



WORK INSTRUCTION

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

August 08, 2024

Validity Date:

n/a

Model code/Part number:

310B / 7M0522-7021

Customer:

TRJ

Car Model:

TOYOTA-RAV 4

Document No.:

WI-ENG-PDE-402

Purpose:

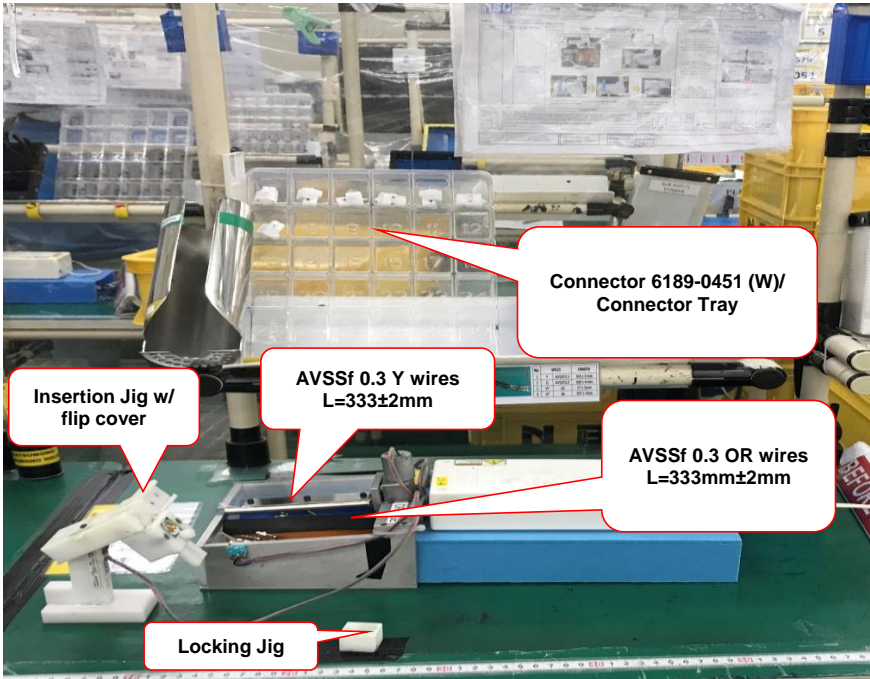
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PARTS:		1. Connector 6189-0451 (W); AVSSf 0.3 wires Y L=333±2mm; AVSSf 0.3 wires OR L=333±2mm				JIG:		1. Insertion jig w/ switch cover 2. Locking jig			
NO.	PROCESS NAME		1 WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS		
1	OFFLINE	Table lay-out	<div>Table Lay-out</div>  <div>Connector 6189-0451 (W) Connector Tray</div> <div>AVSSf 0.3 Y wires L=333±2mm</div> <div>AVSSf 0.3 OR wires L=333mm±2mm</div> <div>Insertion Jig w/ flip cover</div> <div>Locking Jig</div>				<div>Safety Instruction Be sure to wear prescribed 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>		<div>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>		
Revision History											
				Prepared by		Reviewed by		Approved by		Noted by	
08/08/24	1	Transfer Wire insertion to SV tube (Vinyl) to Taping assembly process. Inclusion of car model "", Measurement and Visual inspection/Quality checkpoints.				D.Castillo	C.Villanueva	A. Arañes	N/A		
02/19/22	0	Initial issue.				K.Doria	J.Loterter	C.Villanueva	A. Arañes	N/A	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date: February 19, 2022	

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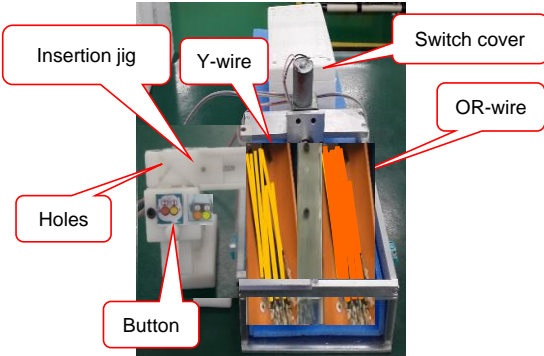

