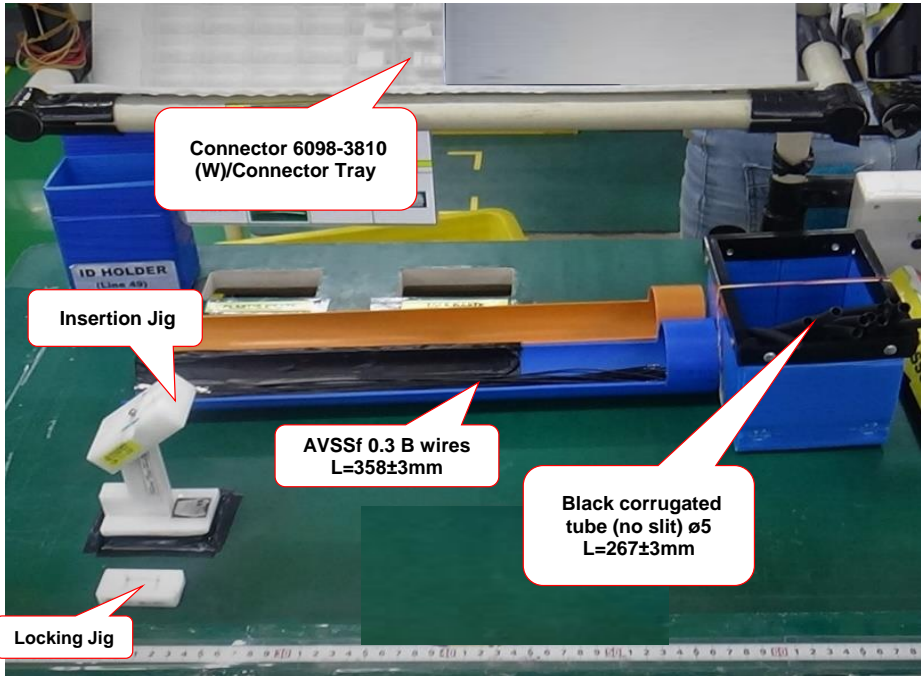
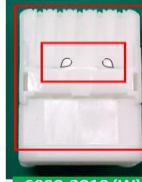
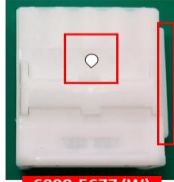




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	Model code/Part number: 240B / 7M0489-7020D		Customer: TRJ	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-837		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	1 of 7

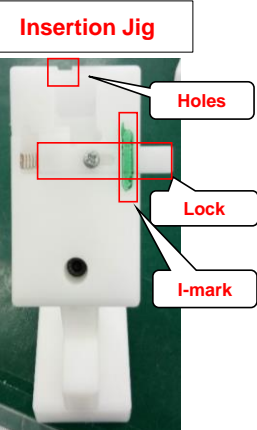


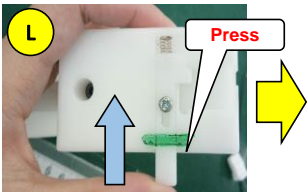
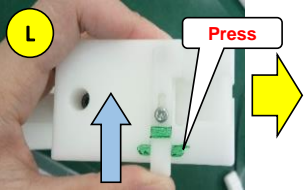

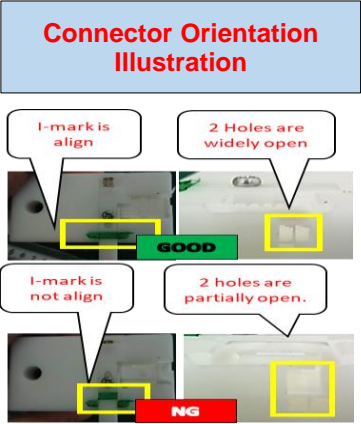
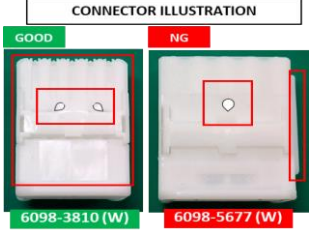
PARTS: 1. Connector 6098-3810 (W); Black corrugated tube (no slit) ø5 L=267±3mm; Black SV tube (Vinyl) ø5 L=28±3mm; AVSSf 0.3 B wires L=358±3mm; Black tape		JIG: 1. Insertion jig 2. Locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
1	Offline Table Lay-out	<div style="text-align: center;"> TABLE LAY-OUT </div> 	<div style="border: 1px dashed red; padding: 5px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>
		QUALITY POINTERS	
		Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. 1. No missing parts/tools 2. No excess parts/tools	
		<div style="text-align: center;"> 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;">GOOD</div>  <div style="background-color: green; color: white; padding: 2px;">6098-3810 (W)</div> </div> <div style="text-align: center;"> <div style="background-color: red; color: white; padding: 2px;">NG</div>  <div style="background-color: red; color: white; padding: 2px;">6098-5677 (W)</div> </div> </div>	

