



## WORK INSTRUCTION

Process Name/Title:

## OFFLINE ASSEMBLY PROCESS

Effectivity Date:

July 25, 2024

Validity Date:

n/a

Model code/Part number:

491D/564D / 7R0151-7020A

Customer: TRMX

Car Model: TOYOTA-SEQUOIA

Document No.:

WI-ENG-PDE-989

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

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## PARTS:

1. Connector 6098-6663 (B); IRRAX A Rope-lay 0.3 B wires L=221±2mm; Black COT (no slit) ø5 L=153±3mm

JIG:

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

OFFLINE

Table lay-out

Connector 6098-6663 (B)/  
Connector Tray

Table Lay-out

Black COT (no slit)  
ø5 L=153±3mmIRRAX A ROPE-LAY 0.3 B  
wires L=221±2mm

Locking jig

**Safety Instruction**

Be sure to wear required 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.

1. No missing parts/tools
2. No excess parts/tools

**Document references:**

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

## Revision History

Prepared by

Reviewed by

Approved by

Noted by

07/25/24 0 Initial issue. Separate process from Taping assembly process.

D. Castillo C. Villanueva A. Arañes n/a

Eff. Date Rev. No Details of Change

Revised Reviewed Approved Noted


Est. Date:

July 25, 2024



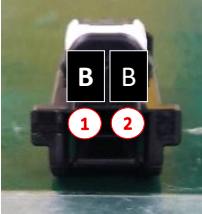

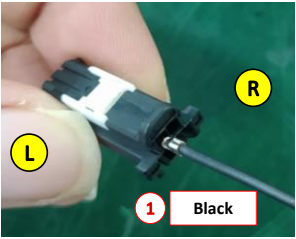
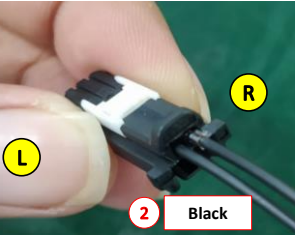
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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	<b>0</b>	Page No.:	<b>2 of 5</b>

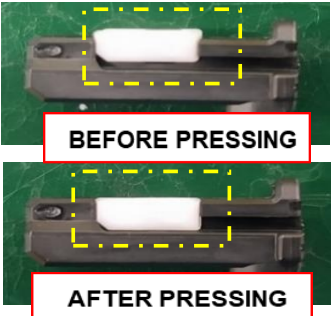
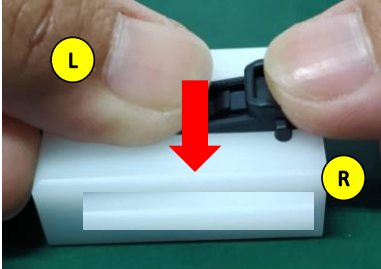
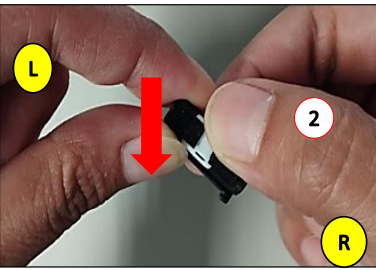
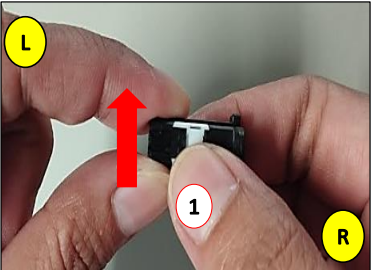

  

