



WORK INSTRUCTION

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

February 19, 2025

Model code/Part number:

164B

/

7M0544-7020B

Customer:

TRJ

Car Model:

TOYOTA-AURIS

Document No.:

WI-ENG-PDE-1202

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1. Connector 6098-3802 (W)
2. IRRAX A 0.3 B L=145±2mm

JIG:

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

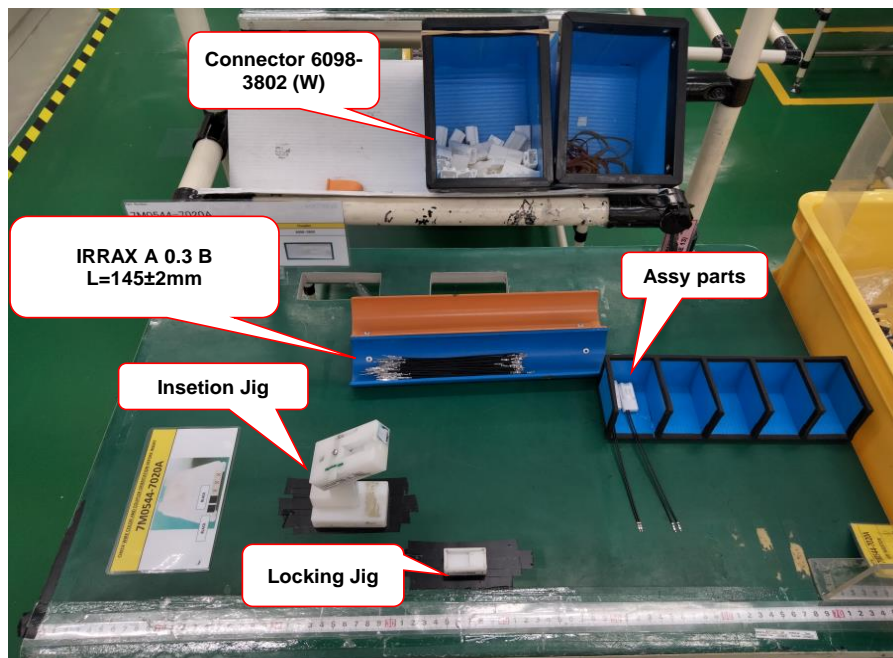
QUALITY POINTERS

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
02/10/2025	1	Change pre-launch to mass-pro	A.Buban	C.Villanueva	A. Arañes	n/a		Alexandra A. Buban	C. Villanueva	A. Arañes	
02/06/2025	0	Initial issue	A.Buban	C.Villanueva	A. Arañes	n/a		A. Buban	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	February 06, 2025			

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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Offline Connector setting to insertion jig 6098-3802 (W)	<div><div>INSERTION JIG</div><div><div>Holes</div><div>Lock</div><div>I-mark</div><div>Lock</div><div>I-mark</div><div>Holes</div><div>CONNECTOR ORIENTATION</div><div>INSERTION JIG ORIENTATION</div></div><div><div>Press</div><div>Press</div><div>Release</div></div><div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6098-3802 (W) into jig using right hand then release the lock.</div><div><div>3. Check the holes/terminal slot for B/B wires.</div></div></div></div>			<div>Connector Orientation Illustration</div> <div><div>I-mark is align</div><div>2 Holes are open</div><div>GOOD</div><div>I-mark is not align</div><div>All holes are open</div><div>NG</div></div> <div><div>1. Use the provided jig per model</div><div>2. No wrong orientation of connector</div><div>3. No wrong use of connector</div><div>4. No damaged connector</div></div>

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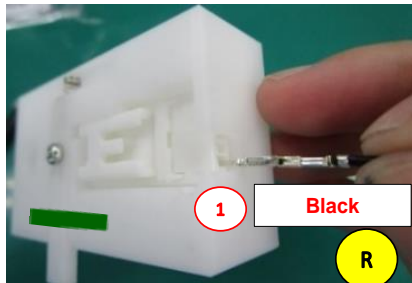
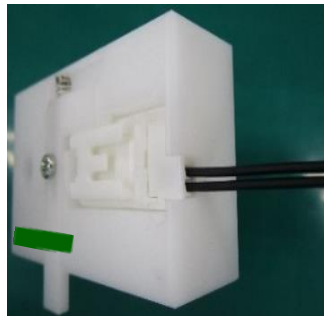
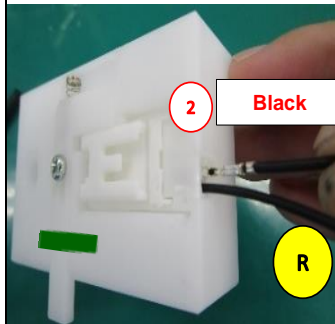
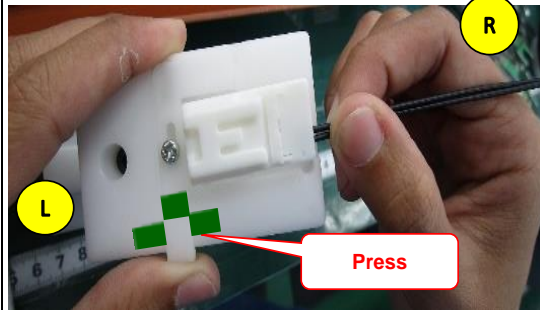
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PARTS:	1. IRRAX A 0.3 B L=145±2mm [2pcs.]		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Offline	<div>Wire insertion to connector 6098-3802 (W)</div> <div><div>WIRE FACING</div></div> <div><div>1. Get the 1st B wire then insert to connector using right hand. Note: Insertion of wire must be from left to right.</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>		<div>Important reminders and note/s;</div> <div>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div>

Important reminders and note/s;
1. Make sure wires are properly inserted.
Conduct Pull-Push-Pull-Push after insertion.
Do not exert extra force.

