2****No Wrong insert****4****3****GOOD****NO GOOD****3****No Terminal Backing Out****4****Check the Alignment**

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