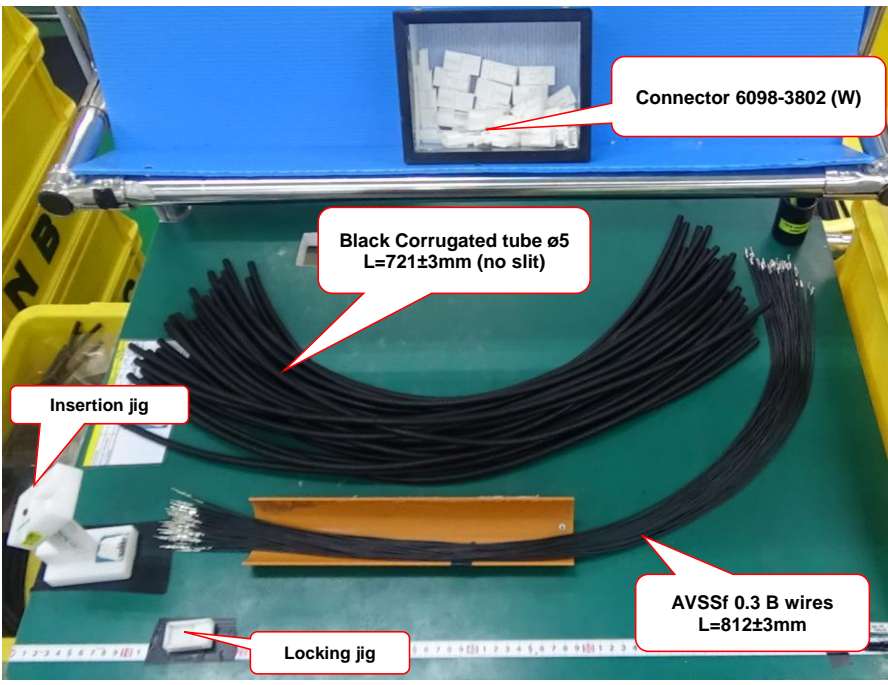
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	Process Name/Title: OFFLINE ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 890B / 7L0099-7020		Customer: TRQSS	Car Model: TOYOTA C-SUV	Document No.:		WI-ENG-PDE-1006	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		0	Page No.:	1 of 7	

PARTS:	1.Connector 6098-3802(W); Corrugated tube Ø5 L=721±3mm (no slit); AVSSf 0.3 B wires L=812±3mm			JIG:	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
1	OFFLINE	<p>Table Lay-out</p> 	<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>Document reference/s:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>	

Revision History						Prepared by	Reviewed by	Approved by	Noted by
10/16/24	0	Initial issue. Seprate Wire insertion to connector and Wire insertion to Corrugated tube process from Taping assembly process due to process improvement and change process sequence due to removal of cover jig. Aligned COT length based on Cutting ledger (from ø5, L=724±7mm to ø5, L=721±3mm due to encountered minimum dimension (taping))				D.Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted
						Est. Date:	October 16, 2024		

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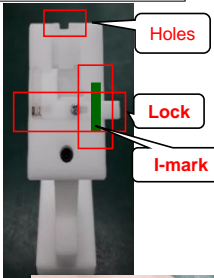
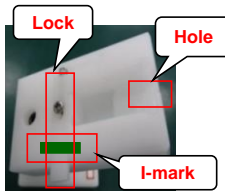

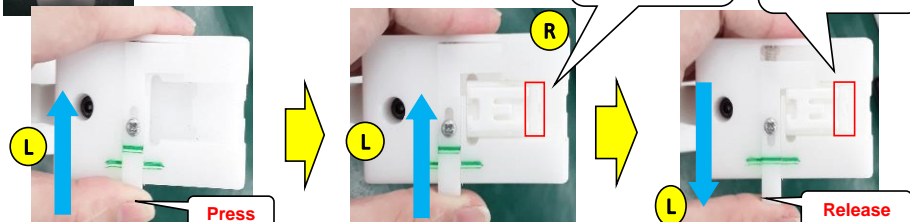



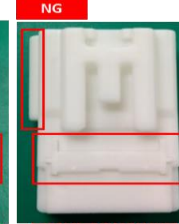
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PARTS:		1. Connector 6098-3802 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	OFFLINE	<div>Connector setting to insertion jig 6098-3802 (W)</div> <div><div><div></div><div></div><div></div><div></div></div><div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Get the connector 6098-3802 (W) using right hand and insert into jig using right hand and release the lock using left hand.</p><p>3. Check the holes/terminal slot for B-B wires.</p></div></div>		n/a	<div><p>1. Use the provided jig per model</p><p>2. No wrong orientation of connector</p><p>3. No wrong use of connector.</p><p>4. No damage Connector.</p></div> <div><div><div>Connector Orientation Illustration</div><div><div></div><div></div></div><div><div>CONNECTOR ILLUSTRATION</div><div><div></div><div></div></div></div></div></div>

