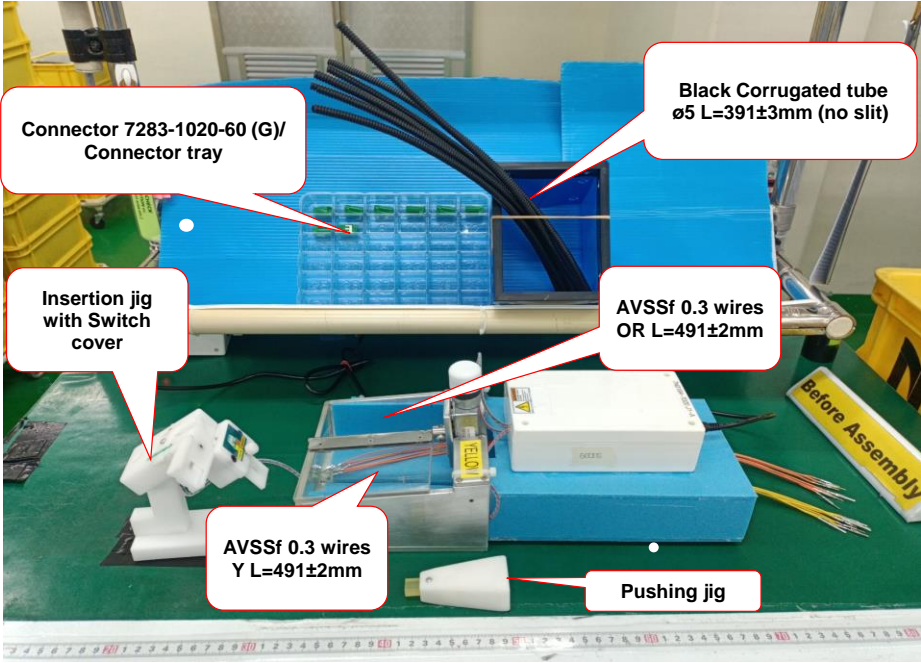
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	Process Name/Title: OFFLINE ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 310D/ 7N0194-7020		Customer: TRJ	Car Model: TOYOTA RAV4	Document No.:		WI-ENG-PDE-857	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		0	Page No.: 1 of 6

PARTS:		1. Parts: AVSSf 0.3 wires Y-OR L=491±2mm; Connector 7283-1020-60 (G)		JIG:		1. Insertion jig with Switch cover 2. Pushing jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1	n/a	<div>Table Lay-out</div> 		<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		<div>Document reference/s: 1. Refer to WI-PRO-CNC-017 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	
02/28/24 0 Initial issue.								D.Castillo		C. Villanueva		A. Arañes		n/a	
Eff. DateRev. No								Revised		Reviewed		Approved		Noted	
Details of Change								Est. Date:		February 28, 2024					

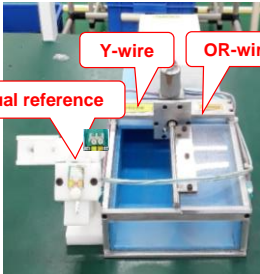
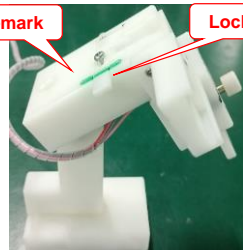

