



## WORK INSTRUCTION

## OFFLINE ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

311D / 7L0158-7020A

Customer:

TRQSS

Car Model:

TOYOTA-RAV4

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

June 27, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-933

Revision No.:

0

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## PARTS:

1. Connector 6098-5673 (GR); IRRAX A ROPE-LAY 0.3 B 260±2mm [2 pcs.]; Black Corrugated tube ø5 t=0.5 L= 189±3mm

JIG:

1. Insertion jig  
2. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

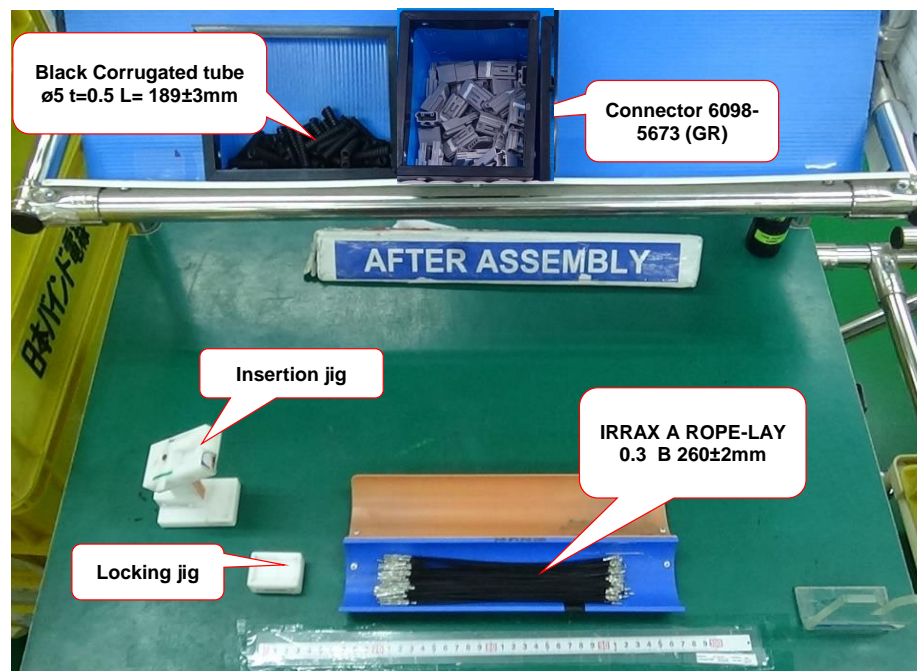
QUALITY POINTERS

1

n/a

Table 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.

1. No missing parts/tools
2. No excess parts/tools

## Revision History

								Prepared by	Reviewed by	Approved by	Noted by
06/27/24	0	Initial issue.						A.Hernandez	C.Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	June 27, 2024			

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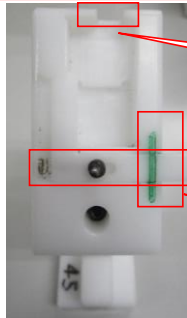
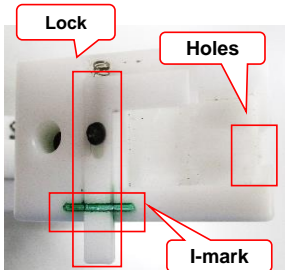

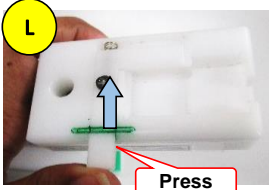
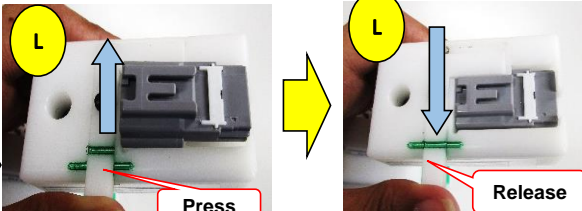

