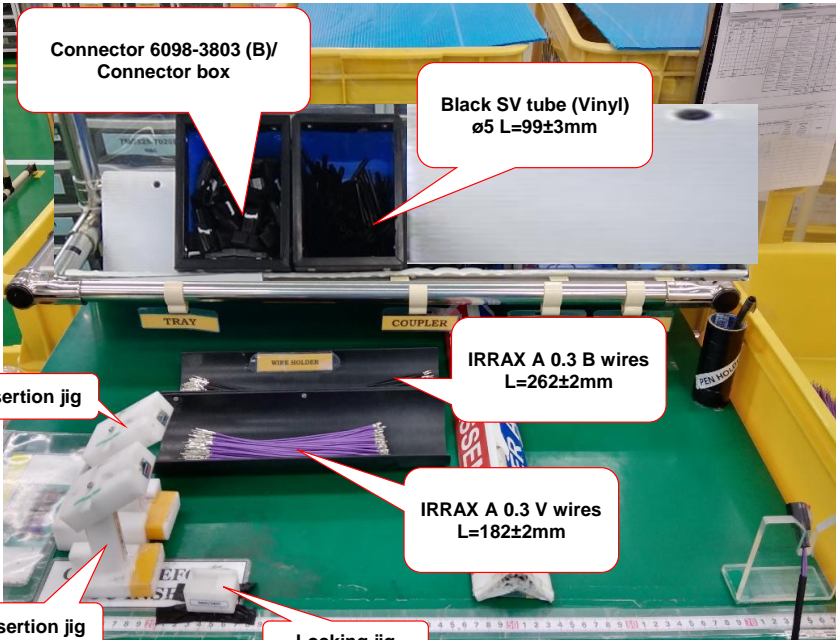
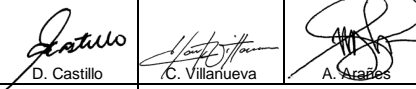

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	Model code/Part number: 400B / 7M0597-7020B		Customer: TRJ	Car Model: TOYOTA-VITZ	Document No.:	WI-ENG-PDE-256		
	Purpose: <input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	4	Page No.:	1 of 9

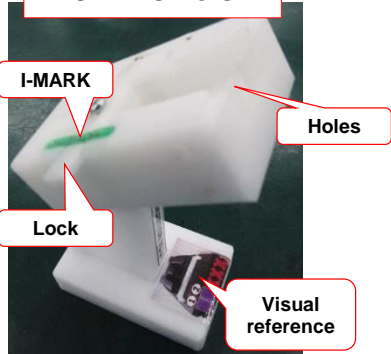
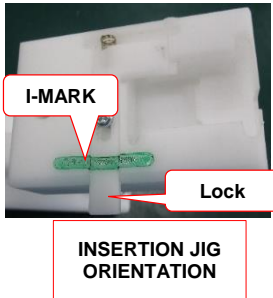

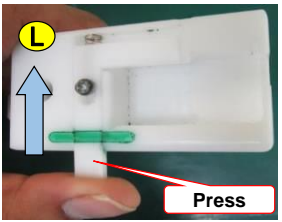
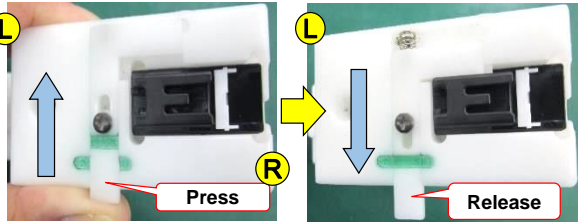

