



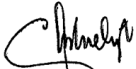



WORK INSTRUCTION
OFFLINE ASSEMBLY PROCESS

Effectivity Date:	March 7, 2025		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-1056		
Revision No.:	0	Page No.:	1 of 8

Process Name/Title:			
Model code/Part number:	559D / 7N0237-7020B	Customer:	TRJ
		Car Model:	TOYOTA HI-ACE
Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO

PARTS:		1. Connector 6098-5677 (W) 2. AVSSf 0.3 P,W,G wires L=810±3mm; 3. Black Corrugated tube Ø7, L=423±3mm 4. Black Corrugated tube Ø5, L=329±3mm		JIG:	1. Insertion jig with & without switch cover. 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	Offline Table lay-out	<div><div>TABLE LAY-OUT</div><div><div>Connector 6098-5677 (W)/Connector tray</div><div>Black Corrugated tube Ø5, L=329±3mm</div><div>Black Corrugated tube Ø5, L=423±3mm</div><div>Insertion jig (A) with switch cover</div><div>AVSSf 0.3 W,G wires L=810±3mm</div><div>AVSSf 0.3 P wires L=810±3mm</div><div>Insertion jig (A) with switch cover</div><div>Locking jig</div></div></div>		<div><div>Safety Instruction Be sure to wear required 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>	<div>1. No missing parts/tools 2. No excess parts/tools</div> <div>Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</div> <div><div>CONNECTOR ILLUSTRATION</div><div><div>GOOD</div><div>NG</div><div><div>6098-5677 (W)</div><div>6098-3810 (W)</div></div></div></div>

Revision History

				Prepared by		Checked by	Reviewed by	Approved by
								
				M. Ariola		J. Loterte	C. Villanueva	A. Arañes
03/07/25	0	Initial issue. Excluded from WI-ENG-PDE-1064. Change purpose from Pre-launch to Masspro. Additional table lay-out; Visual inspection/Quality checkpoints.		M. Ariola	J. Loterte	C. Villanueva	A. Arañes	
Eff. Date	Rev. No	Details of Change		Revised	Checked by	Reviewed by	Approved	Est. Date:
								March 7, 2025

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☐ PROTOTYPE

☐ PRE-LAUNCH


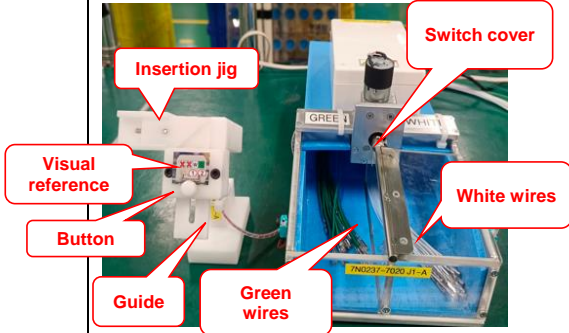
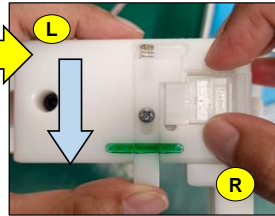
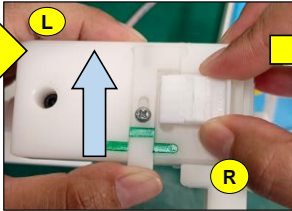
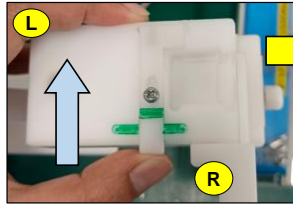
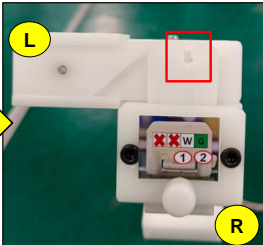
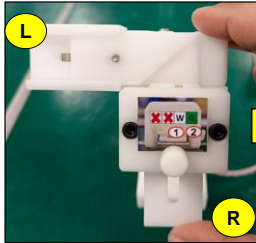
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PARTS:	1. Connector 6098-5677 (W)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Offline Connector setting to Connector 6098-5677 (W)	<div></div> <div></div> <div></div> <div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the connector 6098-5677 (W) into jig using right hand and release the lock.</p><p>3. Push the guide using right hand. the slot for White wire will be opened.</p></div>	n/a	1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector.

