



WORK INSTRUCTION

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

July 4, 2024

Model code/Part number:

311D

/

7L0157-7021A

Customer:

TRQSS

Car Model:

TOYOTA RAV4

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-932

Revision No.:

0

Page No.:

1 of 6

PARTS: 1. Connector 6098-3803 (B); AVSSf 0.3 B L=223±2mm

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

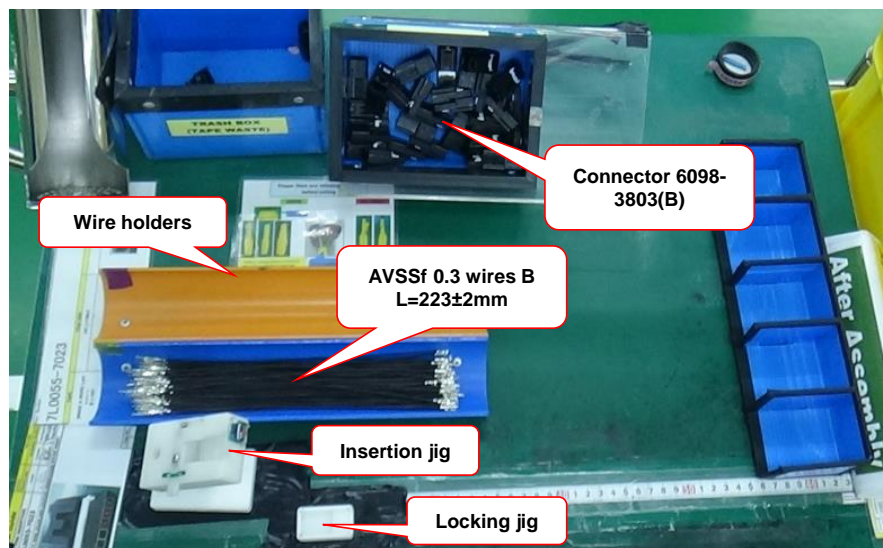
QUALITY POINTERS

1

n/a

Table Lay-out

TABLE LAY-OUT

**Safety Instruction**

Be sure to wear 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 references:

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

07/04/24 0 Initial issue.

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Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

July 4, 2024

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2 of 6

PARTS:	1. Connector 6098-3803 (B)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	n/a Connector Setting to Insertion jig 6098-3803 (B)	<div><div><div>Insertion jig</div><div>Holes</div><div>Visual reference</div><div>Push button</div></div><div><div>Insertion jig orientation</div><div>I-Mark</div><div>CONNECTOR ORIENTATION</div></div><div><div><div><div>↑</div><div>L</div><div>Press</div></div><div><div>↑</div><div>R</div><div>Press</div></div><div><div>↓</div><div>L</div><div>Release</div></div></div><div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the Connector 6098-3803 (B) into jig using right hand and release the lock.</div><div><div>3. Check the holes/terminal slot for B-B wires.</div></div></div></div></div>	n/a	<div><div>Connector Orientation Illustration</div><div><div>I-mark is align</div><div>2 Holes are open</div><div>GOOD</div></div><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></div>

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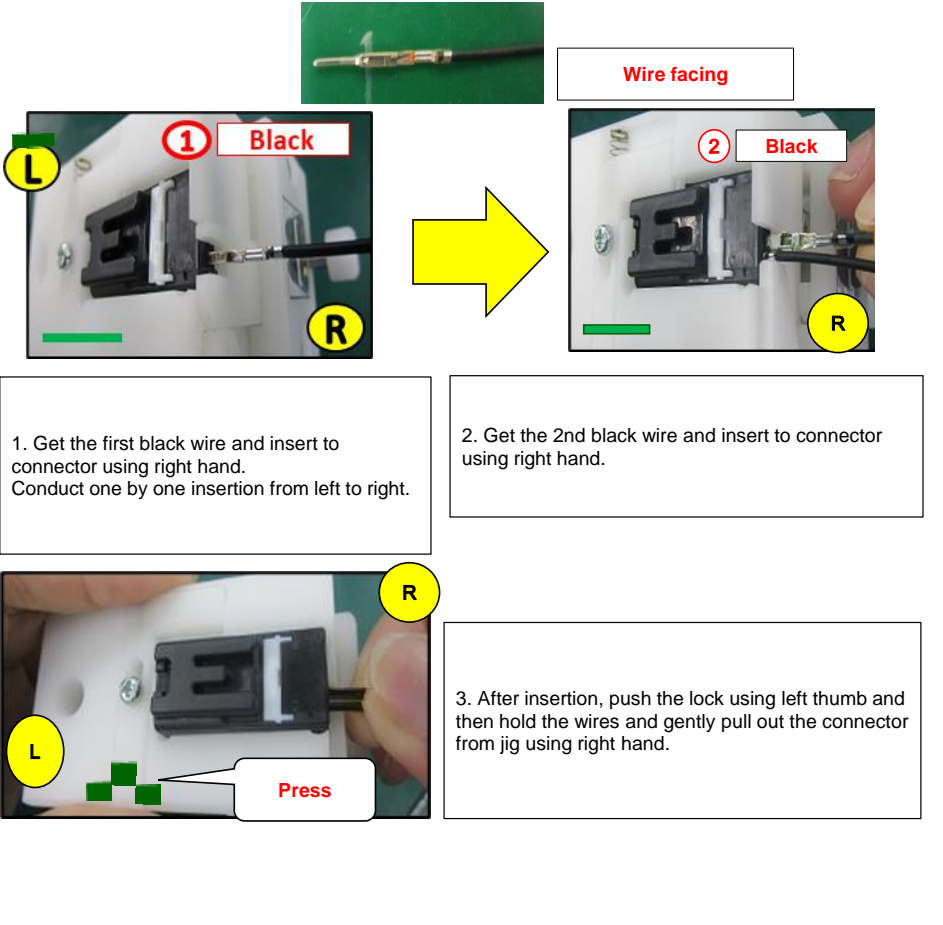
WI-ENG-PDE-932

