



WORK INSTRUCTION

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

September 12, 2024

Model code/Part number:

320B / 7L0054-7025A

Customer:

TRQSS

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-1037

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1. All parts (Connector 6189-0451 (W); TVSSf 0.3 G/BW L=553±3mm; Black SV tube (Vinyl) ø5 L=273±3mm)

JIG:

1. Insertion jig with switch cover
2. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

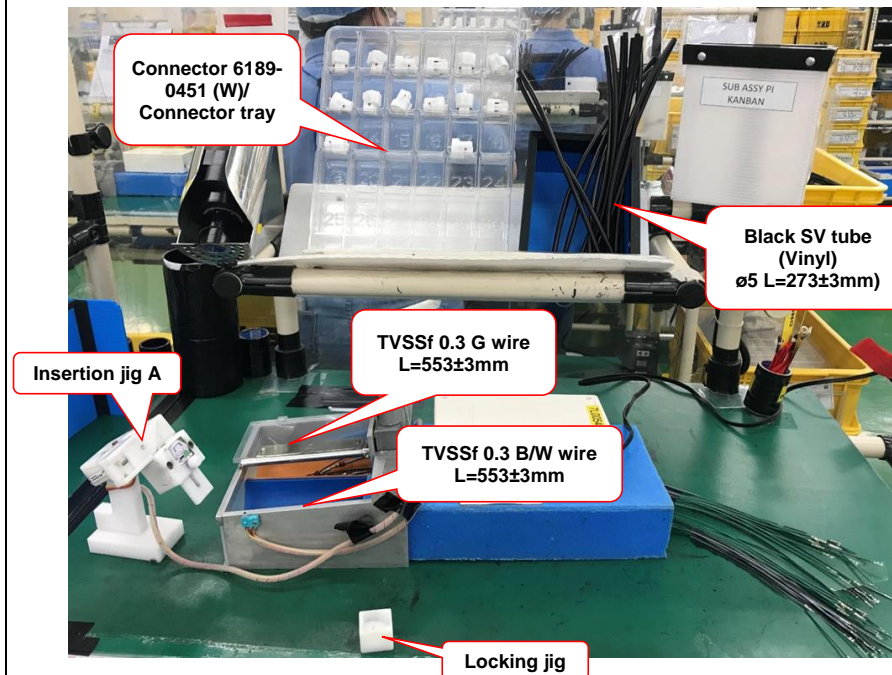
QUALITY POINTERS

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.

Document reference/s:

1. Refer to WI-PRO-CNC-071 Wire and Strip Length Tolerance

1. No missing parts/tools
2. No excess parts/tools
3. No wrong positions of parts/tools


Revision History

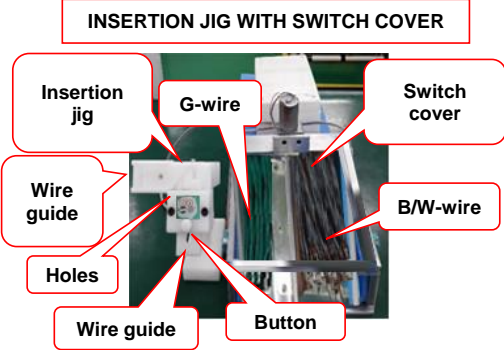
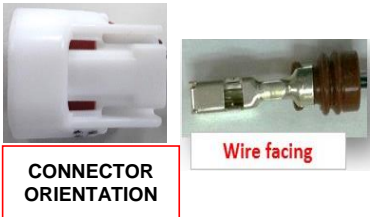
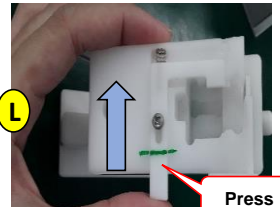
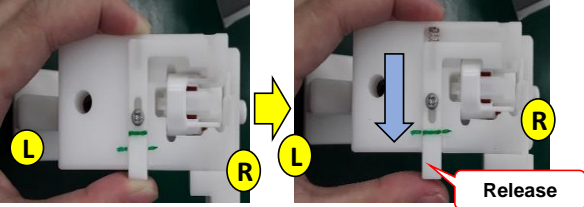
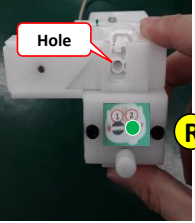


								Prepared by	Reviewed by	Approved by	Noted by
09/12/24	1	Change from Pre-launch to Masspro.	D.Castillo	C. Villanueva	A. Arañes	n/a					
09/09/24	0	Initia issue. Align switch cover to insertion jig. Improve measurement and visual inspection/quality checkpoint.	D.Castillo	C. Villanueva	A. Arañes	n/a					
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 09, 2024			

