



## WORK INSTRUCTION

Process Name/Title:

## OFFLINE ASSEMBLY PROCESS

Model code/Part number:

310B / 7M0524-7020C

Customer:

TRJ

Car Model:

TOYOTA-RAV 4

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Effectivity Date:

December 05, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-167

Revision No.:

6

Page No.:

1 of 6

## PARTS:

1. Connector 6098-3802 (W); AVSSf 0.3 B wires L=789±3mm

JIG:

1. Insertion jig  
2. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

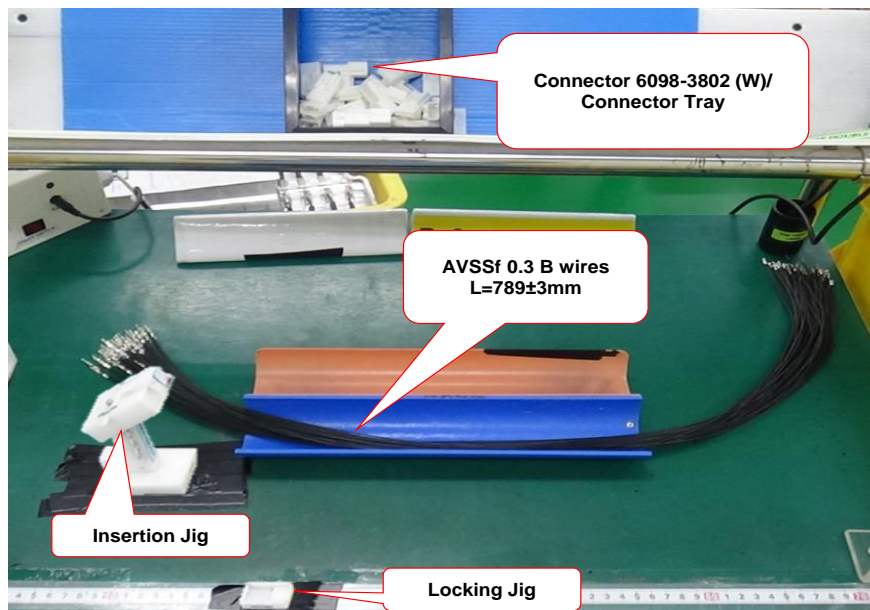
QUALITY POINTERS

1

OFFLINE

Table lay-out

## TABLE LAY-OUT



## Safety Instruction

Be sure to wear required 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

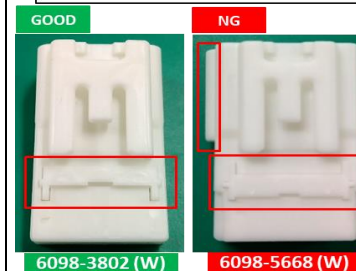
For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

## Document references:




1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

1. No missing parts/tools
2. No excess parts/tool

## CONNECTOR ILLUSTRATION




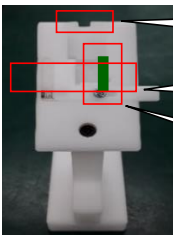
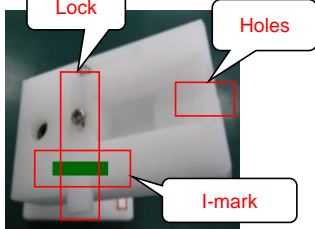

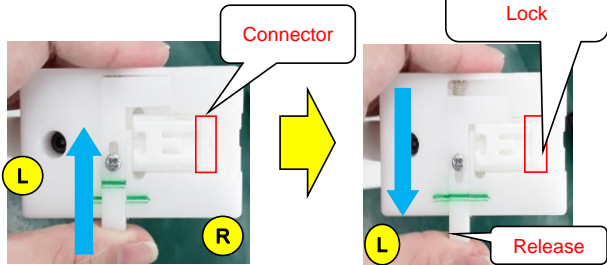



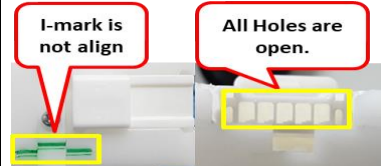
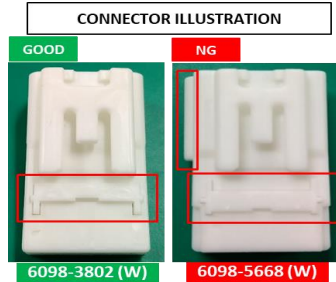
## Revision History

