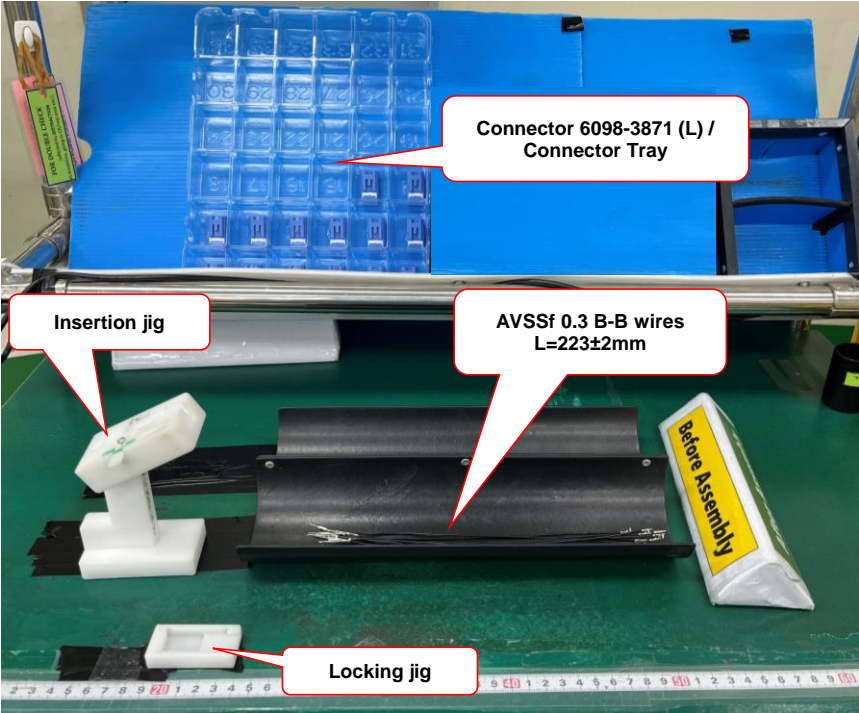




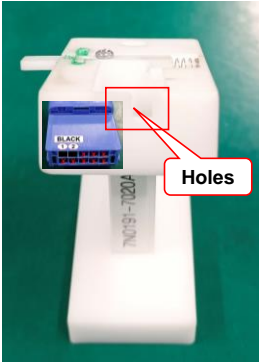
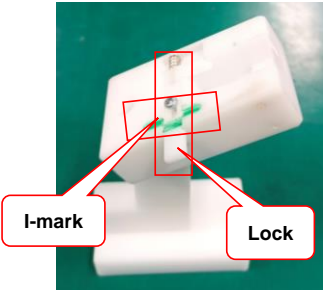

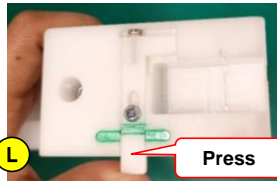
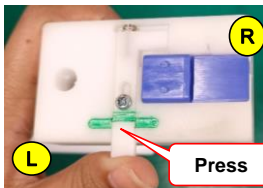
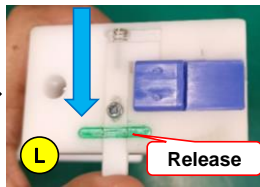
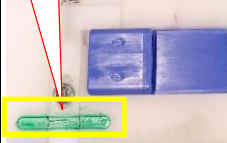

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	Model code/Part number: 310D/ 7N0191-7020A		Customer: TRJ	Car Model: TOYOTA-RAV 4		Document No.:		WI-ENG-PDE-890	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO					Revision No.:		0	Page No.:

PARTS:		1. Connector 6098-3871 (L); AVSSf 0.3 B-B wires L=223±2mm				JIG:		1. Insertion jig 2. Locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	Offline	<div>TABLE LAY-OUT</div>  <div>Connector 6098-3871 (L) / Connector Tray</div> <div>Insertion jig</div> <div>AVSSf 0.3 B-B wires L=223±2mm</div> <div>Before Assembly</div> <div>Locking jig</div>				<div><b>Safety Instruction</b> Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		<div><b>Document reference/s:</b> 1. Refer to <b>WI-PRO-CNC-017</b> 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
									
05/10/24	0	Initial issue.				D. Castillo	C. Villanueva	A. Arañes	N/A
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted

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	Process Name/Title:			Document No.:	WI-ENG-PDE-890		
	Model code/Part number: <b>310D/ 7N0191-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-RAV 4</b>	Revision No.: 0      Page No.:      2 of 6		
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO							

<b>PARTS:</b>	1. Connector 6098-3871 (L)			JIG:	1. Insertion jig			
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
2	Offline Connector setting to insertion jig 6098-3871 (L)	<div><div><b>INSERTION JIG</b></div><div>Holes</div><div>I-mark</div><div>Lock</div><div><b>INSERTION JIG ORIENTATION</b></div><div><b>CONNECTOR ORIENTATION</b></div><div>L</div><div>Press</div><div>1. Press the lock of insertion jig using left thumb.</div><div>L</div><div>Press</div><div>2. Insert the Connector <b>6098-3871 (L)</b> into jig using right hand and release the lock.</div><div>L</div><div>Release</div><div>3. Check the holes/terminal slot for <b>B-B wires</b>.</div></div>			n/a	<div><b>Connector Orientation Illustration</b></div> <div><div>I-mark is align</div><div>2 Hole are open</div><div><b>GOOD</b></div><div>I-mark is not align</div><div>Half holes are open</div><div><b>NG</b></div></div> <div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div>		

