



WORK INSTRUCTION

Process Name/Title: OFFLINE ASSEMBLY PROCESS

Model code/Part number: 311D / 7L0154-7023 Customer: TRQSS Car Model: TOYOTA-RAV4

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

Effectivity Date:

October 2, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1025

Revision No.:

1

Page No.:

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PARTS:

1. Connector 6189-0451 (W)
2. MR SW CP (TVSSf 0.3 G wires L=637±3mm; AVSSf 0.3 B/W wires L=637±3mm)
3. Black Corrugated tube (No slit) ø7, L=346±3mm

JIG:

1. Insertion jig
2. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

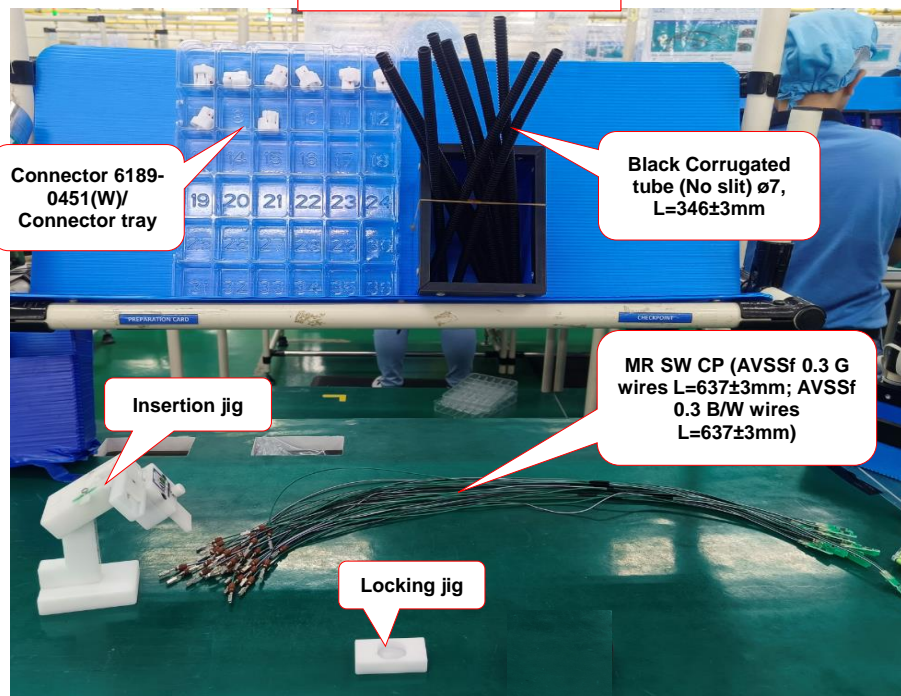
QUALITY POINTERS

1

Offline

Table lay-out

TABLE LAY-OUT



Safety Instruction

Be sure to wear 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.

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

Revision History

Revision History								Prepared by	Reviewed by	Approved by	Noted by
10/02/24	1	Change purpose from Pre-launch to Masspro.						 M. Ariola	 C. Villanueva	 A. Arañes	n/a
			M. Ariola	C. Villanueva	A. Arañes	n/a					
09/06/24	0	Initial issue.									
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 6, 2024			

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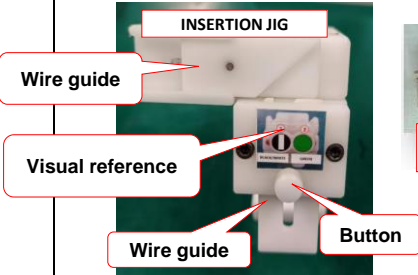


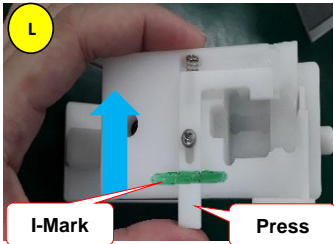
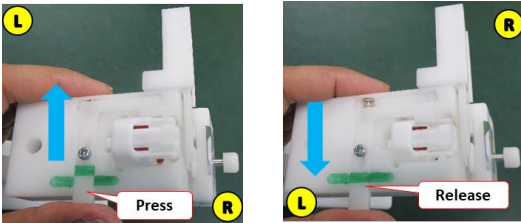
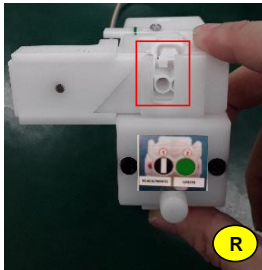


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Connector 6189-0451 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Offline Connector setting to insertion jig Connector 6189-0451 (W)	<div><div></div><div> Wire Facing</div><div> Connector Orientation</div><div></div><div></div><div></div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6189-0451 (W) into jig using right hand and release the lock.</div><div>3. Push the guide using right hand. The slot for B/W wire will be open.</div></div>	n/a	<div><div>Connector Orientation Illustration</div><div> GOOD</div><div> NG</div></div> <div>1. Use provided jig per model 2. No wrong orientation of connector</div>

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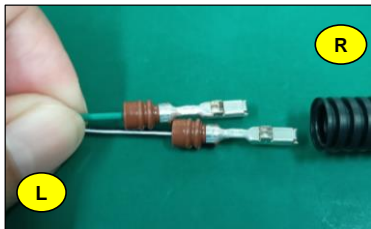
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Black Corrugated tube (No slit) ø7, L=346±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Offline	<div><div>1. Get the Black Corrugated tube (No slit) ø7, L=346±3mm using right hand then insert the wire using left hand.</div></div>		n/a	<div>1. No wrong used of parts. 2. No deformed terminal.</div> <div>Document reference/s: 1. Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</div>

