



WORK INSTRUCTION

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Model code/Part number:

100B / 7M0584-7020A

Customer: TRJ

Car Model:

LEXUS UX

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

April 30, 2024

Validity Date:

n/a

Document No.:

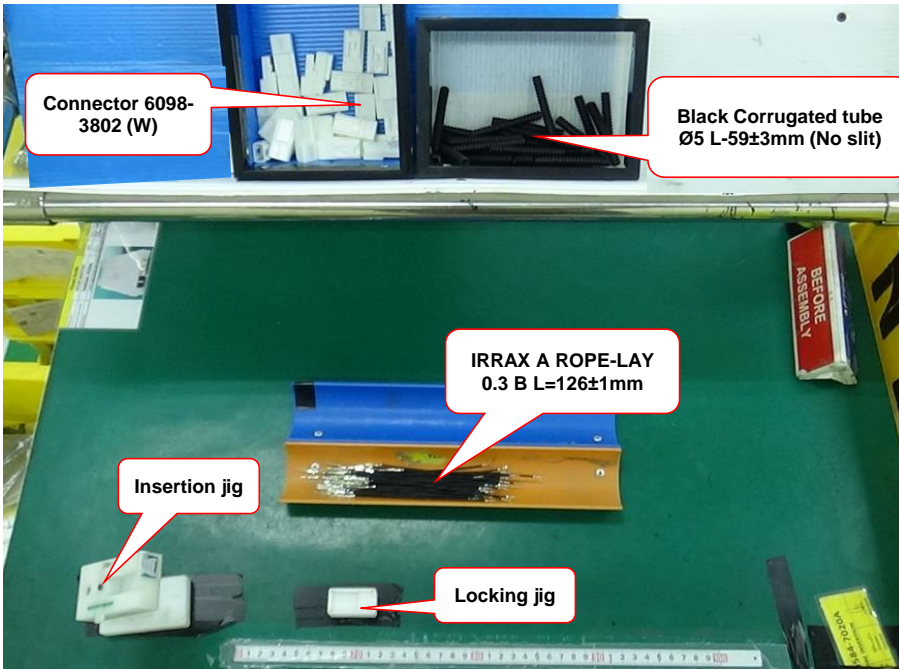


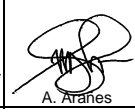
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PARTS:		1.Connector 6098-3802 (W); IRRAX A ROPE-LAY 0.3 B L=126±1mm; Black Corrugated tube Ø5 L-59±3mm (No Slit)				JIG:		1. Insertion jig 2. Locking jig		
NO.	PROCESS NAME		3 WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	P1	Table Lay-out	<div>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>		<div>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>	
Revision History										
04/30/24	3	Inclusion of Measurements, Visual inspection and Car model "LEXUS-UX". Transfer Wire insertion to corrugated tube process form Taping assembly process (WI-ENG-PDE-203). Improved table lay-out.Transfer to new format.				D.Castillo	C.Villanueva	A. Arañes	n/a	
09/15/22	2	Additional table lay-out. Change document title from 'Kitting assembly process' to 'Offline assembly process'. Improve work procedure and illustration in process no.4 - locking method. Improve quality pointers and notes in process no.1,2,3 and 4.				M. Catapang	J. Loterte	C. Villanueva	A. Arañes	
12/07/20	0	Excluded from WI-PRO-ASY-147, transfer process owner from Production to Engineering (WI-ENG-PDE-202). Apply some improvements; Update pictures etc.				J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	
						Prepared by	Reviewed by	Approved by	Noted by	
						 D. Castillo	 C. Villanueva	 A. Arañes	n/a	
						Est. Date:	December 7, 2022			

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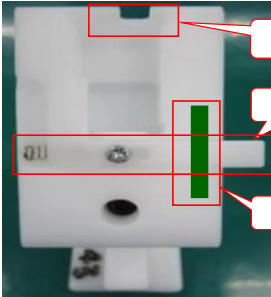

