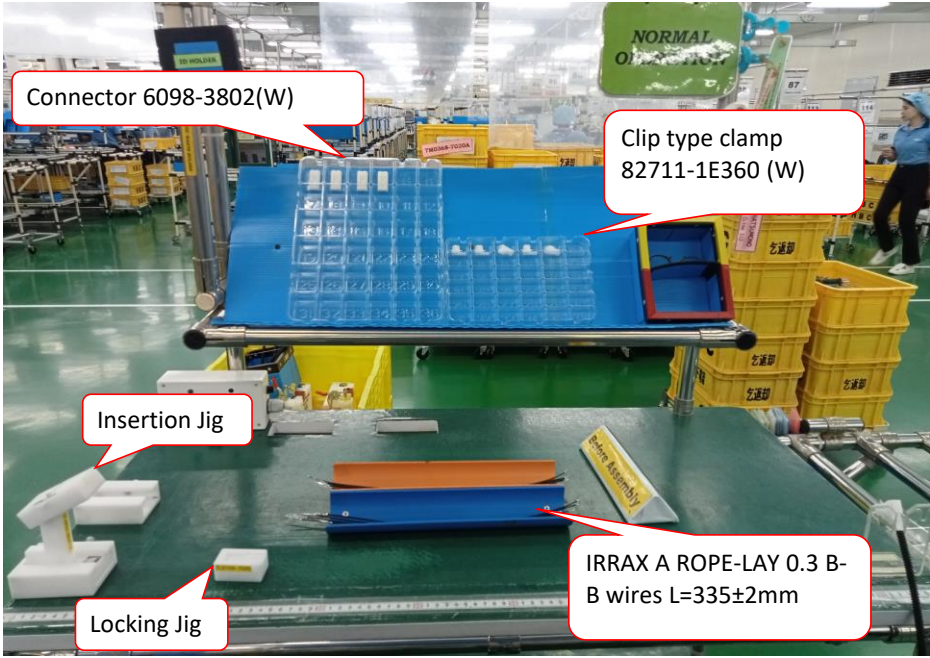




	WORK INSTRUCTION						Effectivity Date:		May 15, 2025			
	OFFLINE ASSEMBLY PROCESS						Validity Date:		n/a			
	Process Name/Title:			Model code/Part number: 400D / 7L0159-7020			Customer: TRQSS		Car Model: TOYOTA-bZ4X(BEV)		Document No.: WI-ENG-PDE-1261	
	Purpose:			<input type="checkbox"/> PROTOTYPE			<input type="checkbox"/> PRE-LAUNCH			<input checked="" type="checkbox"/> MASSPRO		
						Revision No.:		0		Page No.: 1 of 7		

PARTS:		1.Connector 6098-3802 (W) 3.Clip type clamp 82711-1E360 (W) 2. IRRAX A ROPE-LAY 0.3 B-B wires L=335±2mm [2pcs.]				JIG:		1.Insertion Jig 2.Locking Jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	Offline	<div style="text-align: center;"> TABLE LAY-OUT </div> 				<div style="border: 1px solid red; padding: 5px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px; margin-top: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px solid red; padding: 5px; margin-top: 10px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>		<div> Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance </div> <div> 1.No missing parts 2.No excess parts tools </div>	

Revision History								Prepared by		Checked by		Reviewed by		Approved by	
								 A. Buban		 J. Loterte		 C. Villanueva		 A. Arañes	
05/15/25	0	Initial issue						A.Buban	J.Loterte	C.Villanueva	A.Arañes				
Eff. Date	Rev. No	Details of Change						Revised	Checked by	Reviewed by	Approved by	Est. Date:	May 15 ,2025		

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WORK INSTRUCTION

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400D / 7L0159-7020

Customer:

TRQSS

Car Model: TOYOTA-bZ4X(BEV)

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PRE-LAUNCH



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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 Connector setting to insertion jig 6098-3802 (W)	<div><div><div>INSERTION JIG</div><div></div></div><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></div>	n/a	<div><div>Connector Orientation Illustration</div><div><div></div><div></div></div><div><div>1. Use the provided jig per model</div><div>2. No wrong orientation of connector</div><div>3. No wrong use of connector</div><div>4. No damaged connector</div></div></div>

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PRE-LAUNCH




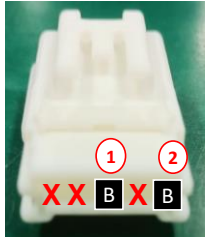
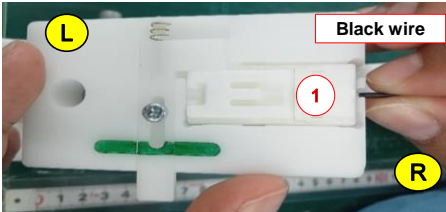

