



WORK INSTRUCTION

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Model code/Part number:

380D / 7L0139-7020B

Customer:

TRQSS

Car Model:

TOYOTA CAMRY

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

October 14, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1114

Revision No.:

1

Page No.:

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PARTS:

1. Connector 6188-0066 (GR) with inserted Dummy Seal [2pcs]; TVSSf 0.3 wires GR-B/W L=677±3mm; Black Corrugated tube Ø5 L=482±3mm (no slit)

JIG:

1. Insertion jig with switch cover
2. Locking jig
3. Terminal cover jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

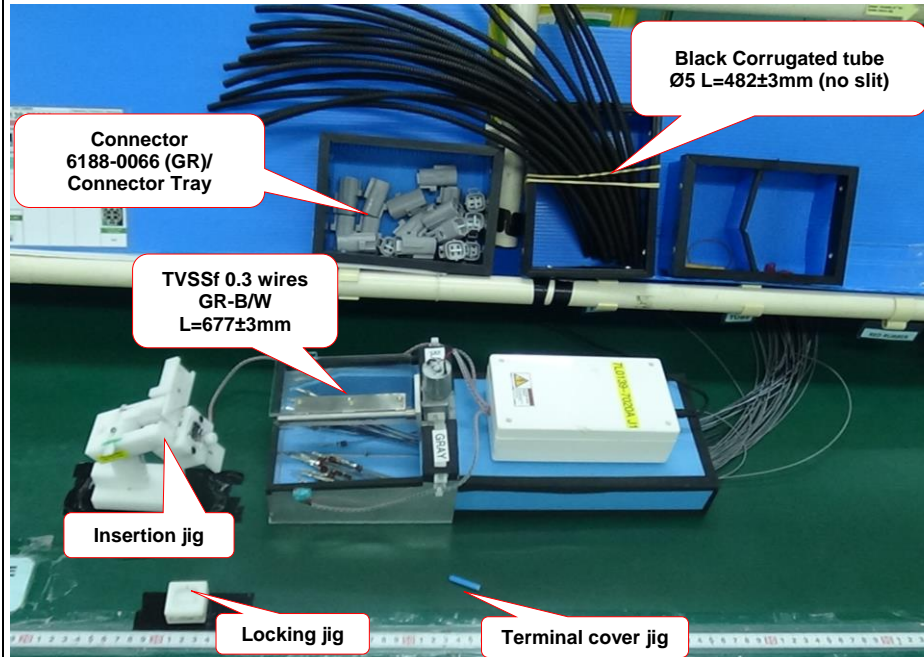
QUALITY POINTERS

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-017** for Wire and Strip Length Tolerance.
2. Refer to **WI-PRO-KIT-007** for Dummy Seal Insertion.

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

Revision History

							Prepared by	Reviewed by	Approved by	Noted by
							 M. Ariola	 C. Villanueva	 A. Arañes	
10/14/24	1	Change purpose from Pre-launch to Masspro.	M. Ariola	C. Villanueva	A. Arañes	n/a				
10/11/24	0	Initial Issue. Update the Visual Inspection/Quality Checkpoint	M. Ariola	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 11, 2024		

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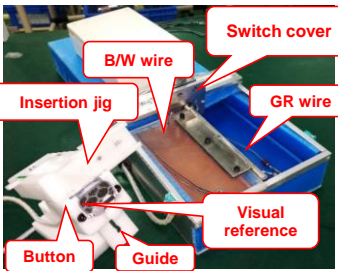
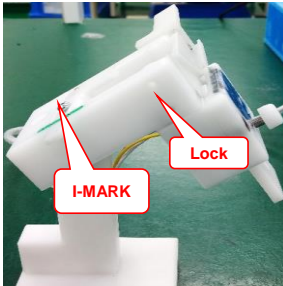
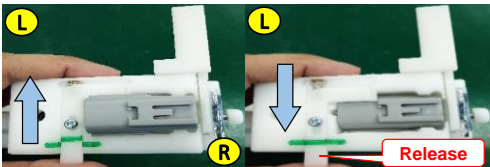
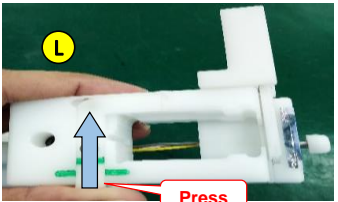
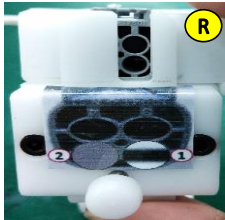
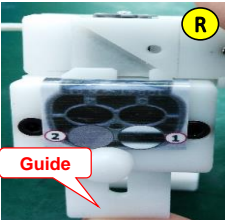
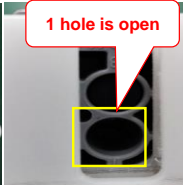

