



## WORK INSTRUCTION

Process Name/Title:

## OFFLINE ASSEMBLY PROCESS

Model code/Part number:

320B

/ 7L0054-7025

Customer:

TRQSS

Car Name:

TOYOTA-RAV4

Effectivity Date:

July 13, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-140

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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## PARTS:

1. All parts (Connector 6189-0451 (W); TVSSf 0.3 G-B/W L=553±3mm; Black SV tube (Vinyl) ø5 L=273±3mm)

JIG:

1. Insertion jig with switch cover
2. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

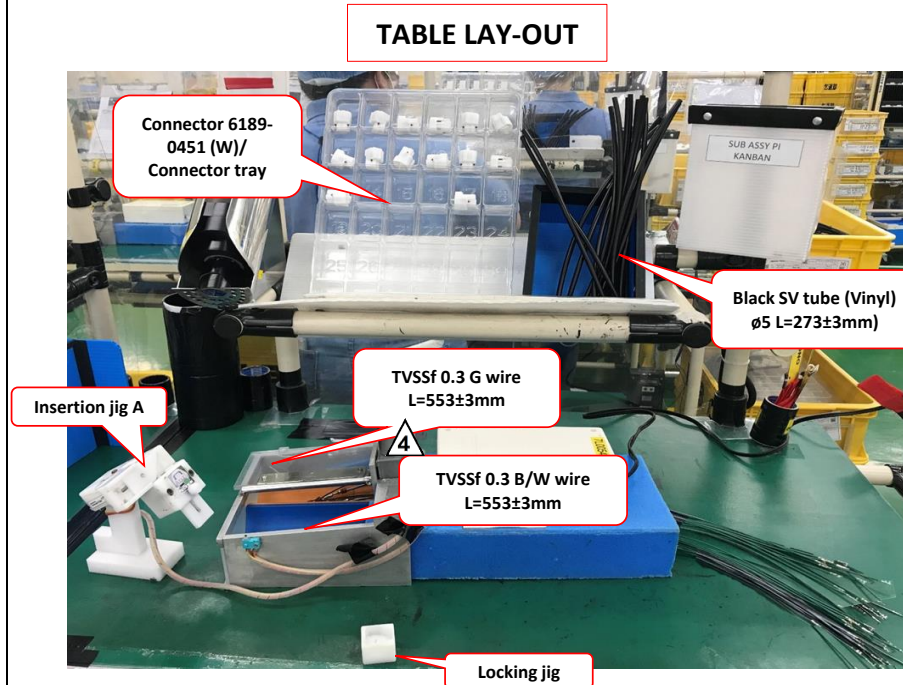
TOOLS/PPE

QUALITY POINTERS

1

n/a

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.

1. No missing parts/tools
2. No excess parts/tools
3. No wrong positions of parts/tools

**Document reference/s:**

1. Refer to WI-PRO-CNC-071 Wire and Strip Length Tolerance

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
07/13/23	4	Updated Template; Inclusion of <b>CAR MODEL "TOYOTA-RAV4"</b> . Inclusion of Quality checkpoints (page 5); Changed Wire color location from B/W-G to G-B/W wire. Inclusion of Quality checkpoints (page 5). Refer to ENGDRR-125 for Document revision request.	M. Ariola	C. Villanueva	A. Arañes	n/a				
01/15/23	3	Change part number from 7L0054-7024 to 7L0054-7025 due to change in PCB (from 2 chip (61C619-0002) to 1 chip(7N0994-7060);Change in wire color from Gray (GR) to Green (G).	K. Doria	J. Loterte	C. Villanueva	A. Arañes				
11/05/21	2	Change part number from 7L0054-7024 to 7L0054-7025 due to additional quantity of clamp (82711-52090) (W) Refer to WI-ENG-PDE-141B). Improve work procedure illustration . Additional table lay-out , Checkpoints in checking wiretolerance	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Ariola	C. Villanueva	A. Arañes	n/a