Revision History						Prepared by	Reviewed by	Approved by	Noted by			
						 D. Castillo	 C. Villanueva	 A. Arañes	n/a			
05/24/24	0	Initial issue.			D. Castillo					C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change			Revised					Reviewed	Approved	Noted
						Est. Date:	May 24, 2024					

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	Model code/Part number: 240B / 7M0489-7020D		Customer: TRJ	Car Model: LEXUS-ES	Document No.: WI-ENG-PDE-837		
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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></div><div></div><div></div><div></div><div></div><div></div><div><p>1. Press the lock of insertion jig using left thumb.</p></div><div><p>2. Insert the connector 6098-3810 (W) into jig using right hand and release the lock.</p></div><div><p>3. Check the holes/terminal slot for B-B wires.</p></div></div> <div>n/a</div>			<div></div> <div></div> <div><p>1. Use provided jig per model</p><p>2. No wrong usage of parts</p><p>3. No wrong orientation of connector</p><p>4. No damaged connector</p></div>			


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PARTS:		1. Black corrugated tube (no slit) ø5 L=267±3mm 2. AVSSf 0.3 B wires L=358±3mm [2pcs]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Offline	<div><div>Wire insertion to Black corrugated tube (no slit) ø5 L=267±3mm</div><div><div>1. Get black corrugated tube ø5 L=267±3mm using left hand and insert Black wires L=358±3mm using right hand.</div></div></div>		n/a	1. No wrong use of parts 2. No deformed terminal

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Model code/Part number:

240B / 7M0489-7020D

Customer:

TRJ

Car Model:

LEXUS-ES

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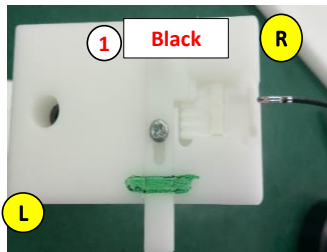
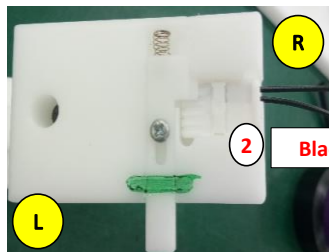

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PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Offline	<div><div></div><div>Wire facing</div></div> <div><div></div><div>1. Get the First Black wire and insert to Slot 1 of connector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

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240B / 7M0489-7020D

Customer:

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Car Model:

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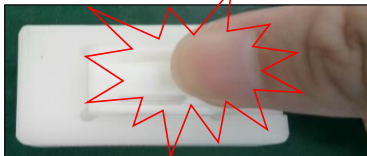
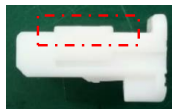

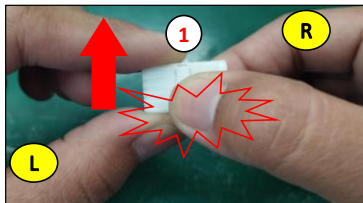
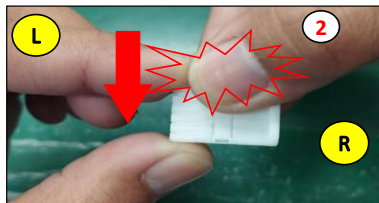

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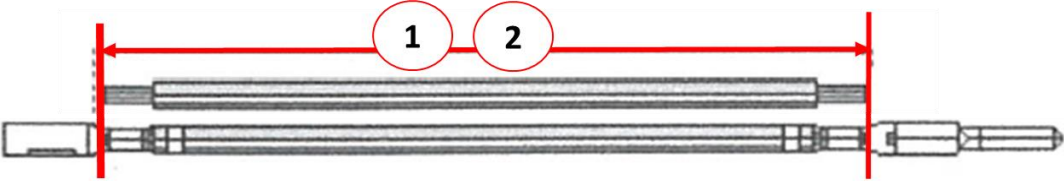
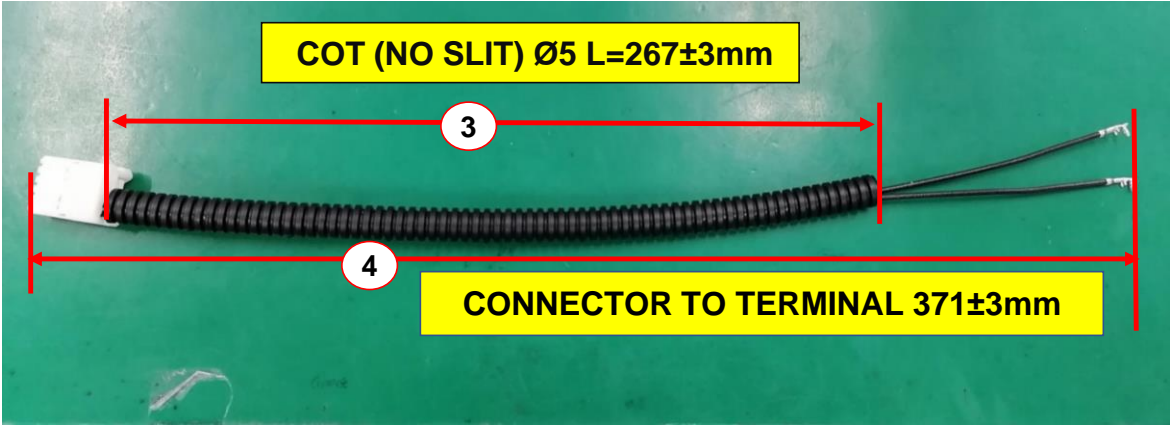