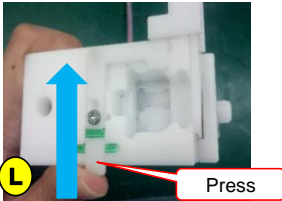
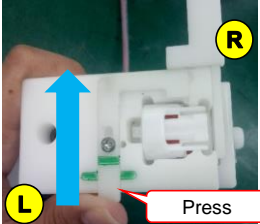
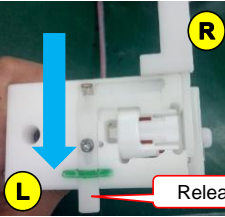
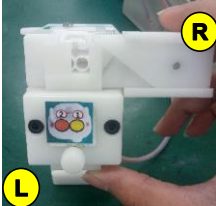
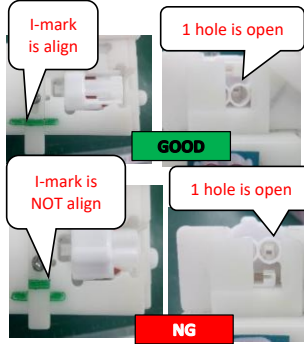
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PARTS:		1. Connector 6189-0451 (W)		JIG:	1. Insertion jig w/switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	OFFLINE Connector setting to insertion jig 6189-0451 (W)	<div><div><div>INSERTION JIG WITH SWITCH</div><div></div></div><div><div></div><div>CONNECTOR ORIENTATION</div></div><div><div></div><div>Press</div></div><div><div>1. Press the lock of insertion jig using left thumb.</div></div><div><div></div><div>Press</div></div><div><div></div><div>Release</div></div><div><div></div></div><div><div>2. Insert the connector 6189-0451 (W) into jig using right hand and release the lock.</div><div>3. Push the wire guide upward, slot for Yellow wire will be open.</div></div></div> <div>N/A</div> <div><div><div>Connector Orientation Illustration</div><div></div><div>GOOD</div><div>NG</div></div><div><div>1. Use provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div></div></div>			

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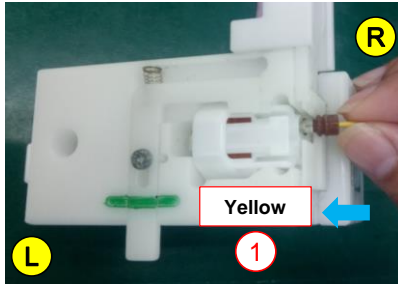
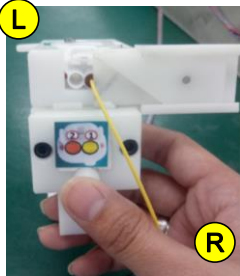
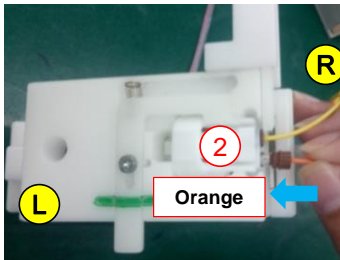
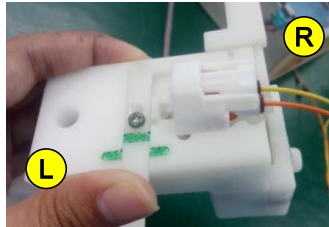
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PARTS:		1. AVSSf 0.3 wires Y L=333±2mm 2. AVSSf 0.3 wires OR L=333±2mm		JIG:	1. Insertion jig w/switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	OFFLINE	<div><div><p>WIRE FACING</p></div><div><p>Yellow</p><p>1</p></div><div><p>2</p></div><div><p>Orange</p><p>3</p></div><div><p>4</p></div></div>		N/A	<p>Important reminders/note/s:</p> <p>1. Insertion of wire must be from left to right.</p> <p>2. 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. Refer to WI-PRO-CNC-017 for wire and strip length tolerance.</p> <p>2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</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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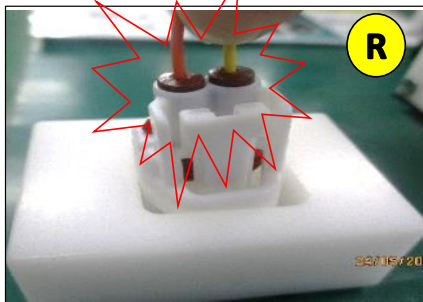




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PARTS:	1. Assy part			JIG:	1. Locking
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	OFFLINE	Connector Lock	<div><div>BEFOREPRESSING</div><div>AFTER PRESSING</div><div><div>GOOD</div><div>NG</div></div><div>1. Put the connector into locking jig using right hand then press 2x to lock. Touch the connector lock to confirm if properly pressed.</div><div>2. Check the double lock deformation</div></div>	<div>LOCKING JIG</div> 	<div>1. No Unlock and half-locked 2. Use provided jig tools per model to avoid damaged lock.</div> <div>Important reminders/Note/s: 1. Manual locking may cause damaged connector</div>

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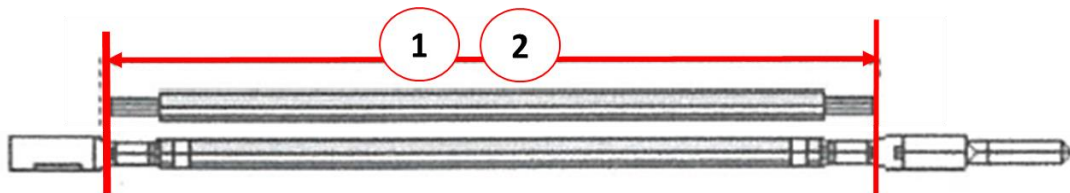