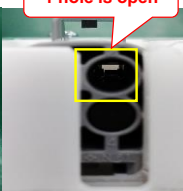
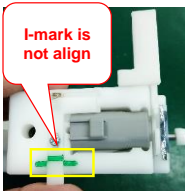
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PARTS:	1. Connector 6188-0066 (GR)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Offline Connector setting to insertion jig 6188-0066 (GR)	<div><div>INSERTION JIG WITH SWITCH COVER</div><div><div>CONNECTOR ORIENTATION</div><div>INSERTION JIG ORIENTATION</div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6188-0066 (GR) into jig using right hand and release the lock. <i>Note: Follow the connector orientation.</i></div><div>3. Push the guide upward using right thumb. Check the holes/terminal slot for B/W wires.</div></div></div> <div><div>Connector Orientation Illustration</div><div><div>GOOD</div><div>NG</div></div><div>1. Use the provided jig per model 2. No wrong orientation of the connector 3. No wrong use of connector 4. No damaged connector</div></div>	N/A	

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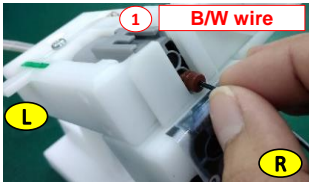



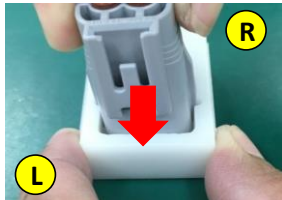






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PARTS:		1. Connector 6188-0066 (GR) with inserted Dummy Seal [2pcs] 2.TVSSf 0.3 wires GR-B/W L=677±3mm		JIG:	1. Insertion jig with switch cover 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Offline	Wire insertion to connector 6188-0066 (GR)		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>Important reminders/Note/s: 1. Please hold the wire near terminal during insertion.</div> <div>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>Document References: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</div> <div>2. Refer to GL-PRO-ASY-028 for Pull-Push procedure.</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. Press the button using right thumb. Slot for Gray wire will be open.</p></div><div><p>3. Get the GR 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></div>			
4	Connector Lock	<div><div><p>1. Put the connector into locking jig using right hand then press 2x. Check if properly locked.</p></div><div><div><p>Before pressing After pressing</p></div><div><div>Connector Cross Sectional View</div><div><div><div>NG</div><div>NG</div><div>GOOD</div></div><div><div></div><div></div><div></div></div><div><div>Unlock Condition</div><div>Half Lock Condition</div><div>Full Lock Condition</div></div></div></div></div></div>		<div><p>LOCKING JIG</p></div>	<div>1. Use the provided jig per model 2. No unlock/half-locked connector</div> <div>Important reminders/Note/s: 1. Manual locking may cause damaged connector.</div> <div>Document reference/s: 1. Refer WI-PRO-KIT-001 Proper locking and checking of connector lock</div>

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PARTS:		1. Assy part 2. Black Corrugated tube Ø5 L=482±3mm (no slit)		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Offline	<div><p>1. Get the terminal cover jig using right hand then insert the GR-B/W wires using left hand.</p></div> <div><p>2. Get the corrugated tube (no slit) Ø5 L=482±3mm using right hand and then insert the GR-B/W wires using left hand.</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div>		<div>TERMINAL COVER JIG</div> 	1. Use the provided locking jig per model 2. No unlock/half-locked connector

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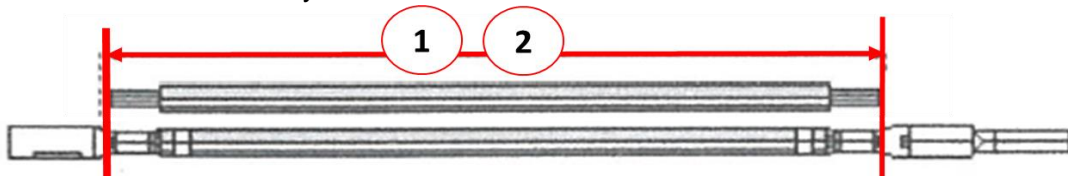