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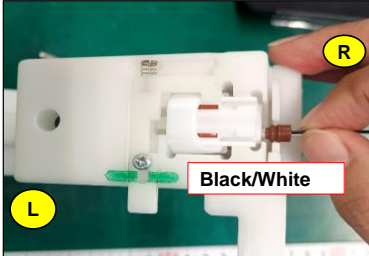
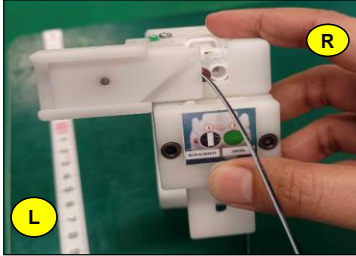

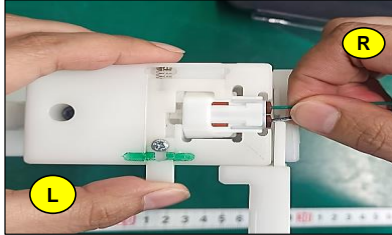
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PARTS:		1. Assy parts 2. MR SW CP (AVSSf 0.3 G wires L=637±3mm; AVSSf 0.3 B/W wires L=637±3mm)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Offline Wire insertion to Connector 6189-0451 (W)	<div><p>1. Get the B/W wire then insert to terminal slot no.1 using right hand.</p></div> <div><p>2. After insertion of B/W wire press the button using right hand. The slot for Green wire will be open.</p></div> <div><p>3. Get the B/W wire then insert to terminal slot no.1 using right hand.</p></div> <div><p>4. After insertion, push the lock of insertion jig using left thumb and then hold the wires and gently pull-out the connector from the jig using right hand</p></div>		n/a	<p>1. No wrong use of connector 2. No damaged connector 3. No wrong insertion 4. One by one insertion 5. No deformed terminal 6. No wrong wire facing</p> <p>Important reminder/Notes/:</p> <p>1. Please hold the wire near terminal during insertion.</p> <p>2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> 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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☐ PROTOTYPE

☐ PRE-LAUNCH

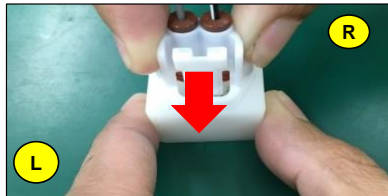







☒ MASSPRO

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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Offline	Connector lock	<div><div>1. Put the connector into locking jig using right hand. Then press to lock 2x using both hands.</div><div>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</div><div><div>BEFORE PRESSING</div><div>AFTER PRESSING</div></div><div><div>Check the double lock deformation</div></div></div> <div><div>LOCKING JIG</div></div> <div>Important reminders/Notes 1. Manual locking may cause damaged connector lock 1. Use the provided jig per model 2. No unclocked/half-locked connector.</div>		

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PROTOTYPE



PRE-LAUNCH



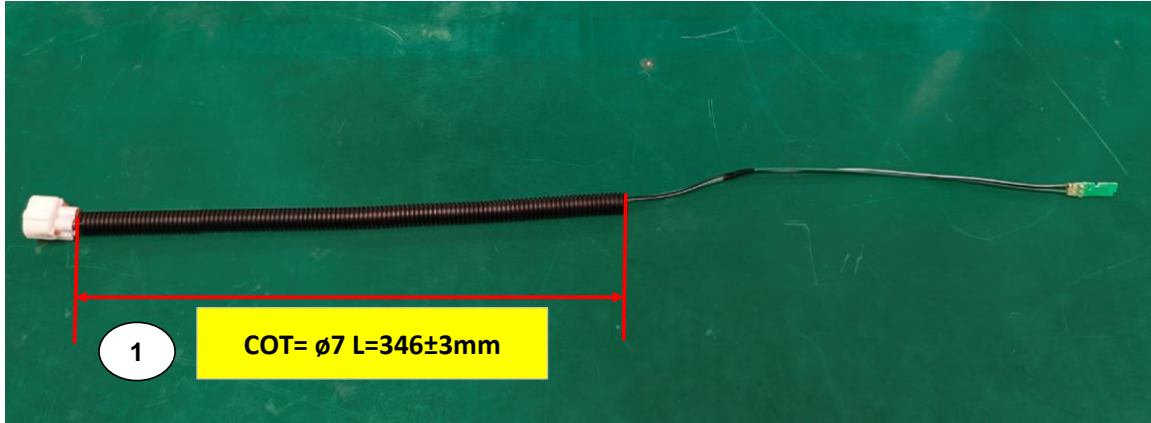
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PARTS:		n/a		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	Offline Measurement				<p>Important reminders/Notes</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>1. No wrong dimension.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly HATsumono, Nakamono and Owarimono Inspection.</p>

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PARTS: n/a

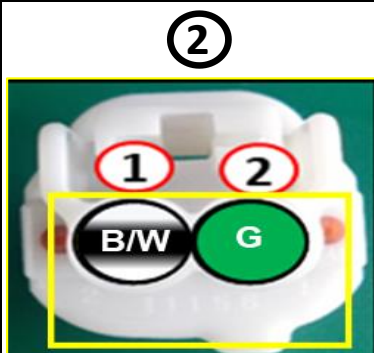
JIG:

n/a

QUALITY CHECKPOINTS

OFFLINE INSERTION

7L0154-7023



① No **UNLOCK/HALF-LOCKED CONNECTOR**

③ No **TERMINAL BACKING OUT**

② No **WRONG INSERT**

④ No **MISSING COT (NO SLIT)**

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