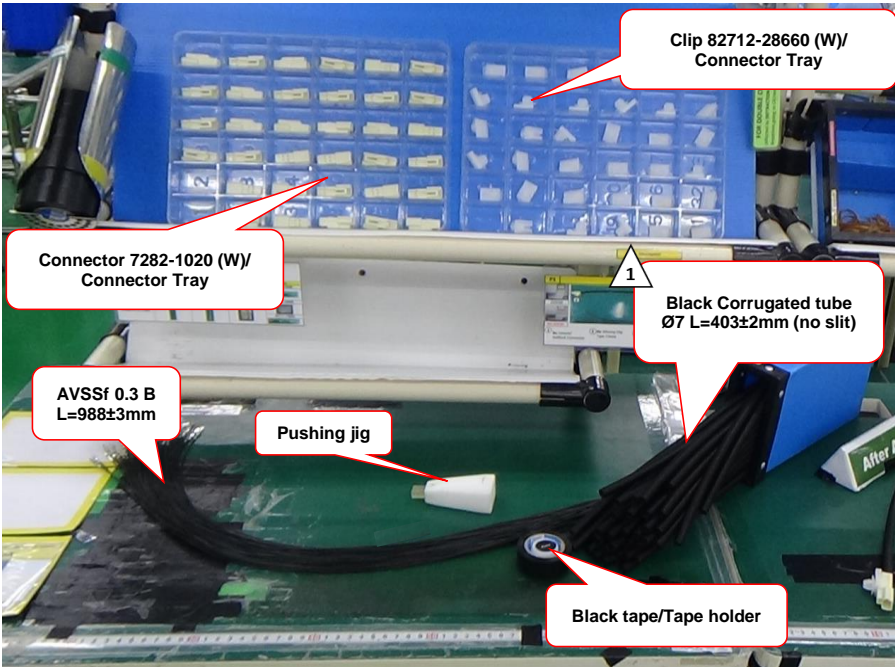

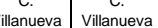

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	Process Name/Title:		Model code/Part number: 468B / 7M0476-7020A		Customer: TRJ		Car Model: TOYOTA HIACE	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.:		WI-ENG-PDE-966	
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PARTS:		1. Connector 7282-1020 (W) 2. AVSSf 0.3 B L=988±3mm		3. Clip 82712-28660 (W) 4. Black corrugated tube (no slit) Ø7 L=403±2mm 5. Black tape	JIG:	1. Pushing jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
1	Offline	Table Lay-out	<div>Table Lay-out</div> 			<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>	Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts

Revision History							Prepared by	Checked	Reviewed by	Approved by
							 D. Castillo	 C. Villanueva	 A. Arañes	
05/02/25	1	Aligned COT tolerance based on Cutting ledger. Improved Visual inspection/Quality pointers.	D. Castillo	-	C. Villanueva	A. Arañes				
10/22/24	0	Initial issue.	D. Castillo	C. Villanueva	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change		Revised	Checked	Reviewed	Approved	Est. Date:	October 22, 2024	

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468B / 7M0476-7020A

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Car Model:

TOYOTA HIACE

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2 of 7**PARTS:****1**

1. Black Corrugated tube Ø7 L=403±2mm (no slit)
2. AVSSf 0.3 B L=988±3mm [2pcs]

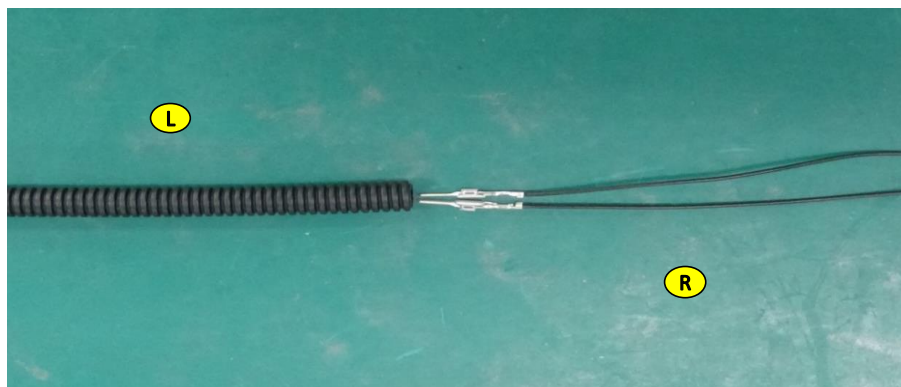
JIG:

n/a

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

2

Offline

1Wire insertion to
corrugated tube
Ø7 L=403±2mm (no slit)

