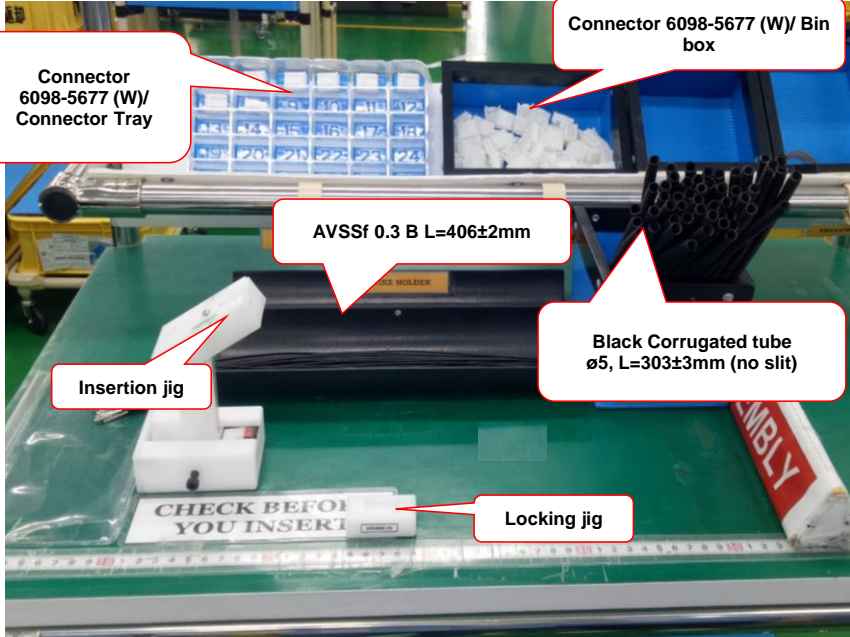



	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>April 16, 2024</b>		
	Process Name/Title: <b>OFFLINE ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>240B / 7M0494-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS ES</b>	Document No.:	<b>WI-ENG-PDE-275</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	3	Page No.:	1 of 7


  


<b>PARTS:</b>		1. Connector 6098-5677 (W); AVSSf 0.3 B wires L=406mm; Corrugated tube ø5, L=303±3mm (no slit)		JIG:	1. Insertion jig 2. Locking jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
1	Offline Table Lay-out			<p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p><b>Document reference/s:</b> 1. Please refer to <b>WI-PRO-CNC-017</b> for wire and strip length tolerance.</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>

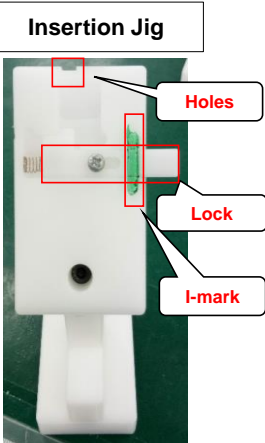


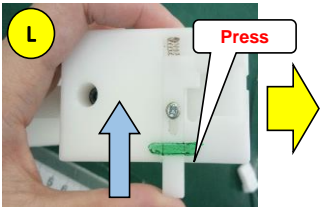
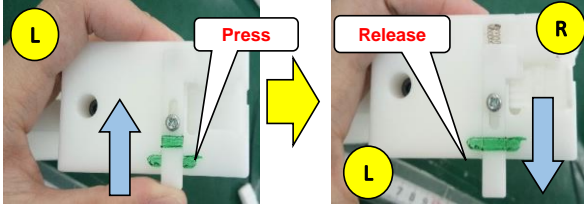

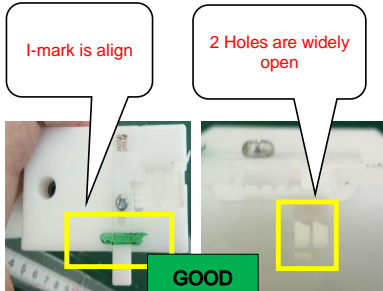
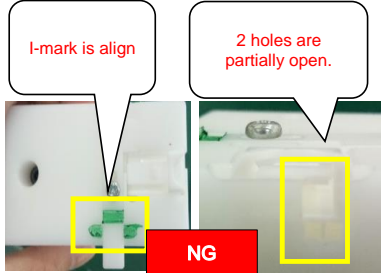
Revision History						Prepared by	Reviewed by	Approved by	Noted by	
04/16/24	3	Change process sequence and remove terminal cover jig due to process improvement. Inclusion of Measurement and Car model "LEXUS ES". Change term from Quality checkpoints to Visual inspection.	D.Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
06/05/23	2	Inclusion of Quality checkpoints ; improve important reminders/note/s and Document references; By two's inspection; Improve work procedure/illustration on process connector lock. Change title from Kitting assembly to Offline assembly process.	J. Loterte	C. Villanueva	A. Arañes	n/a				
09/09/21	1	Change status from Pre-launch to Masspro.	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	May 24, 2021		

