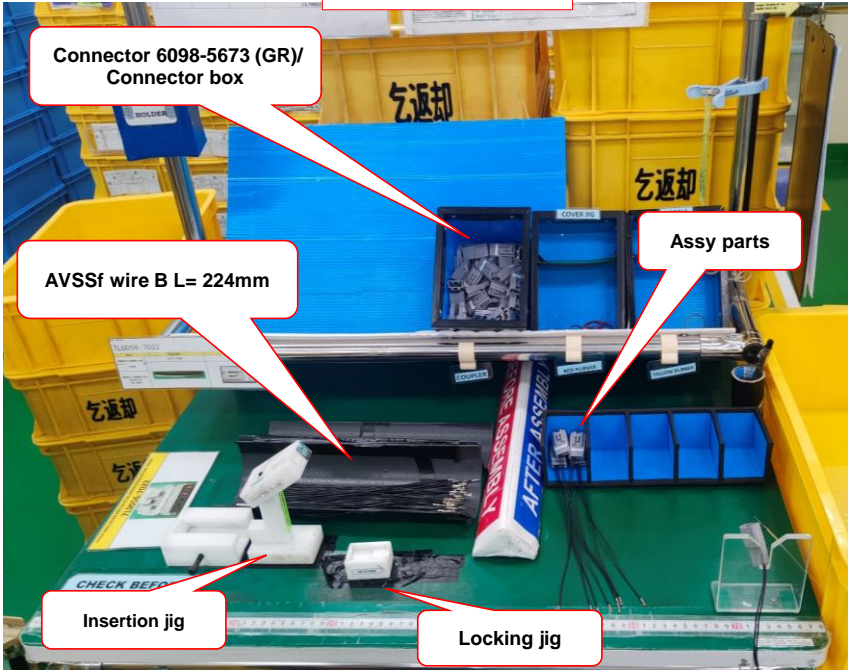

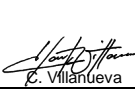
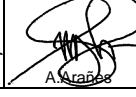
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	Process Name/Title: OFFLINE ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 320B / 7L0056-7022		Customer: TRQSS	Car Model: TOYOTA-RAV4	Document No.:		WI-ENG-PDE-111	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		5	Page No.: 1 of 6

PARTS:	1. Connector 6098-5673 (GR); AVSSf 0.3 wires B L=224±2mm			JIG:	1. Insertion jig 2. Locking jig				
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS			
1	Offline	Table Lay-out				<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		
06/03/24	5	Inclusion of Car model "TOYOTA-RAV 4" and Measurement. Improved Visual inspection/ Quality checkpoints.				D.Castillo	C.Villanueva	A. Arañes	N/A	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
06/09/23	4	Inclusion of table lay-out and quality check points; improve important reminders/note/s and document references; improve connector locking process; change title from kitting assembly process to offline assembly process				J. Loterte	A.Villanueva	A.Arañes	n/a				
05/26/21	3	Remove validity date.				D.Castillo	A.Villanueva	A.Shimamura	A.Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	October 23, 2019		

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320B**/****7L0056-7022**

Customer:

TRQSS

Car Model:

TOYOTA-RAV4

Document No.:

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Purpose:

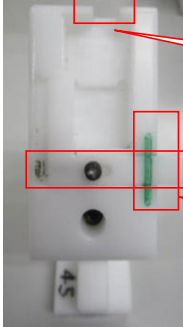
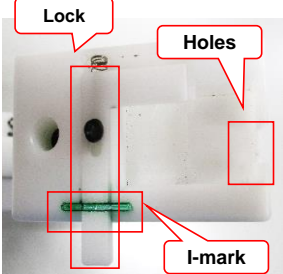

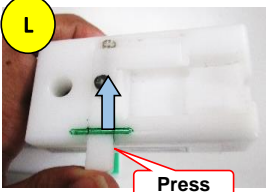
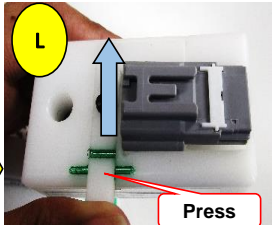
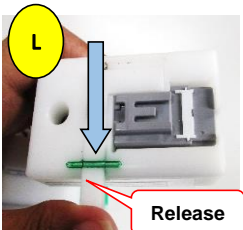