1. No loose insertion
2. No wrong insertion
3. One by one insertion
4. No deformed terminal
5. No wrong wire facing

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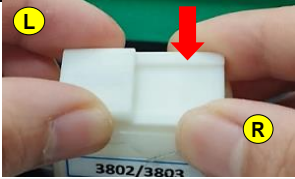


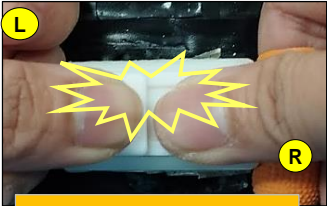
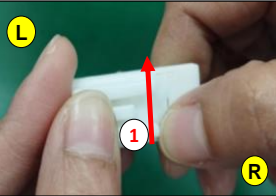
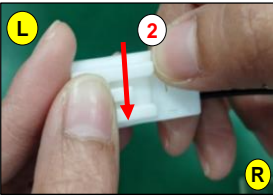



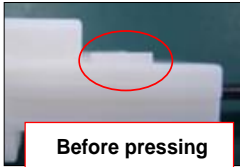
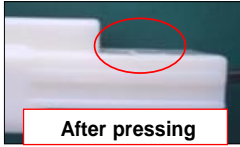
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PARTS:		1. Assy Parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Offline Connector Lock	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div> <div>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

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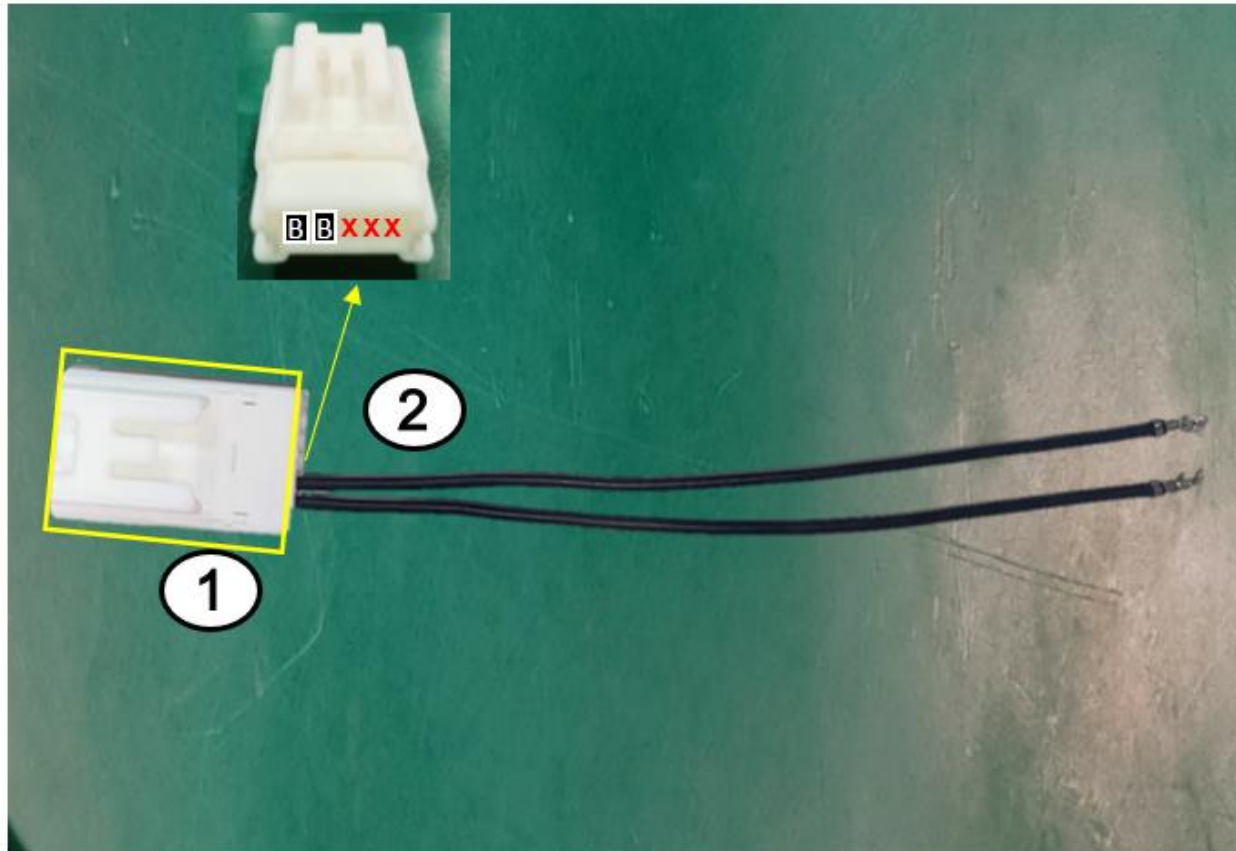
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n/a

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**OFFLINE INSERTION****7M0544-7020B**

① **No Unlocked/Half-locked connector**

② **No Wrong Insert**

③ **No Terminal Backing Out**

④ **No Deformed Terminal**

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