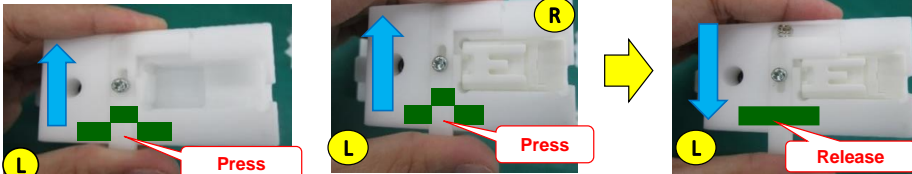







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PARTS:	1. Connector 6098-3802 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1	<div><div>Connector setting to insertion jig 6098-3802 (W)</div><div><div><div><div><div>INSERTION JIG</div><div></div><div><div>Lock</div><div>I-mark</div><div>Holes</div></div><div>CONNECTOR ORIENTATION</div><div></div></div><div><div><div>INSERTION JIG ORIENTATION</div><div></div></div><div><div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6098-3802 (W) into jig using right hand then release the lock. <i>Note: Follow the connector orientation.</i></div><div><div></div><div>3. Check the holes/terminal slot for B-B wires.</div></div></div></div></div></div></div></div></div>	N/A	<div><div>1. Use provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div></div> <div><div>Connector Orientation Illustration</div><div><div><div><div>I-mark is align</div><div></div><div>GOOD</div></div><div><div>1 Hole is open</div><div></div><div>GOOD</div></div><div><div><div>I-mark is not align</div><div></div><div>NG</div></div><div><div>2 holes are open</div><div></div><div>NG</div></div></div><div><div>CONNECTOR ILLUSTRATION</div><div><div><div>GOOD</div><div></div><div>6098-3802 (W)</div></div><div><div>NG</div><div></div><div>6098-5668 (W)</div></div></div></div></div></div></div>

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PARTS:		1.IRRAX A ROPE-LAY 0.3 B L=126±1mm [2pcs] 2.Corrugated tube L=59+3mm (No slit)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1	<div><div>3</div><div>Wire insertion to Black corrugated tube ø5 L=59+3mm (no slit)</div><div></div><div>1.Get Black Corrugated tube ø5 L=59+3mm (no slit) using left hand and insert IRRAX A ROPE-LAY 0.3 B L=126±1mm using right hand.</div></div>		n/a	1. No wrong usage of parts 2.No deformed terminal

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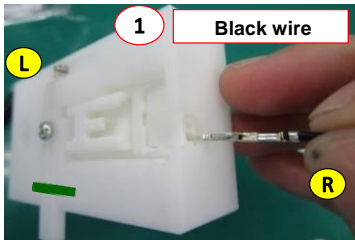
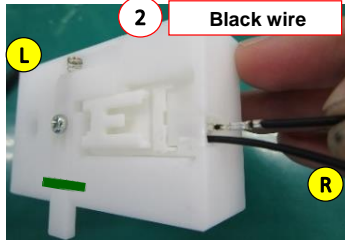
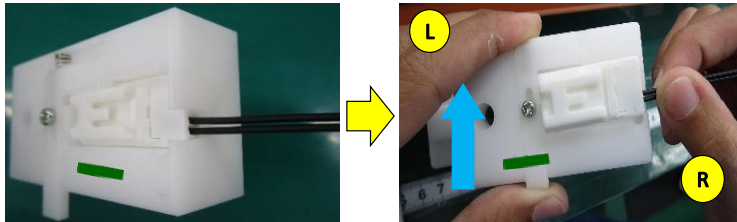
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PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1 Wire insertion to connector 6098-3802 (W)	<div><div>Wire facing</div></div> <div><div>1 Black wire</div></div> <div><div>2 Black wire</div></div> <div><div>1. Get Black wire then insert to terminal slot 1 using right hand. Note: Make sure to hold the COT using right hand while insertion to prevent deformed in 7D0349 Terminal.</div><div>2. Get the B wire then insert to terminal slot 2 using right hand.</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>	N/A	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed 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.</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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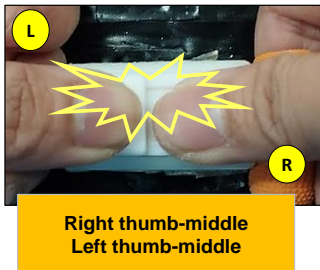
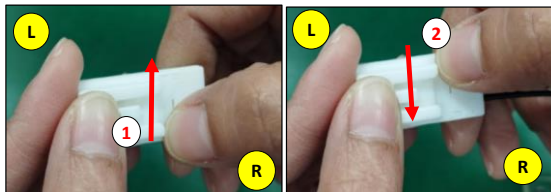





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PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1 Connector Lock	<div><div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div><div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div><div><p>3. Press the lower parts of connector using right hand while left hand holding the middle.</p></div><div><p>4. Press the upper part of connector using right hand while left hand holding the middle.</p></div><div><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>	<div>LOCKING JIG</div> 	<div>1. Use the provided jig tool to lock the connector. 2. No unlock/half-locked connector</div> <div>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR.</div> <div><div><div>GOOD</div><div>Full Lock</div></div><div><div>NG</div><div>Half Lock</div></div></div> <div><div>Before pressing</div></div> <div><div>After pressing</div></div>

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PARTS:

1. Assy parts

JIG:

n/a

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

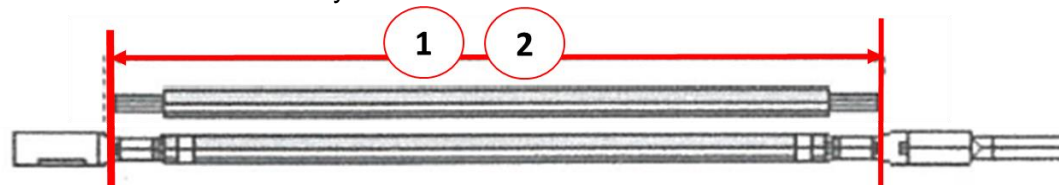
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P1

Measurement

Note:

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

**Measuring tape****Important reminders and note/s:**

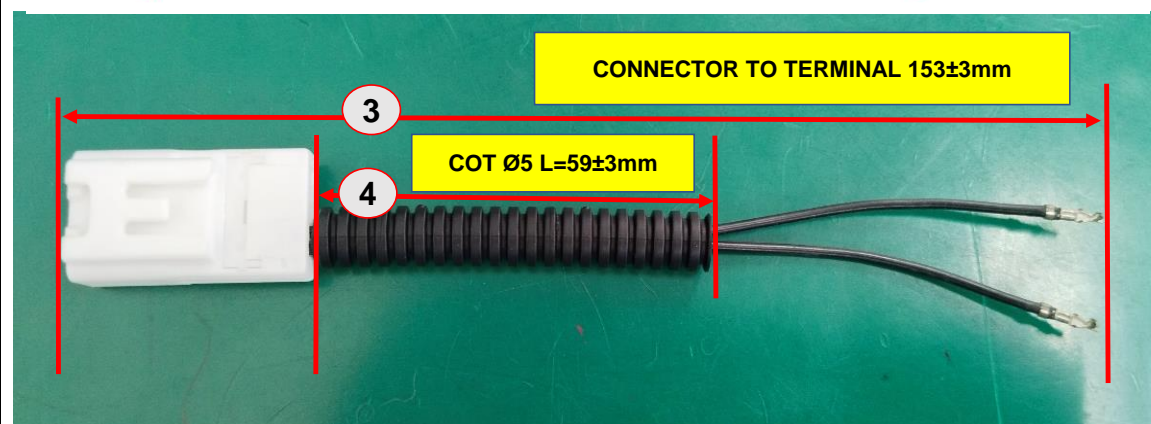
1. Please use calibrated/verified measuring tape when getting the measurement.

2. For Hatsumono, Nakamono and Owarimono.

Document reference/s:

1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection

1. No wrong dimension



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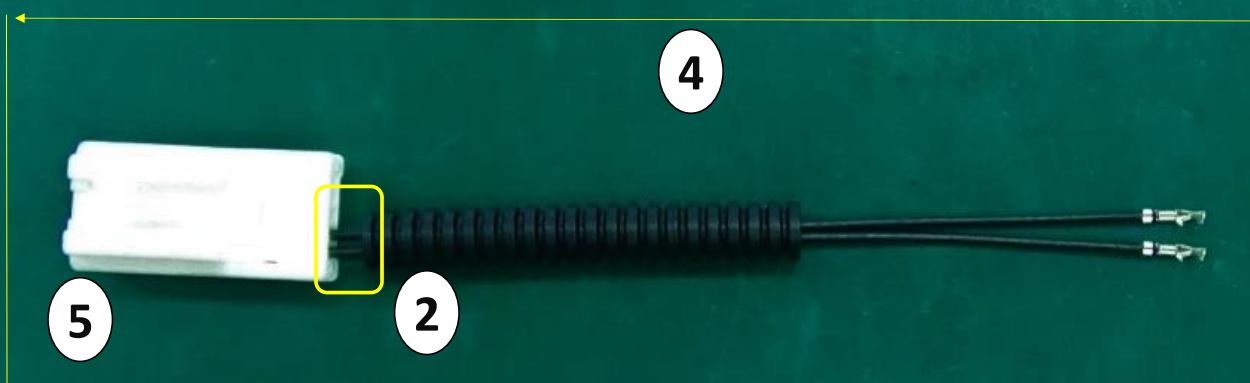
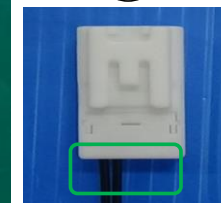
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PARTS:

1. Assy parts

JIG:

n/a

**QUALITY CHECKPOINTS****OFFLINE INSERTION****7M0584-7020A****1****GOOD****NO GOOD****4****5****2****3****GOOD****NO GOOD****1****No Unlock connector****3****No Terminal Backing Out****5****No Deformed terminal****2****No Wrong insert****4****Check the Alignment**

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