							Prepared by	Reviewed by	Approved by	Noted by
12/05/24	6	Transfer Wire insertion to SV tube (Vinyl) and Black Corrugated tube to Taping assembly process. Inclusion of Measurement, update Table lay-out and Visual inspection/ Quality checkpoint.	D.Castillo	C.Villanueva	A. Arañes	n/a				
08/01/23	5	Updated Template; Inclusion of CAR MODEL "TOYOTA RAV4". Updated Table lay-out. Inclusion of Quality Checkpoints on Last page. Transfer process of Wire insertion to COT from P1 to OFFLINE ASSEMBLY PROCESS. Standardized tube description: SV tube (Vinyl). (Please refer to ENGDRR-126)	M Ariola	J. Loterte	C. Villanueva	A. Arañes				
09/23/22	4	Improve Work procedure /illustration on process no. 4 Proper checking of connector lock; Quality pointers; Reminders/Notes and references on page no. 1 to 5	M Ariola	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	August 19, 2020		

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		OFFLINE ASSEMBLY PROCESS				Validity Date:		n/a		
		Model code/Part number: 310B / 7M0524-7020C		Customer: TRJ	Car Model: TOYOTA-RAV 4		Document No.:		WI-ENG-PDE-167	
		Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		6	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		OFFLINE Connector setting to insertion jig 6098-3802 (W)		<div><div></div><div></div><div></div></div> <div></div> <div></div>		n/a		<div><div></div><div></div><div></div></div> <div>1. No. damaged connector 2. Use provided jig per model 3. No wrong orientation of connector</div>		

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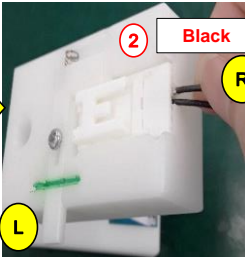
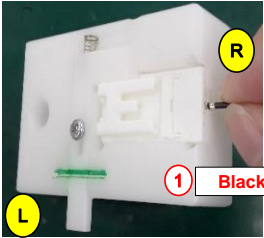
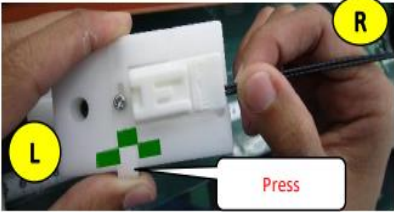
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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		6	Page No.: 3 of 6

<b>PARTS:</b>		1. AVSSf 0.3 B wires L=789±3mm [2pcs]		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
3	OFFLINE Wire insertion to connector 6098-3802 (W)	<div><p>Terminal facing</p></div> <div><p>1. Hold the insertion jig using left hand. Get the <b>1st Black wire</b> and insert to terminal slot 1 using right hand.</p><p>2. Get the <b>2nd Black wire</b> and insert to terminal slot 2 using right hand.</p><p>3. After insertion, push the lock using left thumb, hold the wires and gently pull out the connector from jig using right hand.</p></div> <div><p>Press</p></div>	n/a	<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><b>Important reminder/Note/s:</b> <b>1. Please hold the wire near terminal during insertion</b> <b>2. Insertion must be from left to right</b> <b>3. Make sure wires are properly inserted . Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</b></div> <div><b>Document reference/s</b> <b>1. Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</b> <b>2. Please refer to GL-PRO-ASY-029 for Pull-Push procedure</b></div>	

