


	WORK INSTRUCTION					Effectivity Date:		May 17, 2024	
	OFFLINE ASSEMBLY PROCESS					Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 164B / 7M0611-7020B		Customer: TRJ	Car Model: TOYOTA-AURIS		Document No.: WI-ENG-PDE-081	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		5	Page No.:	1 of 7

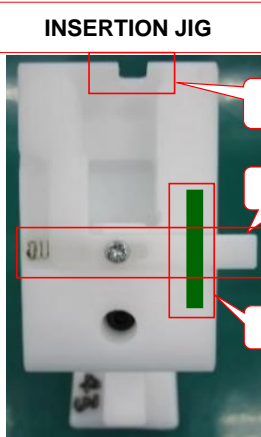
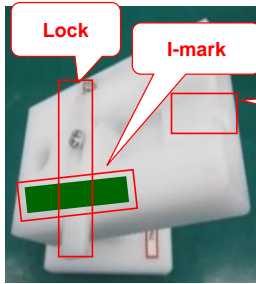
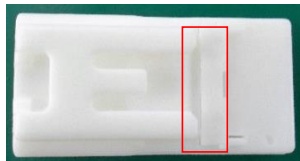
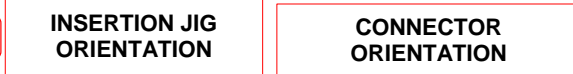
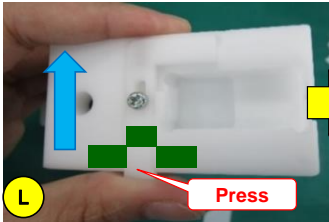
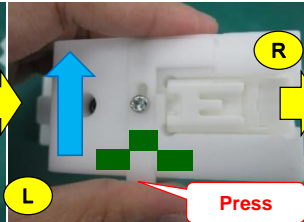
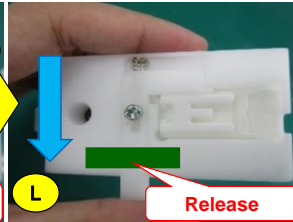

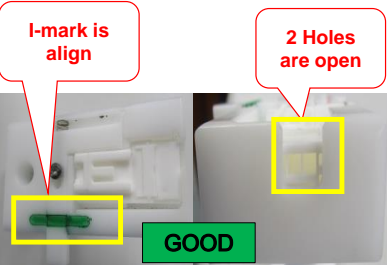
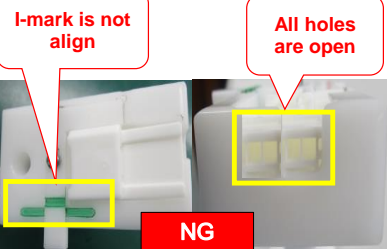
PARTS:	1. Connector 6098-3802 (W); IRRAX A ROPE-LAY B Wires L=126±1mm; Black corrugated tube (w/slit) ø5, L=41±2mm					JIG:	1. Insertion jig 2. Locking jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS		
1	Offline	<div style="border: 1px solid black; padding: 5px; display: inline-block; margin-bottom: 10px;">TABLE LAY-OUT</div>				<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px solid red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	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	
05/17/24	5	Inclusion of Measurement and improved Visual Inspection.	L. Ariola	C. Villanueva	A. Arañes	n/a				n/a			
07/11/23	4	Inclusion of Table lay-out and quality check points; improve important reminders/note/s and document references; improve locking process; update template, inclusion of car model; change title from Kitting assembly process to Offline assembly process	J. Loterte	C. Villanueva	A. Arañes	n/a							
08/19/21	3	Revise due to change of jig from 'Double locking jig' to 'Insertion jig' and provide separate locking jig. Apply notes in quality pointers and update illustration in every process.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes							
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	February 27, 2020					

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		OFFLINE ASSEMBLY PROCESS				Validity Date:		n/a	
Model code/Part number:		164B / 7M0611-7020B		Customer: TRJ		Car Model: TOYOTA-AURIS		Document No.:	
Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:	
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PARTS:		1. Connector 6098-3802 (W)				JIG:		1. Insertion jig			
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
2		Offline		Connector setting to insertion jig 6098-3802 (W)				n/a		Connector Orientation Illustration	
				<div><div></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. Insert the connector 6098-3802 (W) into jig using right hand then release the lock.</p><p>3. Check the holes/terminal slot for B-B wires.</p></div></div>						<div></div> <div></div> <p>1. Use the provided jig per model 2. No wrong orientation of the connector 3. No wrong use of connector 4. No damaged connector</p>	

