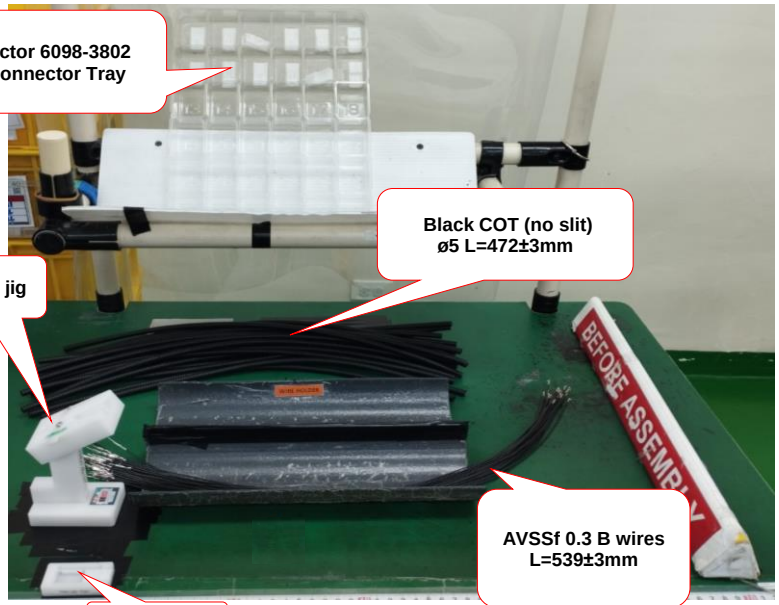
	WORK INSTRUCTION			Effectivity Date:	December 21, 2023		
	Process Name/Title:	OFFLINE ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 200D/220D /7R0126-7021	Customer: TRMX	Car Model: TOYOTA-SEQUIOA	Document No.:	WI-ENG-PDE-564		
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	3	Page No.:	1 of 6

PARTS:	1. All parts: Connector 6098-3802 (W); AVSSf 0.3 B wires L=539±3mm; Black COT (no slit) ø5 L=472±3mm	JIG:	1. Insertion jig 2. Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	3 n/a	Table Lay-out	**Table Lay-out**  	**Safety Instruction** Be sure to wear prescribed 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.	***Document reference/s:*** ***1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance*** 1. No missing parts/tools 2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
12/21/23	3	Remove terminal cover jig and update process sequence due to process improvement. Update table lay-out. Inclusion of Quality pointers and Car Model "TOYOTA-SEQUIOA"	D. Castillo	C.Villanueva	A. Arañes	n/a
09/23/22	2	Improve quality pointers: Reminders/notes and references in process no.1,2,3,4,7 and 8 due to document improvement. Work procedure/illustration in process no.4 - connector lock.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
07/19/22	1	Change document purpose from pre-launch to masspro	M. Catapang	J. Loterte	C. Villanueva	A. Arañes

Prepared by	Reviewed by	Approved by	Noted by
D. Castillo	C. Villanueva	A. Arañes	n/a
Est. Date:	July 15, 2022		

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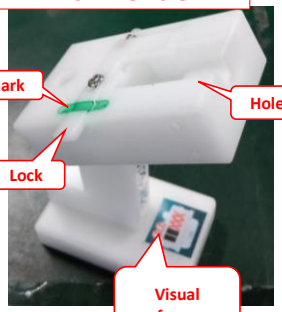
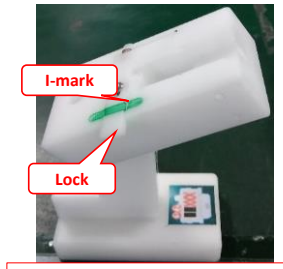
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	3	Page No.:	2 of 6

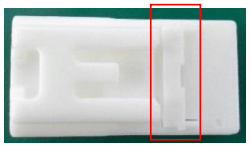
PARTS:	1. Connector 6098-3802 (W)			JIG:	1. Insertion jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
2	n/a	Connector Setting to Insertion jig 6098-3802 (W)		n/a	