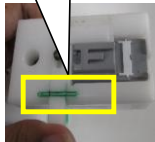

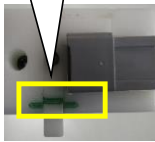
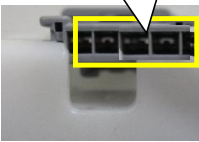
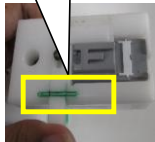

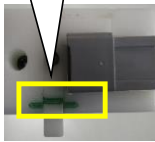
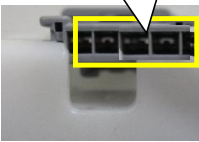
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PARTS:		1. Connector 6098-5673 (GR)		JIG:	1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	Offline	<div><div><div><div><div>Insertion jig</div><div></div></div><div><div><div>Lock</div><div>Holes</div><div></div></div><div><div></div><div>Connector Orientation</div></div></div></div><div><div><div><div><div>L</div><div></div><div>Press</div></div><div><div><div>L</div><div></div><div>Press</div></div><div><div><div>L</div><div></div><div>Release</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></div><div>3. Check the holes/terminal slot for B-B wires.</div></div></div></div><div>n/a</div><td><div><div>Connector Orientation Illustration</div><div><div><div>I-mark is align</div><div></div></div><div><div>2 Holes are open</div><div></div></div></div><div>GOOD</div><div><div><div>I-mark is not align</div><div></div></div><div><div><div>All holes are open</div><div></div></div></div><div>NG</div><div><div>1. Use provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div></div></div></div></td></div></div></div>			<div><div>Connector Orientation Illustration</div><div><div><div>I-mark is align</div><div></div></div><div><div>2 Holes are open</div><div></div></div></div><div>GOOD</div><div><div><div>I-mark is not align</div><div></div></div><div><div><div>All holes are open</div><div></div></div></div><div>NG</div><div><div>1. Use provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div></div></div></div>	

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WORK INSTRUCTION

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OFFLINE ASSEMBLY PROCESS

Effectivity Date:

June 3, 2024

Validity Date:

n/a

Model code/Part number:

320B

/ 7L0056-7022

Customer: TRQS

Car Model: TOYOTA-RAV4

Document No.:

WI-ENG-PDE-111

Purpose:


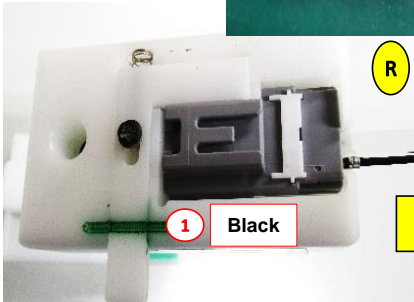
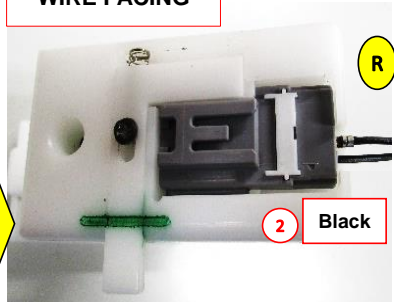
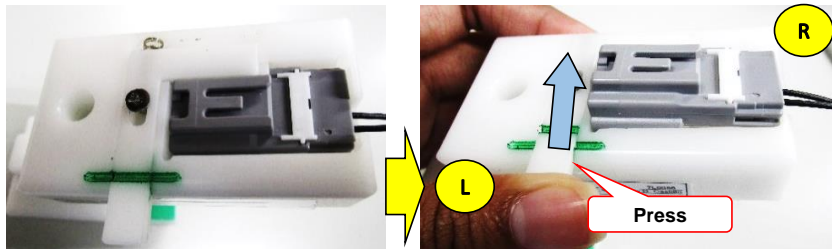
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PARTS:		1. AVSSf 0.3 wires B L=224±2mm [2pcs]		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Offline	<div><div><p>WIRE FACING</p></div><div><p>1. Get the first Black wire and insert to Slot 1 of connector using right hand. Note : Insertion should be left to right.</p></div><div><p>2. Get the second Black wire and insert to Slot 2 of connector using right hand. Note : Insertion should be left to right.</p></div><div><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></div>		n/a	<p>Important reminders and Note/s; 1. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force. Document reference/s: 1. Refer to WI-PRO-CNC-017 for wire and strip length tolerance.</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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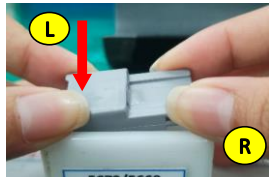
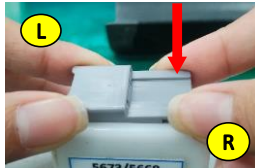