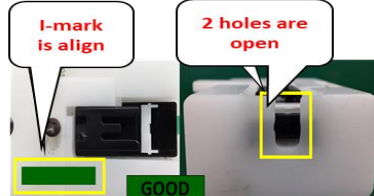



PARTS:		1. Connector 6098-3803 (B); IRRAX A 0.3 B wires L=262±2mm; IRRAX A 0.3 V wires L=182±2mm; Black SV tube (Vinyl) ø5 L=99±3mm				JIG:		1. Insertion jig 2. Locking jig		
NO.	PROCESS NAME	<div style="text-align: center;">  </div>				TOOLS/PPE		QUALITY POINTERS		
1	Offline Table Lay-out					<div style="border: 1px solid red; padding: 5px;"> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px; margin-top: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px solid red; padding: 5px; margin-top: 10px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>		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		
Revision History										
09/25/24	4	Transfer SV tube insertion to Taping assembly process. Inclusion of car model "TOYOTA-VOTZ" and Measurement. Improved Table lay-out and Visual inspection/Quality checkpoints.Standard the term of SV tube (Vinyl).				D.Castillo	C.Villanueva	A. Arañes	N/A	<div style="text-align: center;">  </div>
09/17/22	3	Add Wire insertion to Black vinyl tube ø4 L=37±3mm process from Taping assembly process due to 1MP improvement. Improve Connector lock process.				D.Castillo	J. Loterte	C. Villanueva	A. Arañes	
11/05/21	2	Improve work procedure and illustration. Additional table lay-out. Add note in checking of wire tolerance. Inclusion of process of wire insertion to connector B/B wires.				M.Catapan g	J. Loterte	C. Villanueva	A. Arañes	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date: May 4, 2021

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PARTS:		1. Connector 6098-3803 (B)				JIG:		1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
2	Offline Connector setting to insertion jig 6098-3803 (B)	<div><div><div><div><div>INSERTION JIG 1</div><div></div><div></div><div></div></div><div><div></div><div></div></div><div></div><div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6098-3803 (B) into jig using right hand and release the lock using left hand.</div><div>3. Check the holes/terminal slot for V-V wires.</div></div></div></div><div><div>n/a</div></div><div><div><div><div><div>Connector Orientation Illustration</div><div></div><div></div></div><div><div>CONNECTOR ILLUSTRATION</div><div></div><div></div></div></div><div><div>1. Use the provided jig per model</div><div>2. No wrong orientation of connector</div><div>3. No wrong use of connector</div><div>4. No damaged connector</div></div></div></div></div>							

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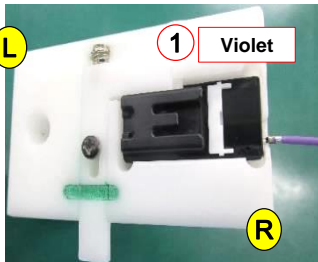
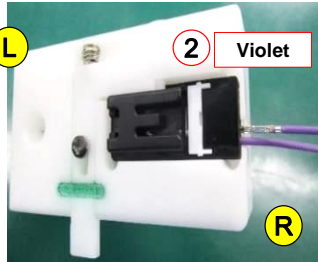
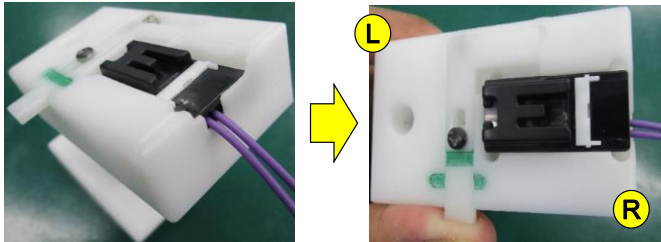
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PARTS:	1. IRRAX A 0.3 V wires L=182±2mm [2pcs]		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Offline	<div>Wire insertion to connector 6098-3803 (B)</div> <div><div><div><p>WIRE FACING</p></div><div><div><div><p>1. Get the 1st V wire and then insert to terminal slot 1 of connector using right hand.</p></div><div><div><p>2. Get the 2nd V wire and then insert to terminal slot 2 of connector using right hand.</p></div><div><div><p>3. After insertion, push the lock using left thumb and then hold the wires and gently pull out connector from jig using right hand.</p></div></div></div></div></div></div></div>	n/a	<div>Important reminders/note/s:</div> <div>1. Insertion of wire must be from left to right.</div> <div>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-CNC-017 for wire and strip length tolerance.</div> <div>2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div> <div>1. No loose insertion</div> <div>2. No wrong insertion</div> <div>3. One by one insertion</div> <div>4. No deformed terminal</div> <div>5. No wrong wire facing</div>