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**PARTS:**

1. Connector 6189-0451 (W)

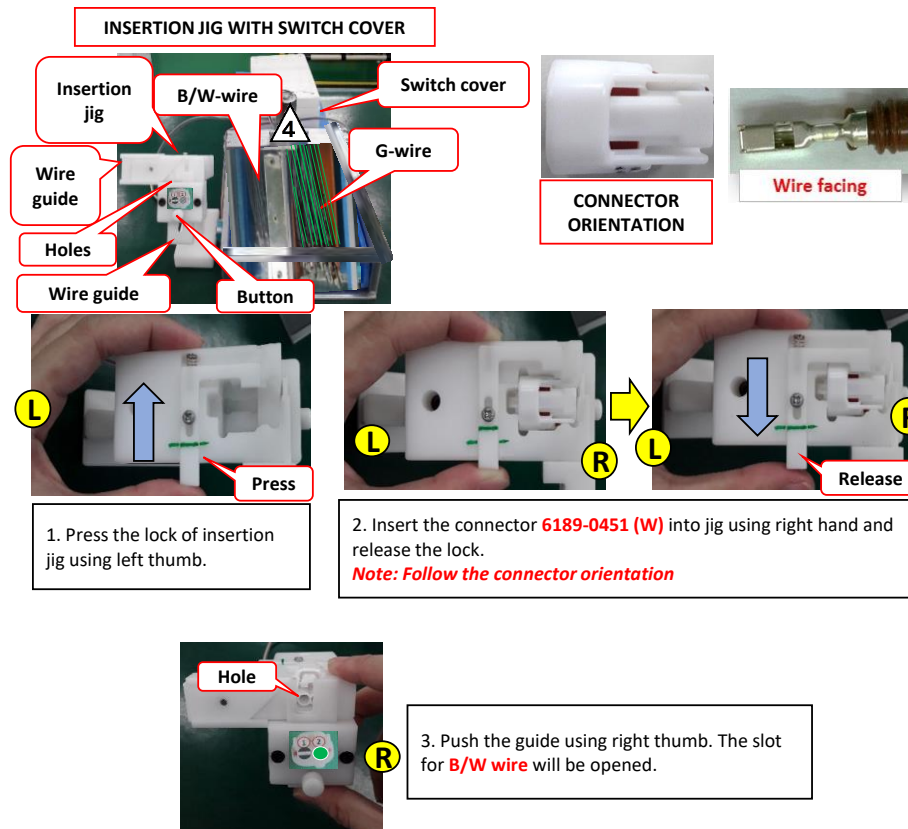
**JIG**

1. Insertion jig with switch cover

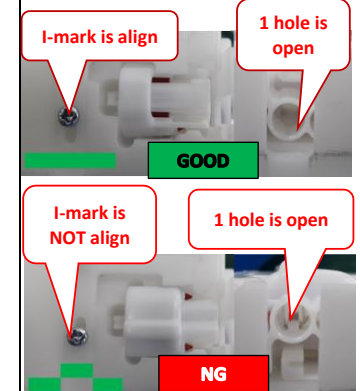
**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

2

n/a

Connector setting to  
insertion jig 6189-0451  
(W)

n/a

**Connector Orientation**

1. Use the provided jig per model
2. No wrong orientation of connector
3. No wrong use of connector
4. No damaged connector

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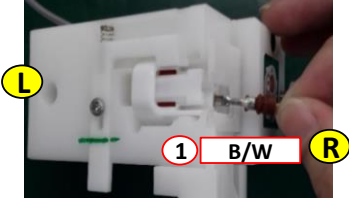
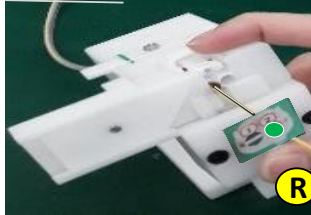
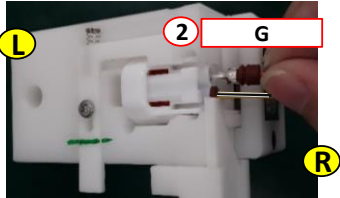
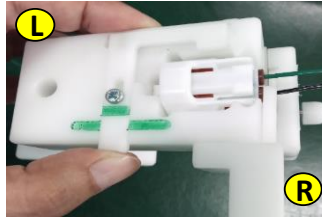
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PARTS:		1. TVSSf 0.3 G/BW L=553±3mm			JIG	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	n/a  Wire insertion to connector 6189-0451 (W)	<div><p>Wire facing</p></div> <div><p>1. Get the <b>B/W wire</b> then insert to terminal slot ① using right hand.</p></div> <div><p>2. After insertion of <b>B/W wire</b> press the button using right thumb. The slot for <b>G wire</b> will be opened.</p></div> <div><p>3. Get the <b>G wire</b> then insert to terminal slot ② using right hand.</p></div> <div><p>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.</p></div>			n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</p> <p><b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal during insertion.</b> <b>2. Insertion of wire must be inserted.</b> <b>3. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b></p> <p><b>Document reference/s:</b> <b>1. Refer to WI-PRO-CNC-017 for Wire and Strip lenght Tolerance</b> <b>2. Please refer to GL-PRO-ASSY-029 for Pull-Push procedure.</b></p>

