



WORK INSTRUCTION

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Model code/Part number:

310D / 7N0246-7020

Customer:

TRJ

Car Model:

TOYOTA-RAV4

Effectivity Date:

April 12, 2025

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1233

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

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PARTS:

1. Connector 6098-3871 (L)
2. AVSSF 0.3 B-B wires L=202±2mm [2pcs.]

JIG:

1. Insertion jig
2. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

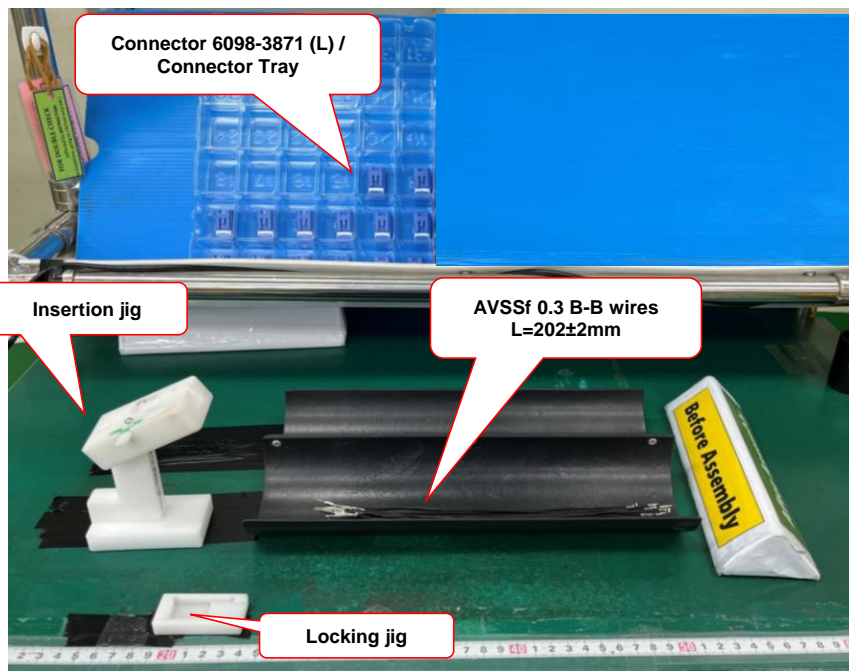
QUALITY POINTERS

1

Offline

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 work place 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	Checked	Reviewed	Approved	Prepared by	Checked by	Reviewed by	Approved by
04/12/25	0	Initial issue.	A.Buban	J.Loterte	C.Villanueva	A.Arañes	A.Buban	J.Loterte	C.Villanueva	A.Arañes

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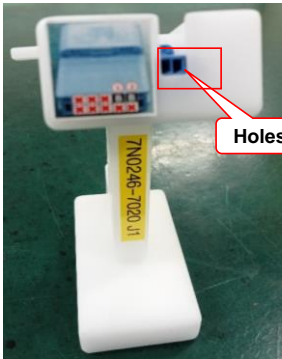
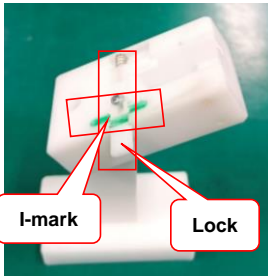

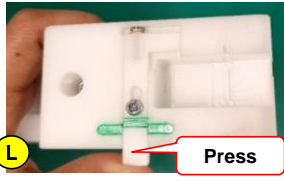
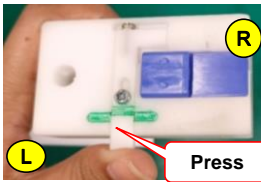
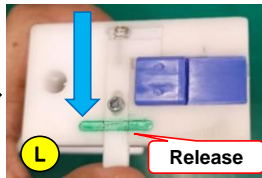



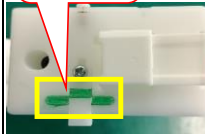

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PARTS:		1. Connector 6098-3871 (L)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Offline Connector setting to insertion jig 6098-3871 (L)	<div><div>INSERTION JIG</div><div>Holes</div><div>I-mark</div><div>Lock</div><div>INSERTION JIG ORIENTATION</div><div>CONNECTOR ORIENTATION</div><div>L</div><div>Press</div><div>L</div><div>Press</div><div>R</div><div>L</div><div>Release</div><div>3. Check the holes/terminal slot for B-B wires.</div></div>		n/a	<div><div>CONNECTOR ORIENTATION ILLUSTRATION</div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div><div>I-mark is not align</div><div>all holes are open</div><div>NG</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>

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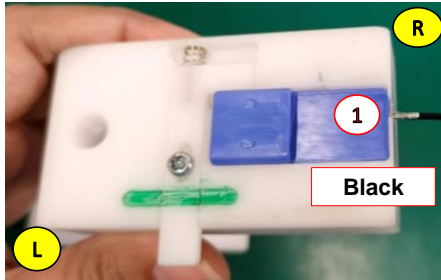
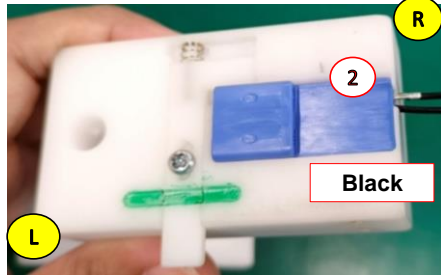

