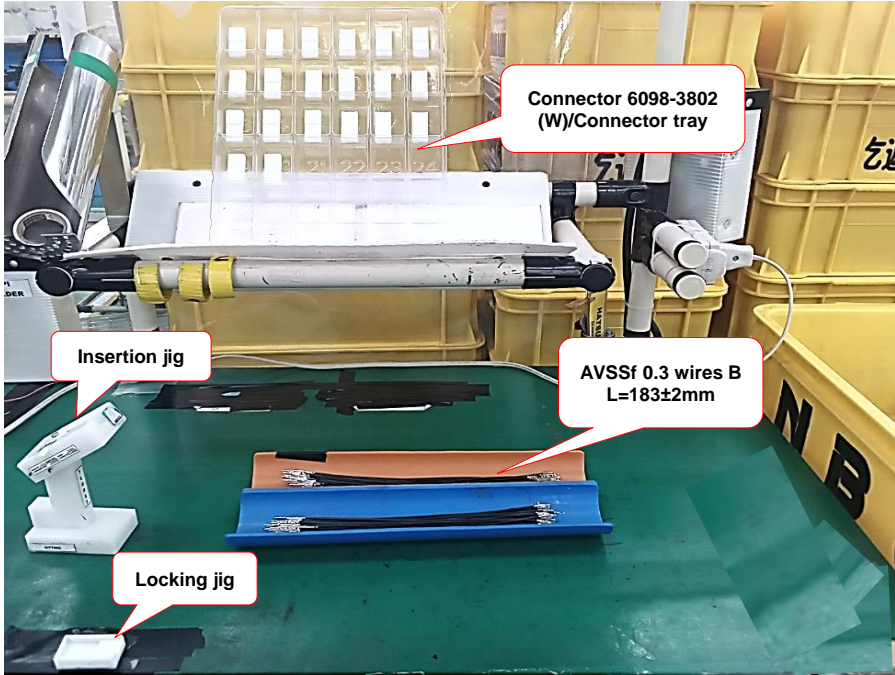

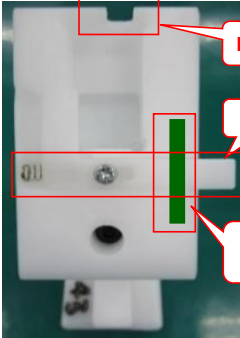
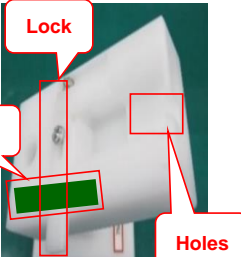

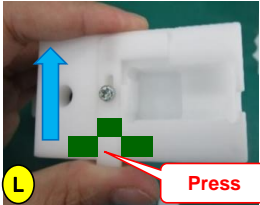
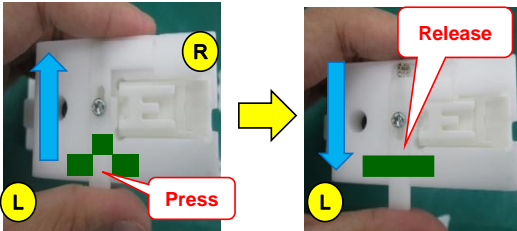



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	<b>OFFLINE ASSEMBLY PROCESS</b>			Validity Date:	<b>n/a</b>		
	Process Name/Title:			Document No.:	<b>WI-ENG-PDE-337</b>		
	Model code/Part number:	<b>177D / 7R0112-7020</b>	Customer:	<b>TRMX</b>	Car Model:	<b>TOYOTA COROLLA</b>	
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	<b>2</b>	Page No.:	<b>1 of 6</b>