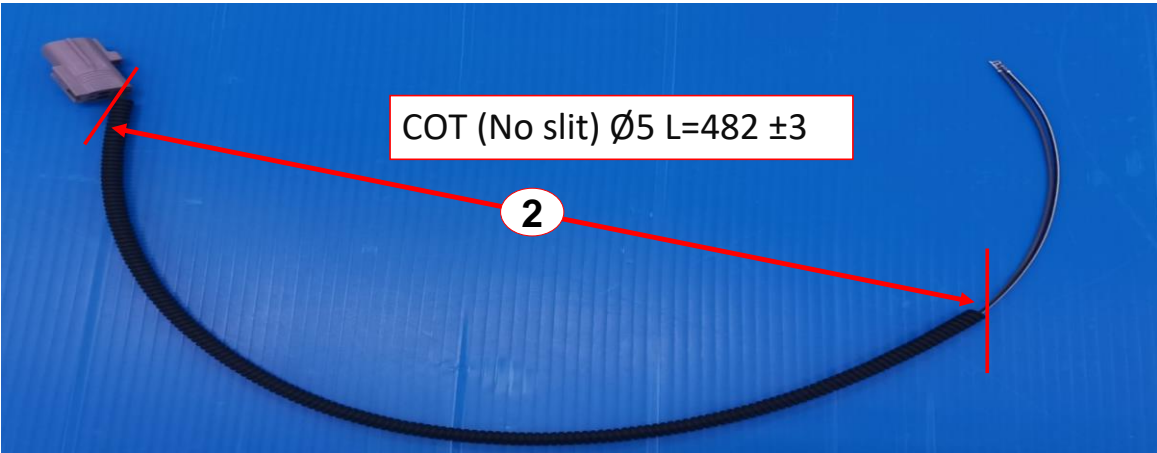
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PARTS:		1. Assy part		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	Offline Measurement	<p>Note:</p> <ol style="list-style-type: none">Measurement point: End of core wire to the end of core wireTerminal is reference only.   <p>COT (No slit) $\varnothing 5$ L=482 ± 3</p> 		MEASURING TAPE	<p>Important reminders and note/s:</p> <ol style="list-style-type: none">Please use calibrated/verified measuring tape when getting the measurement.For Hatsumono, Nakamono and Owarimono. <p>Document reference/s:</p> <ol style="list-style-type: none">Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection <p>1. No wrong dimension</p>

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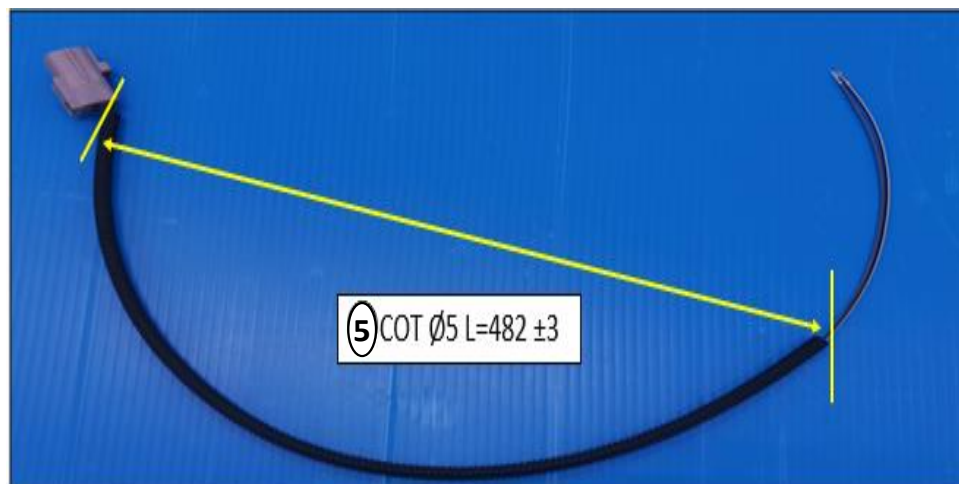
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PARTS:

1. Assy parts

JIG:

N/A

VISUAL INSPECTION/ QUALITY CHECKPOINTS**OFFLINE INSERTION****7L0139-7020B**

- ① **No Unlocked/Half-locked connector**
- ② **No Wrong Insert**
- ③ **No Terminal Backing Out**
- ④ **No Deformed Terminal**
- ⑤ **No Missing COT**

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