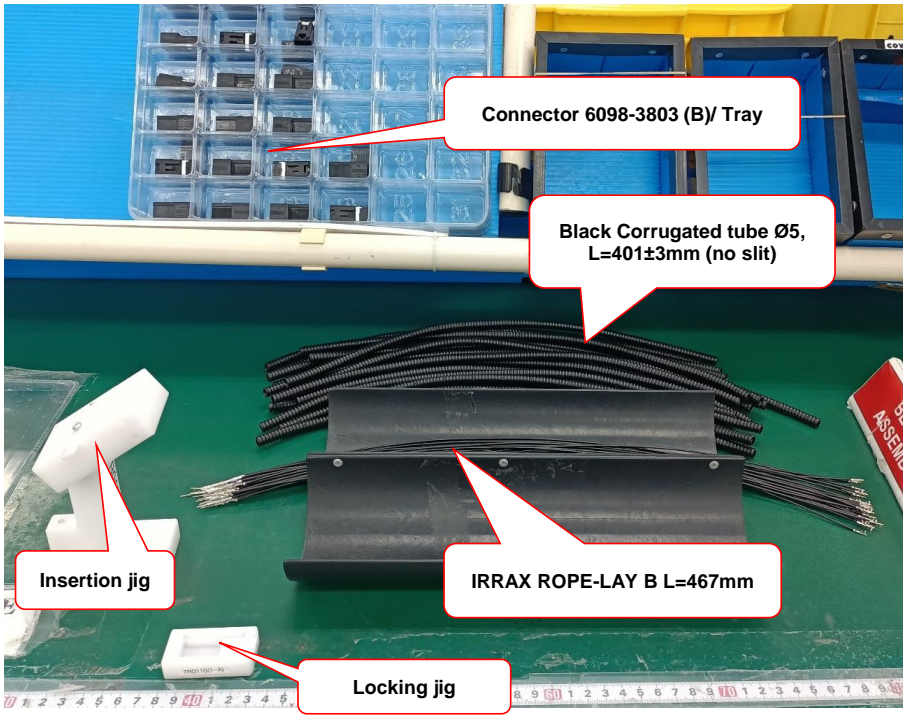
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	Process Name/Title: OFFLINE ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 660B / 7R0110-7020B		Customer: TRMX	Car Model: TOYOTA-SEQUOIA	Document No.:	WI-ENG-PDE-779		
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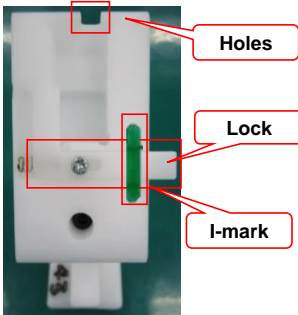

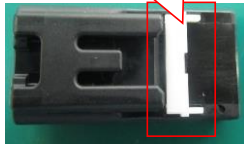

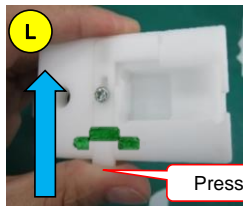
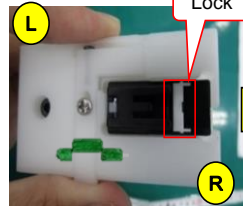
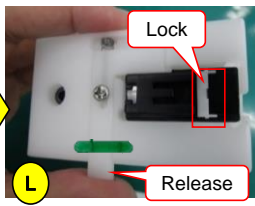






PARTS:	1. Connector 6098-3803 (B); IRRAX ROPE-LAY B L=467±2mm; Black Corrugated tube Ø5, L=401±3mm (no slit)			JIG:	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	Offline	<p style="text-align: center;">TABLE LAY-OUT</p> 		<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	1. No missing parts/tools 2. No excess parts/tools

Revision History								Prepared by	Reviewed by	Approved by	Noted by
06/11/24	0	Initial issue.				D. Castillo	C. Villanueva	A. Arañes	n/a		
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	June 11, 2024

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		OFFLINE ASSEMBLY PROCESS				Validity Date:		n/a	
		Model code/Part number: 660B / 7R0110-7020B		Customer: TRMX	Car Model: TOYOTA-SEQUOIA	Document No.:		WI-ENG-PDE-779	
		Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		0	Page No.:	2 of 6	
PARTS:		1. Connector 6098-3803 (B)				JIG:		1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS		
2	Offline	<div><div><div><div><div>Insertion Jig</div></div><div><div>Insertion Jig Orientation</div></div><div><div>Connector lock</div></div><div><div>Connector Orientation</div></div></div><div><div><div><div><div>L</div></div><div><div>R</div></div><div><div>L</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.</div><div>3. Check the holes/terminal slot for 2 Black wires.</div></div></div></div></div></div>				n/a	<div><div><div>1. Use provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector.</div></div><div><div>Connector Orientation Illustration</div><div><div><div><div>I-mark is align</div></div><div><div>2 holes are open</div></div></div><div><div><div>I-mark is not align</div></div><div><div>All holes are open</div></div></div></div><div><div>CONNECTOR ILLUSTRATION</div><div><div><div>GOOD</div></div><div><div>NG</div></div></div></div></div></div>		