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Purpose:				Page No.: 2 of 6			
<input type="checkbox"/> PROTOTYPE				<input type="checkbox"/> PRE-LAUNCH			
<input checked="" type="checkbox"/> MASSPRO							

PARTS:	1. Connector 6189-0451 (W)			JIG:	1. Insertion jig with switch cover		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
2	Offline Connector setting to insertion jig 6189-0451 (W)	<div>INSERTION JIG WITH SWITCH COVER</div> <div></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 6189-0451 (W) into jig using right hand and release the lock. Note: Follow the connector orientation</div> <div>3. Push the guide using right thumb. The slot for B/W wire will be opened.</div>	n/a	<div>Connector Orientation Illustration</div> <div></div> <div>GOOD</div> <div></div> <div>NG</div> <div>1. Use the provided jig per model</div> <div>2. No wrong orientation of connector</div> <div>3. No wrong use of connector</div> <div>4. No damaged connector</div>			

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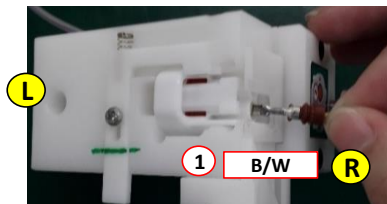
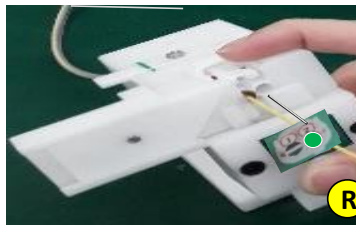
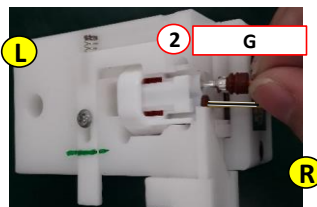
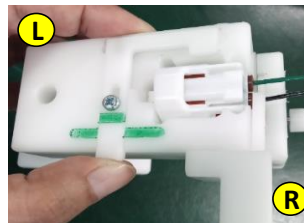
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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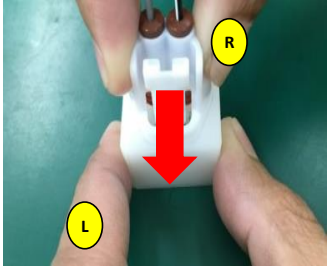
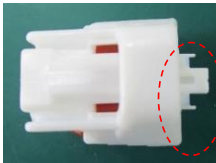





PARTS:		1. TVSSf 0.3 G/BW L=553±3mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Offline	<div><div></div><div><p>1. Get the B/W wire then insert to terminal slot ① using right hand.</p></div><div><p>2. After insertion of B/W wire press the button using right thumb. The slot for G wire will be opened.</p></div><div><p>3. Get the G wire then insert to terminal slot ② using right hand.</p></div><div><p>4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div></div>		n/a	<p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal during insertion.</p> <p>2. Insertion of wire must be inserted.</p> <p>3. Make sure wires are properly inserted.</p> <p>Conduct <u>Pull-Push-Pull-Push</u> after insertion.</p> <p>Do not exert extra force.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip lenght Tolerance</p> <p>2. Please refer to GL-PRO-ASSY-029 for Pull-Push procedure.</p> <p>1. No loose insertion</p> <p>2. No wrong insertion</p> <p>3. One by one insertion</p> <p>4. No deform terminal</p> <p>5. No wrong wire facing</p>

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	4 of 6

PARTS:	1. Assy part 2. Black SV tube (Vinyl) ø5 L=273±3mm			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Connector lock	<div></div> <div>BEFOREPRESSING</div> <div>AFTER PRESSING</div> <div>GOOD</div> <div>NG</div> <div>Check the double lock deformation</div> <div>LOCKING JIG</div> <div>1. Put the connector into locking jig using right hand then press 2x. Touch the connector lock if properly locked.</div>			Important reminders/Note/s: 1. Manual locking may cause damaged connector lock 1. Use the provided locking jig per model 2. No unlock/half-locked connector
5	Wire insertion to Black SV tube (Vinyl) ø5 L=273±3mm	<div></div> <div>1. Get the Black SV tube (Vinyl) ø5 L=273±3mm using right hand then insert the wires using left hand.</div>		n/a	1. No wrong usage of parts 2. No deformed terminal

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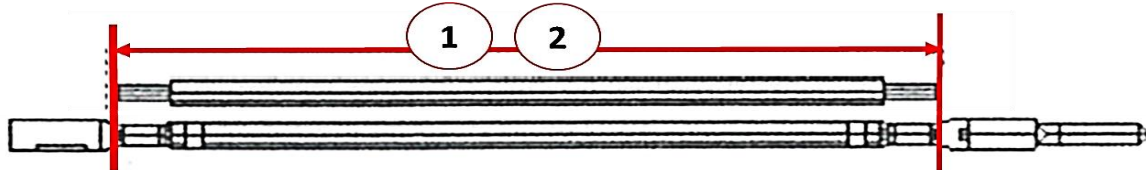

