



WORK INSTRUCTION

Effectivity Date:

October 17, 2024

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

840B / 7N0120-7021

Customer:

TRJ

Car Model:

TOYOTA-SIENTA

Document No.:

WI-ENG-PDE-615

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

1 of 5

PARTS:

1. Connector 6098-3810 (W); AVSSf 0.3 B wires L=1175±3mm

JIG:

1. Insertion jig
2. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

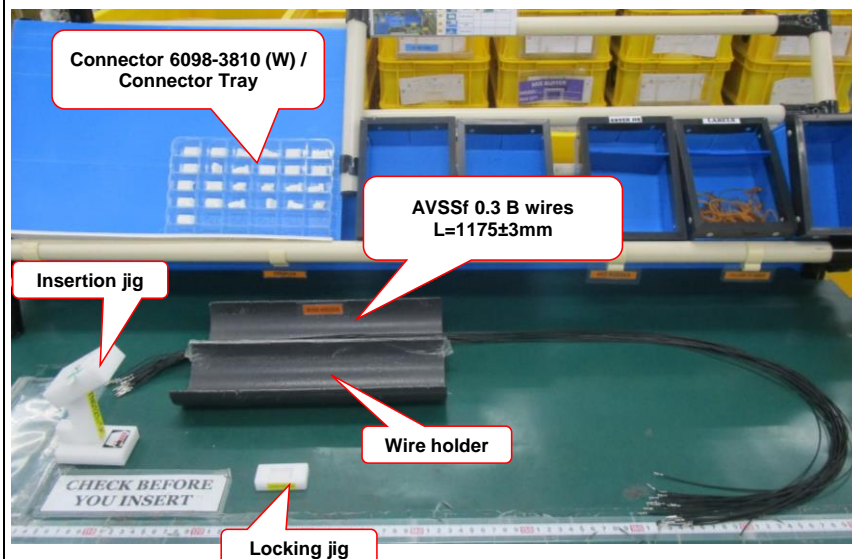
QUALITY POINTERS

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.

Document reference/s:

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

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


Revision History

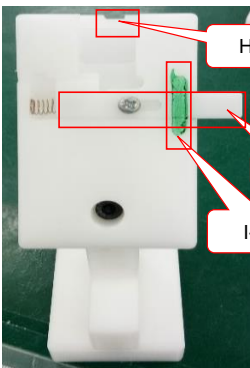


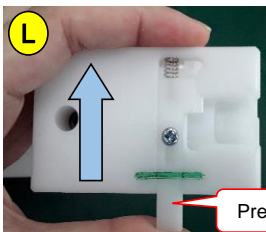
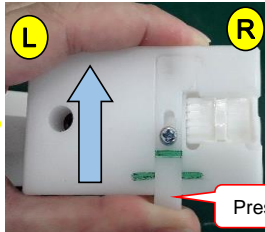
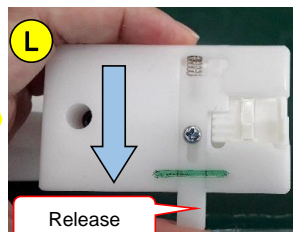

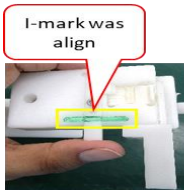
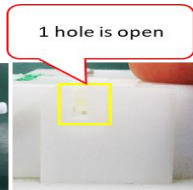
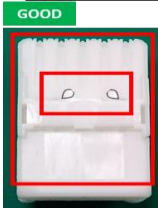
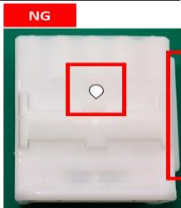
							Prepared by	Reviewed by	Approved by	Noted by
10/17/24	2	Inclusion of car model "TOYOTA-SIENTA", Measurement and Visual inspection/Quality checkpoints.	D.Castillo	C.Villanueva	A. Arañes	N/A				
02/03/23	1	Change purpose from pre-launch to Masspro.	M. Ariola	J.Loterte	C.Villanueva	A. Arañes				
01/24/23	0	Initial issue.	M. Ariola	J.Loterte	C.Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	January 24, 2023		