PARTS:	1. All parts (AVSSf 0.3 wires B L=183±2mm); Connector 6098-3802 (W)			JIG:	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	Offline	Table Lay-out	<div>TABLE LAY-OUT</div> 	<div><b>Safety Instruction</b></div> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) <div><b>Housekeeping</b></div> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. <div><b>Alert level</b></div> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	<b>Document reference/s:</b> 1.Refer to <b>WI-PRO-CNC-017</b> 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
06/11/24	2	Inclusion of Car model :TOYOTA-COROLLA*, Measurement and Visual inspection. Update Connector lock process.	D. Castillo	C.Villanueva	A. Arañes	n/a			
03/15/22	1	Change from Pre-Launch to Masspro and Title from Kitting Assembly to Offline Assembly Process. Additional Table Lay-out.	M. Ariola	J. Loterte	C.Villanueva	A. Arañes			
10/12/21	0	Initial issue.	M. Ariola	J. Loterte	C.Villanueva	A. Arañes			
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 12, 2021	

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		OFFLINE ASSEMBLY PROCESS				Validity Date:		n/a		
		Model code/Part number: 177D / 7R0112-7020		Customer: TRMX	Car Model: TOYOTA COROLLA	Document No.:		WI-ENG-PDE-337		
		Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		2	Page No.:	2 of 6
		PARTS:		1. Connector 6098-3802 (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>Lock</div><div>I-mark</div><div>Holes</div></div><div><div>CONNECTOR ORIENTATION</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 <b>6098-3802 (W)</b> into jig using right hand and release the lock.</div><div>3. Check the holes/terminal slot for <b>B-B wires</b>.</div></div>				n/a		<div><div>Connector Orientation Illustration</div><div><div>I-mark is align</div><div>2 Holes are open</div></div><div>GOOD</div><div><div>I-mark is not align</div><div>All holes are open</div></div><div>NG</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>		

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**177D / 7R0112-7020**

Customer:

**TRMX**

Car Model:

**TOYOTA COROLLA**

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**WI-ENG-PDE-337**

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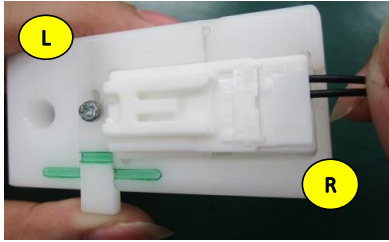
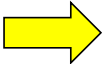
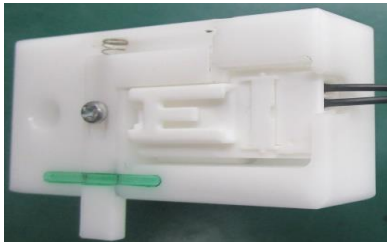
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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<b>PARTS:</b>	1. AVSSf 0.3 wires B L=183±2mm [2pcs]			JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
3	Offline Wire insertion to Connector 6098-3802 (W)	<div><div>WIRE FACING</div></div> <div><div>1. Get <b>Black wire</b> then insert to terminal slot ① using right hand.</div></div> <div><div>2. Get <b>Black wire</b> 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	<p><b>Important reminders/note/s:</b></p> <p>1. Insertion of wire 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><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-CNC-017</b> for wire and strip length tolerance.</p> <p>2. Refer to <b>GL-PRO-ASY-029</b> 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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# WORK INSTRUCTION

Process Name/Title:

## OFFLINE ASSEMBLY PROCESS

Effectivity Date:

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n/a

Model code/Part number:

177D / 7R0112-7020

Customer:

TRMX

Car Model:

TOYOTA COROLLA

Document No.:

WI-ENG-PDE-337

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH



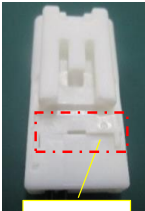
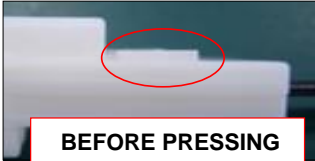
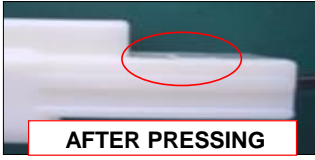
☒ MASSPRO

