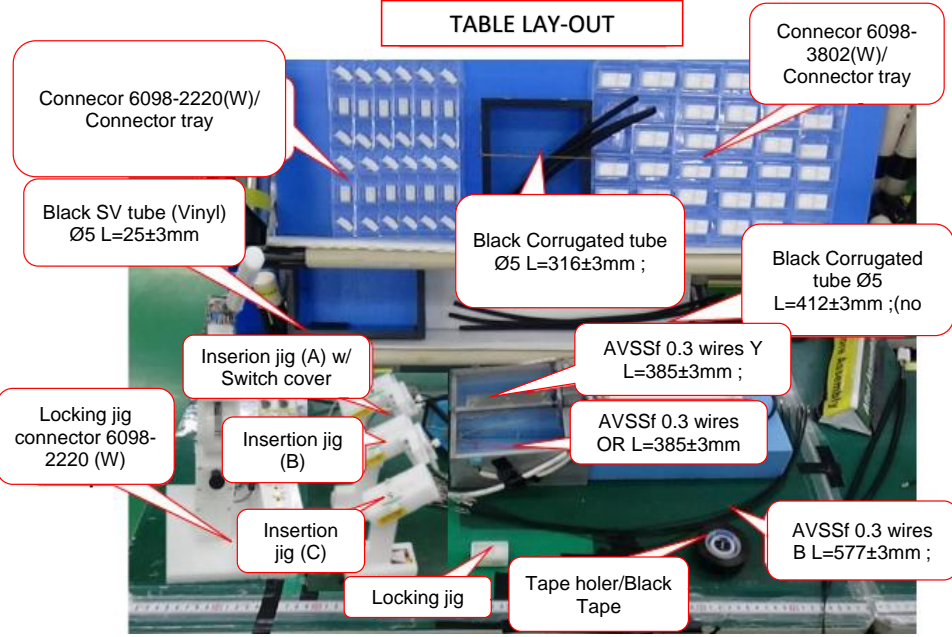
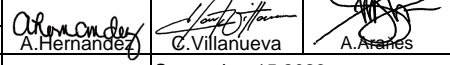
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	Process Name/Title:					Validity Date: n/a		
	Model code/Part number: 382D / 7N0175-7020A		Customer: TRJ		Car Model: TOYOTA-CAMRY		Document No.: WI-ENG-PDE-727A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO					Revision No.: 3		Page No.: 1 of 13

PARTS: 1. Connector 6098-2220 (W); AVSSf 0.3 wires Y L=385±3mm; AVSSf 0.3 wires Y L=385±3mm; Black Corrugated tube Ø5 L=316±3mm; Black Corrugated tube Ø5 L=412±3mm (no slit); AVSSf 0.3 wires B L=577±3mm; Black Vinyl tube Ø5 L=25±3mm ;		JIG: 1. Insertion jig with and w/o switch cover 2. Locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
1	Table Lay-out		<div> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div> 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
06/03/24	3	Additional Work procedure/Illustration and notes on page 4–5 as countermeasure for the customer claim(Broken lock of Connector 6098-2220 (W)).	A.Hernandez	C.Villanueva	A.Arañes	n/a		n/a
9/28/23	2	Correct the process flow from page 4 to 10, 12, improve quality checkpoints	J. Loterte	C.Villanueva	A.Arañes	n/a		
09/21/23	1	Change purpose from pre-launch to mass pro	M.Manalac	J.Loterte	C.Villanueva	A.Arañes		
09/15/23	0	Initial Issue.	M.Manalac	J.Loterte	C.Villanueva	A.Arañes		
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 15,2023