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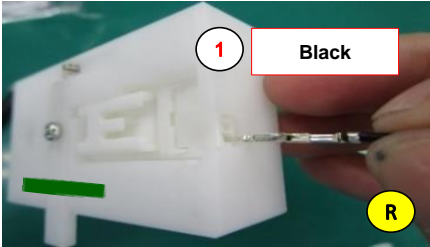
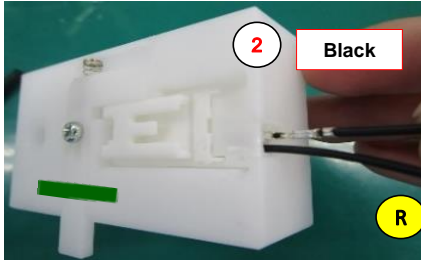

PARTS:		1. IRRAX A ROPE-LAY B Wires L=126±1mm [2pcs] 2. Black corrugated tube (w/slit) ø5, L=41±2mm		JIG:	N/A
NO.	PROCESS NAME	5 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Offline Wire insertion to Black Corrugated tube (w/ slit) ø5 L=41±2mm	 <div>1. Get Black corrugated tube (w/slit) ø5, L=41±2mm using left hand and insert IRRAX A ROPE-LAY B Wires L=126±1mm [2pcs] using right hand.</div>		n/a	1. No wrong usage of parts 2. No Deformed Terminal

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	Model code/Part number: 164B / 7M0611-7020B		Customer: TRJ	Car Model: TOYOTA-AURIS	Document No.: WI-ENG-PDE-081		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	5	Page No.:	4 of 7

PARTS:		1. IRRAX A ROPE-LAY B Wires L=126±1mm [2pcs] 2. Connector 6098-3802 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Offline Wire insertion to connector 6098-3802 (W)	<div><div>WIRE FACING</div></div> <div><div>1. Get the 1st B wire then insert to connector using right hand. Note: Make sure to hold the COT using right hand while insertion to prevent deformed in 7D0349 Terminal.</div></div> <div><div>2. Get the 2nd B wire then insert to connector using right hand.</div></div> <div><div>3. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</div></div>		n/a	<p>Important reminders and note/s:</p> <p>1. Insertion of wire must be from left to right.</p> <p>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.</p> <p>Do not exert extra force.</p> <p>Document reference/s:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing</p>

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Document No.:

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH






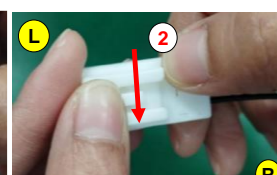




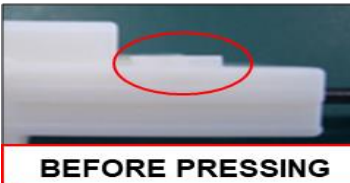

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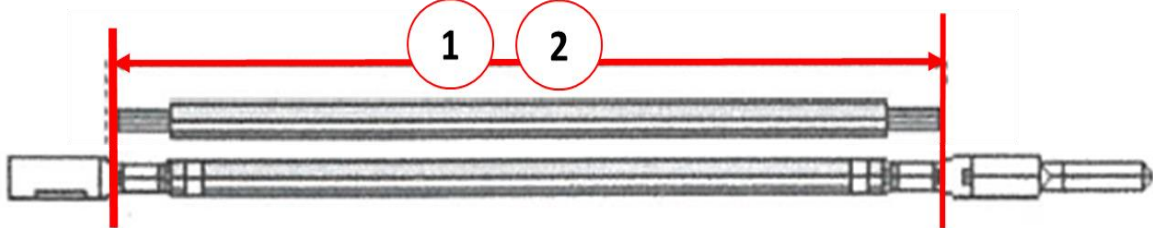

