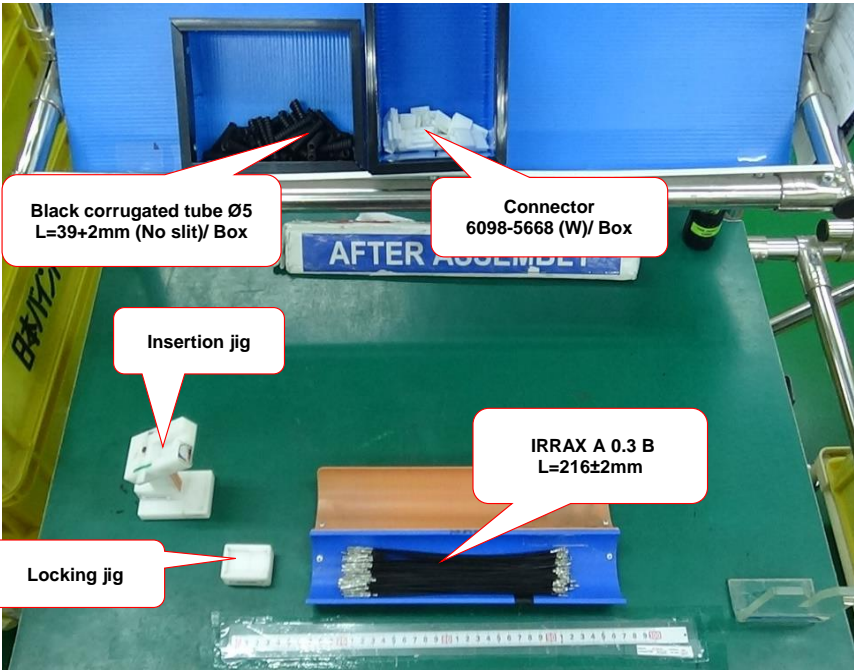


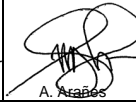

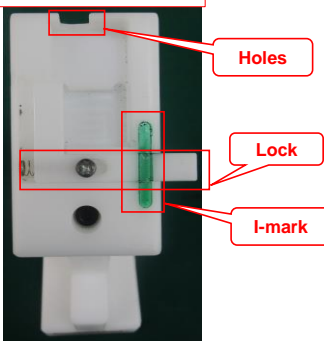
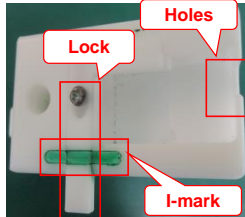
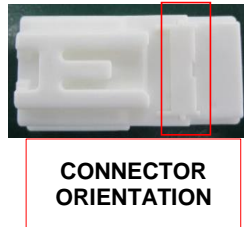
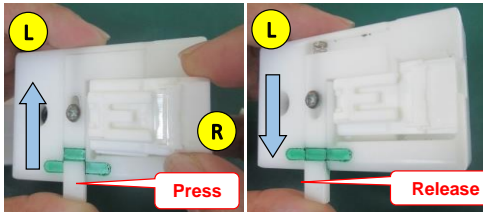
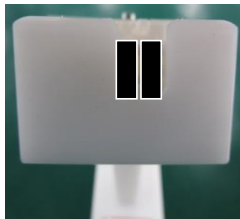
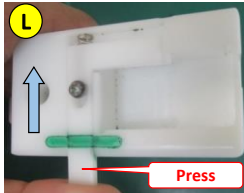
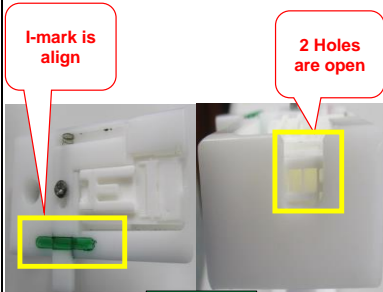
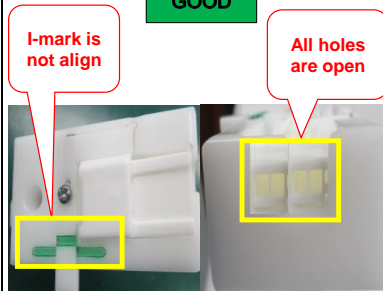
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	Process Name/Title:				Validity Date:		n/a	
	Model code/Part number: 164B / 7M0547-7020C		Customer: TRJ	Car Model: TOYOTA AURIS	Document No.:		WI-ENG-PDE-114	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		3	Page No.:	1 of 6	