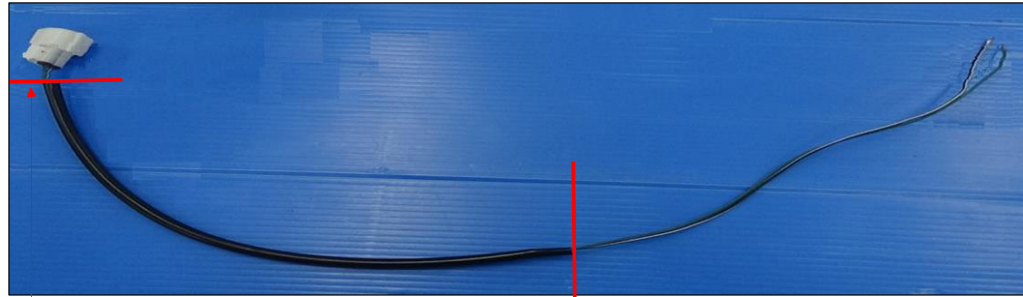
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1.Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	Offline	Measurement	<div>Note:</div> <div><div>1. Measurement point: End of core wire to the end of core wire</div><div>2. Terminal is reference only.</div></div> <div></div> <div></div> <div></div> <div>SV tube (Vinyl) Ø5, t=0.5, L=273±3mm</div>	<div>MEASURING TAPE</div> <div><i>Important reminders and note/s:</i></div> <div><div>1.Please use calibrated /verified measuring tape when getting the measurement.</div><div>2. For Hatsumono,Nakamono and Owarimono.</div></div> <div><i>Document reference/s:</i></div> <div><div>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection.</div></div> <div>1.No wrong dimension</div>

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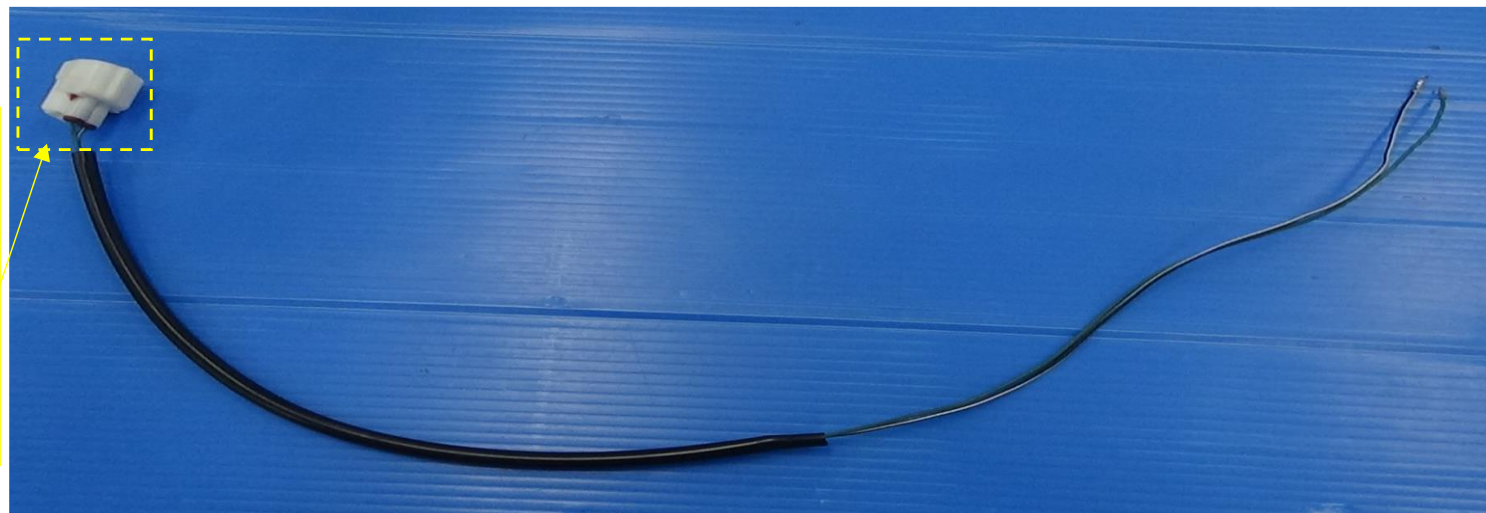
Page No.:

6 of 6**PARTS:**

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**OFFLINE INSERTION****7L0054-7025A****2****① No Unlocked/Half-locked connector****③ No Missing SV tube (Vinyl)****② No Wrong Insert****④ No Terminal Backing Out**

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