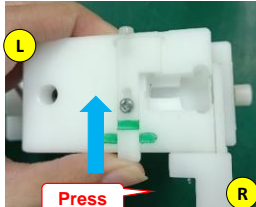
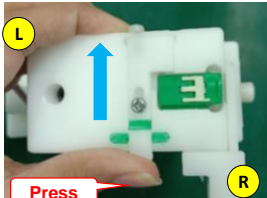
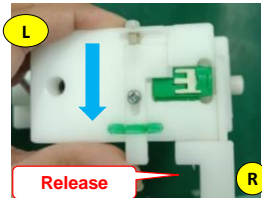
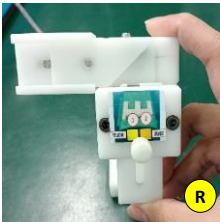
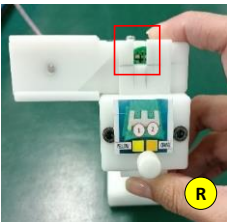
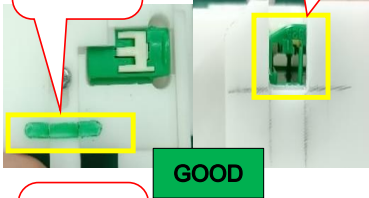
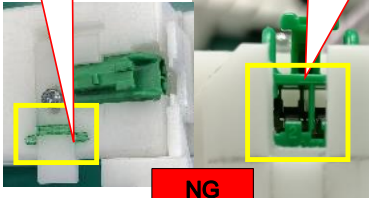
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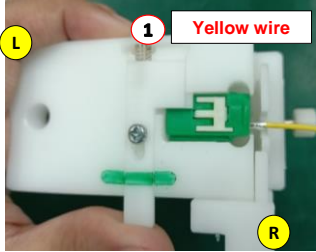
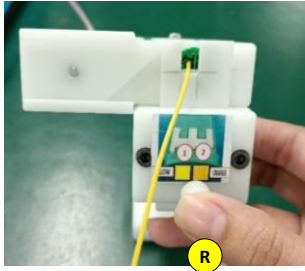
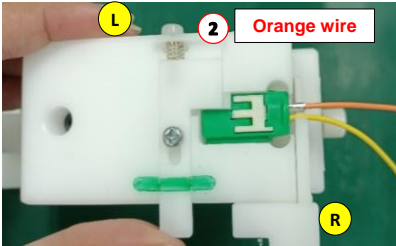
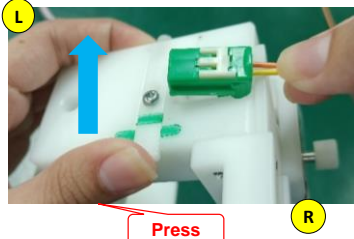
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		OFFLINE ASSEMBLY PROCESS			Validity Date:		n/a					
Model code/Part number:		310D/ 7N0194-7020		Customer:	TRJ	Car Model:	TOYOTA RAV4		Document No.:	WI-ENG-PDE-857		
Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:		0	Page No.:	2 of 6

PARTS:		1. Connector 7283-1020-60 (G)				JIG:		1. Insertion jig with Switch cover					
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS			
2		n/a		<div><div><div><div><div>Insertion Jig with Switch cover</div><div>Y-wire</div><div>OR-wire</div><div>Visual reference</div></div><div></div></div><div><div><div>I-mark</div><div>Lock</div></div><div></div><div><div>Connector Orientation</div><div></div></div></div><div><div><div><div><div>L</div><div>R</div></div><div></div><div><div>Press</div></div></div><div><div>1. Press the insertion jig lock using left hand.</div></div></div><div><div><div><div>L</div><div>R</div></div><div></div><div><div>Press</div></div></div><div><div>2. Get the connector 7283-1020-60 (G) using right hand and insert to insertion jig. Release the lock after insertion.</div></div></div><div><div><div><div>L</div><div>R</div></div><div></div><div><div>Release</div></div></div><div><div>3. Push the lower wire guide upward using right hand. Slot for yellow wire will be open.</div></div></div><div><div><div><div></div><div></div></div></div></div></div></div></div>				N/A		<div><div><div>CONNECTOR ORIENTATION ILLUSTRATION</div><div><div><div><div>I-mark is align</div><div>1 hole is open</div></div><div></div><div><div>GOOD</div></div></div><div><div><div><div>I-mark is not align</div><div>1 hole is open</div></div><div></div><div><div>NG</div></div></div></div></div></div></div>			

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	Model code/Part number: 310D/ 7N0194-7020		Customer: TRJ	Car Model: TOYOTA RAV4	Document No.:	WI-ENG-PDE-857	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	3 of 6


PARTS:	1. AVSSf 0.3 wires Y-OR L=491±2mm 2. Connector 7283-1020-60 (G)			JIG:	1. Insertion jig with Switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a	<div><div>Wire Facing</div></div> <div><div>1. Hold the insertion jig using left hand. Get the Yellow wire and insert to connector using right hand.</div></div> <div><div>2. Press the button using right thumb. slot for Orange wire will be open.</div></div> <div><div>3. Get the Orange wire and insert to connector using right hand.</div></div> <div><div>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.</div></div>		N/A	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing.</div> <div>Important reminders/Note/s: 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.</div> <div>Document References: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance. 2. Refer to GL-PRO-ASY-028 for Pull-Push procedure.</div>