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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>INSERTION JIG 2</div><div><div><div>I-MARK</div><div>Holes</div><div>Lock</div><div>Visual reference</div></div><div><div>I-MARK</div><div>Lock</div></div><div>CONNECTOR ORIENTATION</div><div>INSERTION JIG ORIENTATION</div><div><div><div>L</div><div>↑</div><div>Press</div></div><div><div>L</div><div>↑</div><div>Press</div><div>R</div><div>↓</div><div>Release</div></div></div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6098-3803 (B) into jig using right hand and release the lock using left hand.</div><div><div>3. Check the holes/terminal slot for B-B wires.</div></div></div></div> <div>n/a</div> <td><div><div>Connector Orientation Illustration</div><div><div><div>I-mark is align</div><div>2 holes are open</div><div>GOOD</div></div><div><div>I-mark is not align</div><div>All holes are open</div><div>NG</div></div></div><div>CONNECTOR ILLUSTRATION</div><div><div>GOOD</div><div>6098-3803 (B)</div><div>NG</div><div>6098-3802 (W)</div></div><div><div>1. Use the provided jig per model</div><div>2. No wrong orientation of connector</div><div>3. No wrong use of connector</div><div>4. No damaged connector</div></div></div></td>	<div><div>Connector Orientation Illustration</div><div><div><div>I-mark is align</div><div>2 holes are open</div><div>GOOD</div></div><div><div>I-mark is not align</div><div>All holes are open</div><div>NG</div></div></div><div>CONNECTOR ILLUSTRATION</div><div><div>GOOD</div><div>6098-3803 (B)</div><div>NG</div><div>6098-3802 (W)</div></div><div><div>1. Use the provided jig per model</div><div>2. No wrong orientation of connector</div><div>3. No wrong use of connector</div><div>4. No damaged connector</div></div></div>	

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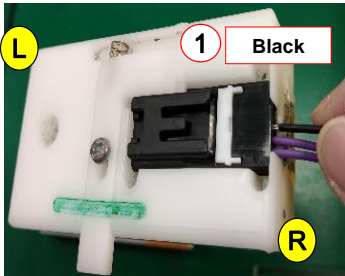
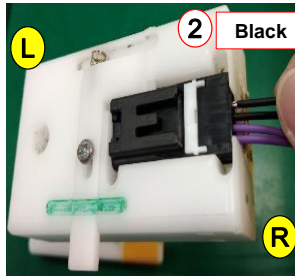
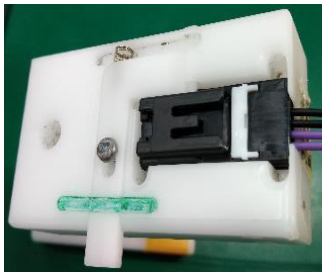

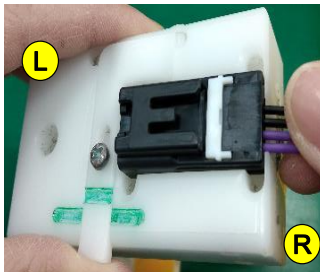
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PARTS:		1. Assy parts 2. IRRAX A 0.3 B wires L=262±2mm [2pcs]		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Offline	<div><div></div><div>WIRE FACING</div><div></div><div><p>1. Get the 1st B wire and then insert to terminal slot 1 of connector using right hand.</p></div><div></div><div><p>2. Get the 2nd B wire and then insert to terminal slot 2 of connector using right hand.</p></div><div></div><div></div><div></div><div><p>3. After insertion, push the lock using left thumb and then hold the wires and gently pull out connector from jig using right hand.</p></div></div>		n/a	<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 <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-CNC-017 for wire and strip length tolerance.</p> <p>2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</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>

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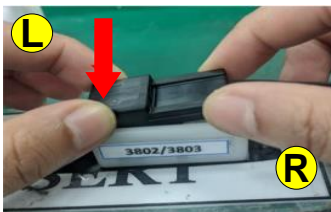




