



WORK INSTRUCTION

Process Name/Title: OFFLINE ASSEMBLY PROCESS

Effectivity Date:

October 3, 2024

Model code/Part number:

311D / 7L0155-7023

Customer: TRQSS

Car Model:

TOYOTA RAV4

Validity Date:

n/a

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Document No.:

WI-ENG-PDE-1085

Revision No.:

0

Page No.:

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PARTS: 1. Connector 6188-0407 (W); MR SW CP (AVSSF 0.3 G-BW wires L=606±3mm; Black Corrugated tube (No slit) ø7, L=315±4mm

JIG:

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

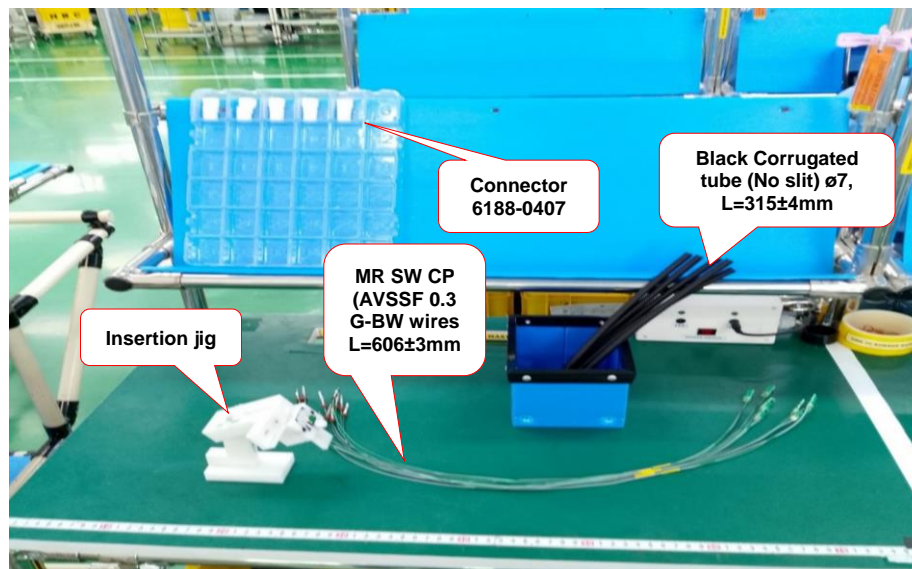
QUALITY POINTERS

1

Offline

Tably Lay-out

Table Lay-out

**Safety Instruction**

Be sure to wear required 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.

Important reminders/Note/s:

1. Refer to WI-ENG-PDE-675 for Offline assembly process
2. 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

10/3/24 0

Initial issue.

A.Hernandez

C.Villanueva

A. Arañes

n/a

A.Hernandez

C.Villanueva

A. Arañes

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Eff. Date Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

October 3, 2024

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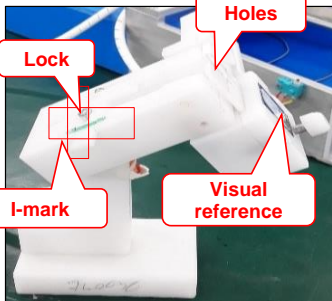
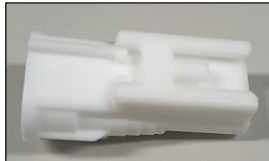

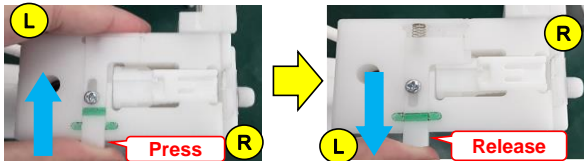
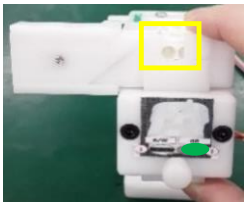


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PARTS:		1. Assy parts 2. Connector 6188-0407 (W)		JIG:	1.Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Offline Connector setting to insertion jig 6188-0407 (W)	<div>INSERTION JIG ILLUSTRATION</div> <div></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 6188-0407 (W) into jig using right hand and release the lock. Note: Refer to above illustration for correct setting.</div> <div>3. Check the holes/terminal slot for B/W wire.</div>		n/a	<div>Connector Orientation Illustration</div> <div></div> <div></div>

