



## WORK INSTRUCTION

Process Name/Title:

## OFFLINE ASSEMBLY PROCESS

Effectivity Date:

October 22, 2024

Validity Date:

n/a

Model code/Part number:

800B/900B/910B / 7N0101-7020D

Customer:

TRJ

Car Model:

LEXUS-NX/RX

Document No.:

WI-ENG-PDE-1143

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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## PARTS:

- Connector 6098-3810 (W)
- Black SV tube (Vinyl)  $\phi 5$  L=69 $\pm$ 3mm

- AVSSf 0.3 B-B wires L=679 $\pm$ 3mm

JIG:

- Insertion jig
- Locking jig

NO.

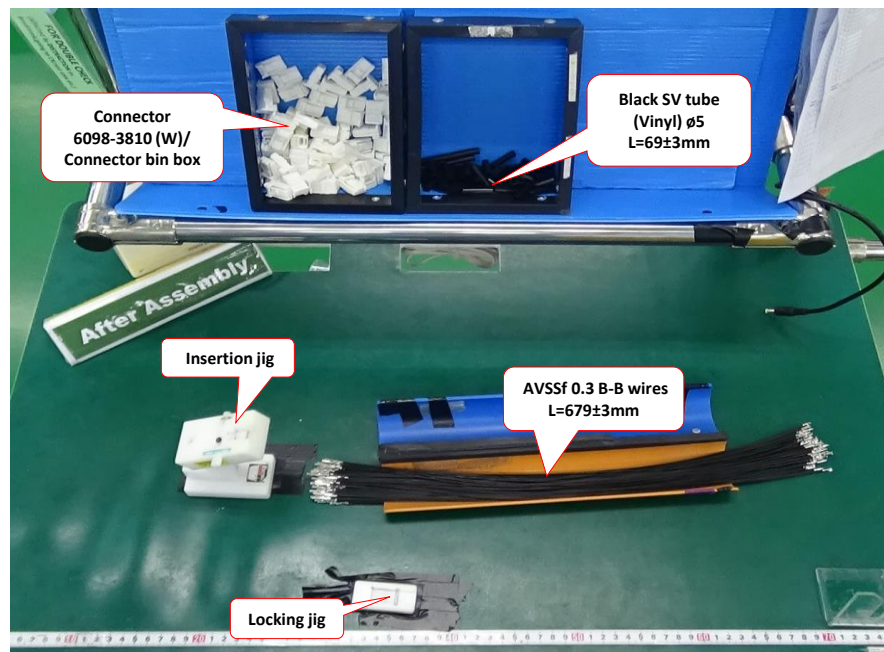
PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

## TABLE LAY-OUT



## Safety Instruction

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

## Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

## Alert level




For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

## 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

Revision History								Prepared by	Reviewed by	Approved by	Noted by
											
10/22/24	1	Change Pre-launch to Masspro	A. Hernandez	C. Villanueva	A. Arañes	n/a					
10/17/24	0	Initial Issue.	A. Hernandez	C. Villanueva	A. Arañes	n/a					
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 17, 2024			

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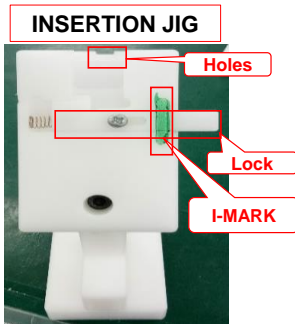
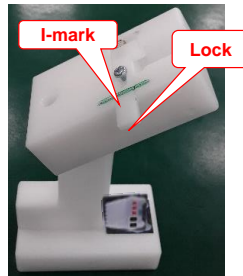
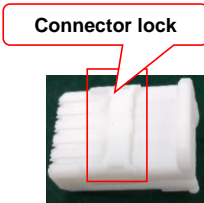
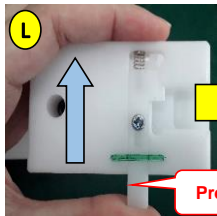
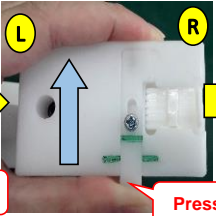
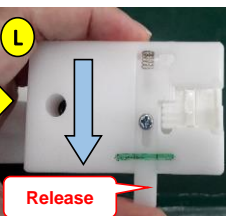