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PROTOTYPE



PRE-LAUNCH



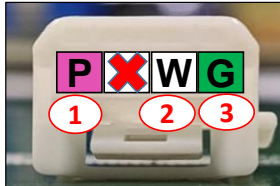


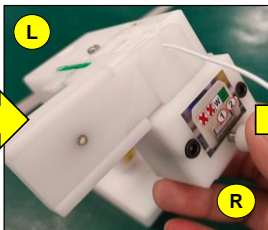
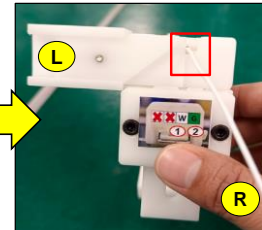
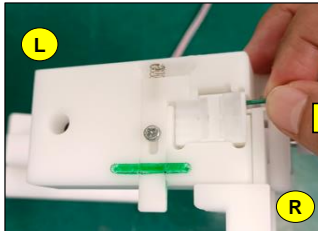
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PARTS:		1. Connector 6098-5677 (W) 2. AVSSf 0.3 W,G wires L=810±3mm;		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Offline Wire insertion to connector 6098-3802 (W)	<div><div></div><div></div><div>CONNECTOR ORIENTATION</div><div>TERMINAL ORIENTATION</div></div> <div><div></div><div>1. Get the White wire then insert to terminal slot ① using right hand.</div><div></div><div>2. After insertion of White wire press the button using right hand. Slot for Green wire will be opened.</div><div></div><div>3. Get the Black wire then insert to terminal slot ② using right hand.</div><div></div><div>4. After insertion, press the lock using left hand thumb then hold the wires and gently pull-out the connector from jig using right hand.</div></div> <div>n/a</div> <div><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. Please hold the wire near terminal during insertion.</p><p>Document references:</p><p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p></div>			

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PROTOTYPE



PRE-LAUNCH



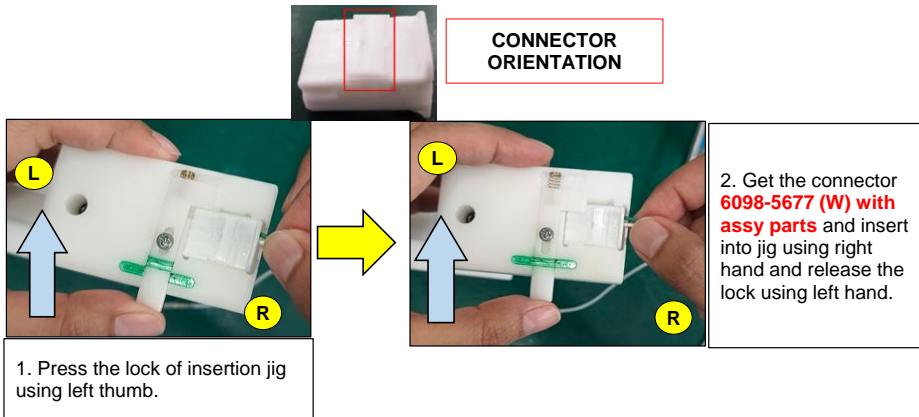
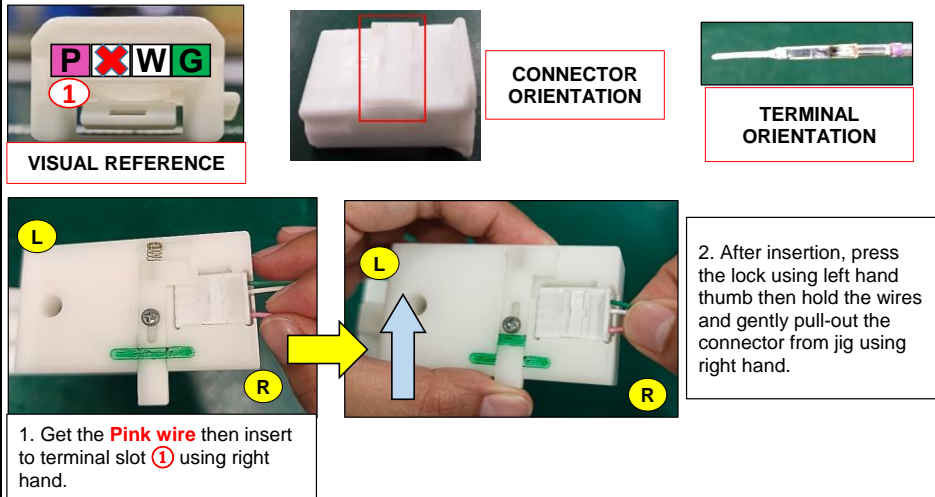
