



## WORK INSTRUCTION

## OFFLINE ASSEMBLY PROCESS

Effectivity Date:

May 15, 2025

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

400D / 7L0162-7020A

Customer:

TRQSS

Car Model: TOYOTA-bZ4X (BEV)

Document No.:

WI-ENG-PDE-1268

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

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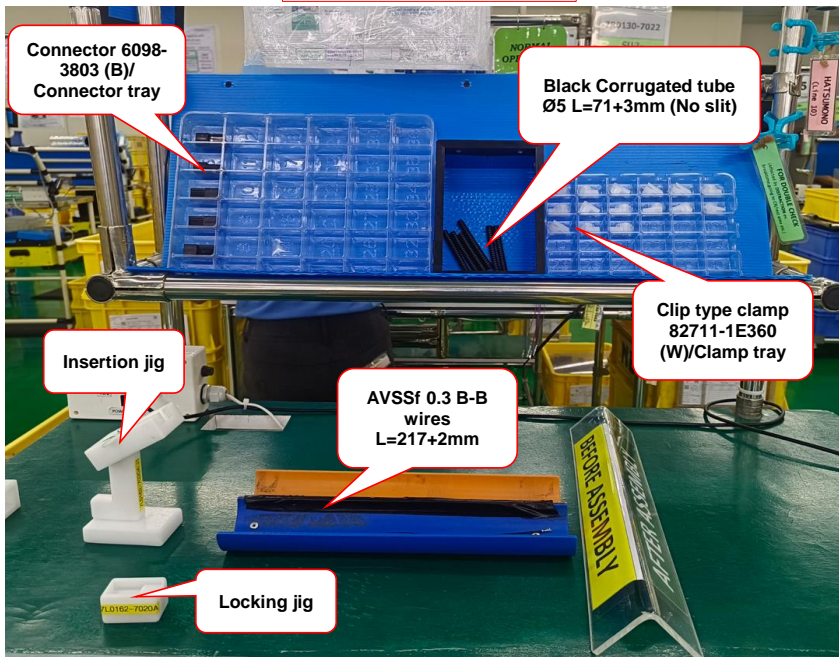
## PARTS:

1. Connector 6098-3803 (B)
2. Black Corrugated tube Ø5 L=71+3mm (No slit)
3. Clip type clamp 82711-1E360

4. AVSSf 0.3 B-B wires L=217+2mm

JIG:

1. Assembly jig
2. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Offline Table lay-out	 <p><b>TABLE LAY-OUT</b></p> <p>Connector 6098-3803 (B)/ Connector tray</p> <p>Black Corrugated tube Ø5 L=71+3mm (No slit)</p> <p>AVSSf 0.3 B-B wires L=217+2mm</p> <p>Clip type clamp 82711-1E360 (WY) Clamp tray</p> <p>Insertion jig</p> <p>Locking jig</p>	<p><b>Safety Instruction</b></p> <p>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b></p> <ol style="list-style-type: none"><li>1. Maintain and always practice 5's.</li><li>2. Personal things on the workplace is prohibited. Keep it in your locker.</li></ol> <p><b>Alert level!</b></p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p><b>Document reference:/s</b></p> <ol style="list-style-type: none"><li>1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</li></ol> <ol style="list-style-type: none"><li>1. No missing parts/tools</li><li>2. No excess parts/tools</li></ol>

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	Prepared by	Reviewed by	Approved by	Noted by
05/15/25	0	Initial issue.						M. Ariola	C. Villanueva	A. Arañes	n/a

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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Offline  Wire Insertion to Connector 6098-3803 (B)	<div><div><div>Insertion Jig</div><div></div></div><div><div>Insertion Jig Orientation</div><div></div></div><div><div>Connector lock</div><div></div></div><div><div>Connector Orientation</div><div></div></div><div><div><div>Press</div><div>1. Press the lock of insertion jig using left thumb.</div></div><div><div><div>Press</div><div>2. Insert the connector <b>6098-3803 (B)</b> into jig using right hand and release the lock.</div></div><div><div><div>Release</div><div>3. Check the holes/terminal slot for 2 Black wires.</div></div></div></div><div><div></div></div></div></div>		n/a	<div><div>1. Use the 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>Connector Orientation Illustration</div><div><div><div>I-mark is align</div><div>GOOD</div></div><div><div>2 holes are open</div><div>GOOD</div></div><div><div>I-mark is not align</div><div>NG</div></div><div><div>All holes are open</div><div>NG</div></div></div><div><div>CONNECTOR ILLUSTRATION</div><div><div><div>GOOD</div><div>6098-3803 (B)</div></div><div><div>NG</div><div>6098-3802 (W)</div></div></div></div></div>