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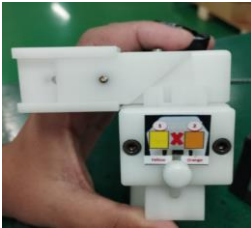
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PARTS:	1. Connector 6098-2220 (W)		JIG:	1. Insertion jig with and w/o switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Connector setting to insertion jig 6098-2220 (W)	<div><div><div><div>Visual reference</div><div>Insertion Jig with Switch Cover</div><div>Y-wire</div><div>OR-wire</div></div><div><div>I-mark</div><div>Lock</div></div><div><div>Connector Orientation</div></div></div><div><div><div><div>L</div><div>↑</div><div>Press</div></div><div><div>R</div></div></div><div><div>→</div></div><div><div><div>L</div><div>↑</div><div>Press</div></div><div><div>R</div></div></div><div><div>→</div></div><div><div><div>L</div><div>↓</div><div>Release</div></div><div><div>R</div></div></div></div><div><div>2. Get the connector 6095-2220(W) using right hand and insert to insertion jig. Release the lock after</div></div><div><div>3. Push the lower guide upward using right hand. Slot for yellow wire will be open.</div></div><div></div></div> <div>n/a</div> <td><div><div>CONNECTOR ORIENTATION ILLUSTRATION</div><div><div><div>I-mark is align</div><div>1 hole is open</div></div><div><div>GOOD</div></div></div><div><div><div>I-mark is not align</div><div>1 hole is open</div></div><div><div>NG</div></div></div></div><div><div>1. Use provided jig per model</div><div>2. No wrong orientation of connector</div></div></td>	<div><div>CONNECTOR ORIENTATION ILLUSTRATION</div><div><div><div>I-mark is align</div><div>1 hole is open</div></div><div><div>GOOD</div></div></div><div><div><div>I-mark is not align</div><div>1 hole is open</div></div><div><div>NG</div></div></div></div> <div><div>1. Use provided jig per model</div><div>2. No wrong orientation of connector</div></div>	

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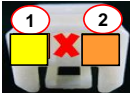


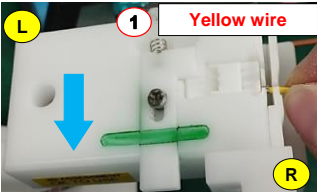
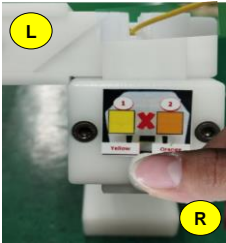
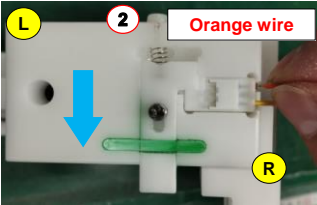
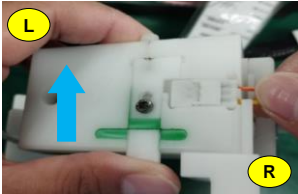
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PARTS:	1. AVSSf 0.3 wires Y L=385±3mm 2. AVSSf 0.3 wires OR L=385±3mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to Connector 6098-2220 (W)	<div><p>VISUAL</p></div> <div><p>Wire facing</p></div> <div><p>Connector Orientation</p></div> <div><p>1 Yellow wire</p><p>1. Hold the insertion jig using left hand. Get the Yellow wire and insert to connector using right hand. Conduct 2x push-pull after wire insertion.</p></div> <div><p>2. Press the button using right thumb. Slot for Orange wire will be open.</p></div> <div><p>2 Orange wire</p><p>3. Get the Orange wire and insert to connector using right hand. Conduct 2x push-pull after wire insertion.</p></div> <div><p>4. 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 wrong facing. 5. No wrong deformed terminal.</p> <p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal during insertion. 2. Insertion must be from left to right. 3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force</p> <p>Document reference/s:</p> <p>1. Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. 2. Please refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>