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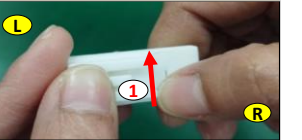
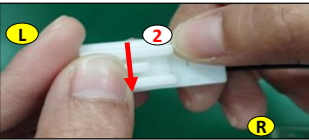
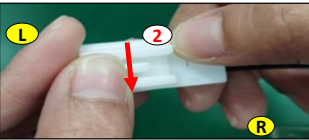

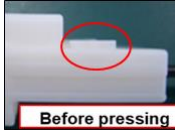
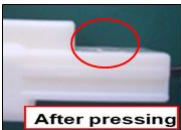


MASSPRO

Revision No.:

**6**

Page No.:


**4 of 6**

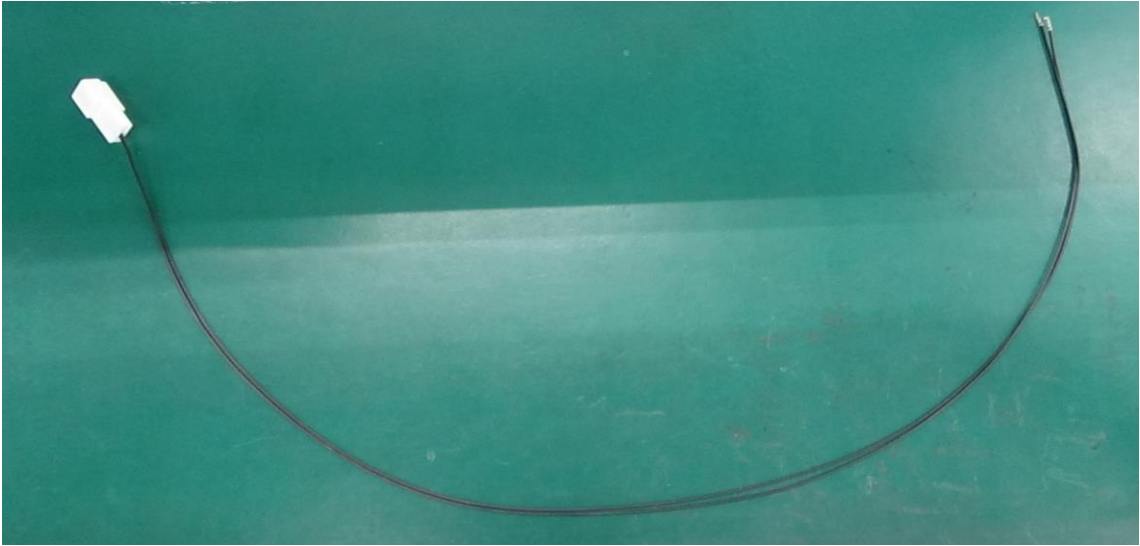
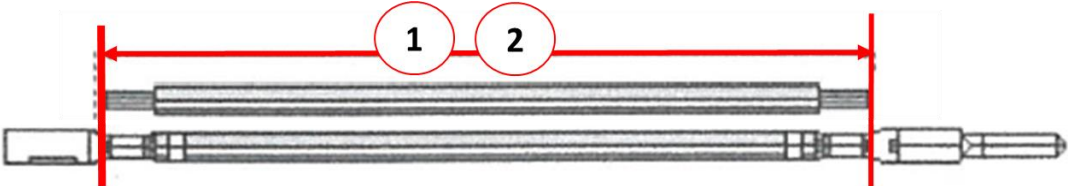

<b>PARTS:</b>		1. Assy part 2. Black tape	JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
4	OFFLINE Connector lock	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div> <div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div> <div><p>3. Press the lower parts of connector using right hand while left hand holding the middle.</p></div> <div><p>4. Press the upper part of connector using right hand while left hand holding the middle.</p></div> <div><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><p><b>LOCKING JIG</b></p></div>	<p>1. No unlock/half-locked connector 2. Use provided jig tool to lock the connector</p> <p><b>Important reminder/Note/s:</b></p> <p><b>1. Manual locking may cause damaged connector lock.</b></p> <p><b>LOCK CONDITION</b></p> <div><p>Before pressing</p><p>After pressing</p></div> <div><p>GOOD Full Lock</p><p>NG Half Lock</p></div>