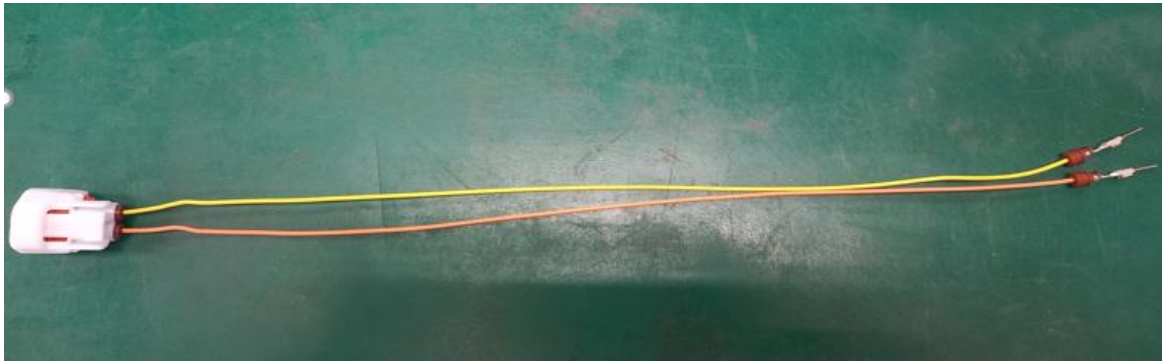
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PARTS:	1. Assy part		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	OFFLINE	<div>1</div> <p>Note:</p> <p>1. Measurement point: End of core wire to the end of core wire</p> <p>2. Terminal is reference only.</p> 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

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PARTS:

1. Assy part

JIG:

n/a

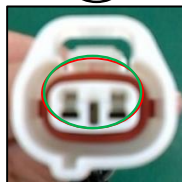


VISUAL INSEPTION/ QUALITY CHECKPOINTS

OFFLINE INSERTION

7M0522-7021

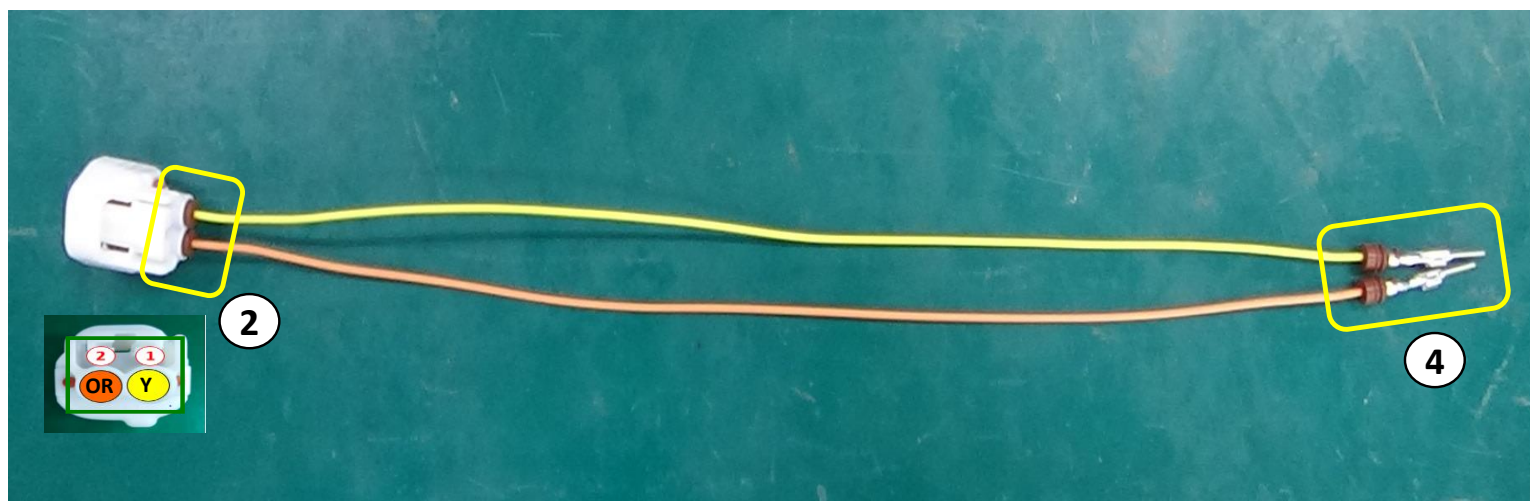
1



GOOD



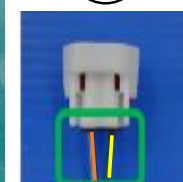
NO GOOD



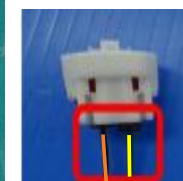
2

4

2



GOOD



NO GOOD

1 No Unlocked/ Half-locked Connector

3 No Terminal Backing Out

2 No Wrong Insert

4 No Deformed Terminal

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