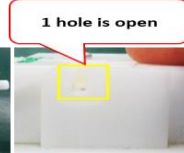

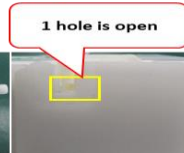
☒ MASSPRO

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PARTS:		1. Connector 6098-3810 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Offline  Connector setting to Insertion jig 6098-3810 (W)	<div><div><p>INSERTION JIG</p></div><div><p>Insertion Jig Orientation</p></div><div><p>CONNECTOR ORIENTATION</p></div></div> <div><div><p>1. Press the lock of insertion jig using left thumb.</p></div><div><p>2. Get the connector <b>6098-3810 (W)</b> using right hand then insert to jig using right hand and release the lock using left thumb. <i>Note: Follow the connector orientation.</i></p></div><div><p>3. Check the holes/terminal slot for <b>B-B wires</b>.</p></div><div></div></div>		N/A	<div><div><p>GOOD</p><p>6098-3810 (W)</p></div><div><p>NG</p><p>6098-5677 (W)</p></div></div> <div><p>Connector Orientation Illustration</p><div><div><p>I-mark was align</p></div><div><p>1 hole is open</p></div></div><p>GOOD</p><div><div><p>I-mark is NOT align</p></div><div><p>1 hole is open</p></div></div><p>NG</p></div>

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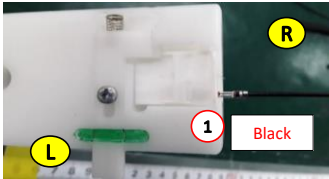
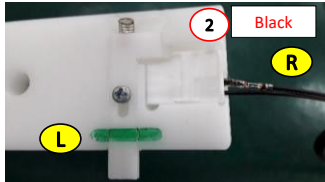
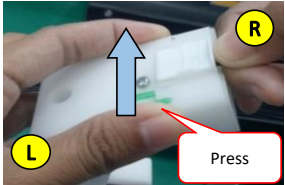
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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<b>PARTS:</b>	1. Black SV tube (Vinyl) $\phi 5$ L=69 $\pm$ 3mm    2. AVSSf 0.3 B-B wires L=679 $\pm$ 3mm    3. Connector 6098-3810 (W)			JIG:	1. Inserton jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
3	Wire insertion to Black SV tube (Vinyl) $\phi 5$ L=69 $\pm$ 3mm			n/a	1. No wrong use of parts 2. No deformed terminal
4	Offline Wire insertion to connector 6098-3810 (W)	 <b>TERMINAL FACING</b>   		n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing  <b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal.</b> <b>2. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b>  <b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b> <b>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b>

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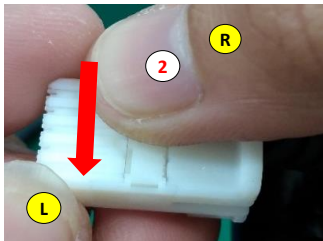
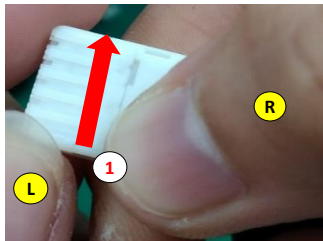
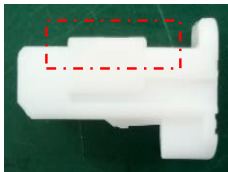
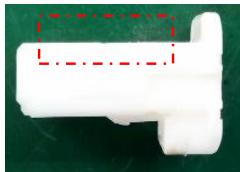

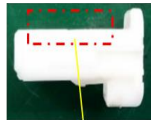
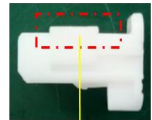
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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Offline Connector Lock	<div><div>1. Put the connector into locking jig using right hand then press 2x using both hands. Touch the connector lock to confirm if properly locked.</div></div> <div><div>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</div><div><div>Before Pressing</div><div>After Pressing</div></div></div>		<div>LOCKING JIG</div> 	<div>1. Use the provided jig per connector</div> <div>2. No unlock/half-locked connector</div> <div><b>Important reminders/Note/s:</b></div> <div>1. <b>MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b></div> <div><b>Document reference/s:</b></div> <div>1. <b>Please refer to GL-PRO-ASY-017 for the verification of connector lock.</b></div> <div><div>CONNECTOR LOCK CONDITION</div><div><div><div>GOOD</div><div>Fully Locked</div></div><div><div>NG</div><div>UnLocked</div></div></div></div>

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**PARTS:**

1. Assy part

JIG:

n/a

**VISUAL INSPECTION / QUALITY CHECKPOINTS****OFFLINE INSERTION****7N0101-7020D****1** No Unlocked / Halflocked Connector**2** No Wrong Insert**3** No Terminal Backing Out**4** No Deformed Terminal

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