PARTS:		1. All parts: Connector 6098-5668 (W); Black corrugated tube Ø5 L=39+2mm (No slit); IRRAX A 0.3 B L=216±2mm		JIG:		1. Insertion jig 2. Locking jig	
NO.	PROCESS NAME	3	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 references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.		
1. No missing parts/tools 2. No excess parts/tools							


Revision History						Prepared by	Reviewed by	Approved by	Noted by	
05/17/24	3	Transfer to new format from Kitting Assembly process to Offline Assembly process. Inclusion of table lay-out, Measurement, Visual inspection and Car model "TOYOTA AURIS". Update connector lock Work Procedure/Illustration. Transfer Wire insertion to corrugated tube(no slit) Ø5 L=39+2mm process from Taping assembly process to Offline assembly process due to Process improvement.	D.Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
05/20/21	2	Removal of validity date. Apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
11/19/20	1	Changed effectivity and validity date. Remove cycle time.	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	February 01, 2018		



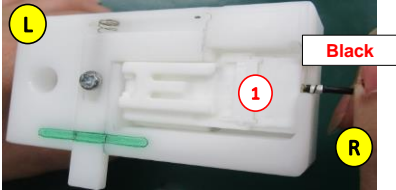
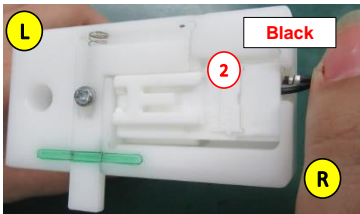
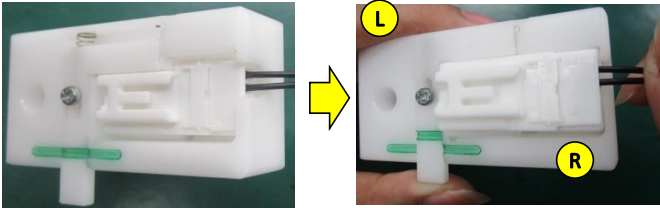
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	<div style="text-align: right;">DCC Stamp</div>

		WORK INSTRUCTION				Effectivity Date:		May 17, 2024		
		OFFLINE ASSEMBLY PROCESS				Validity Date:		n/a		
		Model code/Part number: 164B / 7M0547-7020C		Customer: TRJ	Car Model: TOYOTA AURIS		Document No.:		WI-ENG-PDE-114	
		Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		3	Page No.:	2 of 6
		PARTS:		1. Connector 6098-5668 (W)				JIG:		1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS		
2	Offline	<div><div><div>INSERTION JIG</div><div></div><div></div><div></div><div></div><div><p>2. Insert the connector 6098-5668 (W) into jig using right hand and release the lock. Note: Follow the connector orientation.</p></div><div></div><div><p>3. Check the holes/terminal slot for B-B wires.</p></div></div><div><div></div><div><p>1. Press the lock of insertion jig using left thumb.</p></div></div></div>				n/a		<div><div><div>Connector Orientation Illustration</div><div></div><div></div><div><p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p></div></div></div>		

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	Model code/Part number: 164B / 7M0547-7020C		Customer: TRJ	Car Model: TOYOTA AURIS	Document No.:	WI-ENG-PDE-114	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	3	Page No.:	3 of 6

PARTS:	1. IRRAX A 0.3 B L=216±2mm [2pcs.] 2. Black Corrugated tube (no slit) Ø5 L=39+2mm			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	<div> <div>3</div> <p>Wire insertion to corrugated tube (no slit) Ø5 L=39+2mm</p> </div>	<div>  <div> <p>1. Get black corrugated tube Ø5 L=39+2mm using left hand and get 2pcs IRRAX A 0.3 B L=216±2mm then insert sing right hand.</p> </div> </div>		n/a	1. No wrong usage of parts 2. No deformed terminal Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.
4	<div> <p>Offline</p> <p>Wire insertion to connector 6098-5668 (W)</p> <div> <div>3</div> </div> </div>	<div> <div>  <p>Wire facing</p> </div> <div>  <p>1. Get the B 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. </p> </div> <div>  <p>2. Get the B wire then insert to terminal slot 2 using right hand.</p> </div> <div>  <p>3. After insertion, push the lock button using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p> </div> </div>			<div> <div>3</div> <p>Important reminders/Note/s:</p> <p>1. Insertion of wire must be from left to right.</p> <p>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push 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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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