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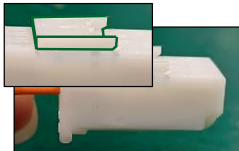
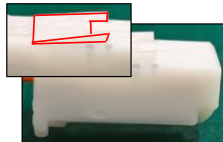
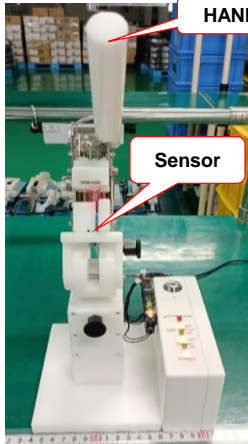
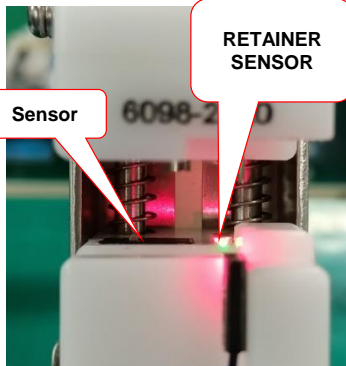
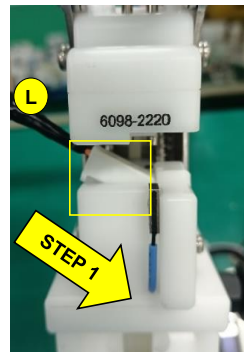
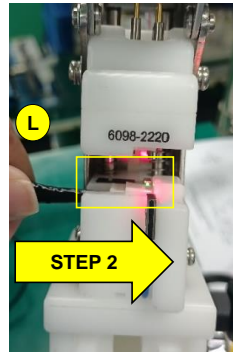
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PARTS:	1. Assy parts		JIG:	1. Locking jig Connector 6098-2220 (W)
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1	Connector Lock	<div><div>CONNECTOR RETAINER ILLUSTRATION</div><div>SIDE VIEW</div><div><div></div><div>GOOD</div><div></div><div>NG</div></div><div><div>1. Check the Retainer lock of connector before insertion to locking jig. <i>Note: Must be NO half-locked condition prior connector locking.</i></div></div></div>	<div><div>3</div><div>Important reminders/Note/s:</div><div><div>1. Incomplete locking process will alarm the jig.</div><div>2. No retainer in connector cannot proceed.</div><div>3. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</div></div></div>
			<div><div><div><div>HANDLE</div><div>Sensor</div></div><div><div>RETAINER SENSOR</div><div>Sensor</div></div><div><div>STEP 1</div></div><div><div>STEP 2</div></div></div><div><div>2. Hold the assy parts using left hand and insert into connector locking jig based on the direction of arrow. Make sure the connector touch the sensor. Sound will be heard if properly lock. NOTE: CONNECTOR LOCKING JIG WILL NOT FUNCTION IF CONNECTOR NOT REACH THE SENSOR.</div></div></div>	

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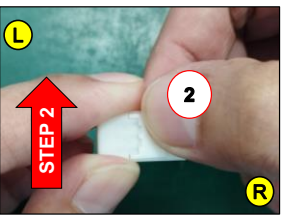
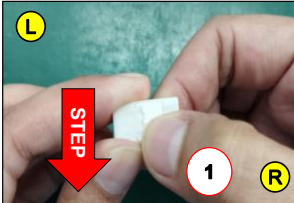
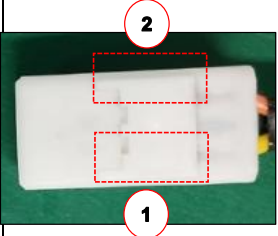
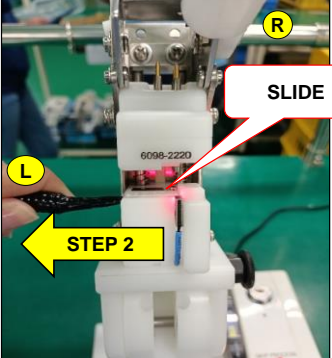
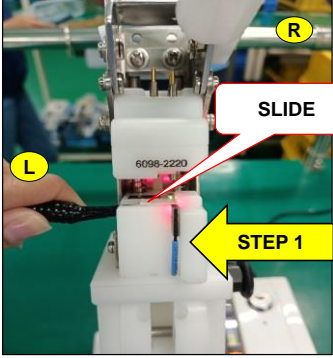
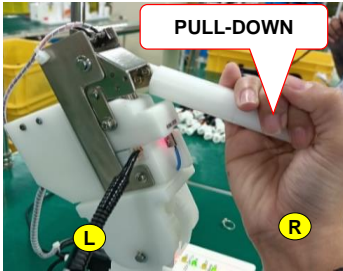
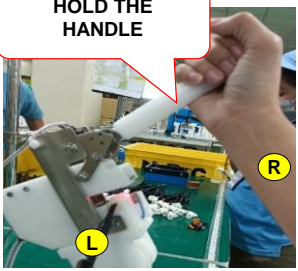