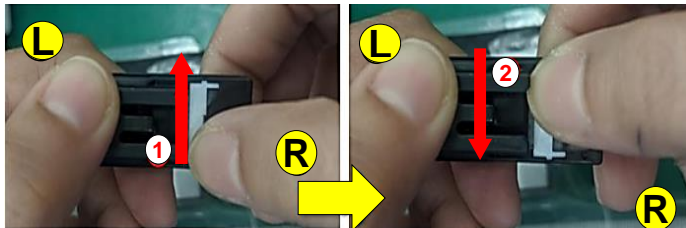





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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	Offline Connector lock	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div> <div><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 touching the connector lock based on the sequence illustrated.</p></div>		<div>LOCKING JIG</div> 	<p>1. No Unlock and half-locked 2. Use provided jig tools per model to avoid damaged lock.</p> <p>Important reminders/Note/s: 1. Manual locking may cause damaged connector</p> <p>Document references: 1. Refer to GL-PRO-ASY-017 for the verification of lock</p> <div><p>Before pressing</p><p>After pressing</p></div> <div><p>GOOD Full Lock</p><p>NG Half Lock</p></div>

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PARTS:

1. Black SV tube (Vinyl) $\varnothing 5$ L=99 \pm 3mm
2. Assy parts

JIG:

n/a

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

7

Offline

Wire insertion to
Black SV tube (Vinyl) $\varnothing 5$
L=99 \pm 3mm



1. Get the SV tube (Vinyl) $\varnothing 5$ L=99 \pm 3mm using right hand then insert the **B-B wires** using left hand.



2. Continue to insert the **V-V wires** using left hand.



n/a

1. No wrong use of parts
2. No deformed terminal

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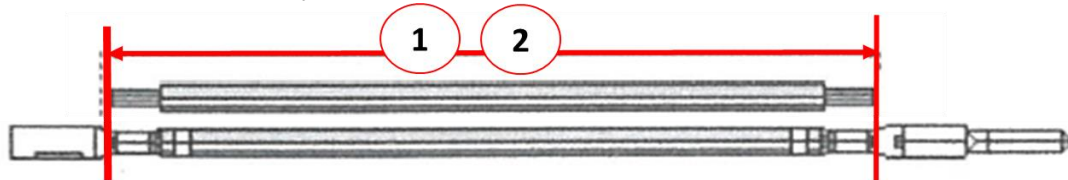
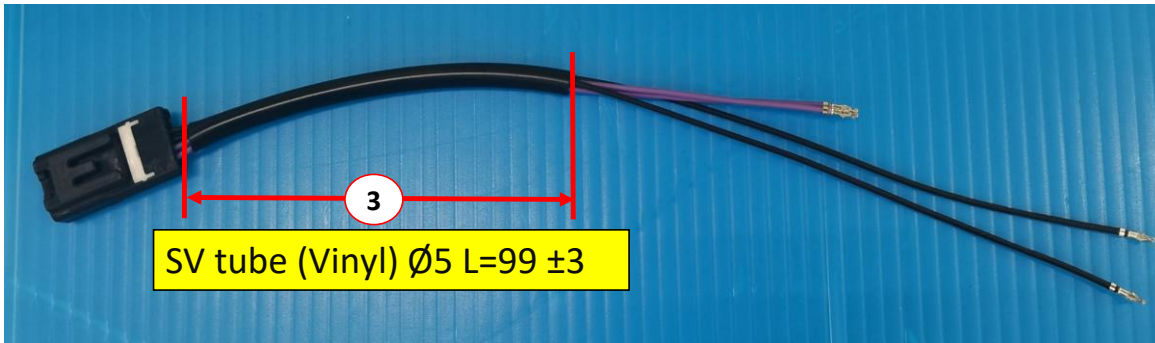

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	Offline Measurement	<p>Note:</p> <ol style="list-style-type: none">1. Measurement point: End of core wire to the end of core wire2. Terminal is reference only.   <p>SV tube (Vinyl) $\varnothing 5$ L=99 ± 3</p>	<div>MEASURING TAPE</div> 	<p>Important reminders and note/s:</p> <ol style="list-style-type: none">1. Please use calibrated/verified measuring tape when getting the measurement.2. For Hatsumono, Nakamono and Owarimono. <p>Document reference/s:</p> <ol style="list-style-type: none">1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection <p>1. No wrong dimension</p>

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PARTS:

1. Assy parts

JIG:

N/A

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7M0597-7020B****1****GOOD****NO GOOD****3****4****2****5****GOOD****NO GOOD**

- 1** No **Unlocked/ Half-locked Connector**
- 2** No **Wrong insert**
- 3** No **Missing SV tube (Vinyl)**

- 4** No **Deformed Terminal**
- 5** No **Terminal Backing**

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