1. Get **Black Corrugated tube Ø7 L=403±2mm (no slit)** using left hand and insert **Black wire AVSSf 0.3 B L=988±3mm** using right hand.


n/a

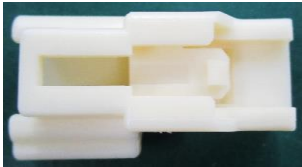

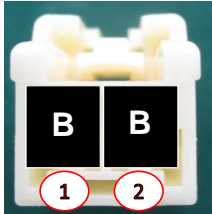
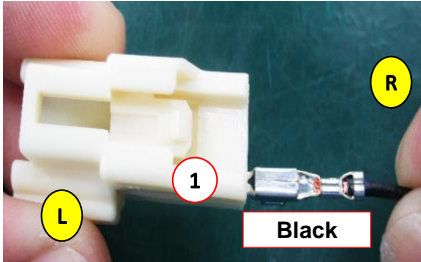
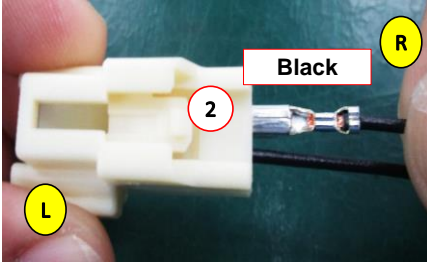
1. No wrong usage of parts
2. No deformed terminal

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	OFFLINE ASSEMBLY PROCESS				Validity Date:	n/a				
	Process Name/Title:		Model code/Part number: 468B / 7M0476-7020A		Customer: TRJ	Car Model: TOYOTA HIACE		Document No.:	WI-ENG-PDE-966	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		1	Page No.:	3 of 7	

PARTS:		1. Connector 7282-1020 (W) 2. Asy parts		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
3	Offline Wire insertion to connector 7282-1020 (W)	<div> CONNECTOR ORIENTATION</div> <div> WIRE FACING</div> <div> VISUAL REFERENCE</div> <div> 1 Black Note: Insertion of wires must be from left to right.</div> <div> 2 Black</div>		n/a	<p>1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing</p> <p>Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>	

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PARTS: 1. Assy parts

JIG:

1. Pushing jig

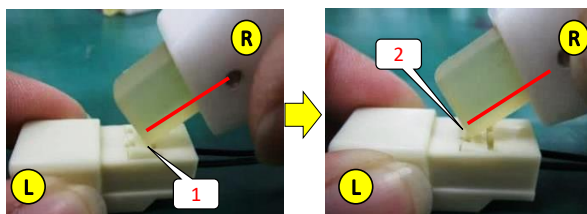
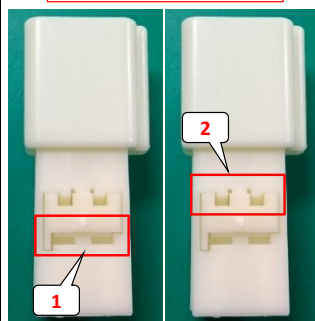
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
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4

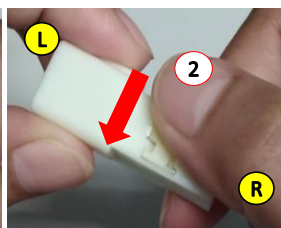
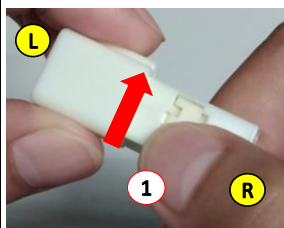
Offline

Connector lock

Pressing sequence

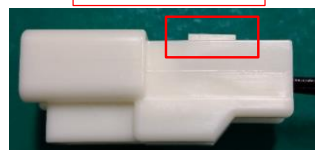


1. Hold the connector using left hand and place on the table. Get the pushing jig using right hand and start the sequential locking based on the above illustration. Push the lower part of the connector lock first and then push the upper part.

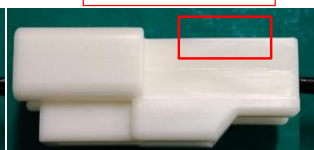


2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.