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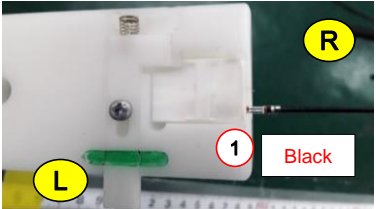
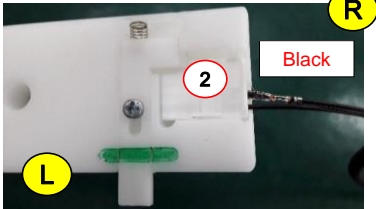
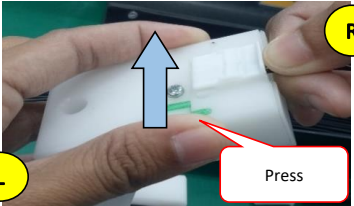

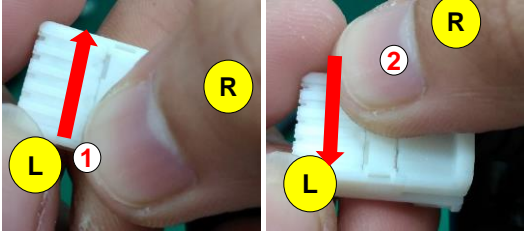


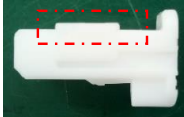
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Model code/Part number:		840B / 7N0120-7021		Customer:	TRJ	Car Model:	TOYOTA-SIENTA		
Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Document No.: WI-ENG-PDE-615	
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PARTS:		1. Connector 6098-3810 (W)				JIG:		1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
2	OFFLINE	<div><div><div>INSERTION JIG</div><div></div></div><div><div></div><div><div>CONNECTOR ORIENTATION</div><div></div></div></div><div><div><div></div><div></div><div></div></div><div><div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Get the connector 6098-3810 (W) using right hand then insert to jig using right hand and release the lock using left thumb. <i>Note: Follow the connector orientation.</i></p><p>3. Check the holes/terminal slot for B-B wires.</p></div><div></div></div></div><div><div><div>Connector Orientation Illustration</div><div><div></div><div></div></div><div><div></div><div></div></div></div><div><p>1. Use provided jig per model</p><p>2. No wrong usage of parts</p><p>3. No wrong orientation of connector</p><p>4. No damaged connector</p></div></div><div>N/A</div></div>							

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.:	3 of 5


PARTS:	1. AVSSf 0.3 B-B L=1175±3mm [2pcs]			JIG:	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Wire Insertion to Connector 6098-3810 (W)	<div><p>1. Get 1st black wire then insert to terminal slot ① using right hand.</p></div> <div><p>2. Get 2nd Black wire then insert to terminal slot ② using right hand.</p></div> <div><p>3. 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>		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.</p> <p>Conduct Pull-Push-Pull-Push 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 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>
4	Connector lock	<div><p>1. Put the connector into locking jig using right hand then press 2x using both hands. Touch the connector lock to confirm if properly locked.</p></div> <div><p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div>		<div>LOCKING JIG</div> 	<p>Important reminders/Note/s:</p> <p>1. Manual locking may cause damaged connector lock.</p> <p>1. Use the provided locking jig per model 2. No unlock/half-locked connector</p> <div><p>Before Pressing After Pressing</p></div>


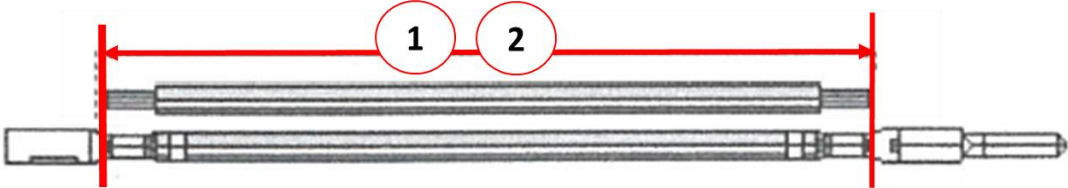

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	2	Page No.:	4 of 5

PARTS:	1. Assy part			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
5	OFFLINE	Measurement	<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> <p>1. No wrong dimension</p>	

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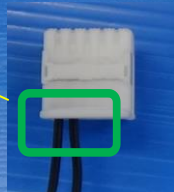
Page No.:

5 of 5**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7N0120-7021****1****GOOD****NO GOOD****2****3****GOOD****NO GOOD****1****No Unlocked/ Half-locked connector****2****No Wrong insert****3****No Terminal Backing Out**

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