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PARTS:		1. Assy parts 2. AVSSf 0.3 P wire L=810±3mm;		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Connector setting to insertion jig 6098-5677 (W)	 <p>CONNECTOR ORIENTATION</p> <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Get the connector 6098-5677 (W) with assy parts and insert into jig using right hand and release the lock using left hand.</p>		n/a	1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector.
5	Offline Wire insertion to Connector 6098-3802 (W)	 <p>VISUAL REFERENCE</p> <p>CONNECTOR ORIENTATION</p> <p>TERMINAL ORIENTATION</p> <p>1. Get the Pink wire then insert to terminal slot ① using right hand.</p> <p>2. After insertion, press the lock using left hand thumb then hold the wires and gently pull-out the connector from jig using right hand.</p>			1. No wrong use of connector 2. No damaged connector 3. No wrong insert 4. One by one insertion 5. No deformed terminal 6. No wrong terminal Orientation Important reminders/Note/s: 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 2. Please hold the wire near terminal during insertion. Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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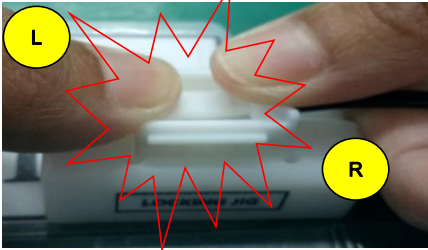
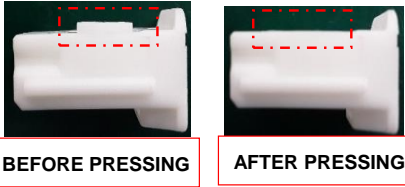
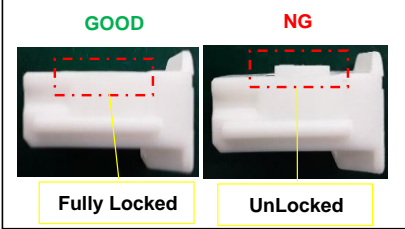
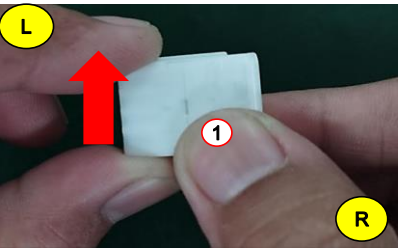
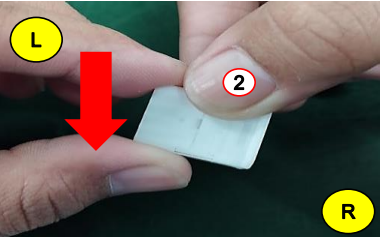