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		Process Name/Title: <b>OFFLINE ASSEMBLY PROCESS</b>			Validity Date:	n/a			
		Model code/Part number: <b>240B / 7M0494-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS ES</b>	Document No.:	<b>WI-ENG-PDE-275</b>		
		Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	3	Page No.:	2 of 7	


  

<b>PARTS:</b>		1. Connector 6098-5677 (W)		JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
2	Offline Connector Setting to Insertion jig 6098-5677 (W)	<div> <div> <b>Insertion Jig</b>   </div> <div> <b>Insertion Jig Orientation</b>   </div> <div> <b>Connector Orientation</b>   </div> </div> <div>    </div> <div> <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector <b>6098-5677 (W)</b> into jig using right hand and release the lock.</p> <p>3. Check the holes/terminal slot for <b>B/B wires.</b></p> </div>	n/a	<div> <b>Connector Orientation Illustration</b>   </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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	Process Name/Title: OFFLINE ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 240B / 7M0494-7020C		Customer: TRJ	Car Model: LEXUS ES	Document No.:	WI-ENG-PDE-275	
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PARTS:		1. Corrugated tube ø5, L=303±3mm 2. AVSSf 0.3 B L=406±2mm [2pcs]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Offline <div>3</div> Wire insertion to Black Corrugated tube ø5, L=303±3mm (No slit)	<div><div>1. Get Black Corrugated tube ø5, L=303±3mm using left hand and insert two (2) Black wires L=406mm using right hand.</div></div>		n/a	1. No wrong usage of parts 2. No deformed terminal

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# WORK INSTRUCTION

Process Name/Title:

## OFFLINE ASSEMBLY PROCESS

Effectivity Date:

April 16, 2024

Validity Date:

n/a

Model code/Part number:

240B / 7M0494-7020C

Customer: TRJ

Car Model: LEXUS ES

Document No.:

WI-ENG-PDE-275

Purpose:

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☐ PRE-LAUNCH


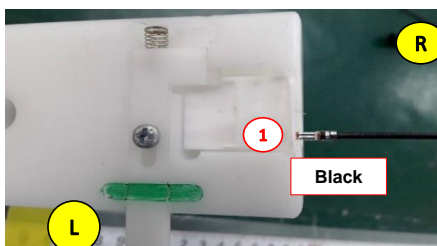
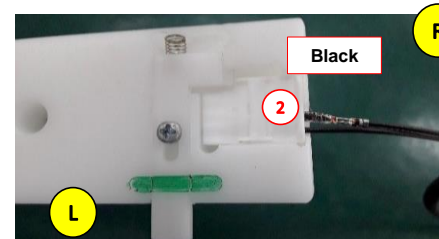
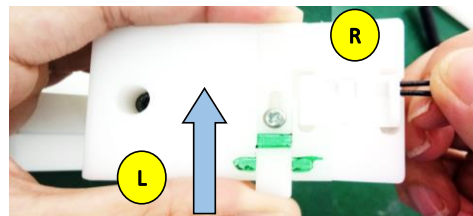
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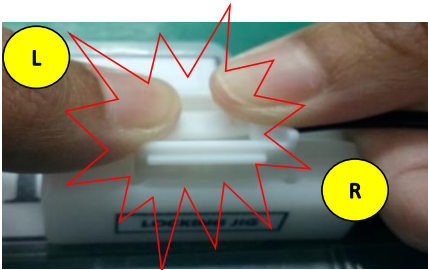
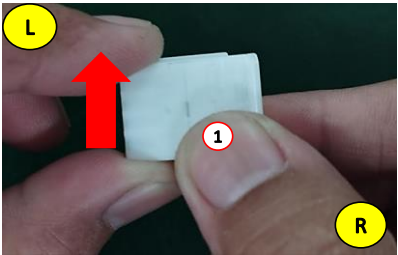