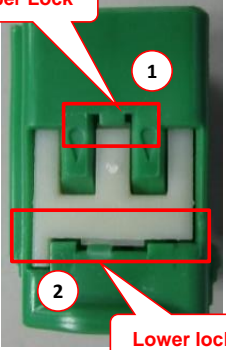




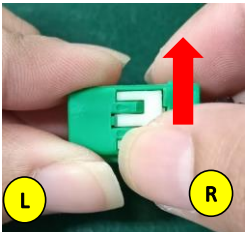
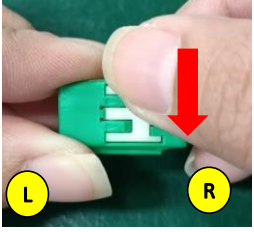
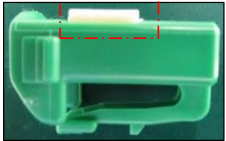


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	Process Name/Title:		Model code/Part number: 310D/ 7N0194-7020		Customer: TRJ	Car Model: TOYOTA RAV4		Document No.:	WI-ENG-PDE-857	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		0	Page No.:	4 of 6	


PARTS:	1. Assy parts			JIG:	1. Pushing jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
4	n/a	Connector Lock	<div><div><div>Connector lock sequence</div><div><div>Upper Lock</div><div>Lower lock</div></div></div><div><div>1</div><div>1</div></div><div><div>2</div><div>2</div></div><div><div><div>L R</div><div>L R</div></div><div>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</div></div><div><div><div>Before Pressing</div><div>After Pressing</div></div></div></div> <div><div><div>PUSHING JIG</div></div><div><div>Important reminders/Note/s:</div><div>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR.</div><div>1. Use the provided jig per connector</div><div>2. No unlock/half-locked connector</div></div></div>					

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	Process Name/Title:			Document No.:	WI-ENG-PDE-857		
	Model code/Part number: 310D/ 7N0194-7020		Customer: TRJ	Car Model: TOYOTA RAV4	Revision No.: 0		
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Page No.:	5 of 6		

PARTS:		1. Assy parts 2. Black Corrugated tube ø5 L=391±3mm (no slit)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	n/a	<div><p>1. Get the Black Corrugated tube ø5 L=391±3mm (no slit) using right hand then insert the Y-OR wires.</p></div>			1. Use the provided jig per connector 2. No unlock/half-locked connector

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**WORK INSTRUCTION**

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

February 28, 2024

Model code/Part number:

310D/ 7N0194-7020Customer: **TRJ**

Car Model:

TOYOTA RAV4

Document No.:

WI-ENG-PDE-857

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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0

Page No.:

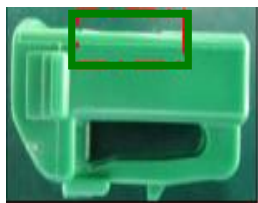
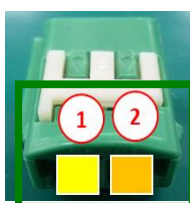
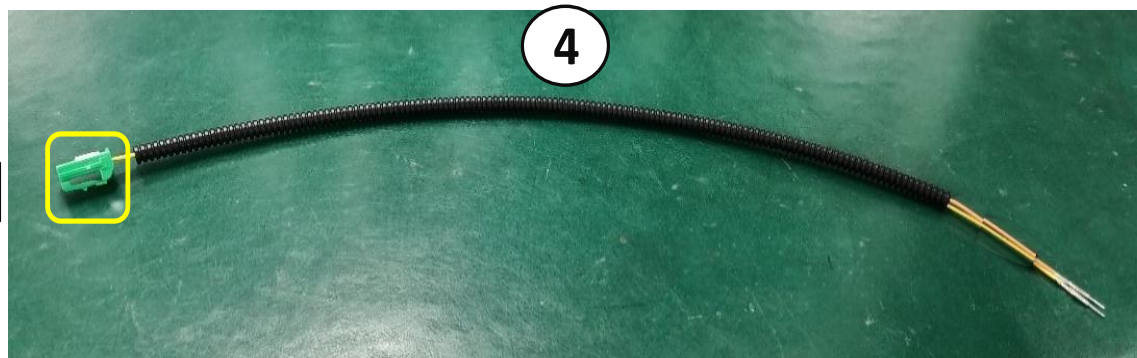
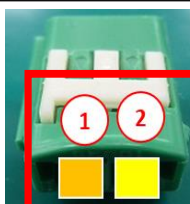
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PARTS:

n/a

JIG:

N/A

QUALITY CHECKPOINTS**OFFLINE INSERTION****7N0194-7020****GOOD****GOOD****GOOD****NO GOOD****NO GOOD****NO GOOD**

① No **Unlock/
Halflock
Connector**

② No **Wrong Insert**

③ No **Terminal Backing Out**

④ No **Missing COT**

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