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PARTS:	1.AVSSF 0.3 B-B wires L=202±2mm [2pcs.]		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Offline Wire insertion to connector 6098-3871 (L)	<div><div>WIRE FACING</div></div> <div><div>1. Get Black wire then insert to terminal slot ① using right hand.</div></div> <div><div>2. Get Black wire then 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></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/note/s:</p> <p>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push 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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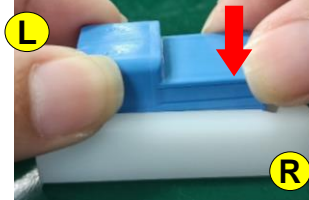



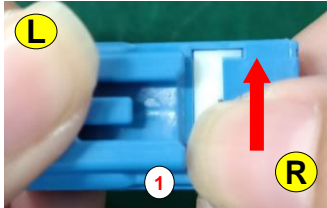


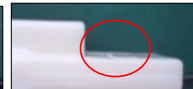
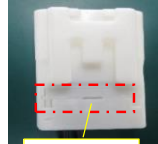

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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Offline Connector Lock	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div> <div><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 touching the connector lock based on the sequence illustrated.</p></div>		<div>LOCKING JIG</div> 	<p>Important reminders /Note/s; 1.MANUAL LOCKING MAY CAUSED DAMAGED LOCK</p> <p>Document reference/s; 1.Please refer to GL-PRO-ASS-017 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><p>GOOD</p><p>Full Lock</p></div><div><p>NG</p><p>Half Lock</p></div></div>

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PARTS:

1. Assy parts

JIG:

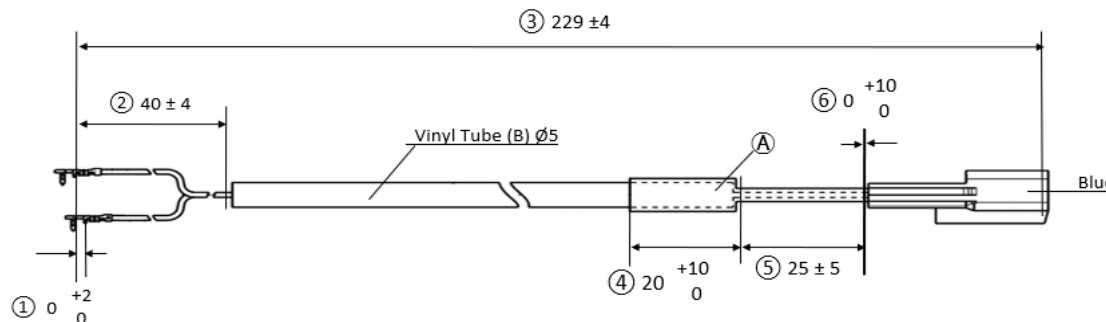
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NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

5

Offline

Measurement

**NOTE:**

① - Taping (L)

*UNIT OF DIMENSION: millimeter (mm)

*MEASURING TOOL: measuring tape

WIRE TYPE TABLE

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

**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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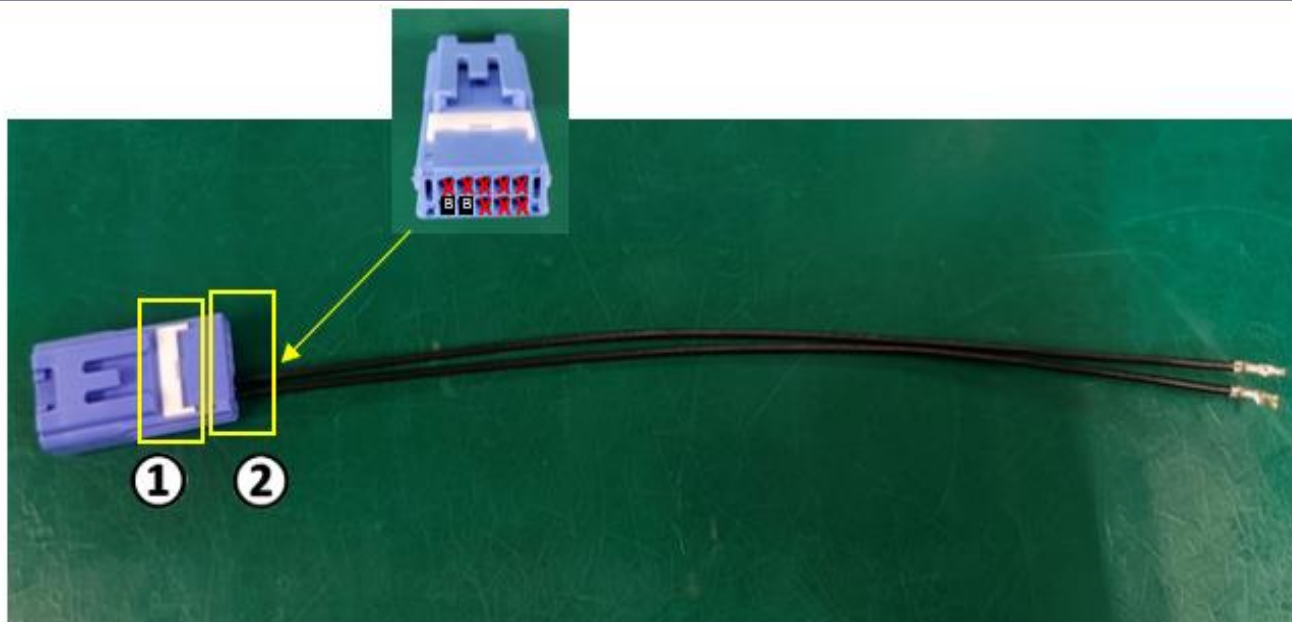
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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**OFFLINE INSERTION****7N0246-7020**

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

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