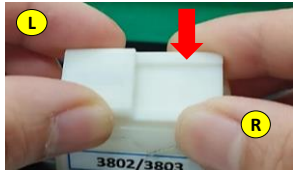
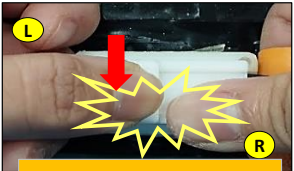


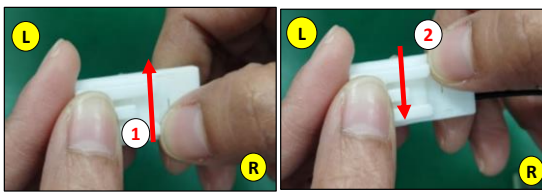




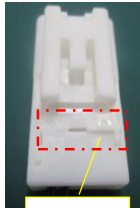
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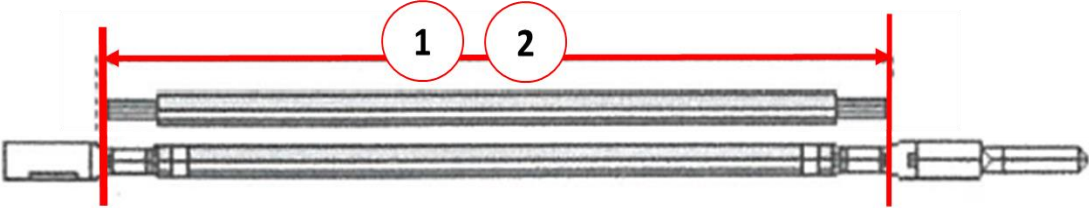

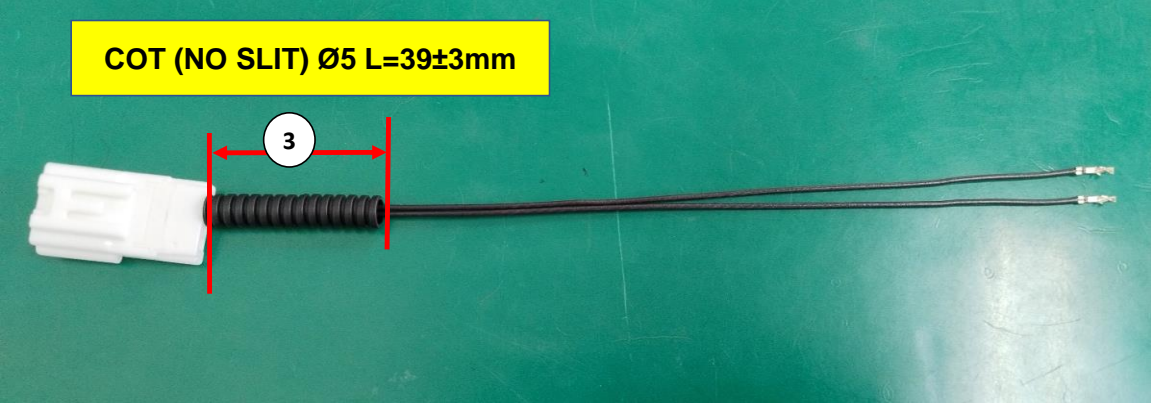
PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	3 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Offline Connector Lock	<div><div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div><div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div><div><p>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> <div><div>LOCKING JIG</div></div> <div><p>1. Use the provided jig per connector 2. No unlock/half-locked coupler</p><p>Important reminders/Note/s: <i>1. Manual locking may cause damaged lock.</i></p><p>Document reference/s: <i>1. Refer to GL-PRO-ASY-017 for verification of connector lock.</i></p><div><p>Before pressing</p><p>After pressing</p></div><div><div><p>GOOD</p><p>Full Lock</p></div><div><p>NG</p><p>Half Lock</p></div></div></div>		

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	Process Name/Title:		Model code/Part number: 164B / 7M0547-7020C		Customer: TRJ	Car Model: TOYOTA AURIS	Document No.:	WI-ENG-PDE-114	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	3	Page No.:	5 of 6	

PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	3	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></div>	Measuring tape	<div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.</div> <div>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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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ VISUAL INSPECTION****OFFLINE INSERTION****7M0547-7020C**

1

**GOOD****NO GOOD**

3

**GOOD****NO GOOD**

4

5

2



1

No Unlock connector

3

No Terminal Backing Out

2

No Wrong insert

4

Check the Alignment

5

No Deformed terminal

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