Before pressing



After pressing

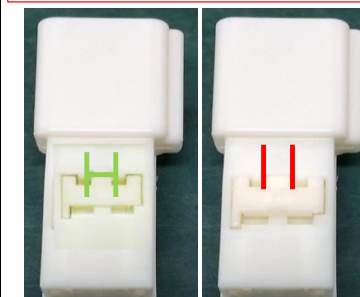


Pushing jig



1. No unlocked/half-locked connector
2. No damage connector

LOCKED CONDITION




GOOD

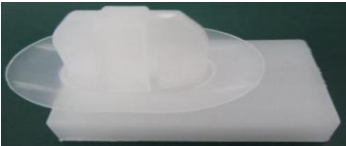
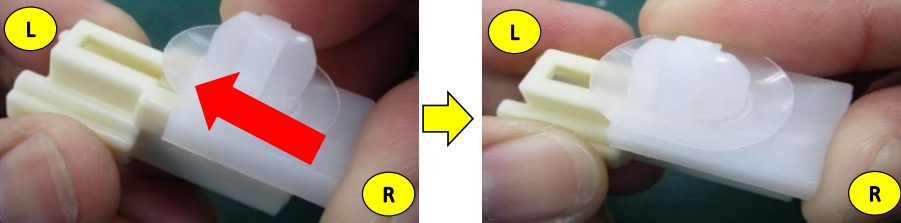
NG

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	WORK INSTRUCTION				Effectivity Date:		May 2, 2025	
	Process Name/Title: OFFLINE ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 468B / 7M0476-7020A		Customer: TRJ	Car Model: TOYOTA HIACE	Document No.:		WI-ENG-PDE-966	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		1	Page No.: 5 of 7

PARTS:		1. Clip Clamp 82712-28660 (W) 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
5	Offline Clip Clamp Attachment 82712-28660 (W)	<div><p>CLAMP ORIENTATION</p><p>1. Hold the connector using left hand, get the clip 82712-28660 (W) then attach to connector using right hand.</p></div>	n/a	1. No damaged clamp 2. No missingclamp	

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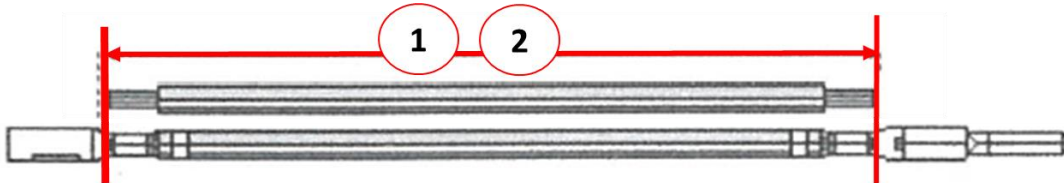

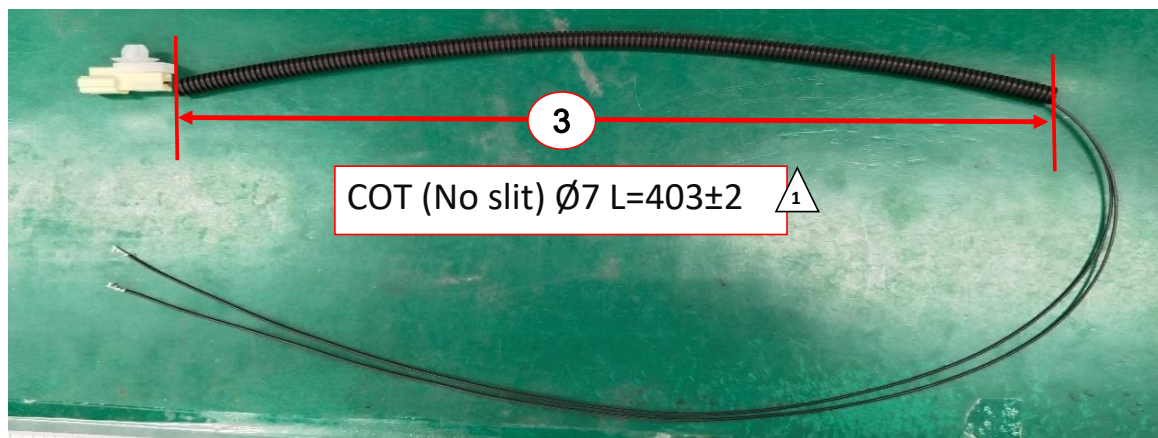
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	Offline	Measurement	<p>Note:</p> <ol style="list-style-type: none">1. Measurement point: End of core wire to the end of core wire2. Terminal is reference only.    <p>COT (No slit) $\varnothing 7$ L=403\pm2 $\triangle 1$</p>	<p>MEASURING TAPE</p>	<p>Important reminders and 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-assembly Hatsumono Nakamono Owarimono Inspection <p>1. No wrong dimension</p>