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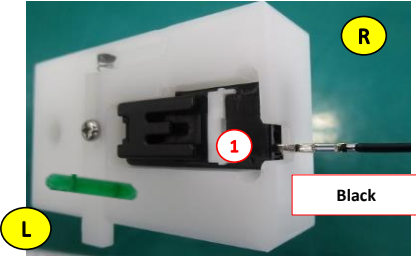
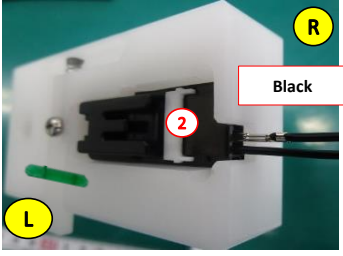
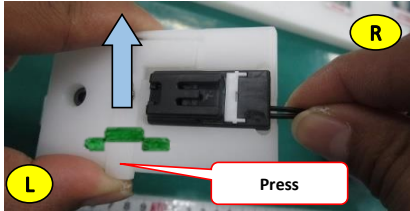
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	Model code/Part number: 660B / 7R0110-7020B		Customer: TRMX	Car Model: TOYOTA-SEQUOIA	Document No.:		WI-ENG-PDE-779	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		0	Page No.:

PARTS:		1. IRRAX ROPE-LAY B L=467mm [2pcs] 2. Black Corrugated tube Ø5, L=401±3mm (no slit)			JIG:		1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE		QUALITY POINTERS	
3	Wire insertion to Corrugated tube Ø5, L=401±3mm (no slit)	 <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> 1. Get Black Corrugated tube Ø5 L=401±3mm (no slit) using left hand and insert IRRAX ROPE-LAY B L=467±2mm using right hand. </div>			n/a		1. No wrong usage of parts 2. No deformed terminal	
4	Offline Wire insertion to Connector 6098-3803 (B)	<div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  <p>Wire facing</p> </div> <div style="text-align: center;">  <p>1. Get 1st black wire then insert to terminal slot 1 using right hand.</p> </div> </div> <div style="display: flex; justify-content: space-around; margin-top: 10px;"> <div style="text-align: center;">  <p>2. Get 2nd Black wire then insert to terminal slot 2 using right hand.</p> </div> <div style="text-align: center;">  <p>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.</p> </div> </div>			n/a		1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing Important reminders/Note/s: 1. <i>Please hold the wire near terminal during insertion.</i> 2. <i>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.</i> Do not exert extra force. 3. <i>Insertion should be from left to right.</i> Document reference:/s 1. <i>Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i> 2. <i>Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i>	

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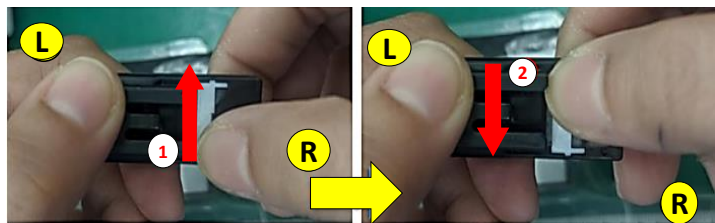


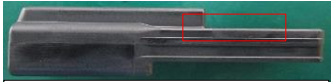


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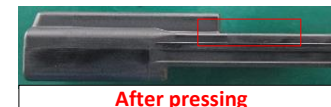
PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Offline	Connector lock			
		<div><div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div><div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div></div> <div><div><p>3. Press the lower parts of connector using right hand while left hand holding the middle.</p></div><div><p>4. Press the upper part of connector using right hand while left hand holding the middle.</p></div><div><p>5. Lift then press the connector in the middle using left and right hand.</p></div></div> <div><div><p>6. Ensure that connector is in locked condition by touching the connector lock based on the sequence illustrated.</p></div></div>		<div>LOCKING JIG</div> 	<div>1. No Unlock and half-locked</div> <div>2. Use provided jig tools per model to avoid damaged lock.</div> <div>Important reminders/Note/s:</div> <div>1. Manual locking may cause damaged connector.</div> <div>2. Refer WI-PRO-KIT-001 Proper locking and checking of connector lock.</div> <div><p>Before pressing</p><p>After pressing</p><div><div>GOOD</div><div>NG</div><p>Full Lock</p><p>Half Lock</p></div></div>