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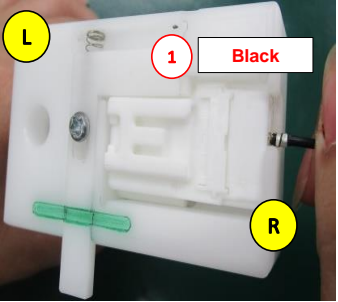
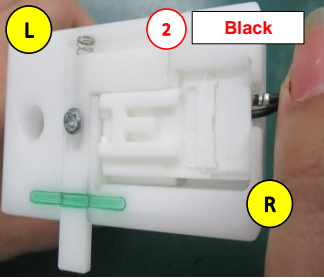
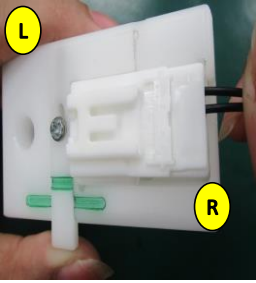
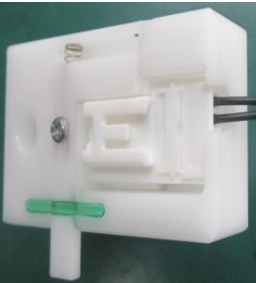
PARTS:		1. AVSSf 0.3 wires B L=812±3mm [2pcs] 2. Black Corrugated tube ø5 L=721±3mm (no slit)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	OFFLINE	<div></div> <div>1. Get Black Corrugated tube ø5 L=721±3mm (no slit) using left hand and insert two (2) Black wires L=812±3mm using right hand.</div>		n/a	1. No wrong use of parts 2. No deformed terminal

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	4 of 7

PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	OFFLINE Wire insertion to connector 6098-3802 (W)	<div><p>Wire facing</p></div> <div><p>1. Get the 1st Black wire then insert to terminal slot 1 of connector using right hand.</p></div> <div><p>2. Get the 2nd Black wire then insert to terminal slot 2 of connector using right hand.</p></div> <div><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>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p>Important reminders/Note/s:</p> <p>1. Insertion of wires must be from left to right 2. Please hold the wire near terminal. 3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</p>

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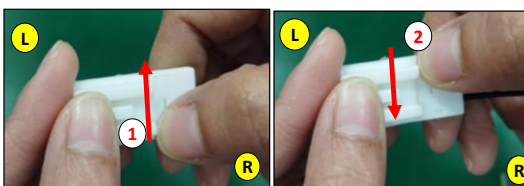




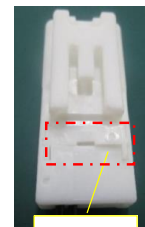
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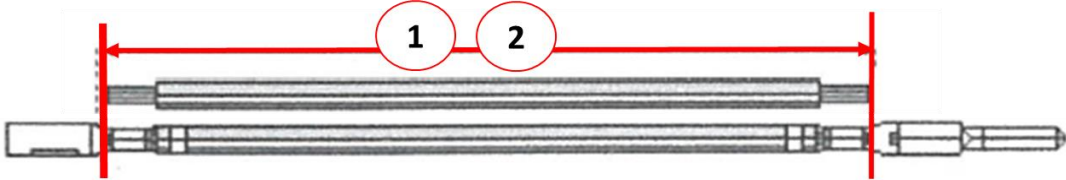
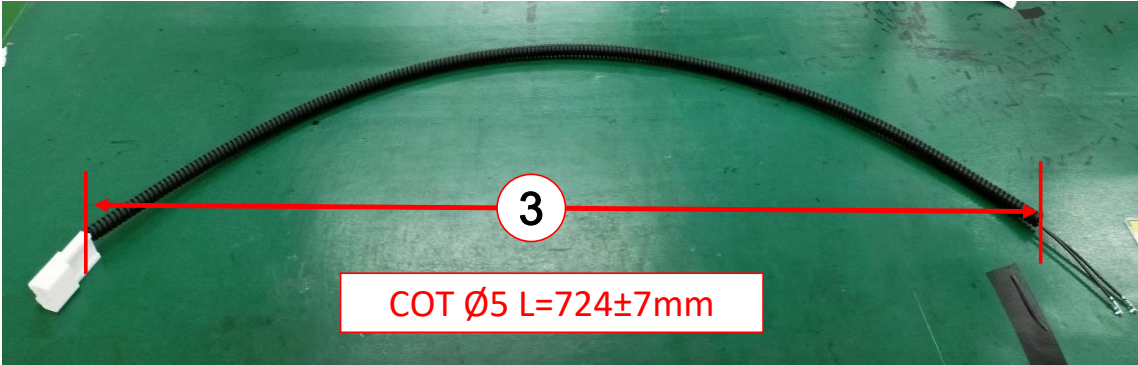

PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	OFFLINE Connector Lock	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div> <div><p>2. Press the lower part of connector to fully insert 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>GOOD</p><p>Full Lock</p></div><div><p>NG</p><p>Half Lock</p></div></div> <p>Important reminders/Note/s:</p> <p>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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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
6	OFFLINE	Measurement Note: 1. Measurement point: End of core wire to the end of core wire 2. Terminal is reference only.  	<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>	

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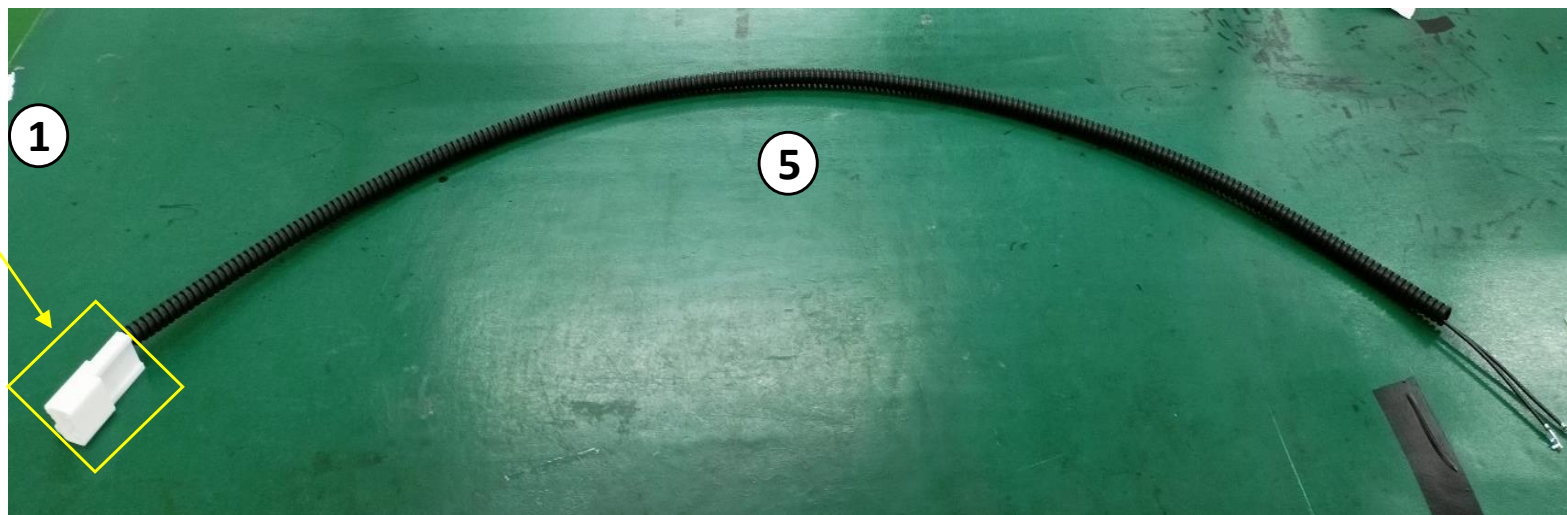
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**OFFLINE INSERTION****7L0099-7020****① No Unlocked/Half-locked connector****③ No Terminal Backing Out****② No Wrong Insert****④ No Deformed Terminal****⑤ No Missing COT**

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