INSERTION JIG

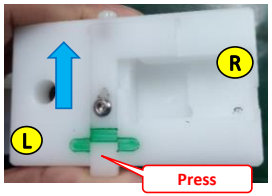




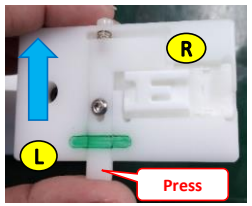
INSERTION JIG ORIENTATION

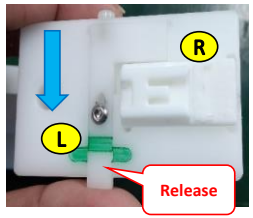


CONNECTOR ORIENTATION



1. Press the lock of insertion jig using left thumb.

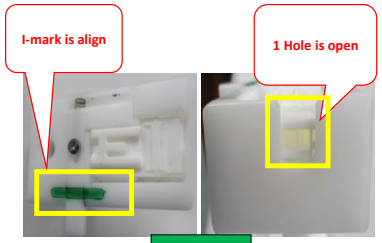




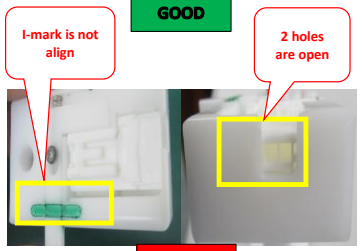
2. Insert the connector **6098-3802 (W)** into jig using right hand then release the lock.
Note: Follow the connector orientation

3. Check the holes/terminal slot for **B-B wires.**

Connector Orientation Illustration

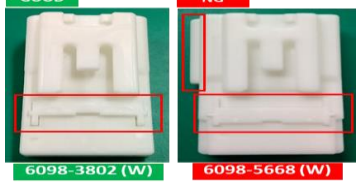


GOOD



NG

CONNECTOR ILLUSTRATION



1. Use provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No damaged connector

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	Model code/Part number: 200D/220D /7R0126-7021	Customer: TRMX	Car Model: TOYOTA-SEQUIOA	Document No.:	WI-ENG-PDE-564		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	3	Page No.:	3 of 6

PARTS:	1. AVSSf 0.3 B wires L=539±3mm [2pcs] 2. Black Corrugated tube ø5 L=472±3mm (no slit)	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	3 n/a	Wire insertion to corrugated tube (no slit) ø5 L=472±3mm	 1. Get the **Black corrugated tube ø5 L=472±3mm (no slit)** uisng left had and get **B-B wires** using right hand then insert.	n/a	1. No wrong usage of parts 2. No deformed terminal

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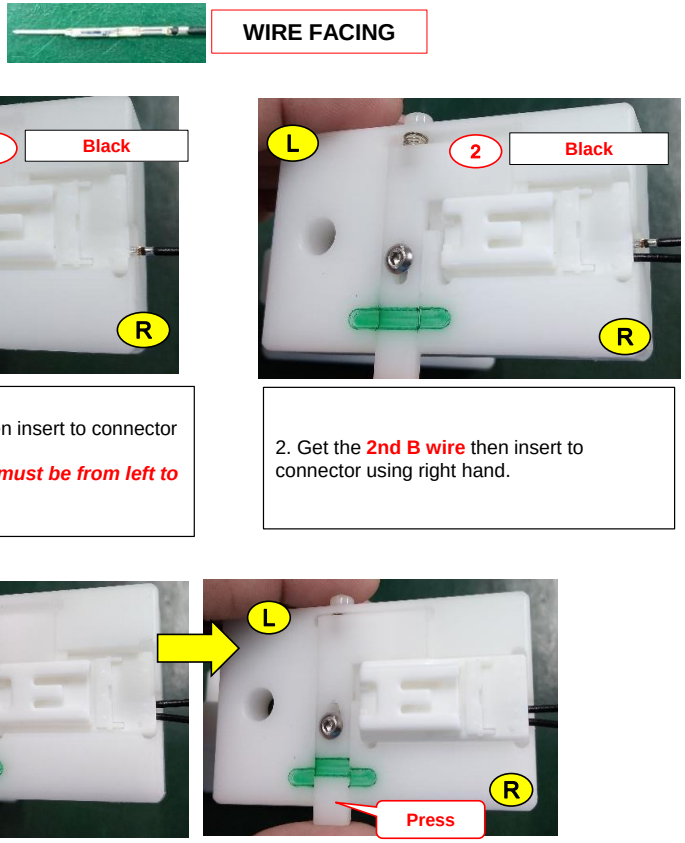
PARTS:	1. Assy parts	JIG:	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	3 n/a	Wire insertion to connector 6098-3802 (W)	 1. Get the **1st B wire** then insert to connector using right hand. ***Note: Insertion of wire must be from left to right.*** 2. Get the **2nd B wire** then insert to connector using right hand. 3. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.	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. Please hold the wire near terminal.*** ***2. Make sure wires are properly inserted.*** ***Conduct Pull-Push-Pull-Push after insertion.*** ***Do not exert extra force.*** ***Document references:*** ***1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.*** ***2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance***