LOCKING JIG**Important reminders/Note/s:**

1. Manual locking may cause damaged connector.
2. Refer WI-PRO-KIT-001 Proper locking and checking of connector lock.



Before pressing



After pressing

GOOD**NG**

Full Lock



Half Lock

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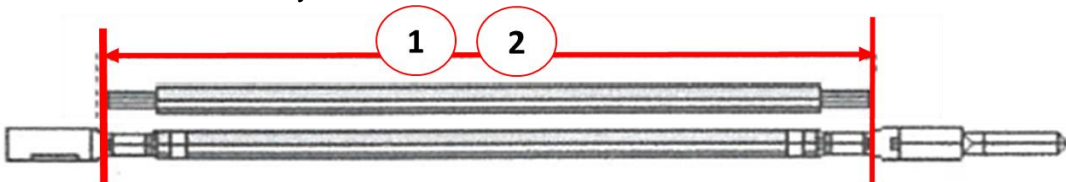
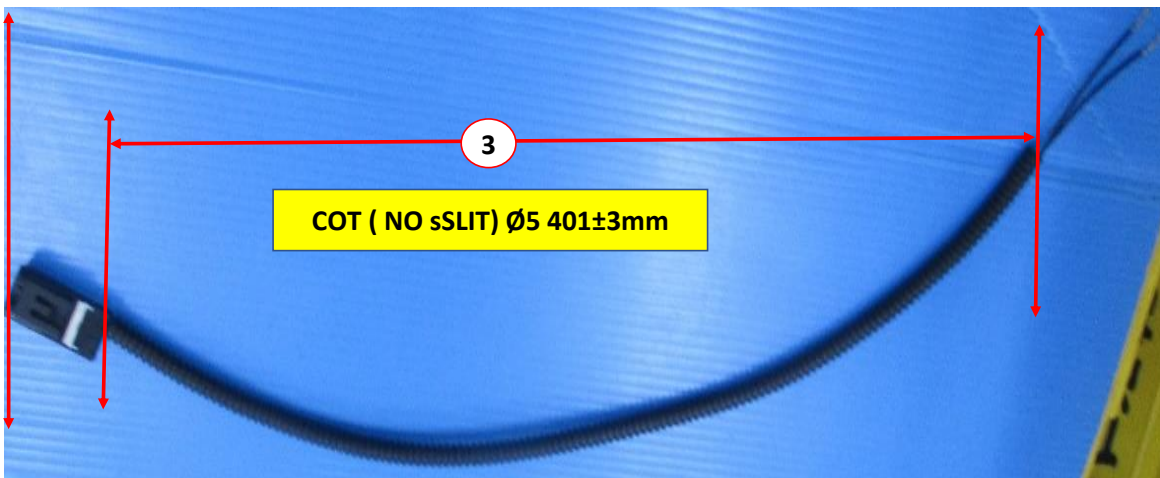

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PARTS:	1. Assy parts		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
6	Offline	Measurement	<div>Note: 1. Measurement point: End of core wire to the end of core wire 2. Terminal is reference only.</div> <div></div> <div></div> <div>COT (NO sSLIT) Ø5 401±3mm</div>	<div>MEASURING TAPE</div> <div></div>	<div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension</div>

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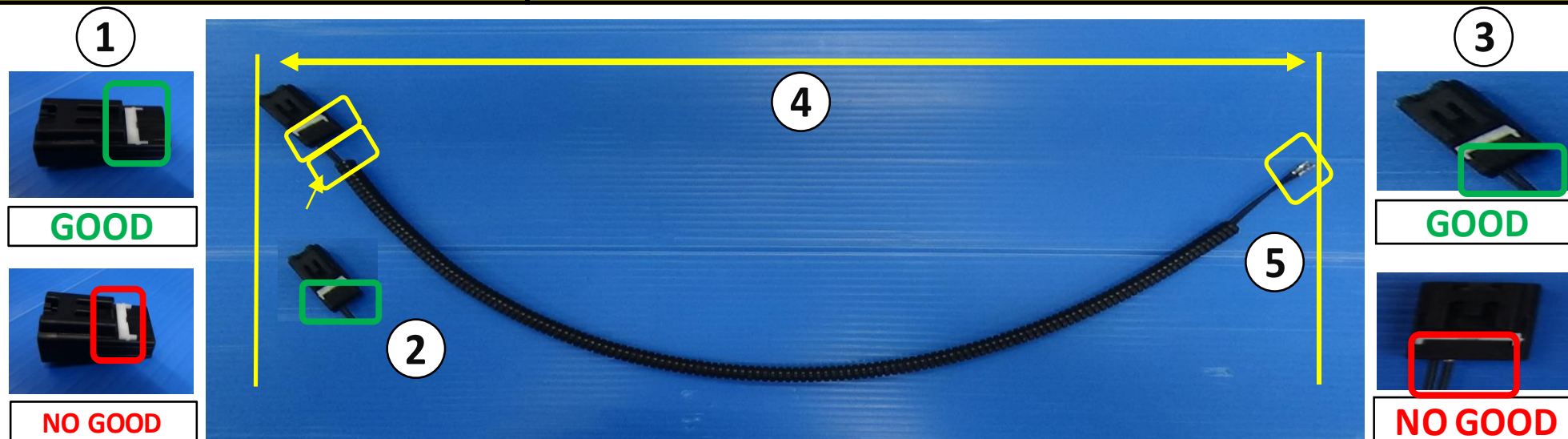
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**OFFLINE INSERTION****7R0110-7020B****1 No Unlock connector****3 No Terminal Backing Out****2 No Wrong insert****4 Check the Alignment****5 No Deform terminal**

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