PARTS:	1. Assy parts			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Offline Connector lock	<div><p>1. Put the connector into locking jig using right hand then press to lock 2x.</p></div> <div><p>Before Pressing</p><p>After Pressing</p></div> <div><p>1</p><p>2</p><p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div>		<div><p>LOCKING JIG</p></div>	<p>Important reminders/Note/s:</p> <p>1. Manual locking may cause damaged connector lock.</p> <p>1. Use provided jig tool per model to avoid damaged lock. 2. No Unlock and half-locked connector 3. No damaged lock</p>

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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>Note: 1. Measurement point: End of core wire to the end of core wire 2. Terminal is reference only.</div> <div></div> <div></div>	MEASURING TAPE 	<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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Model code/Part number:

240B / 7M0489-7020DCustomer: **TRJ**

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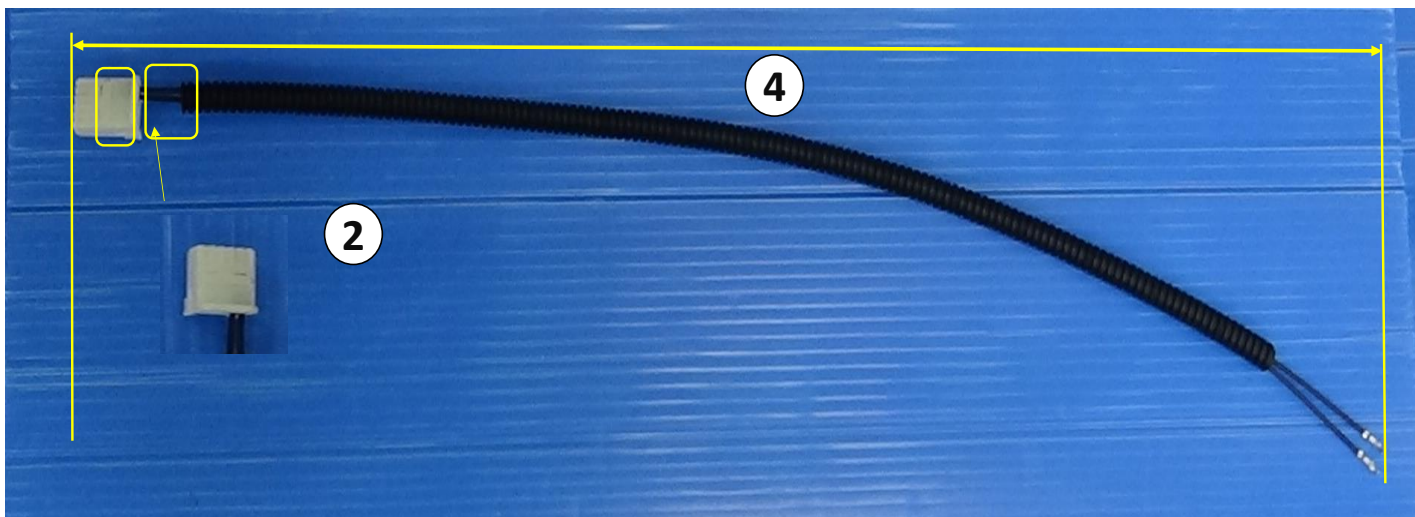
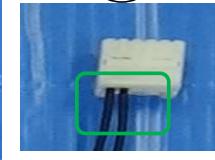
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION**OFFLINE INSERTION****7M0489-7020D****1****GOOD****NO GOOD****2****4****3****GOOD****NO GOOD****1****No Unlock/Halflocked connector****3****No Terminal Backing Out****2****No Wrong insert****4****Check the Alignment**

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