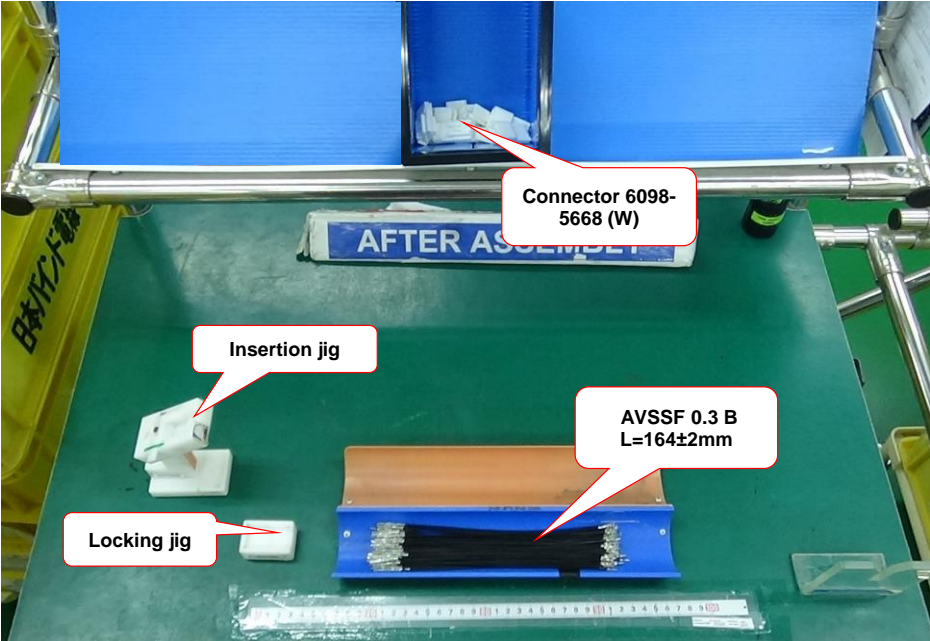
	WORK INSTRUCTION				Effectivity Date:		April 11, 2025	
	OFFLINE ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 310D / 7N0245-7020		Customer: TRJ	Car Model: TOYOTA-RAV4		Document No.: WI-ENG-PDE-1232
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		0	Page No.: 1 of 6

PARTS:		1. Connector 6098-5668 (W) 2. AVSSF 0.3 B-B wires L=164±2mm [2pcs.]		JIG:	1. Insertion jig 2. Locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
1	Offline Table Lay-out	<div>TABLE LAY-OUT</div> 		<div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<div>Document reference/s:</div> <p>1. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length Tolerance</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>	

Revision History								Prepared by	Checked by	Reviewed by	Approved by
04/11/25	0	Initial issue.				A.Buban	J.Loterte	C.Villanueva	A.Arañes		
Eff. Date	Rev. No	Details of Change				Revised	Checked	Reviewed	Approved	Est. Date:	April 11, 2025

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**WORK INSTRUCTION****OFFLINE ASSEMBLY PROCESS**

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310D / 7N0245-7020

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Purpose:



PROTOTYPE



PRE-LAUNCH




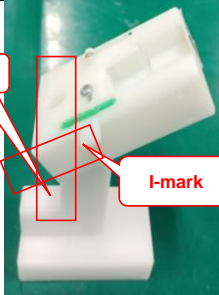
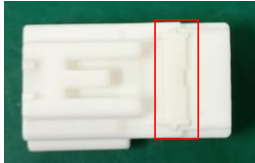
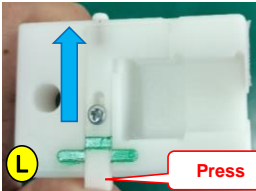
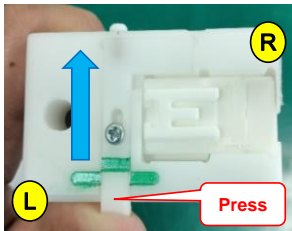
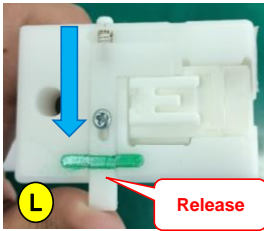





MASSPRO

Revision No.:

0

Page No.:

2 of 6

PARTS:	1. Connector 6098-5668 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Offline  Connector setting to insertion jig 6098-5668 (W)	<div><div>INSERTION JIG</div><div></div></div> <div><div>Lock</div><div></div><div>CONNECTOR ORIENTATION</div><div></div></div> <div><div>INSERTION JIG ORIENTATION</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 <b>6098-5668 (W)</b> into jig using right hand then release the lock.</div><div><div></div><div>3. Check the holes/terminal slot for <b>B-B wires.</b></div></div></div> <div>n/a</div> <div><div>CONNECTOR ORIENTATION ILLUSTRATION</div><div><div></div><div></div><div>GOOD</div></div><div><div></div><div></div><div>NG</div></div><div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div></div>		

n/a

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## WORK INSTRUCTION

Process Name/Title:

## OFFLINE ASSEMBLY PROCESS

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Model code/Part number:

310D / 7N0245-7020

Customer: TRJ

Car Model: TOYOTA-RAV4

Document No.:

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Purpose:



PROTOTYPE



PRE-LAUNCH




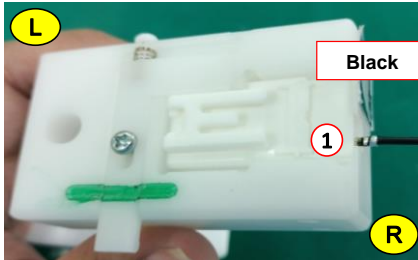
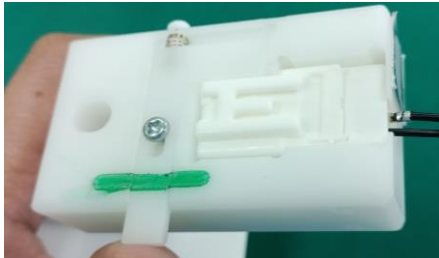

MASSPRO

Revision No.:

0

Page No.:

3 of 6

PARTS:	1. IRRAX A 0.3 B L=164±2mm [2pcs]		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Offline  Wire insertion to connector 6098-5668 (W)	<div><div>WIRE FACING</div></div> <div><div><div>L</div><div>Black</div><div>1</div><div>R</div></div><div>1. Get <u>Black wire</u> then insert to terminal slot ① using right hand. <b>Note: Insertion of wire must be from left to right.</b></div></div> <div><div></div><div>2. Get <u>Black wire</u> then insert to terminal slot ② using right hand.</div></div> <div><div></div><div>3. After insertion, push the lock button using left thumb then hold the wires and gently pull out the connector from jig using right hand.</div></div>	n/a	<div>Document reference/s: 1. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length Tolerance</div> <div>Important reminders/note/s: 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</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

## OFFLINE ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

310D / 7N0245-7020

Customer: TRJ

Car Model: TOYOTA-RAV4

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

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Effectivity Date:

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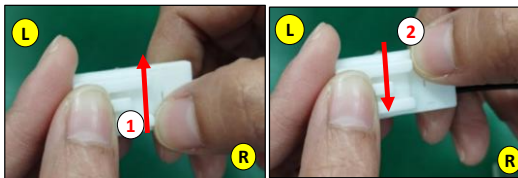



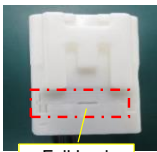

WI-ENG-PDE-1232

Revision No.:

0

Page No.:

4 of 6

PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	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>LOCKING JIG</div> 	<p><b>Important reminders /Note/s;</b> 1.MANUAL LOCKING MAY CAUSED DAMAGED LOCK</p> <p><b>Document reference/s;</b> 1.Please refer to <b>GL-PRO-ASS-017</b> for the verification of connector lock.</p> <p>1. Use the provided locking jig per model 2. No unlock/half-locked connector</p> <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>

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**310D / 7N0245-7020**Customer: **TRJ**Car Model: **TOYOTA-RAV4**

Document No.:

**WI-ENG-PDE-1232**

Purpose:

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Revision No.:

0

Page No.:

5 of 6

**PARTS:**

1. Assy Parts

JIG:

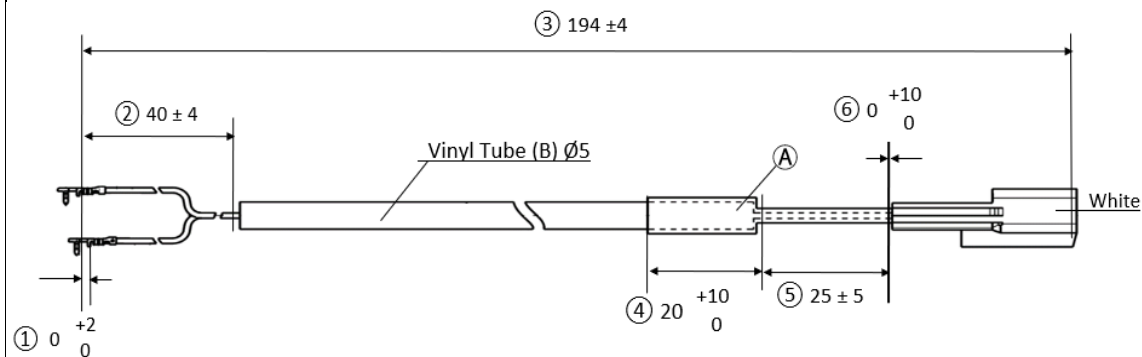
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**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

5

Offline

Measurement

**WIRE TYPE TABLE**

No.	Color	Wire Type
1	B	AVSS 0.3 f
2	B	AVSS 0.3 f

**NOTE:**

A - Taping (L)

\*Unit of dimension is in millimeter (mm)

\*Measuring Tool: measuring tape

**MEASURING  
TAPE****Document reference/s:**

1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection

**Important reminders and note/s:**

1. Please use **calibrated/verified measuring tape** when getting the measurement.

2. For Hatsumono and Owarimono.

1. No wrong dimension

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**WI-ENG-PDE-1232**

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PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

0

Page No.:

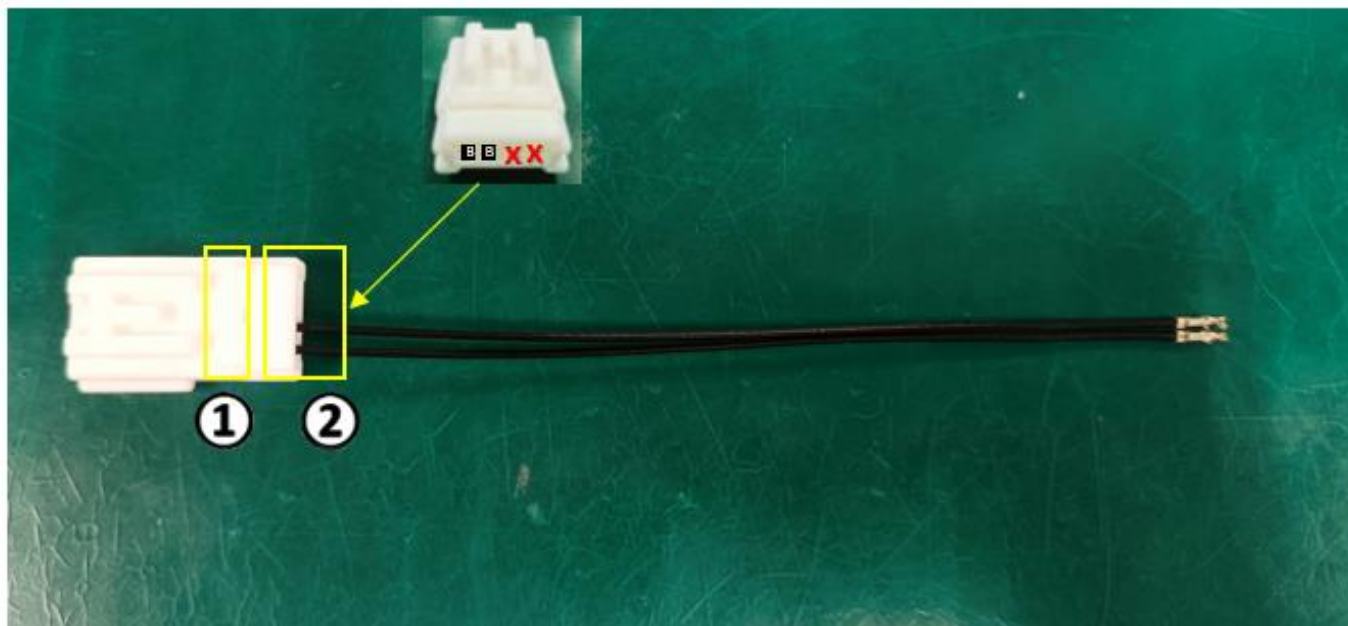
6 of 6

**PARTS:**

1. Assy Parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7N0245-7020**

- ① **No Unlocked/Half-locked connector**
- ② **No Wrong Insert**
- ③ **No Terminal Backing Out**
- ④ **No Deformed Terminal**

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