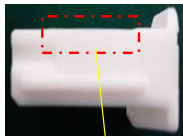
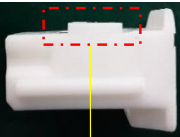

PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Offline  Wire Insertion to Connector 6098-5677 (W)	<div><div><div></div><div></div><div><div>1. Hold the insertion jig using left hand, get the <b>first Black wire</b> and insert to <b>Slot 1</b> of connector using right hand.</div></div></div><div><div></div><div><div>2. Get the <b>2nd Black wire</b> and insert to <b>Slot 2</b> of connector using right hand.</div></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>n/a</div> <div><p><b>Important reminders/Note/s:</b></p><p>1. Insertion sequence must be from left to right.</p><p>2. Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</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></div>		

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	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>April 16, 2024</b>		
	Process Name/Title: <b>OFFLINE ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>240B / 7M0494-7020C</b>		Customer: <b>TRJ</b>	Car Model: <b>LEXUS ES</b>	Document No.:	<b>WI-ENG-PDE-275</b>	
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<b>PARTS:</b>	1. Assy part			JIG:	1. Locking jig		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
5	Offline Connector Lock	<div><div>1. Put the connector into locking jig using right hand then press 2x to lock. Touch the connector lock to confirm if properly pressed.</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>GOOD Fully Locked</div><div>NG UnLocked</div></div></div>			<div><div>LOCKING JIG</div></div>	<p><b>Important reminders/Note/s:</b></p> <p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <p><b>Document references:</b></p> <p>1. Refer to <b>GL-PRO-ASY-017</b> for verification of 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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**240B / 7M0494-7020C**Customer: **TRJ**Car Model: **LEXUS ES**

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<b>PARTS:</b>		1. Assy part		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
6	Offline Measurement			<div>Measuring tape</div> 	<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>

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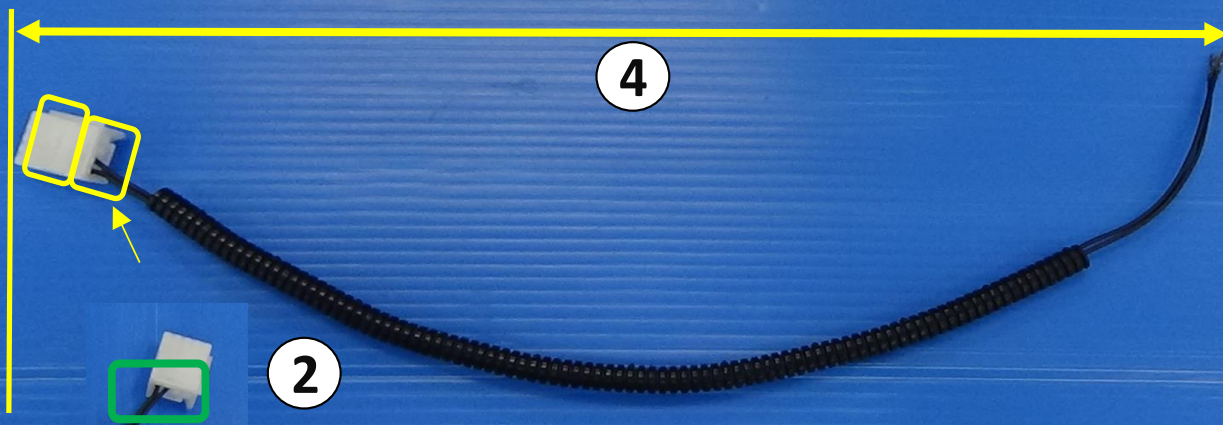
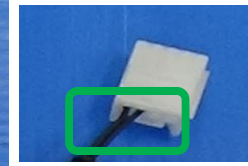
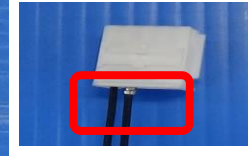
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION****OFFLINE INSERTION****7M0494-7020C****1****GOOD****NO GOOD****4****2****3****GOOD****NO GOOD****1** No Unlock/Half-locked connector**2** No Wrong insert**3** No Terminal Backing Out**4** Check the Alignment

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