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PARTS:		1. MR SW CP (AVSSF 0.3 G-BW wires L=606±3mm 2. Black Corrugated tube (No slit) ø7, L=315±4mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Offline	<div></div> <div>1. Get the Black Corrugated tube (No slit) ø7, L=315±4mm using right hand then insert the wire using left hand.</div> <div></div>		n/a	1. No wrong usage of parts 2. No deformed terminal

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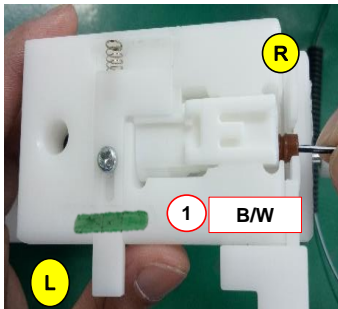
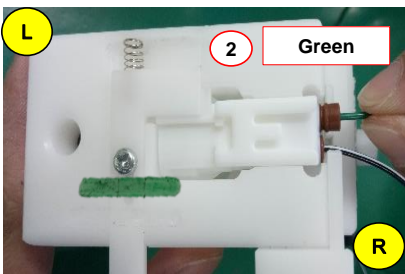
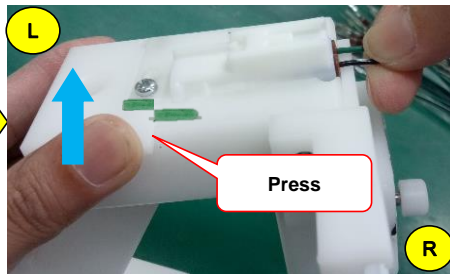
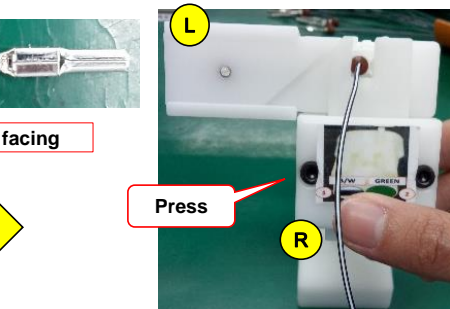


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PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Offline Wire insertion to connector 6188-0407 (W)	<div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div><p>1. Hold the Insertion jig using left hand. Get Black/White wire then insert to terminal slot 1 using right hand.</p><p>2. Push the button using right hand. The slot for Green wire will be opened.</p><p>3. Get Green wire then insert to terminal slot 2 using right hand.</p><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>		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. 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. 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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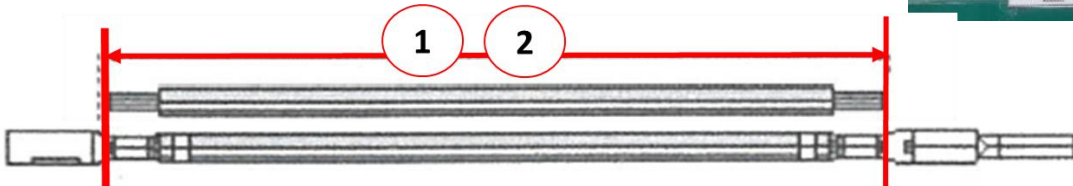