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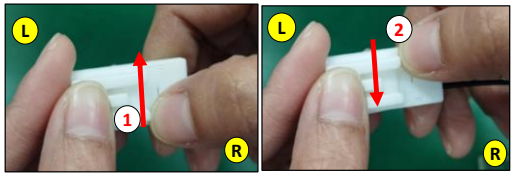
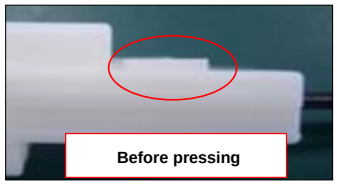
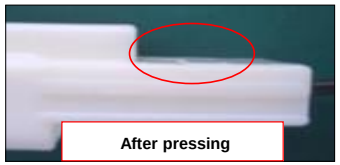
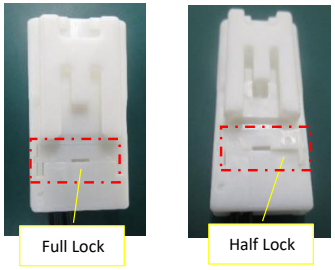
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	3	Page No.: 5 of 6

PARTS:	1. Assy parts	JIG:	1. Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	3 n/a	Connector lock	1. Load the connector into the jig holding both side of the connector, tip first. 2. Press the lower part of connector to fully insert into the locking jig. Right thumb-Lower Left thumb-middle 3. Press the lower parts of connector using right hand while left hand holding the middle. Right thumb-upper Left thumb-middle 4. Press the upper part of connector using right hand while left hand holding the middle. Right thumb-middle Left thumb-middle 5. Lift then press the connector in the middle using left and right hand.  6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.	LOCKING JIG	  GOOD NG  ***Important reminders/Note/s:*** ***1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR*** 1. Use the provided jig tool to lock the connector. 2. No unlock/half-locked connector

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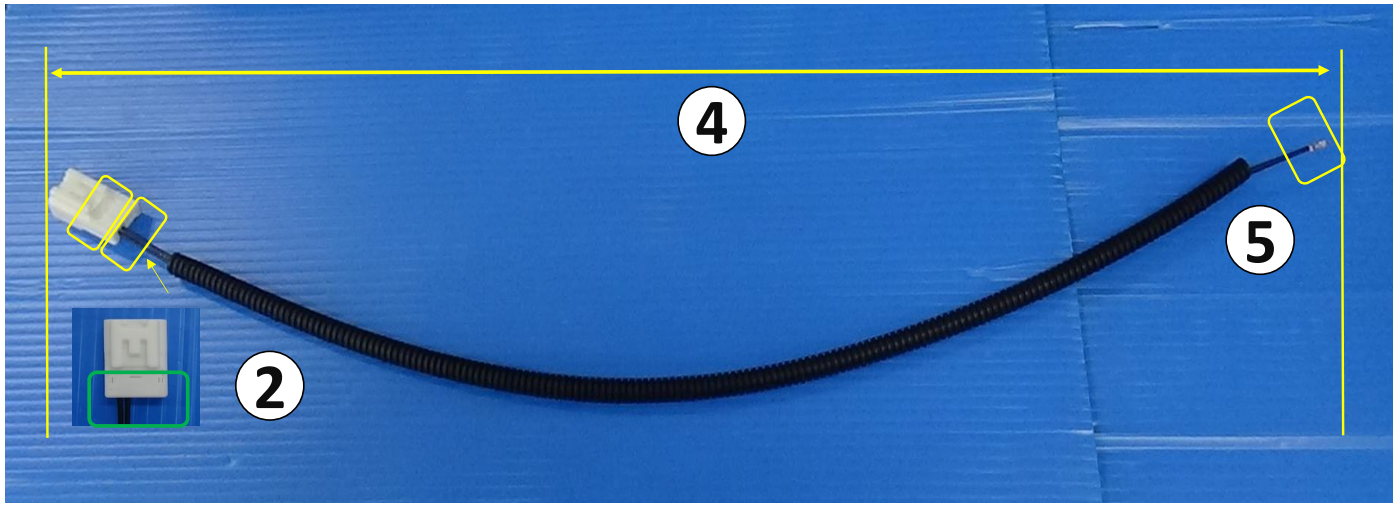
PARTS:	n/a	JIG:	n/a

3 QUALITY CHECKPOINTS

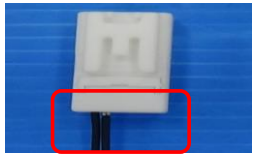
OFFLINE INSERTION 7R0126-7021

GOOD

NO GOOD



GOOD



NO GOOD

1 No Unlock connector

2 No Wrong insert

3 No Terminal Backing Out

4 Check the Alignment

5 No Deform terminal

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