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PARTS:	1. Assy parts	JIG:	1. Locking jig Connector 6098-2220 (W)
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION 	TOOLS/PPE  QUALITY POINTERS
5	P1 Connector lock (Continuation)	<div><p>3. Hold the handle of the connector locking jig using right hand then gently pull down and bring back to original position after locking. Note: Pull down one time only.</p><p>4. Remove the locked connector using left hand based on the illustration, follow the direction of arrow.</p><p>5. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div>	<p>1. Please ensure that Connector lock/retainer will not touch or hit by any object prior insertion into locking jig to avoid half-lock connector.</p> <p>2. Maintain 10mm proper holding of wire to connector</p> <p>3.Connector must be fully inserted to connector slot.</p> <p>4. Make sure no offset setting before locking process.</p> <p>5.No wrong setting of connector.</p> <p>6. No damaged connector lock</p> <p>7. No unlocked/ half-locked connector</p> <p> Important reminders/Note/s:</p> <p><i>1. Incomplete locking process will alarm the jig.</i></p> <p><i>2. No retainer in connector cannot proceed.</i></p> <p><i>3. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</i></p>

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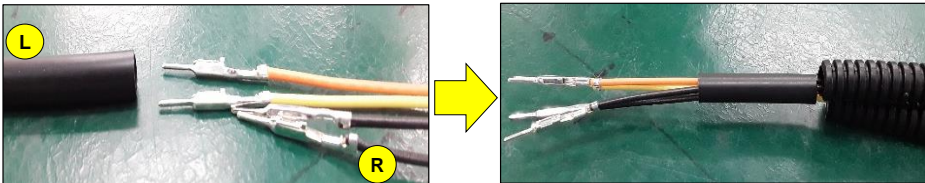
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PARTS:		1. Assy parts	3. Black SV tube (Vinyl) Ø5 L=25±3mm	JIG:	n/a
		2. Black Corrugated tube Ø5 L=316±3mm			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1	Wire insertion to Black Corrugated tube Ø5 L=316±3mm	 <div>1. Get the Black Corrugated tube Ø5 L=316±3mm using right hand then insert the Y-OR wires.</div>	n/a	1.No wrong use of parts. 2. No deformed terminals.
7		Wire insertion to Black SV tube (Vinyl) Ø5 L=25±3mm	 <div>1. Combine the assy parts (Y/OR wires with COT Ø5 L=316±3mm and 2 Black wires with COT Ø5 L=412±3mm) then get the Black SV tube (Vinyl) Ø5 L=25±3mm using left hand and insert the wires using right hand.</div>		1.No wrong use of parts. 2. No deformed terminals.

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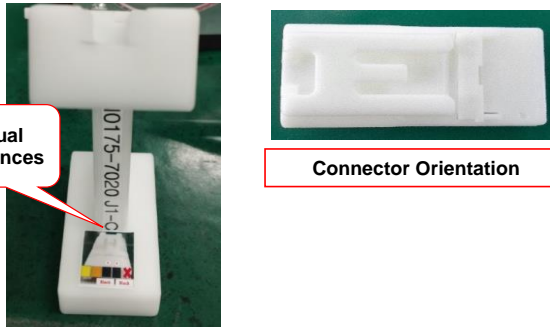

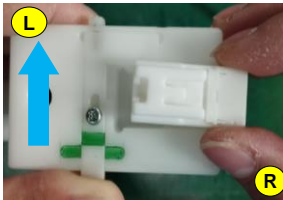
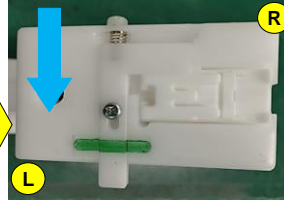

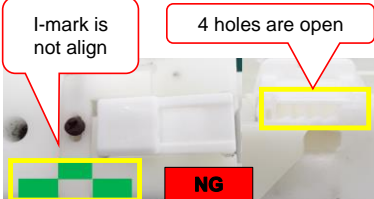
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PARTS:	1. Connector 6098-3802 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P1 Connector setting to insertion jig (6098-3802 (W))	<div><p>Insertion Jig Orientation</p></div> <div><p>Visual references</p><p>Connector Orientation</p></div> <div><p>Press</p></div> <div><p>L</p><p>R</p></div> <div><p>L</p><p>R</p></div> <div><p>1. Press the lock of insertion jig using left hand.</p><p>2. Get the connector 6098-3802 (W) using right hand and insert to insertion jig. Release the lock after insertion.</p></div>	n/a	<div><p>CONNECTOR ORIENTATION ILLUSTRATION</p></div> <div><p>I-mark is align</p><p>2 holes are open</p><p>GOOD</p></div> <div><p>I-mark is not align</p><p>4 holes are open</p><p>NG</p></div> <div><p>1. Use the provided jig per model</p><p>2. No wrong orientation of connector</p></div>

