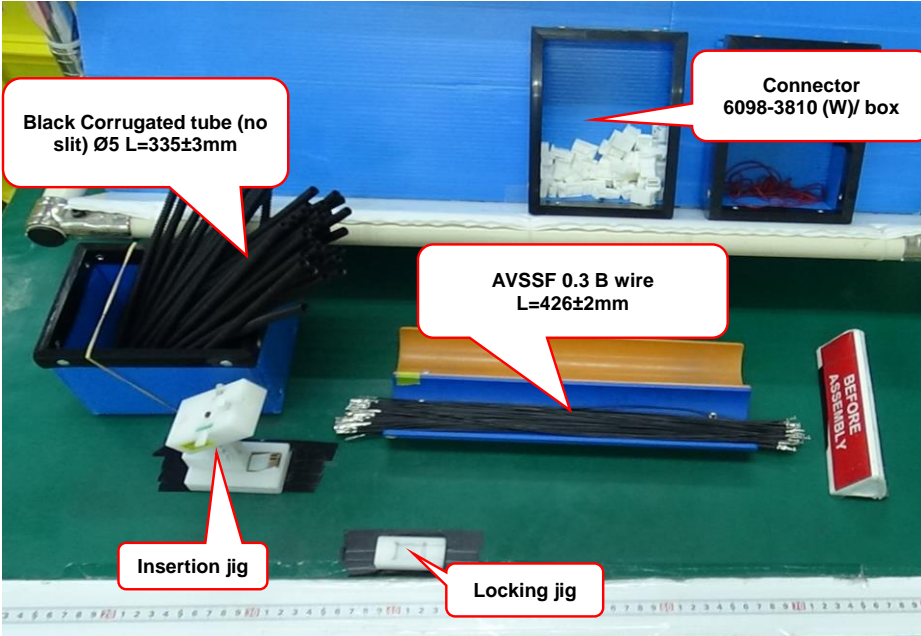

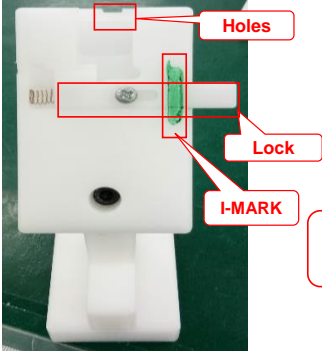




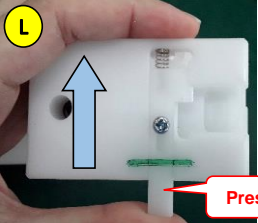
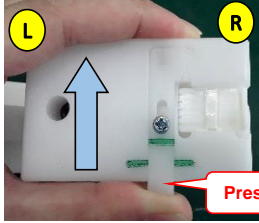







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	Model code/Part number: 946B / 7N0074-7020A	Customer: TRJ	Car Model: LEXUS-ES	Document No.:	WI-ENG-PDE-847		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	1 of 7

PARTS:		1.Connector 6098-3810 (W); Black Corrugatedtube (no slit) Ø5 L=335±3mm; AVSSF 0.3 B wire L=426±2mm		JIG:	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	Offline	<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/tools 2. No excess parts/tools</p>