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PARTS:	1. Assy Parts		JIG:	1. Locking jig
NO.	PROCESS NAME	<div>2</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Offline	Connector Lock	<div>LOCKING JIG</div> <div></div>	<div>1. Use the provided jig per connector</div> <div>2. No unlock/half-locked of connector lock</div> <div><b>Important reminders/note/s:</b></div> <div>1. <b>MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</b></div> <div><b>Document reference/s:</b></div> <div>1. Please refer to <b>GL-PRO-ASY-017</b> for the verification of connector lock.</div> <div><div><div>GOOD</div><div></div><div>Full Lock</div></div><div><div>NG</div><div></div><div>Half Lock</div></div></div> <div><div></div><div>BEFORE PRESSING</div></div> <div><div></div><div>AFTER PRESSING</div></div>

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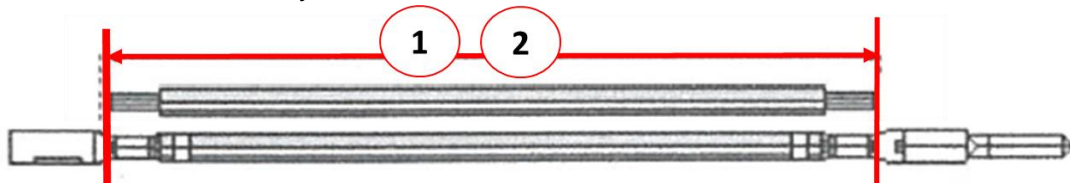

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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

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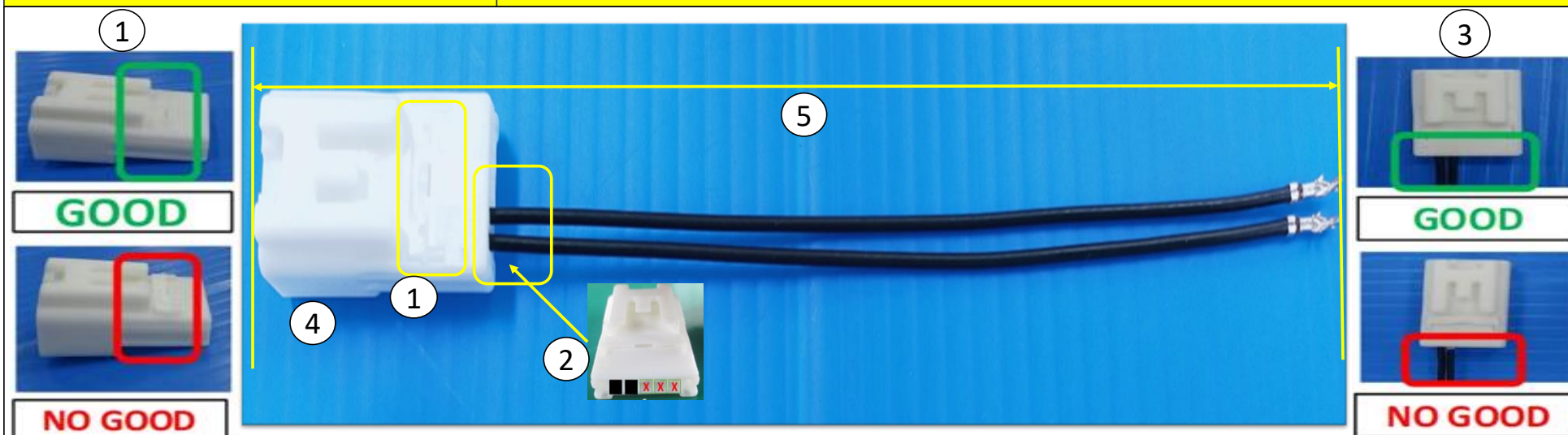
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7R0112-7020**

① **No Unlocked/Half-locked Connector**

③ **No Terminal Backing Out**

⑤ **Check the Alignment**

② **No Wrong insert**

④ **No Deformed terminal**

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