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Customer:

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Car Model:

**TOYOTA-RAV 4**

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**WI-ENG-PDE-890**

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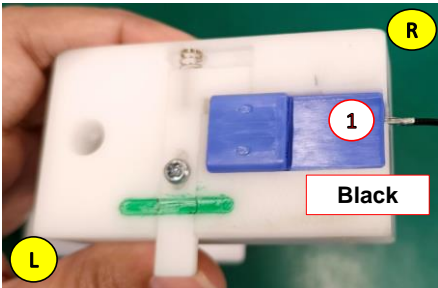
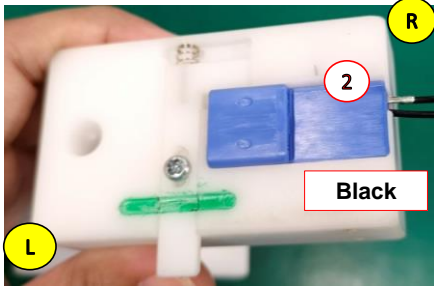

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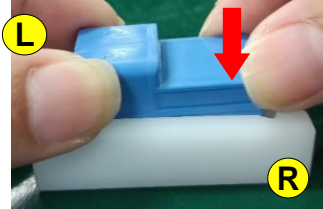
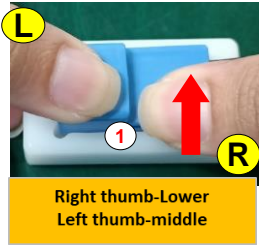
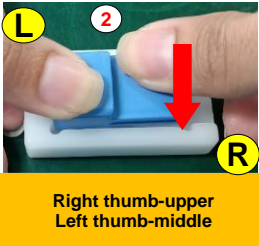
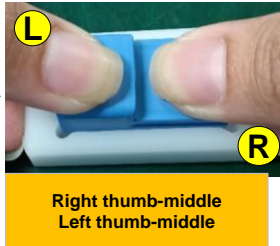
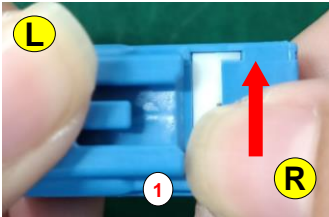

<b>PARTS:</b>		1. AVSSf 0.3 B-B wires L=223±2mm [2pcs]		JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
3	Offline	<div><div>WIRE FACING</div></div> <div><div>1. Get <b>Black wire</b> then insert to terminal slot ① using right hand.</div></div> <div><div>2. Get <b>Black wire</b> then insert to terminal slot ② using right hand.</div></div> <div><div>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.</div></div>		n/a	<p><b>Important reminders/note/s:</b></p> <p>1. Insertion of wire must be from left to right.</p> <p>2. Make sure wires are properly inserted. Conduct <b><u>Pull-Push-Pull-Push</u></b> after insertion. Do not exert extra force.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-CNC-017</b> for wire and strip length tolerance.</p> <p>2. Refer to <b>GL-PRO-ASY-029</b> 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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	Model code/Part number: 310D/ 7N0191-7020A		Customer: TRJ	Car Model: TOYOTA-RAV 4	Document No.:	WI-ENG-PDE-890	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	4 of 6

PARTS:	1. Assy parts			JIG:	1. Locking jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
4	Offline Connector lock	<div><div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div><div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div></div> <div><div><p>Right thumb-Lower Left thumb-middle</p><p>3. Press the lower parts of connector using right hand while left hand holding the middle.</p></div><div><p>Right thumb-upper Left thumb-middle</p><p>4. Press the upper part of connector using right hand while left hand holding the middle.</p></div><div><p>Right thumb-middle Left thumb-middle</p><p>5. Lift then press the connector in the middle using left and right hand.</p></div></div> <div><div><p>6. Ensure that connector is in locked condition by touching the connector lock based on the sequence illustrated.</p></div></div>			<div>LOCKING JIG</div> 	<p>1. No Unlock and half-locked 2. Use provided jig tools per model to avoid damaged lock.</p> <p><b>Important reminders/Note/s:</b> <b>1. Manual locking may cause damaged connector</b></p>	

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Car Model:

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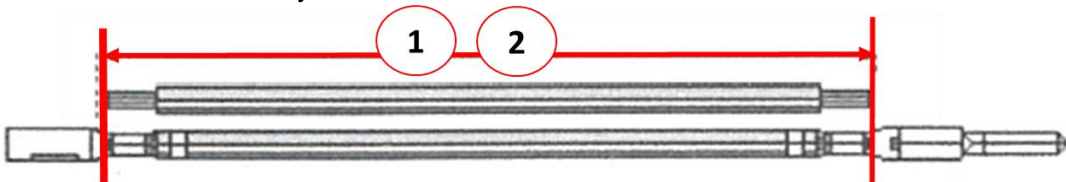

