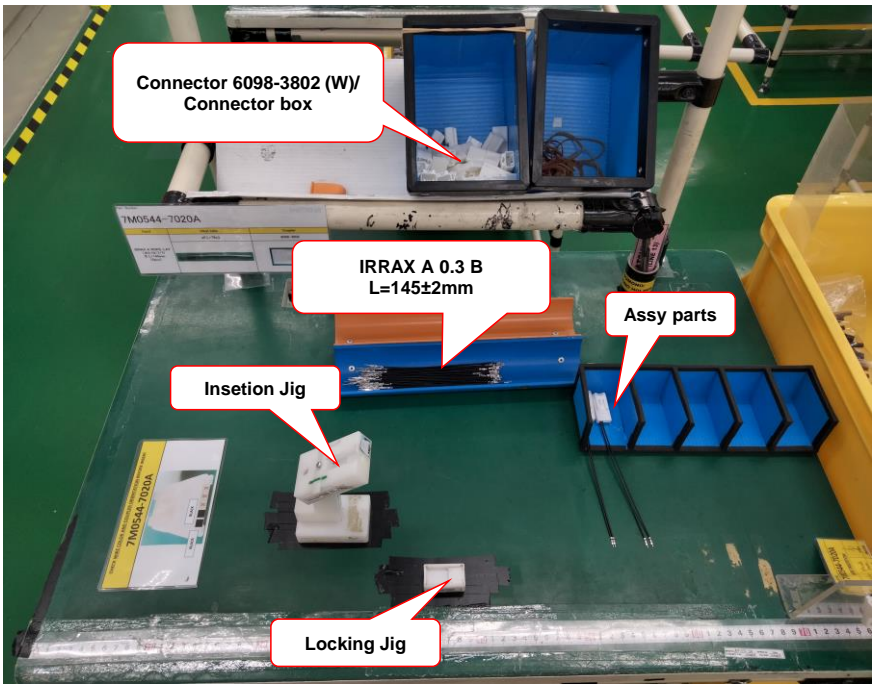

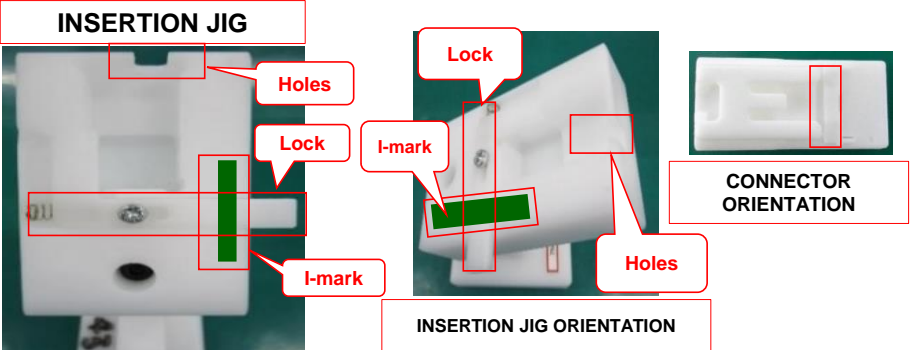
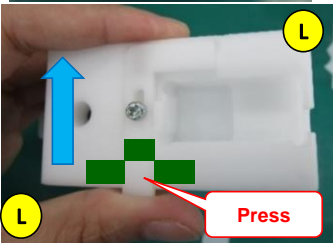
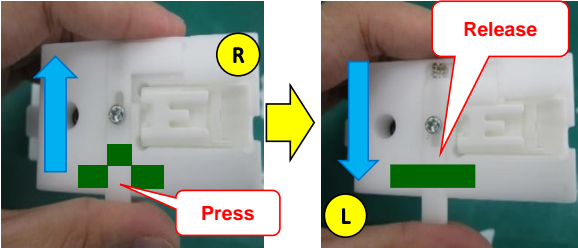

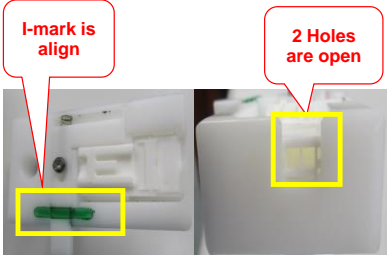
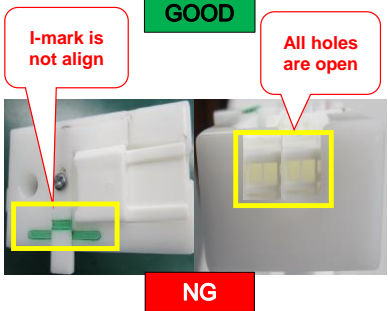
	WORK INSTRUCTION OFFLINE ASSEMBLY PROCESS				Effectivity Date:		May 17, 2024	
	Process Name/Title:				Validity Date:		n/a	
	Model code/Part number: 164B / 7M0544-7020A		Customer: TRJ	Car Model: TOYOTA AURIS	Document No.:		WI-ENG-PDE-113	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		3	Page No.: 1 of 6