Revision No.:

0

Page No.:

3 of 6

PARTS:	1. AVSSf 0.3 B L=223±2mm			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a Wire insertion to connector 6098-3803 (B)	<div data-bbox="542 389 1482 1318"><p>1. Get the first black wire and insert to connector using right hand. Conduct one by one insertion from left to right.</p><p>2. Get the 2nd black wire and insert to connector using right hand.</p><p>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.</p></div>		n/a	<p>Important reminders/Note/s:</p> <p>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>2. No loose insertion 3. No wrong insertion 4. No deform terminal 5. No wrong wire facing</p> <p>Document references:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</p>

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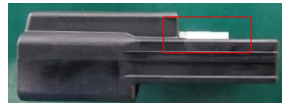
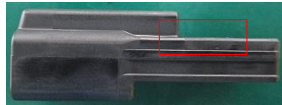


WI-ENG-PDE-932

Revision No.:

0

Page No.:

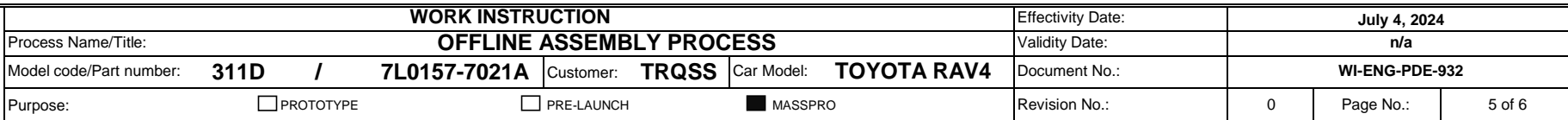
4 of 6

PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	n/a	Connector Lock	<div>LOCKING JIG</div> 	<div>1. No Unlock and half-locked</div> <div>2. Use provided jig tools per model to avoid damaged lock.</div> <div>Important reminders/Note/s:</div> <div>1. Manual locking may cause damaged connector</div> <div>Document references:</div> <div>1.Refer WI-PRO-KIT-001 Proper locking and checking of connector lock</div> <div><div><div>Before pressing</div></div><div><div>After pressing</div></div><div><div><div>GOOD</div><div>Full Lock</div></div><div><div>NG</div><div>Half Lock</div></div></div></div>

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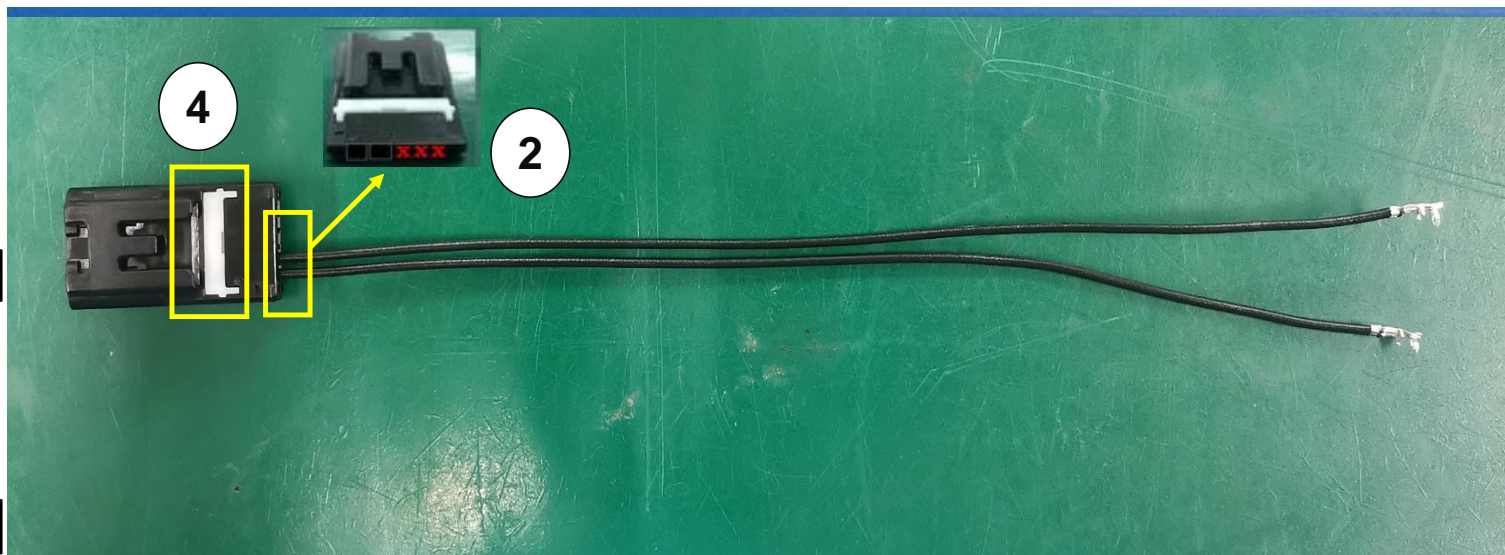
Page No.:

6 of 6

PARTS: n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**OFFLINE INSERTION****7L0157-7021A****1****GOOD****NO GOOD****4****2****3****GOOD****NO GOOD****1** No **Unlock** connector**3** No **Terminal Backing Out****2** No **Wrong** insert**4** No **Deform** terminal**5** Check the **Alignment**

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