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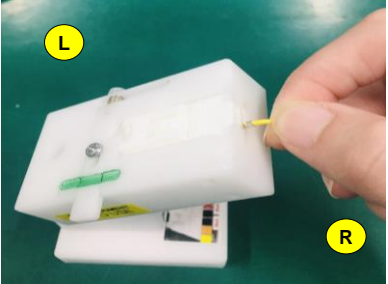
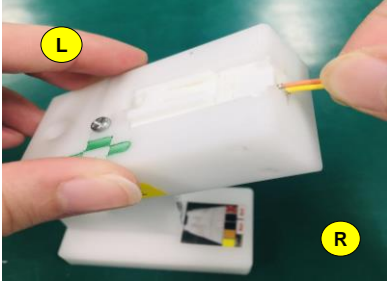
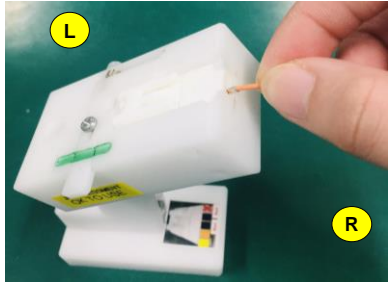
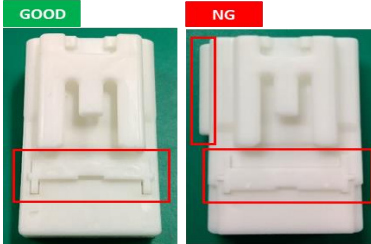
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PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1 Wire insertion to Connector 6089-3802 (W)	<div></div> <div>1. Get the Yellow wire and insert to terminal slot 1 using right hand</div> <div></div> <div>2.. Get the Orange wire and insert to terminal slot 2 using right hand</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>		n/a	<div>CONNECTOR ILLUSTRATION</div> <div></div> <div>6098-3802 (W)</div> <div>6098-5668 (W)</div> <div>1. Use the provided jig per model 2. No wrong orientation of connector</div>

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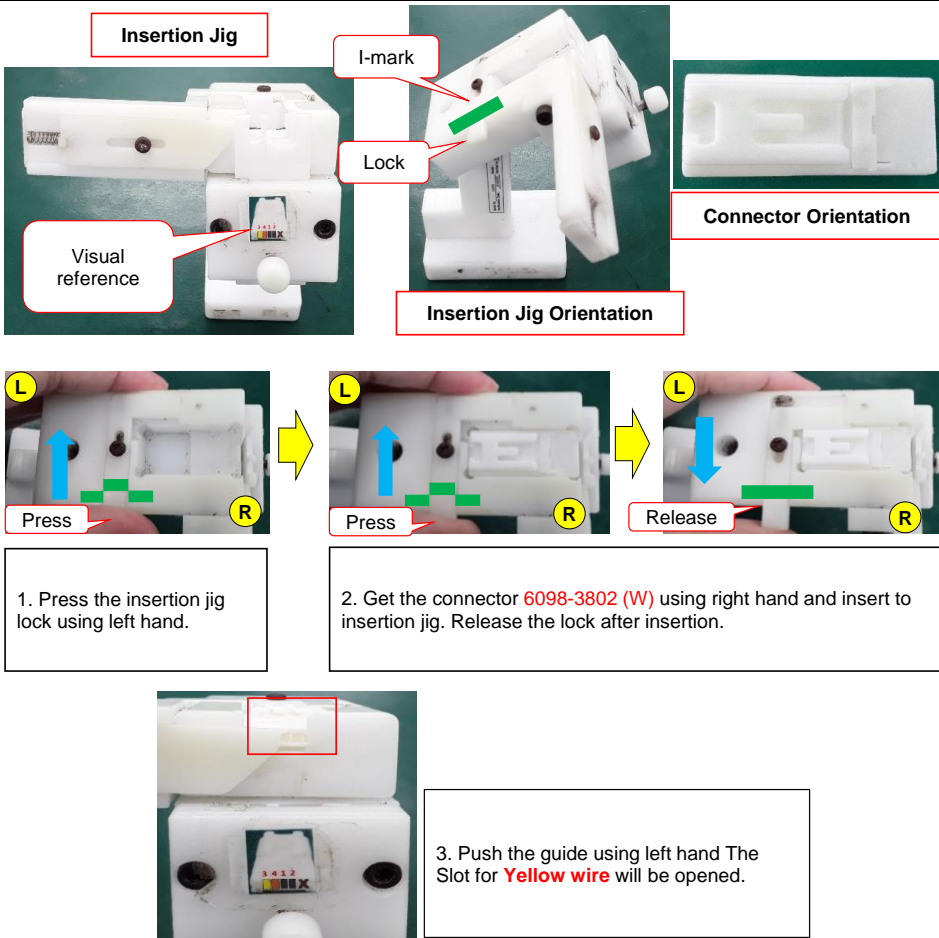
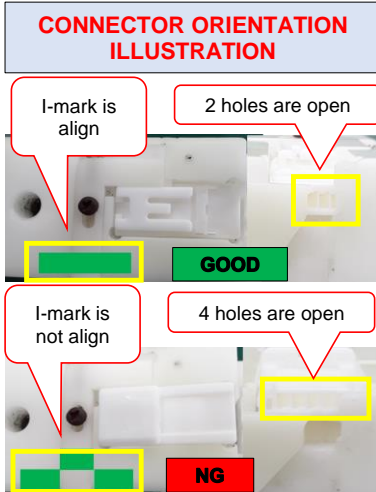
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PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	P1	<p>Connector setting to Insertion jig (Assy parts)</p>  <p>1. Press the insertion jig lock using left hand.</p> <p>2. Get the connector 6098-3802 (W) using right hand and insert to insertion jig. Release the lock after insertion.</p> <p>3. Push the guide using left hand The Slot for Yellow wire will be opened.</p>		n/a	<p>CONNECTOR ORIENTATION ILLUSTRATION</p>  <p>1. Use the provided jig per model</p> <p>2. No wrong orientation of connector</p>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 3, 2024