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PARTS:	1. Assy parts			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	Offline Connector Lock	<div></div> <div></div> <div></div> <div></div> <div></div> <div>1. Put the connector into locking jig using right hand then press 2x to lock. Touch the connector lock to confirm if properly pressed.</div> <div>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</div>		<div></div>	<p>Important reminders/Note/s:</p> <p>1. Manual Locking may caused damaged connector lock.</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-017 for verification of connector lock.</p> <p>1. Use the provided jog per model 2. No unlocked/half-locked connector</p>

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PARTS:		1. Black Corrugated tube Ø5, L=329±3mm 2. Assy parts		3. Black Corrugated tube Ø7, L=423±3mm		JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
7	Offline	Wire insertion to Black Corrugated tube Ø5, L=329±3mm	<div></div>			n/a	1. No wrong usage of parts 2. No deformed terminal
8		Wire insertion to Black Corrugated tube Ø7, L=423±3mm	<div></div>			n/a	1. No wrong usage of parts 2. No deformed terminal

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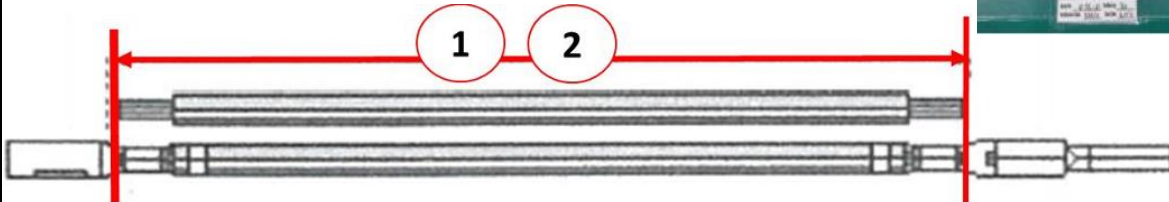
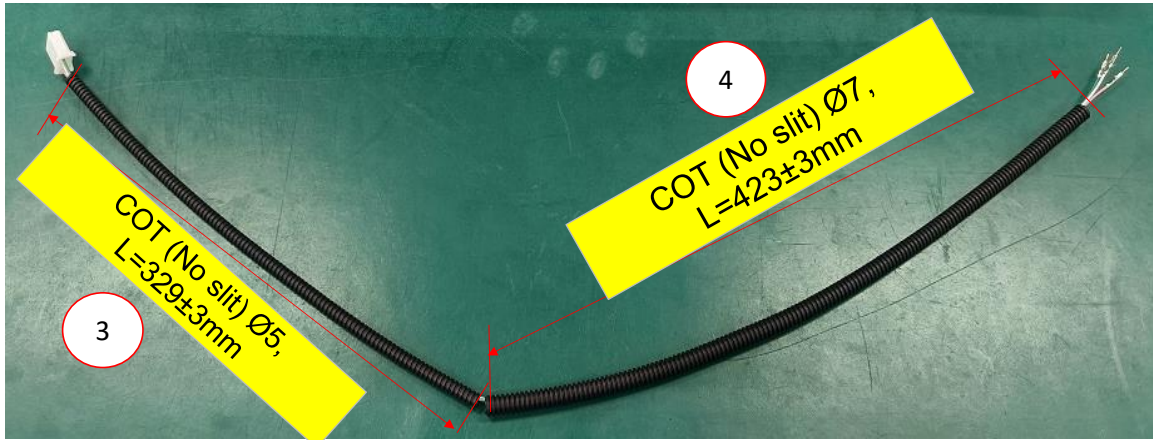

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	Offline Measurement	<p>Note:</p> <ol style="list-style-type: none">1. Measurement point: End of core wire to the end of core wire.2. Terminal is reference only.   			<p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Please use calibrated/verified measuring tape when getting the measurement.2. For Hatsumono, Nakamono and Owarimono. <p>Document reference/s:</p> <ol style="list-style-type: none">1. Refer to WI-PRO-ASY-056 For sub-assy hatsumono, Nakamono and Owarimono. <p>1. No wrong dimension</p>

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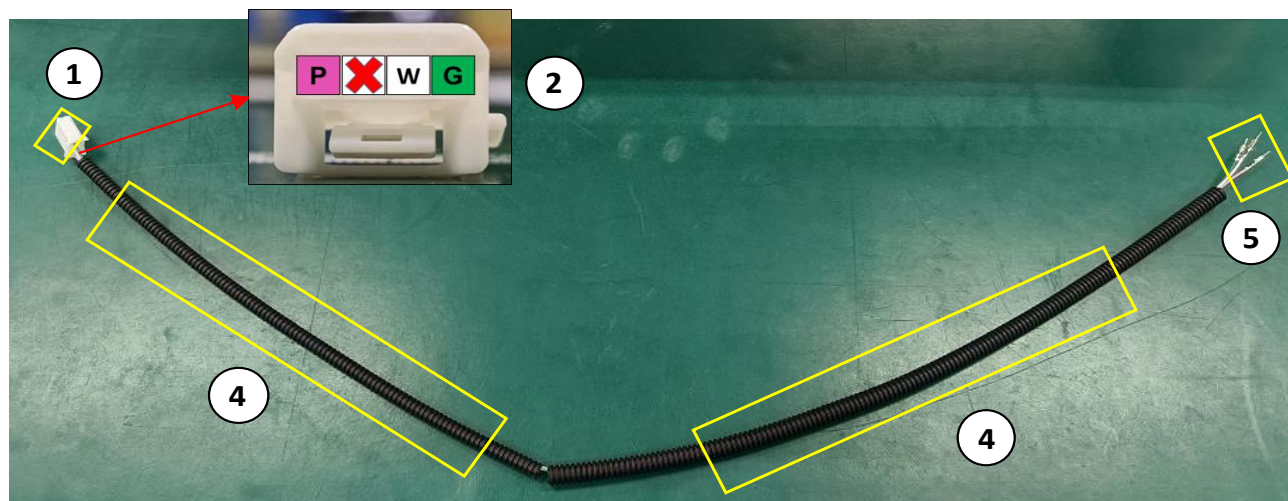
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**OFFLINE INSERTION****7N0237-7020B**

- ① **No Unlocked/Half-locked connector**
- ② **No Wrong Insert**
- ③ **No Terminal Backing Out**
- ④ **No Missing/ wrong used of COT**
- ⑤ **No Deformed Terminal**

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