n/a

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

Connector Orientation Illustration

CONNECTOR ILLUSTRATION

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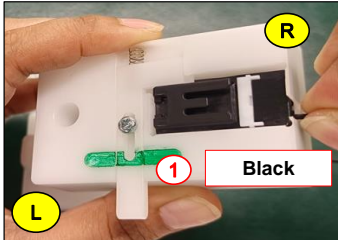
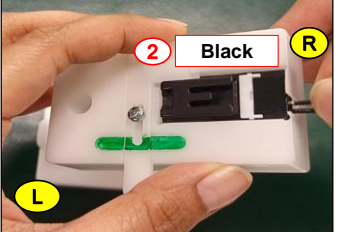
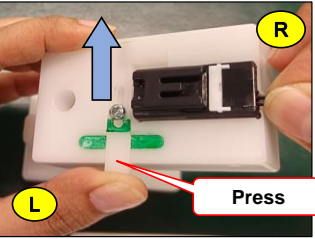
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<b>PARTS:</b>		1. Connector 6098-3803 (B) 2. Black Corrugated tube Ø5 L=71+3mm (No slit) 3. AVSSf 0.3 B-B wires L=217+2mm		JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
3	Wire insertion to Black Corrugated tube Ø5 L=71+3mm (No slit)	 <div>1. Get the Black Corrugated tube <b>Ø5 L=71+3mm (No slit)</b> using right hand then insert the <b>AVSSf 0.3 B-B wires L=217+2mm</b>.</div>		n/a	1. No wrong usage of parts. 2. No deformed terminal
4	Offline Wire insertion to Connector 6098-3803 (B)	 <div>1. Get <b>1st black wire</b> then insert to terminal slot <b>1</b> using right hand.</div>  <div>2. Get <b>2nd Black wire</b> then insert to terminal slot <b>2</b> using right hand.</div>  <div>3. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</div>		n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing  <b>Important reminders/Note/s:</b>  1. Please hold the wire near terminal during insertion. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 3. Insertion should be from left to right.  <b>Document reference:/s</b>  1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

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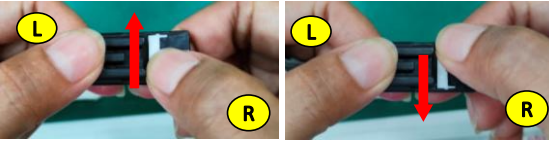


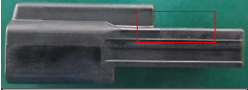


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PARTS:	1. Assy parts			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Offline Connector lock	<div><p>1. Load the connetor into the jig holding both side of the connector, tip first.</p></div> <div><p>2. 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><b>LOCKING JIG</b></div> 	<p><b>Important reminders/Note/s:</b></p> <p>1. Manual locking may cause damaged connector</p> <p><b>Document references:</b></p> <p>1.Refer <b>WI-PRO-KIT-001</b> Proper locking and checking of connector lock</p> <p>1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p> <div><p><b>Before pressing</b></p><p><b>After pressing</b></p></div> <div><p><b>GOOD</b> <b>Full Lock</b></p><p><b>NG</b> <b>Half Lock</b></p></div>

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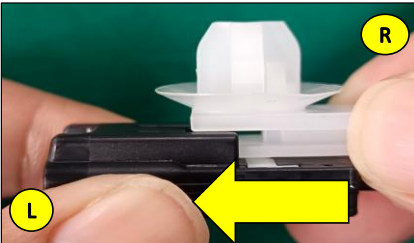
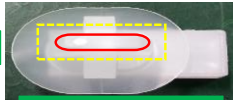
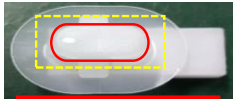
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PARTS:		1. Assy parts 2. Clip type clamp 82711-1E360 (W)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	Offline  Clip attachment (Clip type clamp)	<div><div>CLAMP ORIENTATION</div></div> <div></div> <div>1. Hold the connector using left hand, get tge clip type clamp <b>82711-1E360 (W)</b> then insert the clamp using right hand. <i>Note: Sound will be heard if properly inserted.</i></div>			<div>CLIP CLAMP ILLUSTRATION</div> <div><div>GOOD</div><div>82711-1E360 (W)</div></div> <div><div>NG</div><div>82711-12B10 (W)</div></div> <div>1. No wrong used of clamp 2. No damaged clamp 3. No missing clamp</div>