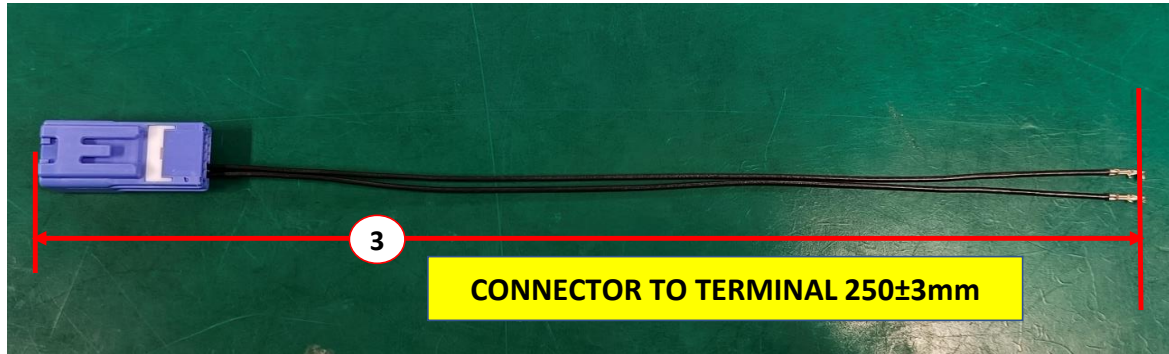
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Offline	Measurement	<div>Note: 1. Measurement point: End of core wire to the end of core wire 2. Terminal is reference only.</div> <div></div> <div></div> <div>MEASURING TAPE</div>	<div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.  2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div>
			<div></div> <div>CONNECTOR TO TERMINAL 250±3mm</div>	<div>1. No wrong dimension</div>

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# WORK INSTRUCTION

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PARTS:

1. Assy parts

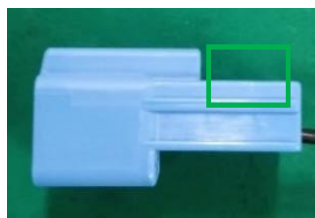
JIG:

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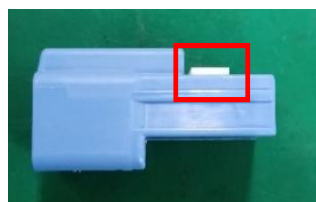
### QUALITY CHECKPOINTS

## OFFLINE INSERTION

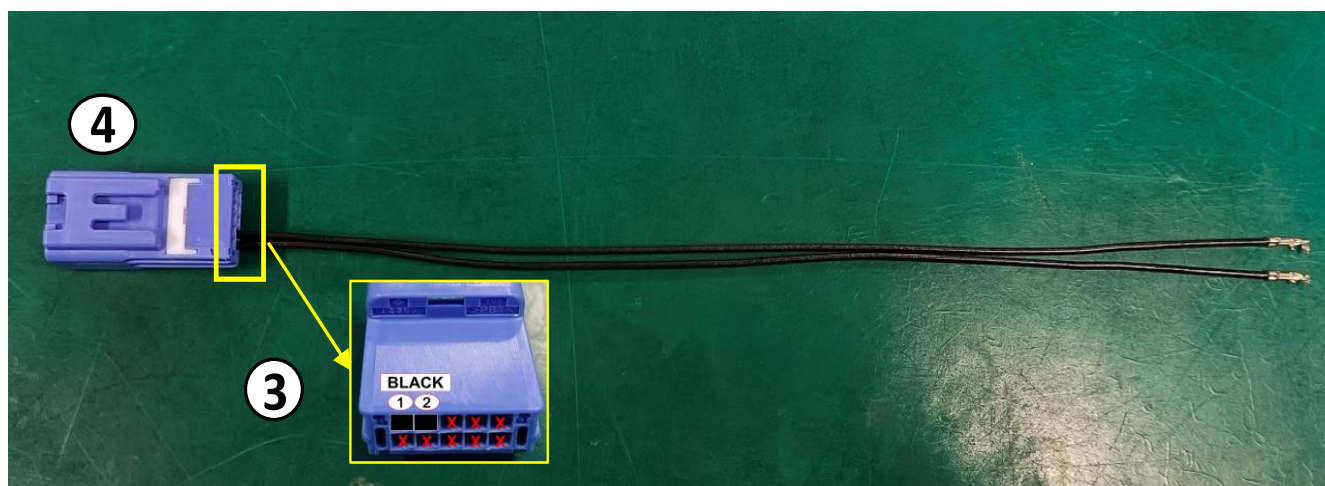
# 7N0191-7020A



GOOD



NO GOOD



① No Unlocked/ Half Locked Connector

② No Terminal Backing Out

③ No wrong insert

④ No Deformed Terminal



GOOD



NO GOOD

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