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PARTS:	1. Connector 6098-3802(W) 2.IRRAX A ROPE-LAY 0.3 B-B wires L=335±2mm [2pcs.]		JIG:	1.Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Offline Wire Insertion to connector 6098-3802 (W)	<div><div>TERMINAL FACING</div><div></div></div> <div><div>VISUAL REFERENCE</div><div></div><div>1. Hold the connector 6098-3802 (W) then get the 1st Black wire and insert to terminal slot 1 using right hand. Conduct 2x push-pull after wire insertion.</div></div> <div><div></div><div>2. Get the 2nd Black wire and insert to terminal slot 2 using right hand. Conduct 2x push-pull after wire insertion.</div></div> <div><div></div><div>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</div></div>	n/a	<p>Document reference/s:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>Important reminders and note/s;</p> <p>1.Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p>

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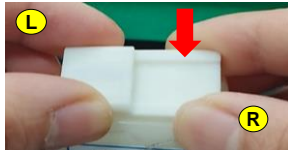









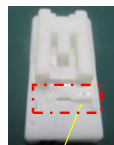
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PARTS:		1.Assy Parts		JIG:	1.Locking Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Offline Connector Lock	<div><div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div><div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div><div><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><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></div>		<div>LOCKING JIG</div> 	<div>1. No Unlock and half-locked 2. Use provided jig tools per model to avoid damaged lock.</div> <div>Important reminders/note/s: 1.MANUAL LOCKING MAY CAUSED DAMAGED LOCK 2. Use provided jig tool per model to avoid damaged lock.</div> <div>Document references; 1.Please refer to GL-PRO-ASY-017 for the verification of connector lock.</div> <div><div><p>Before pressing</p><p>After pressing</p></div><div><div>GOOD</div><p>Full Lock</p><div>NG</div><p>Half Lock</p></div></div>

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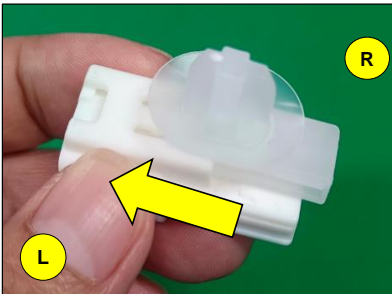
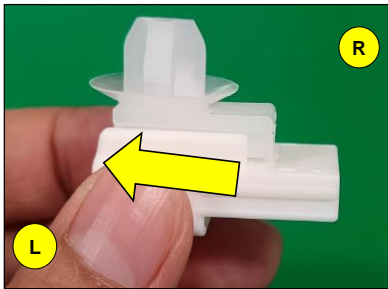
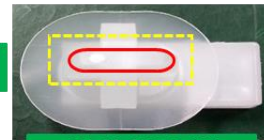
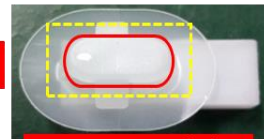
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PARTS:		1. Clip type clamp 82711-1E360 (W) 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Offline Clamp attachment (Clip type clamp)	<div></div> <div></div> <div></div> <div>1. Hold the Connector using left hand, get the clip type clamp 82711-1E360 (W) then insert the clamp using right hand. Note: Follow the illustration. Sound will be heard if properly inserted.</div>		n/a	<p>Document reference/s:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>CLIP CLAMP ILLUSTRATION</p> <div>GOOD 82711-1E360 (W)</div> <div>NG 82711-12B10 (W)</div> <p>1.No wrong used of Clip Type clamp</p>

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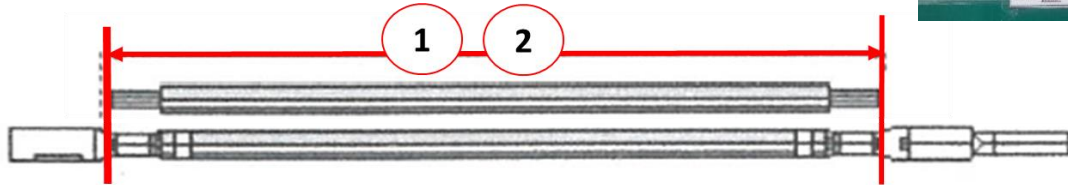