Process Name/Title:

Model code/Part number:

382D

/

7N0175-7020A

Customer: TRJ

Car Model: TOYOTA-CAMRY

Validity Date:

n/a

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Document No.:






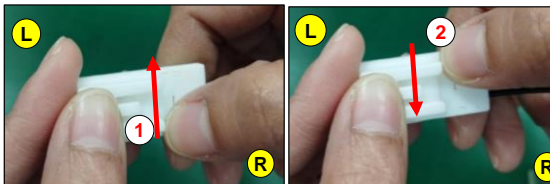



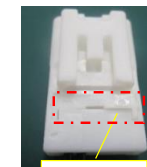
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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
12	P1 Connector setting to Insertion jig 6098-3802 (W)	<div><div><p>1. Load the connector into the jig holding both side of the connector, tip 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>		n/a	<div><div><p>Before pressing</p></div><div><p>After pressing</p></div></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: 1. Manual locking may cause damaged connector lock.</p>

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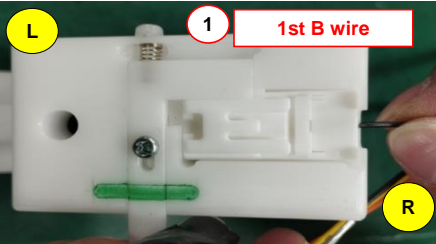
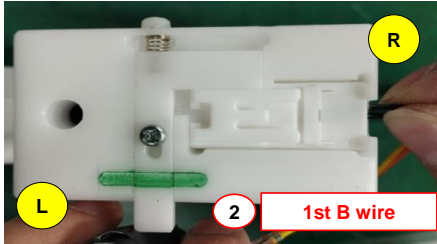
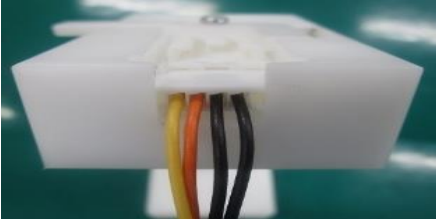
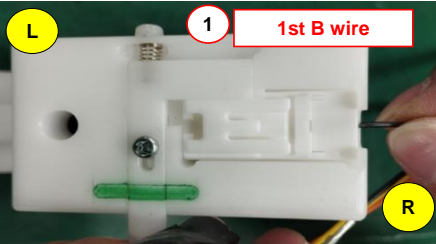
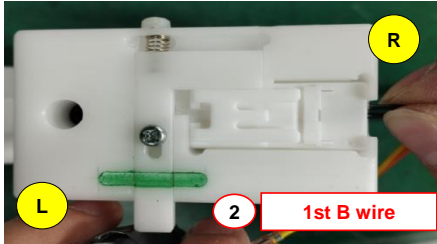
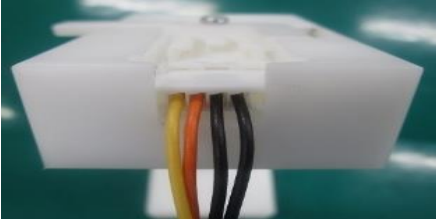
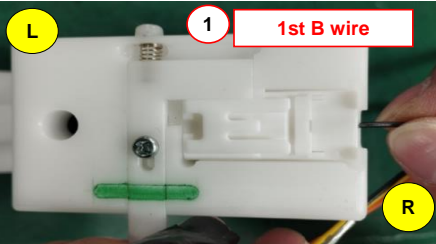
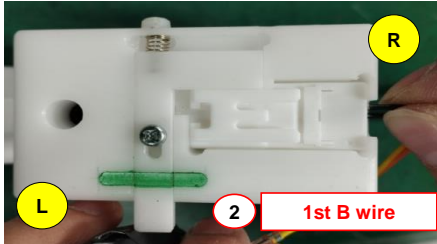
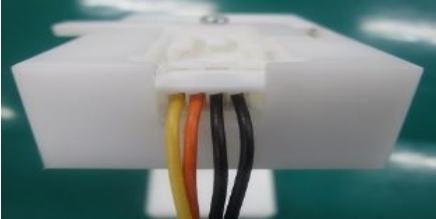
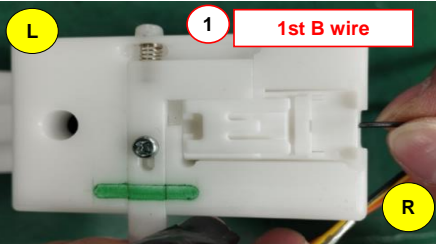
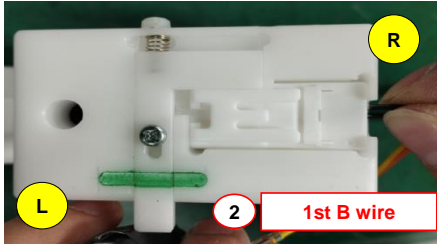
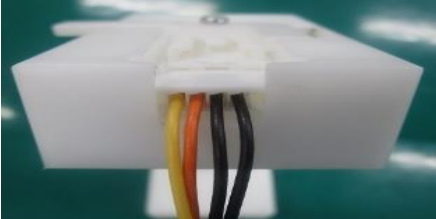
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PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
11	P1	<div><div><p>Connector Orientation</p></div><div><p>Wire facing</p></div><div><div><p>1. Hold the 1st Black wire and insert to terminal slot 3 using right hand. Conduct 2x Pull-Push-Pull-Push after insertion</p></div><div><p>2. Hold the 2nd Black wire and insert to terminal slot 3 using right hand. Conduct 2x Pull-Push-Pull-Push after