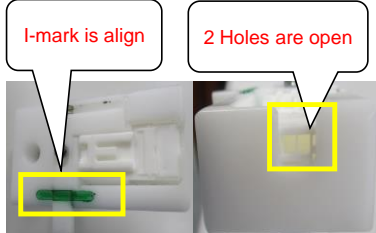
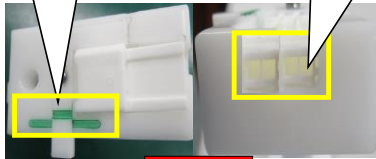
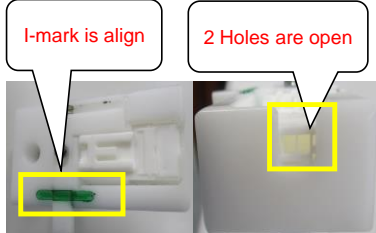
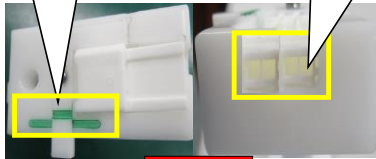
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PARTS:	1. Connector 6098-5673 (GR)			JIG:	1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	n/a	<div><div>Insertion jig</div><div></div><div></div><div></div><div>Connector Orientation</div><div></div><div></div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector (6098-5673) into jig using right hand and release the lock.</div><div></div><div>3. Check the holes/terminal slot for B-B wires.</div></div> <div>n/a</div> <td><div>Connector Orientation Illustration</div><div></div><div>GOOD</div><div></div><div>NG</div><div>1. Use the provided jig per model 2. No wrong orientation of connector</div></td>			<div>Connector Orientation Illustration</div> <div></div> <div>GOOD</div> <div></div> <div>NG</div> <div>1. Use the provided jig per model 2. No wrong orientation of connector</div>	

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PARTS:		1. IRRAX A ROPE-LAY 0.3 B 260±2mm [2 pcs.] 2. Black Corrugated tube ø5 t=0.5 L= 189±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a	<div>Wire insertion to Black Corrugated tube ø5 t=0.5 L= 189±3mm</div> <div></div> <div>1. Get black corrugated tube <b>ø5 L=189±2mm</b> (with slit) using left hand and insert <b>IRRAX A 0.3 B L=260 mm</b> using right hand.</div>		n/a	1. No wrong usage of parts 2. No deformed terminal

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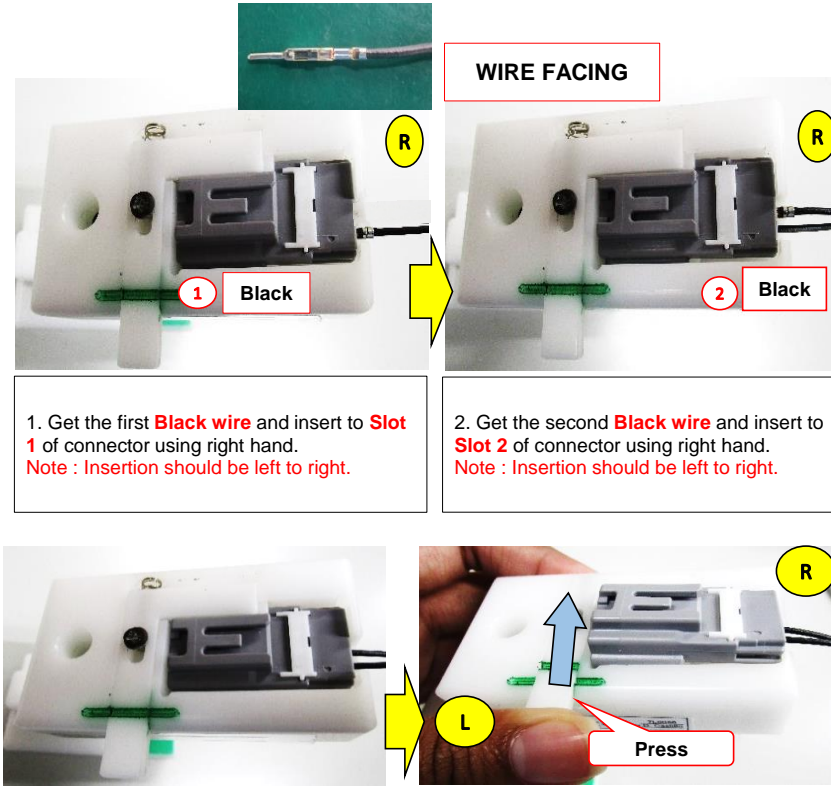
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PARTS:	1. IRRAX A ROPE-LAY 0.3 B 260±2mm [2 pcs.];		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	n/a  Wire insertion to Connector 6098-5673 (GR)	<div><p>1. Get the first <b>Black wire</b> and insert to <b>Slot 1</b> of connector using right hand. <b>Note : Insertion should be left to right.</b></p><p>2. Get the second <b>Black wire</b> and insert to <b>Slot 2</b> of connector using right hand. <b>Note : Insertion should be left to right.</b></p><p>3. After insertion, press 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><b>Important reminders and Note/s;</b></p> <p><b>1. Make sure wires are properly inserted.</b></p> <p><b>Conduct Pull-Push-Pull-Push after insertion.</b></p> <p><b>Do not exert extra force.</b></p> <p><b>Document reference/s:</b></p> <p><b>1. Refer to WI-PRO-CNC-017 for wire and strip length tolerance.</b></p> <p>1. No loose insertion 2. No wrong dimension 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p>