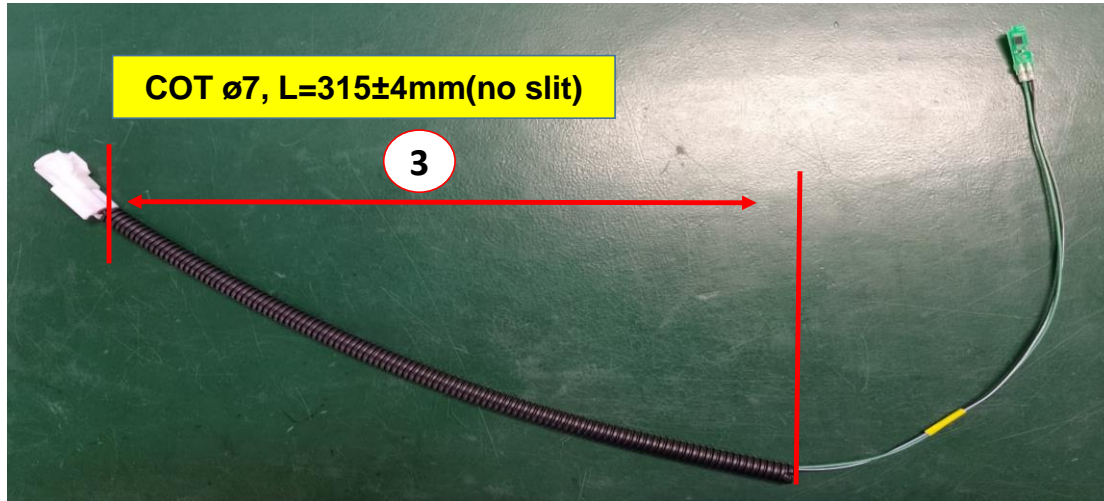
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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Offline	Measurement	<p>Note:</p> <ol style="list-style-type: none">1. Measurement point: End of core wire to the end of core wire2. Terminal is reference only.   <p>MEASURING TAPE</p>  <p>COT ø7, L=315±4mm(no slit)</p> <p>3</p>		<p>Important reminders and note/s:</p> <ol style="list-style-type: none">1. Please use calibrated/verified measuring tape when getting the measurement.2. For Hatsumono, Nakamono and Owarimono. <p>Document reference/s:</p> <ol style="list-style-type: none">1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection <p>1. No wrong dimension</p>

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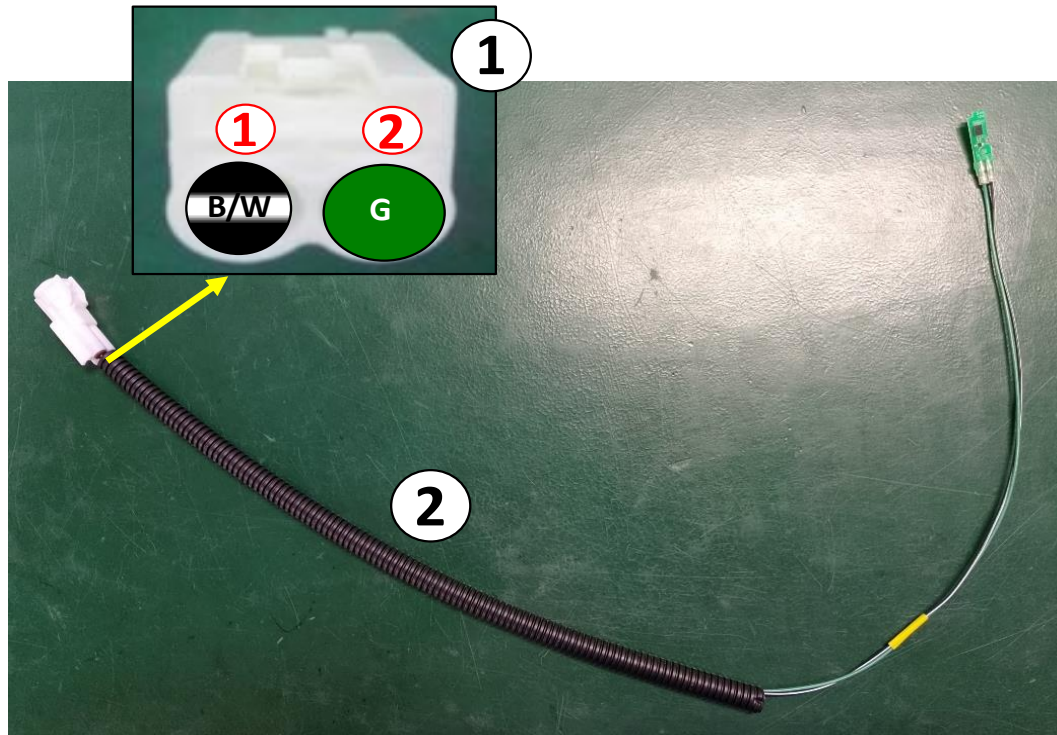
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n/a

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**OFFLINE INSERTION****7L0155-7023**

- ① No **Wrong Insert**
- ② No **Missing COT**
- ③ No **Deformed Terminal**
- ④ No **Terminal Backing Out**

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