Revision History							Prepared by	Reviewed by	Approved by	Noted by
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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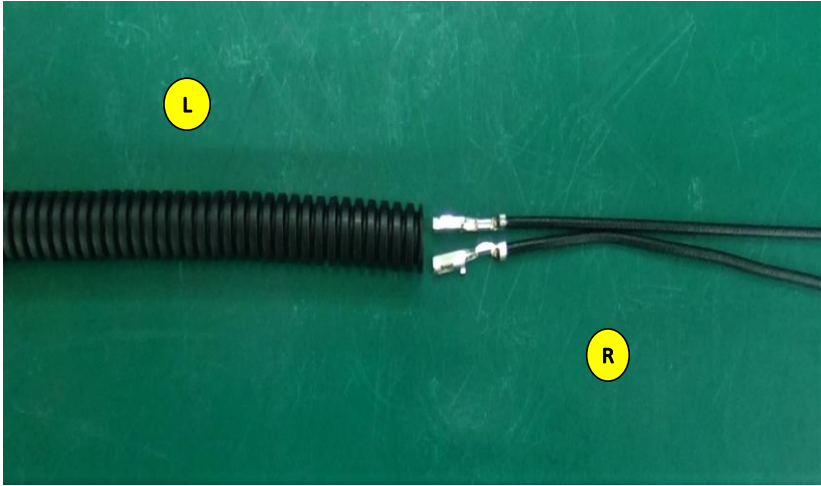
PARTS:	1. Connector 6098-3810 (W)			JIG:	1. Insertion jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
2	Offline Connector setting to insertion jig 6098-3810 (W)	<div><div>INSERTION JIG</div><div>INSERTION JIG ORIENTATION</div><div>Connector lock</div><div>Connector orientation</div><div>Visual reference</div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Get the connector 6098-3810 (W) using right hand then insert to jig using right hand and release the lock using left thumb.</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>GOOD</div> <div>I-mark is not align</div>  <div>No holes are open</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>Important reminders/Note/s: 1. Follow the connector orientation</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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	Model code/Part number: 946B / 7N0074-7020A		Customer: TRJ	Car Model: LEXUS-ES	Document No.: WI-ENG-PDE-847		
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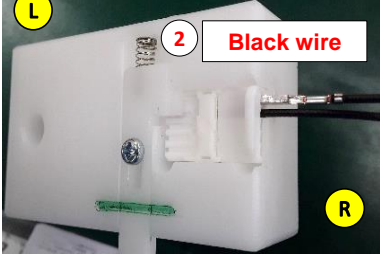
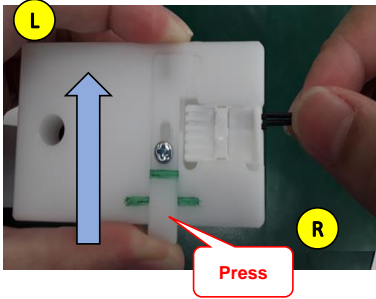
PARTS:		1. Black Corrugated tube (no slit) Ø5 L=335±3mm 2.AVSSf 0.3 B wire L=426±2mm [2pcs]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Offline	<div></div> <div>1.Get Black Corrugated tube (no slit) Ø5 L=335±3mm using left hand and insert AVSSf 0.3 B wire L=426±2mm (2pcs) using right hand.</div>		n/a	1. No wrong use of parts 2. No deformed terminal

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	Process Name/Title:		Model code/Part number: 946B / 7N0074-7020A		Customer: TRJ	Car Model: LEXUS-ES		Document No.: WI-ENG-PDE-847
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	0	Page No.:	4 of 7

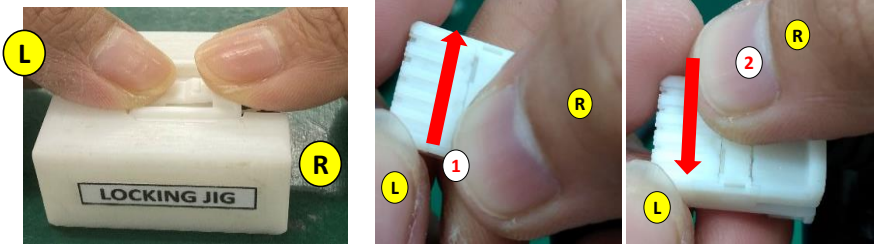
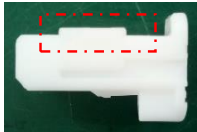
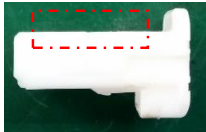
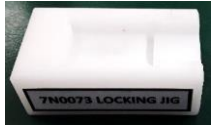
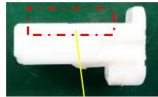
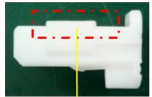
PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Offline Wire insertion to connector 6098-3810 (W)	<div><div>Wire facing</div></div> <div><div>1. Get 1st black wire then insert to terminal slot 1 using right hand.</div></div> <div><div>2. Get 2nd Black wire then insert to terminal slot 2 using right hand.</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>		n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</div> <div>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. 3. Insertion of wires must be from left to right</div> <div>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</div>