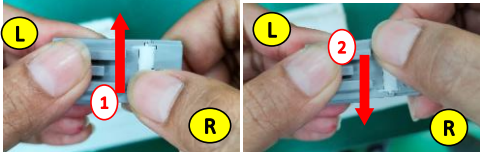





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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Offline Connector Lock	<div><div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div><div>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

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Customer:

TRQSS

Car Model:

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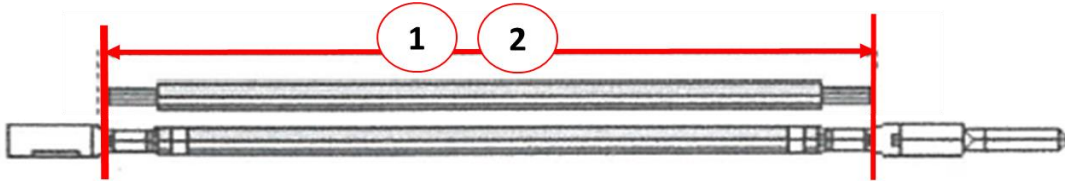


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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Offline	Measurement	<div>Note: 1. Measurement point: End of core wire to the end of core wire 2. Terminal is reference only.</div> <div></div>	<div><div>MEASURING TAPE</div></div>	<div><div>Important reminders and note/s:</div><div>1. Please use calibrated /verified measuring tape when getting the measurement.</div><div>2. For Hatsumono, Nakamono and Owarimono.</div><div>Document reference/s:</div><div>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection.</div><div>1. No wrong dimension</div></div>
			<div></div>		

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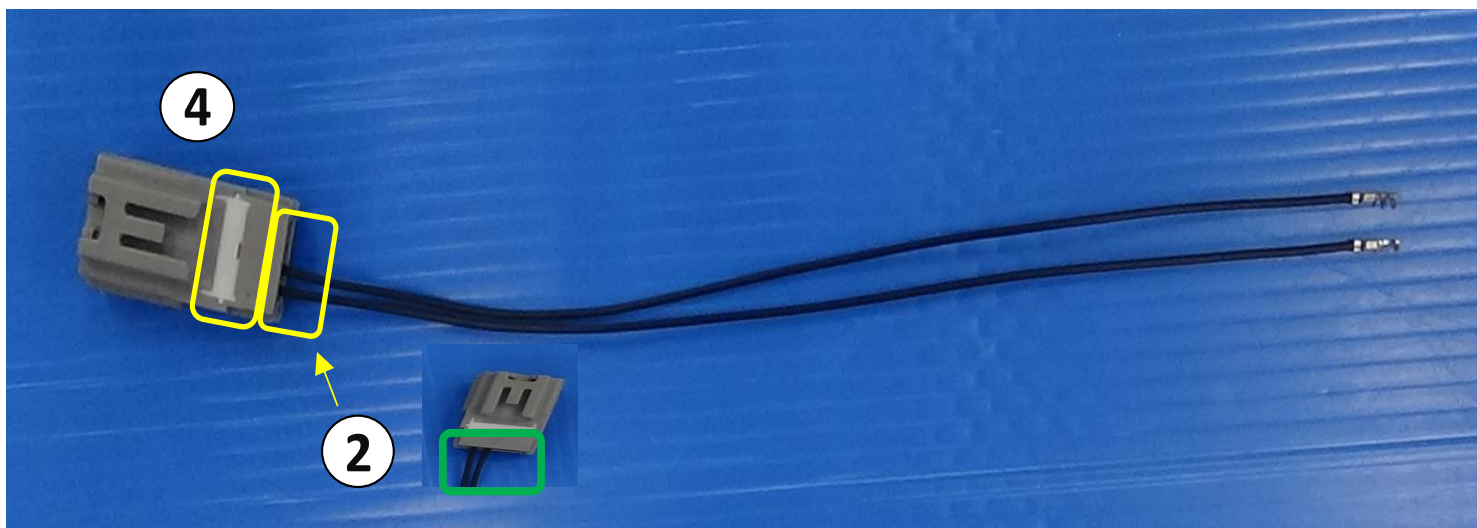
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7L0056-7022****1****GOOD****NO GOOD****4****2****3****GOOD****NO GOOD****1 No Unlocked/Half-locked connector****3 No Terminal Backing Out****2 No Wrong insert****4 No Deformed terminal**

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