PARTS:		1. Connector 6098-3802 (W); IRRAX A 0.3 B L=145±2mm		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	Offline Table Lay-out	<div style="text-align: center;"> TABLE LAY-OUT  </div>		<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: 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
05/17/24	3	Inclusion of all improvements (Table lay-out; important reminders and note/s; Document references; Measurement and Visual inspection). Improve work procedure/Illustration on process 1 connector lock and change assembly process name from kitting assembly to offline assembly. Inclusion of Car model "TOYOTA-AURIS".	D. Castillo	C. Villanueva	A. Arañes	n/a	
05/14/21	2	Removal of validity date. Apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	
11/14/20	1	Changed effectivity and validity date. Remove cycle time.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: May 5, 2020

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	WORK INSTRUCTION			Effectivity Date:	May 17, 2024		
	Process Name/Title: OFFLINE ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 164B / 7M0544-7020A		Customer: TRJ	Car Model: TOYOTA AURIS	Document No.: WI-ENG-PDE-113		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	3	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>INSERTION JIG</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 6098-3802 (W) into jig using right hand then release the lock.</div><div>3. Check the holes/terminal slot for B-B wires.</div></div>			n/a	<div>Connector Orientation Illustration</div> <div></div> <div></div>		


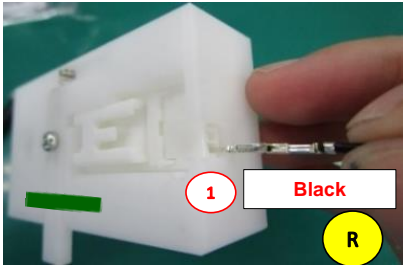
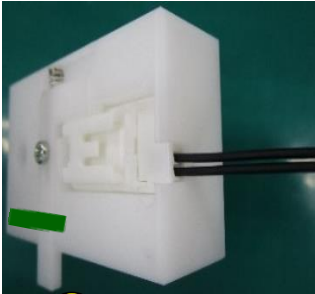
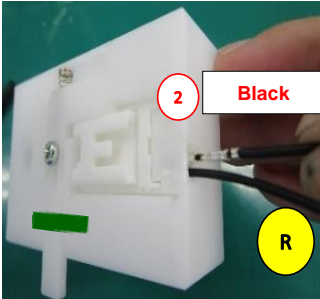
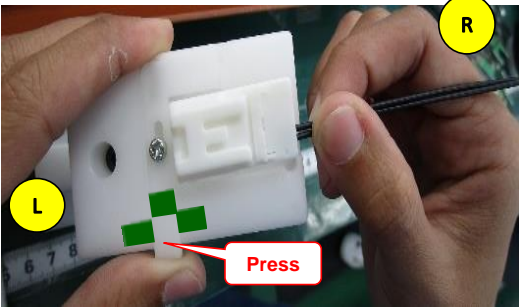

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	Model code/Part number: 164B / 7M0544-7020A		Customer: TRJ	Car Model: TOYOTA AURIS	Document No.: WI-ENG-PDE-113		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	3	Page No.:	3 of 6

PARTS:	1. IRRAX A 0.3 B L=145±2mm [2pcs]			JIG:	1. Insertion jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
3	Offline Wire insertion to connector 6098-3802 (W)	<div><div>WIRE FACING</div></div> <div><div>1. Get the 1st B wire then insert to connector using right hand.</div></div> <div><div>2. Get the 2nd B wire then insert to connector using right hand.</div></div> <div><div>3. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</div></div>			n/a	<div>Important reminders/note/s: <i>1. Insertion of wire must be from left to right.</i> <i>2. Make sure wires are properly inserted.</i> <i>Conduct Pull-Push-Pull-Push after insertion.</i> <i>Do not exert extra force.</i></div> <div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div>		

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**WORK INSTRUCTION**

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164B / 7M0544-7020A

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Car Model:

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Document No.:

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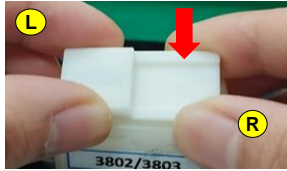