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	5 of 7

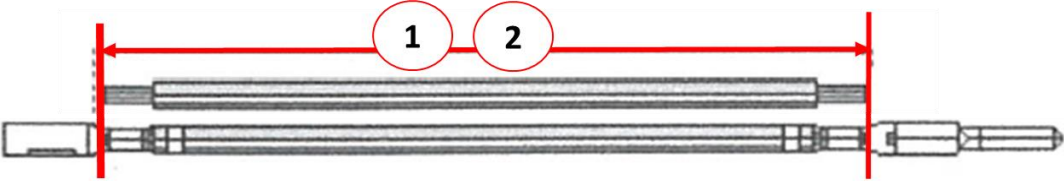
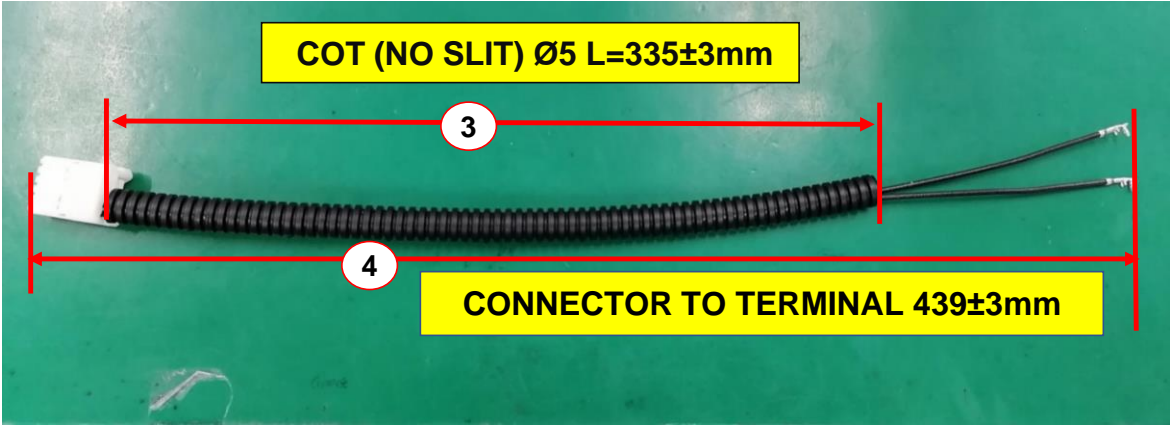

PARTS:	1. Assy parts			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Offline Connector Lock	<div></div> <div><div>1. Put the connector into locking jig using right hand then press 2x using both hands. Touch the connector lock to confirm if properly locked.</div><div>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</div></div> <div><div>Before Pressing</div><div>After Pressing</div></div>		<div>LOCKING JIG </div> <div>CONNECTOR LOCK CONDITION <div><div>GOOD  Fully Locked</div><div>NG  UnLocked</div></div></div>	<p>Important reminders/Note/s:</p> <p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <p>1. Use the provided locking jig per model 2. No unlock/half-locked connector</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>			<div>MEASURING TAPE</div> <div></div>	<div>Important reminders and 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 Owarimono Inspection</div> <div>1. No wrong dimension</div>

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946B / 7N0074-7020ACustomer: **TRJ**

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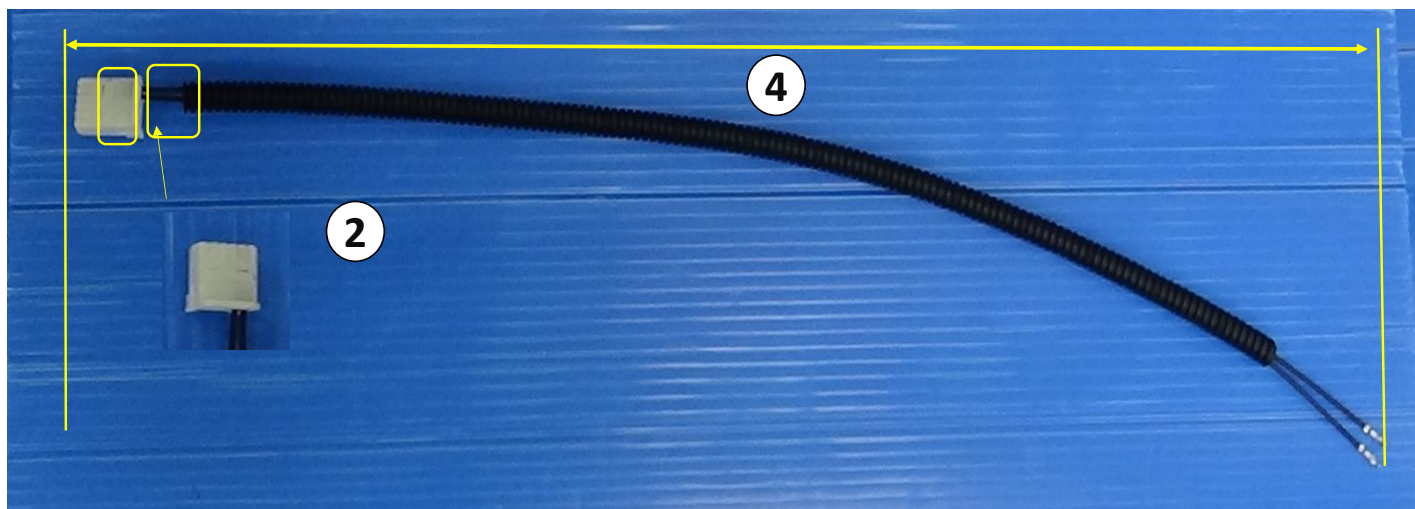
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION**OFFLINE INSERTION****7N0074-7020A****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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