insertion</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></div></div> <div><div><p>1. Hold the 1st Black wire and insert to terminal slot 3 using right hand. Conduct 2x Pull-Push-Pull-Push after insertion</p></div><div><p>2. Hold the 2nd Black wire and insert to terminal slot 3 using right hand. Conduct 2x Pull-Push-Pull-Push after insertion</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></div> <div><div><p>1. Hold the 1st Black wire and insert to terminal slot 3 using right hand. Conduct 2x Pull-Push-Pull-Push after insertion</p></div><div><p>2. Hold the 2nd Black wire and insert to terminal slot 3 using right hand. Conduct 2x Pull-Push-Pull-Push after insertion</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></div> <div><div><p>1. Hold the 1st Black wire and insert to terminal slot 3 using right hand. Conduct 2x Pull-Push-Pull-Push after insertion</p></div><div><p>2. Hold the 2nd Black wire and insert to terminal slot 3 using right hand. Conduct 2x Pull-Push-Pull-Push after insertion</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></div> <div>9</div> <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><div>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.</div><div>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div></div>		

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PARTS:		1. Assy parts 2. Black Corrugated tube Ø5 L=412±3mm		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
13	P1	<div><div><p>1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the B-B wires using left hand.</p></div><div><p>2. Get the corrugated tube (no slit) Ø5 L=412±3mm using right hand then insert the B-B wires using left hand.</p></div><div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div></div>		<div><div>TERMINAL COVER JIG</div></div>	1.No wrong use of parts. 2. No deformed terminals.

