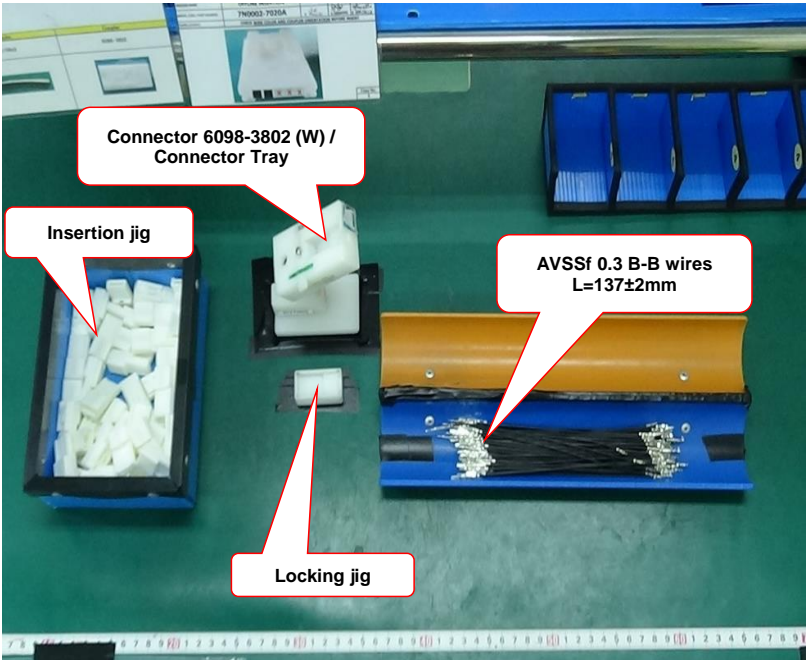

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	OFFLINE ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 150B / 7N0001-7020A		Customer: TRMX	Car Model: TOYOTA COROLLA		Document No.:
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		2	Page No.: 1 of 6

PARTS:	1. All parts: Connector 6098-3802 (W); AVSSf 0.3 wires B L=137mm			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 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				Prepared by	Reviewed by	Approved by	Noted by
05/22/24	2	Inclusion of all improvements (Table lay-out; important reminders and note/s; Document references; Measurements, Visual inspection and Car model"TOYOTA-COROLLA"). Change assembly process name from kitting assembly to offline assembly and improve work procedure/Illustration on process 1 connector lock. Transfer to new format.	D.Castillo	C.Villanueva	A. Arañes	n/a	
03/15/21	1	Revise due to standardize the color of connector in accordance with color standardization of plastic parts (Please refer to GL-COM-003 for Color Standardization for Plastic Parts). Apply some improvements. Removal of cycle time.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	
09/15/20	0	Initial issue	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: September 15, 2020

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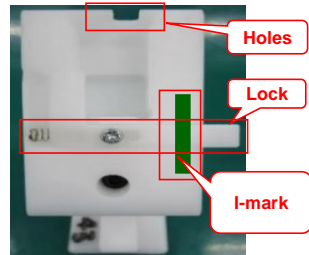
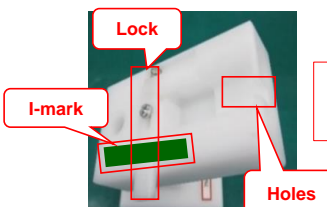
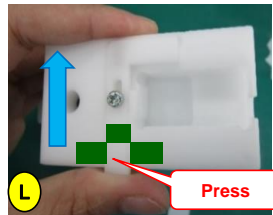
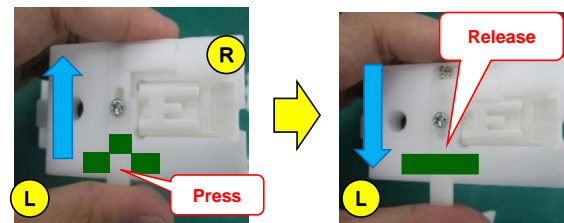





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PARTS:		1. Connector 6098-3802 (W)		JIG:	1. Insertion Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Offline Connector Setting to Insertion jig 6098-3802 (W)	<div><div><div>INSERTION JIG</div><div></div><div><div>Lock</div><div>I-mark</div><div>Holes</div></div><div>CONNECTOR ORIENTATION</div><div></div><div>INSERTION JIG ORIENTATION</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 6098-3802 (W) into jig using right hand then release the lock.</div><div>3. Check the holes/terminal slot for B-B wires.</div></div><td>n/a</td><td><div><div>Connector Orientation Illustration</div><div><div><div>I-mark is align</div><div>2 Holes are open</div></div><div></div><div>GOOD</div></div><div><div><div>I-mark is not align</div><div>All holes are open</div></div><div></div><div>NG</div></div></div><div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector/wire facing</div></td></div>		n/a	<div><div>Connector Orientation Illustration</div><div><div><div>I-mark is align</div><div>2 Holes are open</div></div><div></div><div>GOOD</div></div><div><div><div>I-mark is not align</div><div>All holes are open</div></div><div></div><div>NG</div></div></div> <div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector/wire facing</div>