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	6	Page No.:	5 of 6

<b>PARTS:</b>	1. Assy parts			JIG:	n/a	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
5	OFFLINE Measurement	<div>Note: 1. Measurement point: End of core wire to the end of core wire 2. Terminal is reference only.</div> <div></div>	<div>MEASURING TAPE</div> 	<div><b>Important reminders and note/s:</b> 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono and Owarimono.</div> <div><b>Document reference/s:</b> 1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension</div>		

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Page No.:

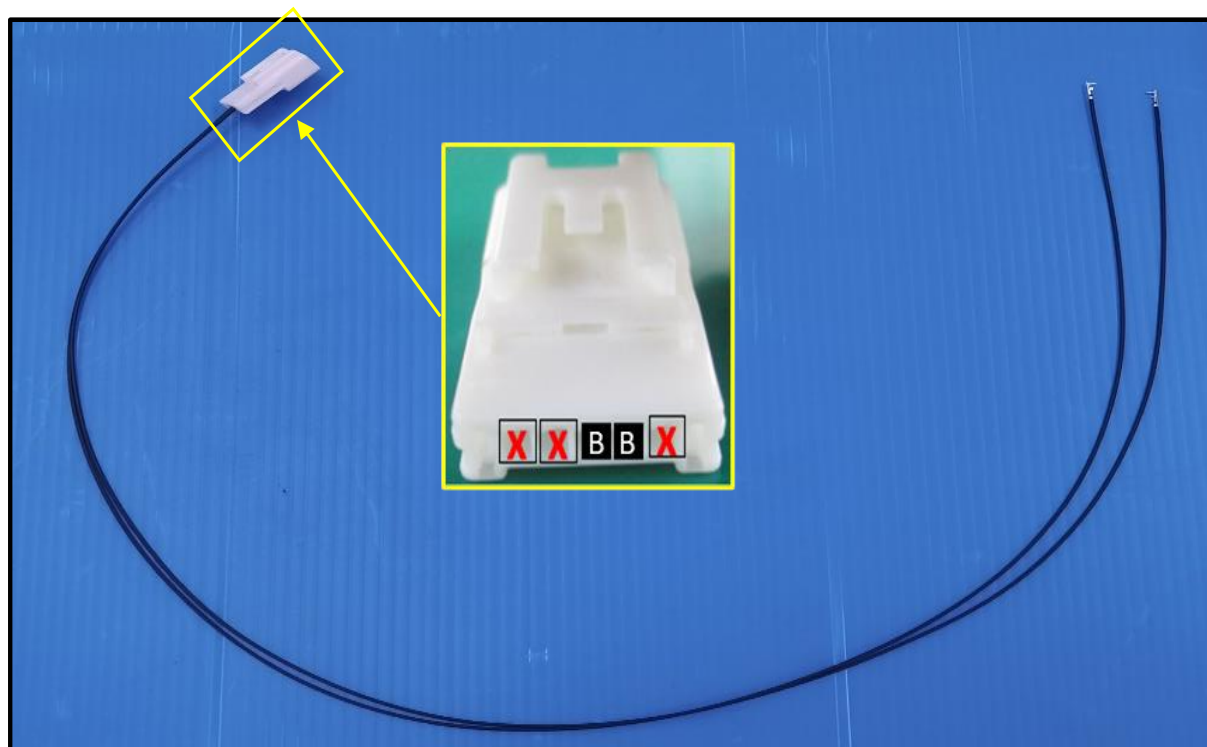
6 of 6

**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7M0524-7020C**

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

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