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PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	n/a	Connector lock	<div>LOCKING JIG</div> <div></div>	<div>1. Use the provided jig per model 2. No unlocked/half-locked connector</div> <div><b>Important reminders/Note/s:</b> <b>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR LOCK</b> <b>2. Use provided jig tool per model to avoid damaged lock.</b> <b>Document references:</b> <b>1. Refer to GL-PRO-ASY-017 for the verification of connector lock.</b></div> <div><div><div><p>Before pressing</p></div><div><p>After pressing</p></div></div><div><div><div><p>GOOD</p><p>Full Lock</p></div><div><p>NG</p><p>Half Lock</p></div></div></div></div>

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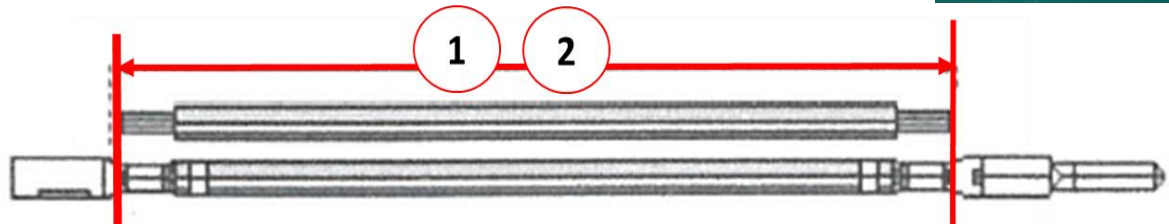


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PARTS:		1. Assy Parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	n/a	Measurement	<p>Note:</p> <ol style="list-style-type: none"><li>1. Measurement point: End of core wire to the end of core wire</li><li>2. Terminal is reference only.</li></ol>  	<div>Measuring tape</div>  <p><b>Important reminders and note/s:</b></p> <ol style="list-style-type: none"><li>1. Please use calibrated/verified measuring tape when getting the measurement.</li><li>2. For Hatsumono, Nakamono and Owarimono.</li></ol> <p><b>Document reference/s:</b></p> <ol style="list-style-type: none"><li>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection.</li></ol>	<p>ø5 t=0.5 L= 189±3mm</p> <p>1. No wrong dimension</p>

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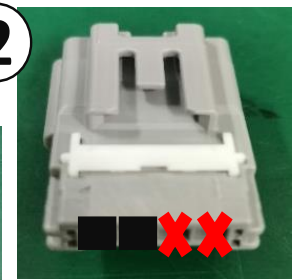
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PARTS:

n/a

JIG:

n/a

**VISUAL INSPECTION/QUALITY CHECKPOINTS****Offline****7L0158-7020A****①****GOOD****NO GOOD****①** No **Unlock/Halflock Connector****③****④****②** No **Wrong Insert****③** No **Deformed Terminal****④** No **Terminal Backing out****②****GOOD****NO GOOD**

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