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**PARTS:**

1. Assy parts

JIG:

n/a

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

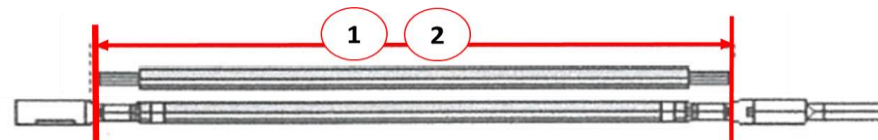
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Offline

Measurement

Note:

1. Measurement point: End of core wire to the end of core wire
2. Terminal is reference only.

**MEASURING TAPE**

1. No wrong dimension.

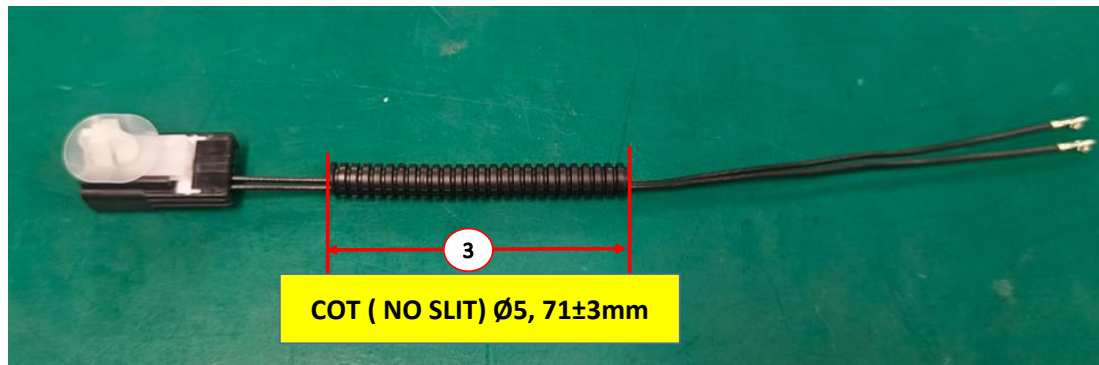
**Important reminders and note/s:**

1. Please use calibrated/verified measuring tape when getting the measurement.

2. For Hatsumono, Nakamono and Owarimono.

**Document reference/s:**

1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection



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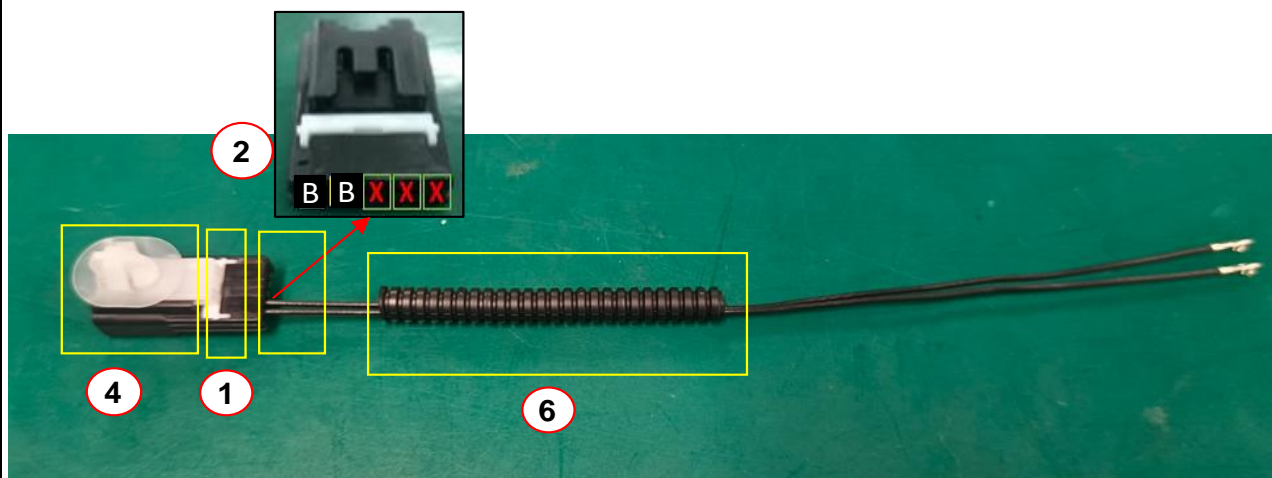
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PARTS:

n/a

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7L0162-7020A**

- ① No Unlocked/Half-locked connector
- ② No Wrong Insert
- ③ No Terminal Backing Out
- ④ No Missing clip
- ⑤ No Deformed Terminal
- ⑥ No Missing COT

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