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PARTS:

n/a

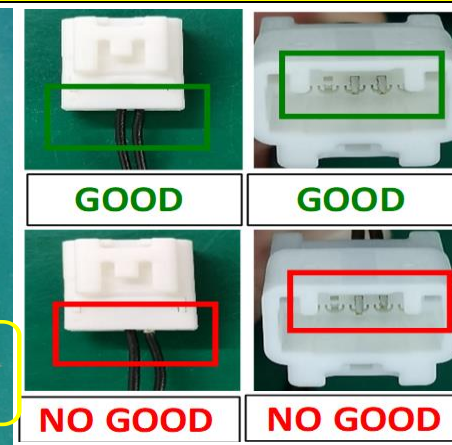
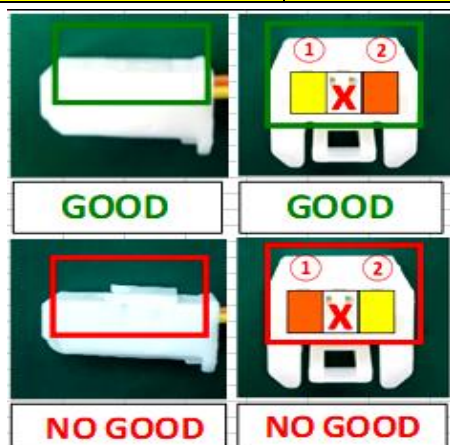
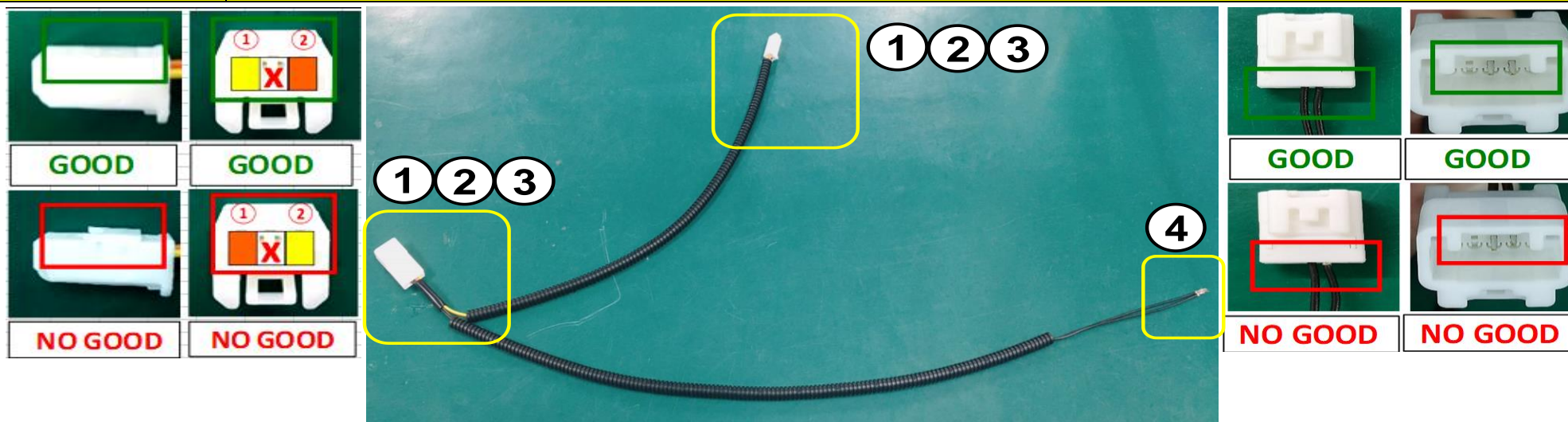
JIG:

n/a

QUALITY CHECKPOINTS

P1

7N0175-7020A



- ① No Unlock/Half-locked connector
- ② No Wrong insert
- ③ No Terminal backing out.
- ④ No Deformed terminal

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