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468B / 7M0476-7020ACustomer: **TRJ**Car Model: **TOYOTA HIACE**

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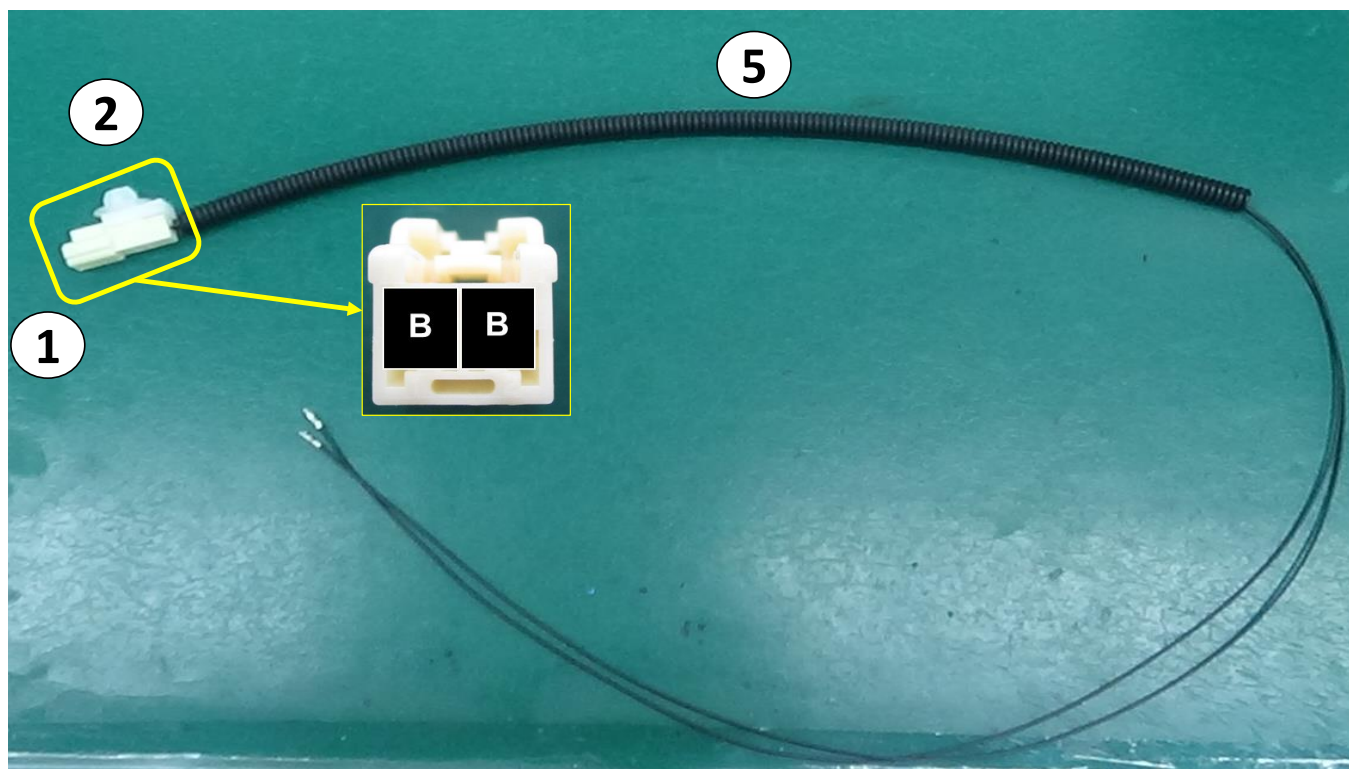
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7M0476-7020A**

- 1** No **Unlock / Halflocked Connector**
- 2** No **Missing Clip Type Clamp**
- 3** No **Terminal Backing Out**
- 4** No **Deformed Terminal**
- 5** No **Missing COT**

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