<b>PARTS:</b>	1. Connector 6098-6663 (B) 2. IRRAX A Rope-lay 0.3 B wires L=221±2mm [2pcs.] 3. Black corrugated tube ø5 L=153±3mm (no slit)			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	Wire insertion to black corrugated tube ø5 L=153±3mm (no slit)	 <div style="border: 1px solid black; padding: 5px; margin-top: 10px;">         1. Get the <b>Black corrugated tube ø5 L=153±3mm (no slit)</b> using left hand and get <b>B-B wires</b> using right hand then insert.       </div>		n/a	1. No deformed terminal 2. No wrong usage of parts
3	OFFLINE  Wire insertion to connector 6098-6663 (B)	<div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;">  <div style="border: 1px solid red; padding: 5px; text-align: center;"> <b>CONNECTOR ORIENTATION</b> </div> </div> <div style="width: 50%;">  <div style="border: 1px solid red; padding: 5px; text-align: center;"> <b>VISUAL REFERENCE</b> </div> </div> <div style="width: 50%;">  <div style="border: 1px solid red; padding: 5px; text-align: center;"> <b>WIRE FACING</b> </div> </div> <div style="width: 50%;">  <div style="border: 1px solid red; padding: 5px; margin-top: 10px;">         1. Hold the connector <b>6098-6663 (B)</b> then get the <b>first Black wire</b> and insert to terminal <b>slot 1</b> using right hand. Conduct <b>2x</b> push pull after wire insertion.  <b>Note: Make sure to hold the COT using right hand while insertion to prevent deformed in 7D0349 Terminal.</b> </div> </div> <div style="width: 50%;">  <div style="border: 1px solid red; padding: 5px; margin-top: 10px;">         2. Hold the connector <b>6098-6663 (B)</b> then get the <b>second Black wire</b> and insert to terminal <b>slot 2</b> using right hand. Conduct <b>2x</b> push pull after wire insertion.       </div> </div> </div>		n/a	1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing  <b>Important reminders/Note/s:</b> 1. <b>Please hold the wire near terminal.</b> 2. <b>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> 1. Refer to <b>GL-PRO-ASY-029</b> for <b>Pull-Push procedure.</b> 2. Refer to <b>WI-PRO-CNC-017</b> for <b>Wire and Strip Length Tolerance</b>

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	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:		0	Page No.:

<b>PARTS:</b>		1. Assy parts		JIG:	1. Locking jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
4	OFFLINE Connector lock	<div><p>1. Put the connector into locking jig using right hand then press to lock <b>2x</b> using both hands.</p></div> <div><p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div>		<div><b>LOCKING JIG</b></div> 	<p><b>Important reminders/Note/s:</b></p> <p><b>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b></p> <p>1. Use the provided jig per connector 2. No unlock/half-locked connector</p>	

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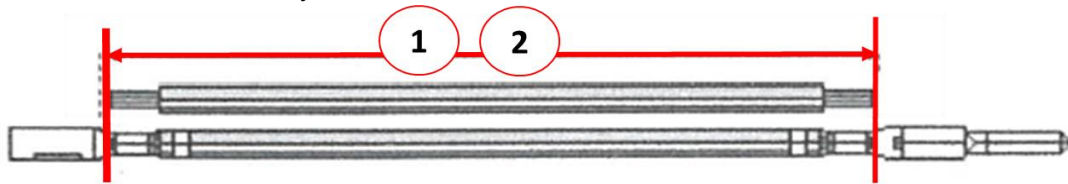
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	OFFLINE	<div>Measurement</div> <div><p>Note:</p><p>1. Measurement point: End of core wire to the end of core wire</p><p>2. Terminal is reference only.</p><p>COT Ø5 L=153±3</p></div>	<div>MEASURING TAPE</div>	<div><p><b>Important reminders and note/s:</b></p><p>1. Please use calibrated/verified measuring tape when getting the measurement.</p><p>2. For Hatsumono, Nakamono and Owarimono.</p><p><b>Document reference/s:</b></p><p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p></div>
			<div>1. No wrong dimension</div>	

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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7R0151-7020A****1****GOOD****NO GOOD****2****GOOD****NO GOOD****1****3****1****No Unlocked/Half-locked connector****2****No Terminal Backing Out****3****No Missing COT**

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