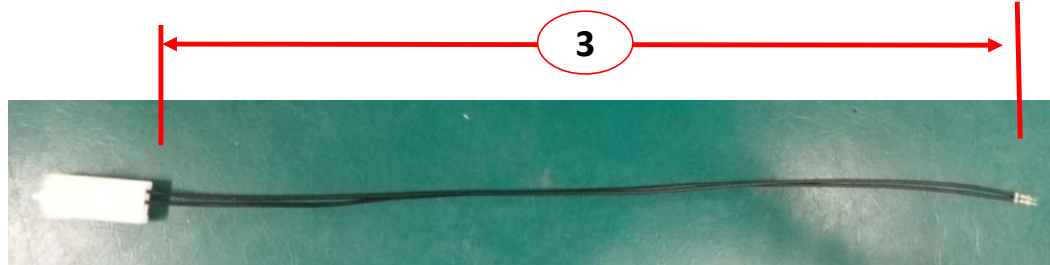
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PARTS:		1.Assy Parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	Offline	Measurement	<p>Note:</p> <ol style="list-style-type: none">1. Measurement point: End of core wire to the end of core wire2. Terminal is reference only.   		<p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Please use calibrated/verified measuring tape when getting the measurement.2. For Hatsumono, Nakamono, and Owarimono. <p>Document reference/s:</p> <ol style="list-style-type: none">1. Refer to WI-PRO-ASY -056 for sub-assembly Hatsumono, Nakamono, and Owarimono <p>1. No wrong Dimension</p>

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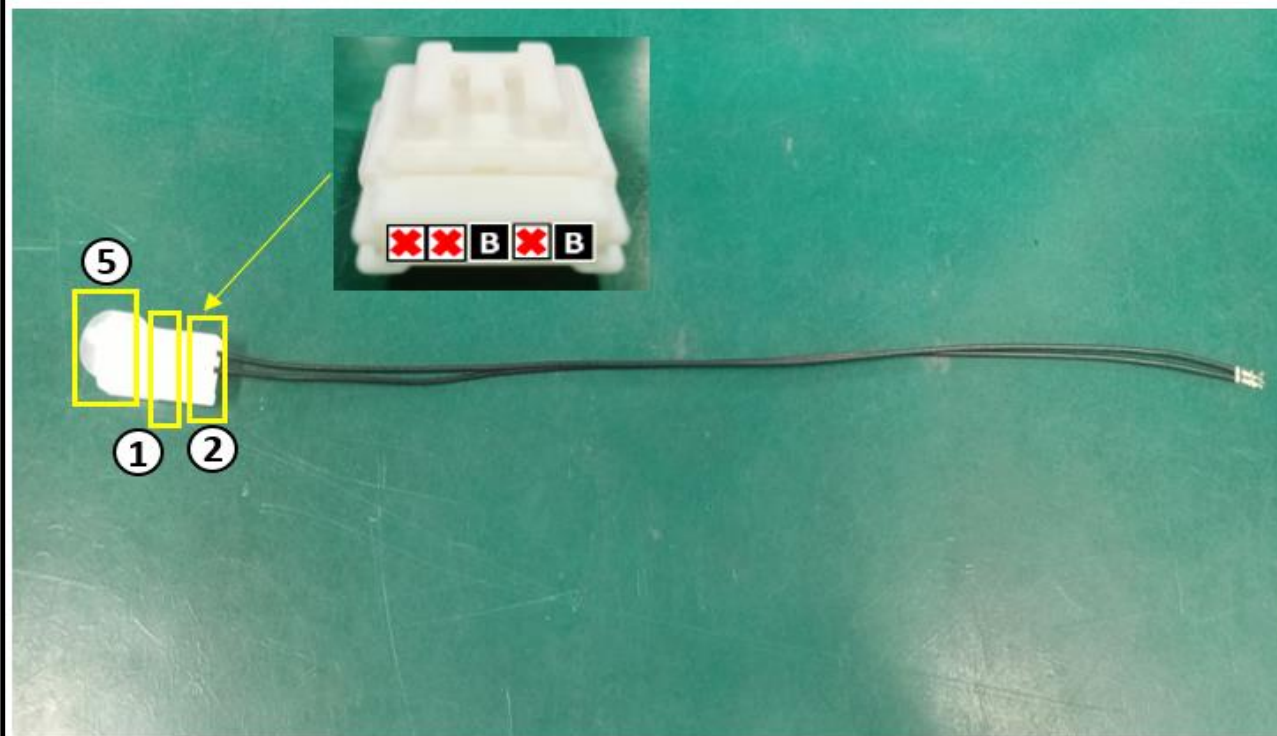
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PARTS:

1.Assy Parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**OFFLINE INSERTION****7L0159-7020**

- ① **No Unlocked/Half-locked connector**
- ② **No Wrong Insert**
- ③ **No Deformed Terminal**
- ④ **No Terminal Backing Out**
- ⑤ **No MISSING /No Wrong Use of Clip type clamp**

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