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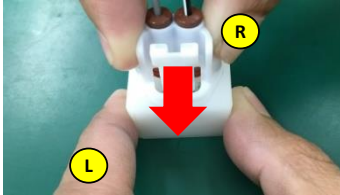
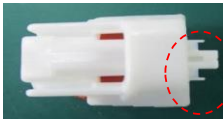





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<b>PARTS:</b>	1. Black SV tube (Sunprene) $\phi 5$ L=273 $\pm$ 3mm			<b>JIG</b>	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Connector lock	<div></div> <div>1. Put the connector into locking jig using right hand then press <b>2x</b>. Touch the connector lock if properly locked.</div> <div><b>BEFORE PRESSING</b></div> <div><b>AFTER PRESSING</b></div> <div><b>GOOD</b></div> <div><b>NG</b></div> <div>Check the double lock deformation</div>		<div><b>LOCKING JIG</b></div> 	<i>Important reminders/Note/s:</i> <b>1. Manual locking may cause damaged connector lock</b>  1. Use the provided locking jig per model 2. No unlock/half-locked connector
5	Wire insertion to Black SV tube (Sunprene) $\phi 5$ L=273 $\pm$ 3mm	<div></div> <div>1. Get the <b>Black SV tube (Sunprene) <math>\phi 5</math> L=273<math>\pm</math>3mm</b> using right hand then insert the wires using left hand.</div>		n/a	1. No wrong usage of parts 2. No deformed terminal

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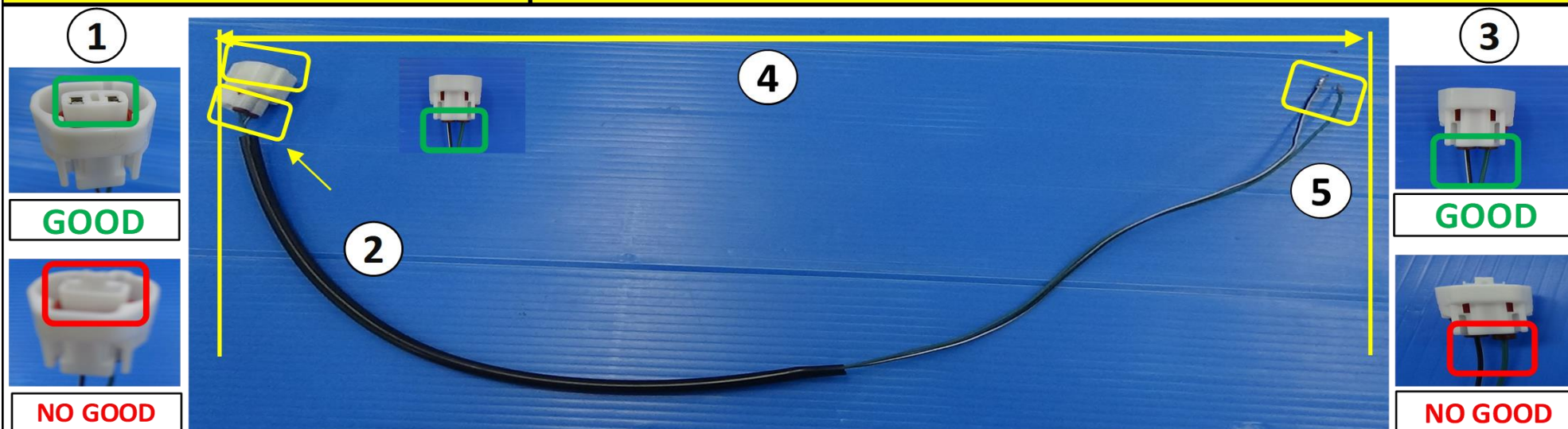
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n/a

**JIG**

n/a

**4 QUALITY CHECKPOINTS****OFFLINE INSERTION****7L0054-7025****1 No Unlock connector****3 No Terminal Backing Out****2 No Wrong insert****4 Check the Alignment****5 No Deform terminal**

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