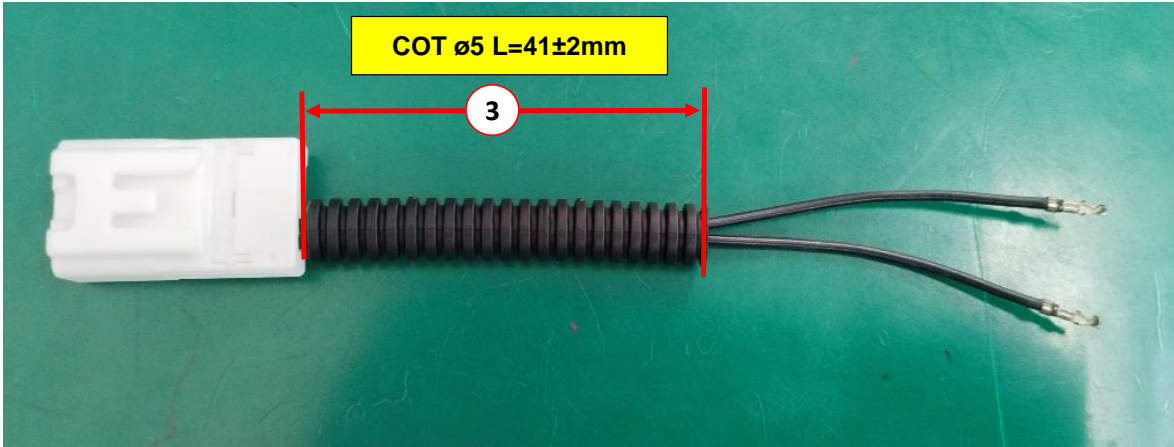
PARTS:		1. Assy Parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Offline Connector lock	<div><div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div><div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div><div><div><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><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><p>6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div></div></div></div></div>		<div>LOCKING JIG</div> 	<div>1. Use the provided jig per connector 2. No unlock/half-locked of connector lock</div> <div>Important reminders and note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</div> <div>Documents reference: 1. Please refer to GL-PRO-ASY-017 for the verification of connector lock.</div> <div><div><div><p>GOOD</p><p>Full Lock</p></div><div><p>NG</p><p>Half Lock</p></div></div><div><p>BEFORE PRESSING</p></div><div><p>AFTER PRESSING</p></div></div>

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	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		5	Page No.: 6 of 7

PARTS:	1. Assy Parts			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
6	Offline Measurement	<p>Note:</p> <p>1. Measurement point: End of core wire to the end of core wire</p> <p>2. Terminal is reference only.</p>   <p>COT ø5 L=41±2mm</p> 	Measuring tape	<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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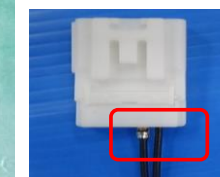
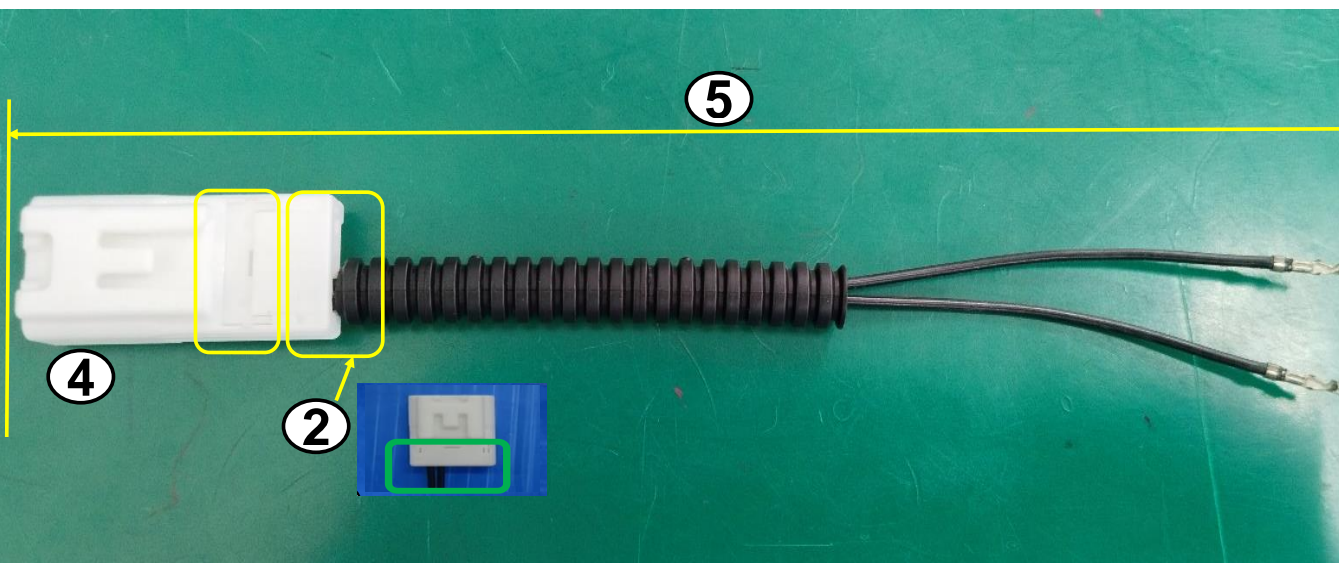
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ VISUAL INSPECTION****OFFLINE INSERTION****7M0611-7020B****①****GOOD****NO GOOD****③****GOOD****NO GOOD****①****No Unlock / Halflock Connector****③****No Terminal Backing Out****②****No Wrong Insert****④****No Deformed Terminal****⑤****Check the Alignment**

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