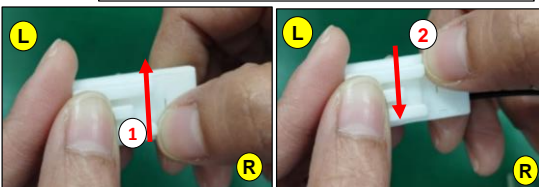


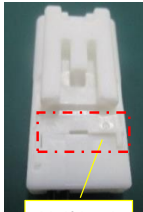

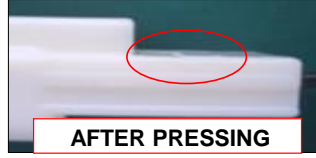
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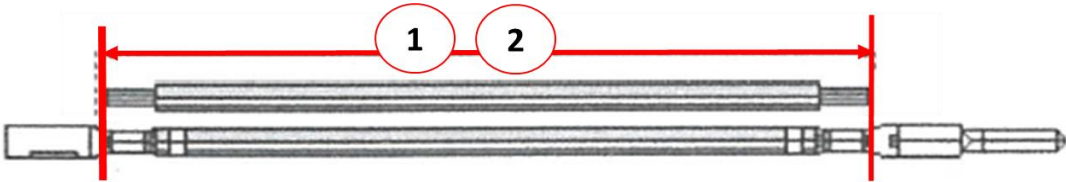


PARTS:		1.Assy Parts		JIG:	1. Locking jig
NO.	PROCESS NAME	3 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Offline Connector Lock	<div><div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div><div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div><div><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>		<div>LOCKING JIG</div> 	<div>1. Use the provided jig per connector 2. No unlock/half-locked of connector lock</div> <div>3<div>Important reminders/note/s: 1.MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</div></div> <div>Document reference/s: 1.Please refer to GL-PRO-ASY-017 for the verification of connector lock.</div> <div><div>GOOD</div><p>Full Lock</p><div>NG</div><p>Half Lock</p></div> <div><p>BEFORE PRESSING</p><p>AFTER PRESSING</p></div>

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	Model code/Part number: 164B / 7M0544-7020A		Customer: TRJ	Car Model: TOYOTA AURIS	Document No.: WI-ENG-PDE-113		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	3	Page No.:	5 of 6

PARTS:	1.Assy Parts			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	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>		Measuring tape 	Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono. Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection
				1. No wrong dimension	

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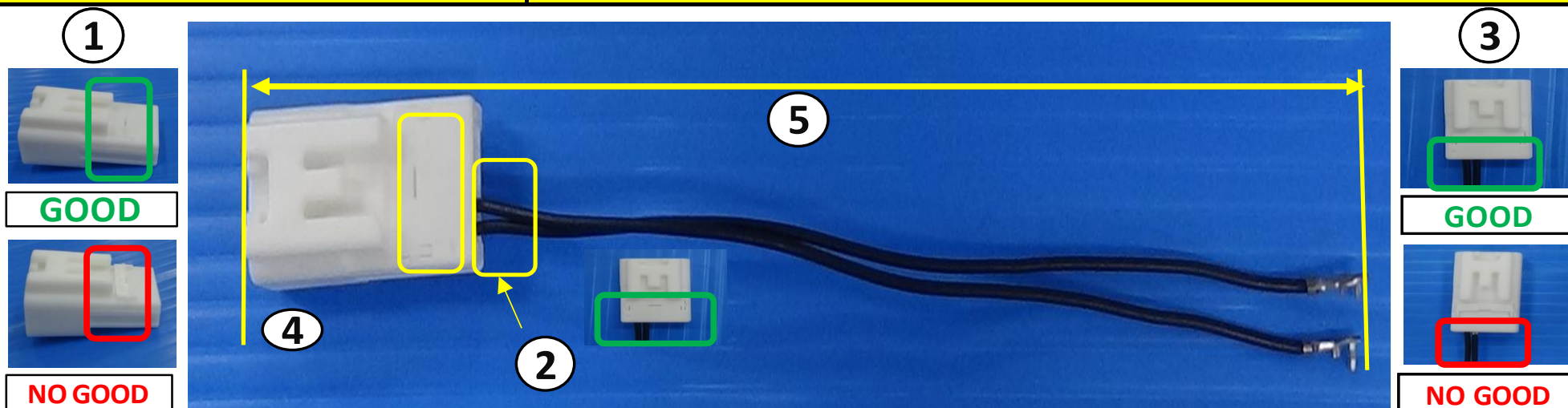
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7M0544-7020A****1 No Unlocked connector****3 No Terminal Backing Out****5 Check the Alignment****2 No Wrong insert****4 No Deformed terminal**

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