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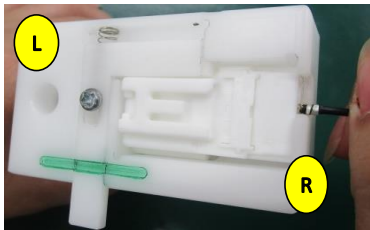
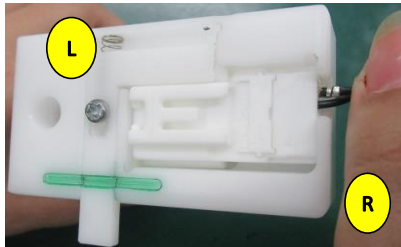
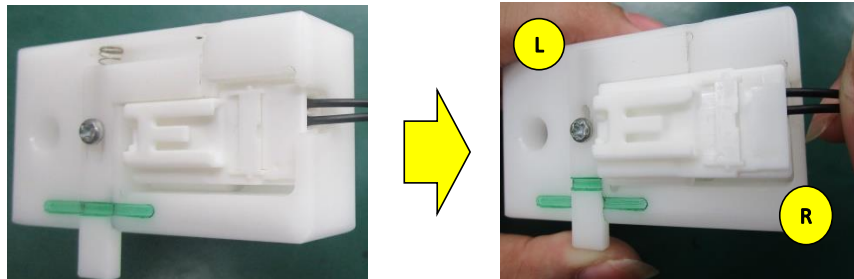
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PARTS:	1. AVSSf 0.3 wires B L=137±2mm [2pcs.]			JIG:	1. Insertion Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Offline Wire insertion to connector 6098-3802 (W)	<div><div>WIRE FACING</div></div> <div><div>1. Get Black wire then insert to terminal slot ① using right hand. Note: Insertion must be from left to right.</div></div> <div><div>2. Get 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>2</div> <div>Important reminders/note/s: <i>1. Make sure wires are properly inserted.</i> <i>Conduct Pull-Push-Pull-Push after insertion.</i> <i>Do not exert extra force.</i></div> <div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div>

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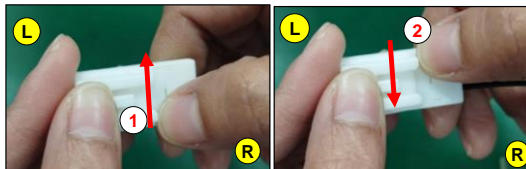




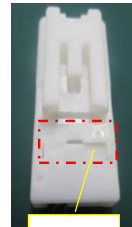
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PARTS:		1. Assy parts		JIG:	1. Locking Jig
NO.	PROCESS NAME	2 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	n/a	Connector Lock	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div> <div><p>2. 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 slide touching the connector lock based on the sequence illustrated.</p></div>	<div><p>LOCKING JIG</p></div>	<div><p>Before pressing</p></div> <div><p>After pressing</p></div> <div><div><p>Full Lock</p></div><div><p>Half Lock</p></div></div> <p>GOOD NG</p> <p>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR.</p> <p>1. Use the provided jig tool to lock the connector. 2. No unlock/half-locked connector</p>

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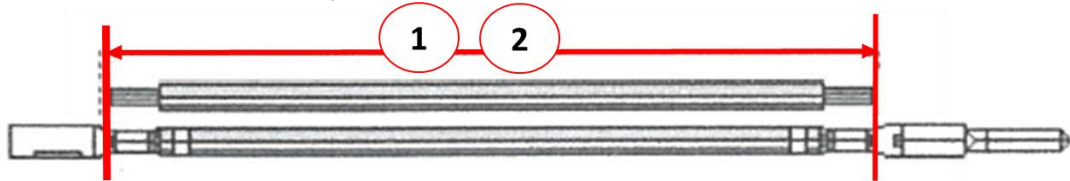

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PARTS:	1. Assy part		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Offline	Measurement	<div>Measuring tape</div> 	<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when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

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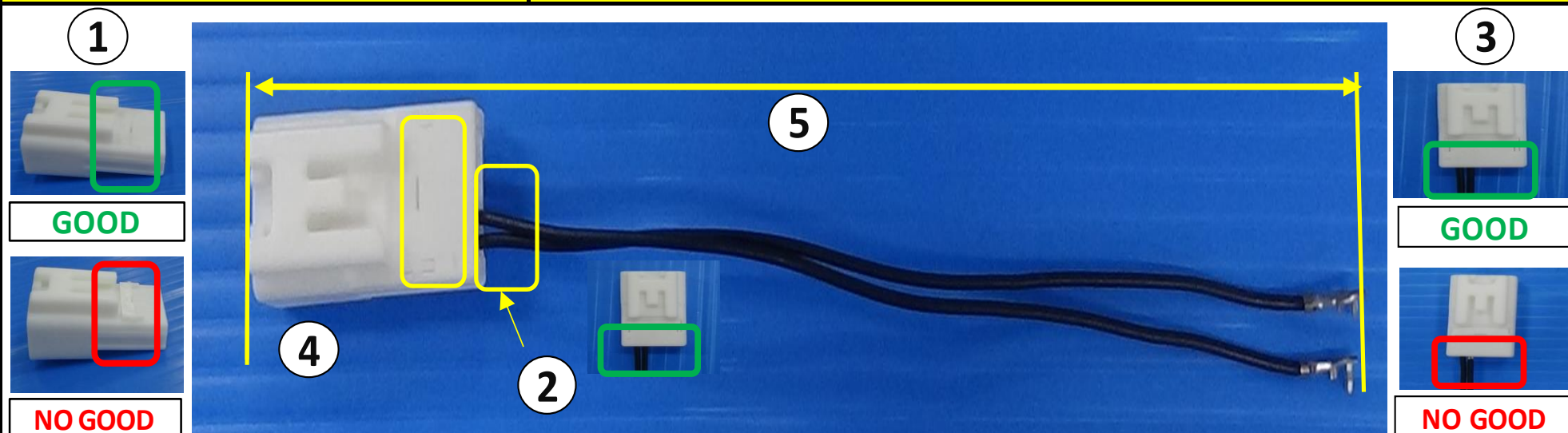
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7N0001-7020A****1****No Unlocked/
Half-locked connector****2****No Wrong insert****3****No Terminal Backing Out****4****No Deformed terminal****5****Check the Alignment**

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