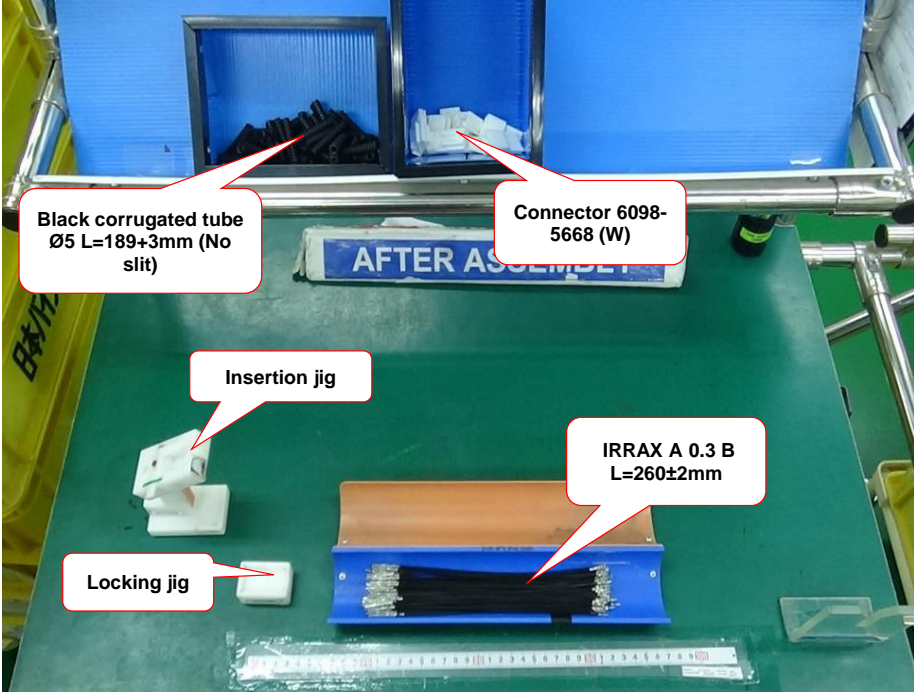



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	Process Name/Title:		Model code/Part number: 310D/ 7N0192-7020		Customer: TRJ		Car Model: TOYOTA-RAV 4		
	Document No.: WI-ENG-PDE-895		Revision No.:		0		Page No.: 1 of 6		
Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO			


PARTS:		1. Connector 6098-5668 (W); IRRAX A ROPE-LAY 0.3 B wires L=260±2mm; Black Corrugated tube Ø5 L=189±3mm (No slit)		JIG:		1. Insertion jig 2. Locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1	Offline Table Lay-out	<div>TABLE LAY-OUT</div> 		<div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>		<div>Document reference/s:</div> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>	




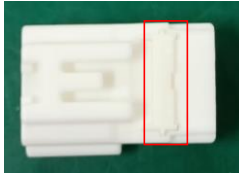
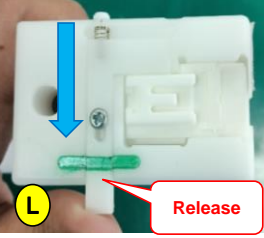
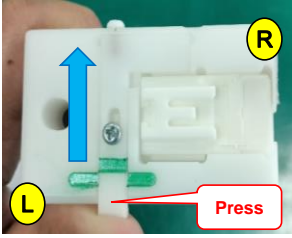
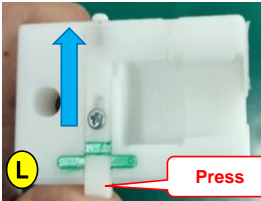



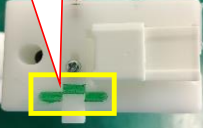



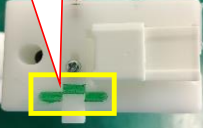

Revision History				Prepared by		Reviewed by		Approved by		Noted by	
											
05/20/24 0 Initial issue.				D.Castillo		C.Villanueva		A.Arañes		n/a	
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted	Est. Date:		May 20, 2024	

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	Process Name/Title:			Document No.:	WI-ENG-PDE-895		
	Model code/Part number: 310D/ 7N0192-7020		Customer: TRJ	Car Model: TOYOTA-RAV 4	Revision No.: 0 Page No.: 2 of 6		
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO							


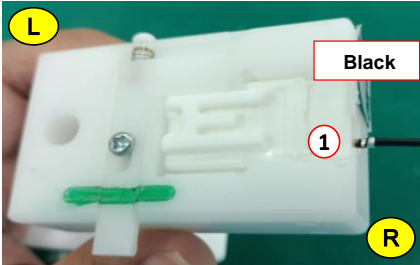
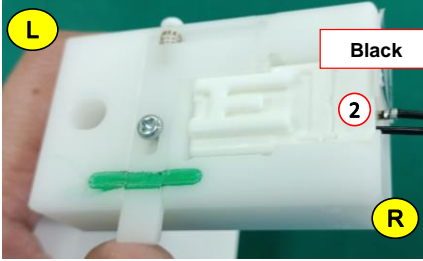

PARTS:		1. Connector 6098-5668 (W)		JIG:	1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS		
2	Offline Connector setting to insertion jig 6098-5668 (W)	<div><div>INSERTION JIG</div><div>Lock</div><div>I-mark</div><div>CONNECTOR ORIENTATION</div><div>INSERTION JIG ORIENTATION</div><div>Press</div><div>Press</div><div>Release</div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6098-5668 (W) into jig using right hand then release the lock.</div><div></div><div>3. Check the holes/terminal slot for B-B wires.</div></div> <div>n/a</div> <td><div>CONNECTOR ORIENTATION ILLUSTRATION</div><div><div>I-mark is align</div><div>1 hole is 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>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div></td>	<div>CONNECTOR ORIENTATION ILLUSTRATION</div> <div><div>I-mark is align</div><div>1 hole is 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>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div>			

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	Process Name/Title:		310D/ 7N0192-7020		Customer:	TRJ	Car Model:	TOYOTA-RAV 4
	Model code/Part number:		310D/ 7N0192-7020		Document No.:	WI-ENG-PDE-895		
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO					Revision No.:	0	Page No.:	3 of 6

PARTS:	1. IRRAX A 0.3 B L=260±2mm [2pcs] 2. Black corrugated tube Ø5 L=189±3mm (No slit)			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Wire Insertion to Black Corrugated tube ø5 L=189±3mm (no slit)	 <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> 1. Get 2pcs IRRAX A ROPE-LAY 0.3 B wire L=260±2mm using right hand and get the Black Corrugated tube ø5 L=189±3mm (no slit) using left hand and insert to wires. </div>		n/a	Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 1. No wrong usage of parts 2. No deformed terminal
4	Offline Wire insertion to connector 6098-5668 (W)	<div style="display: flex; align-items: center;">  <div style="margin: 0 10px; font-size: 2em;">→</div>  </div> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> WIRE FACING </div> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> 1. Get Black wire then insert to terminal slot 1 using right hand. <i>Note: Make sure to hold the COT using right hand while insertion to prevent deformed in 7D0349 Terminal.</i> </div> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> 2. Get Black wire then insert to terminal slot 2 using right hand. </div> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;">  3. After insertion, push the lock button using left thumb then hold the wires and gently pull out the connector from jig using right hand. </div>		n/a	Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance Important reminders/note/s: 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing

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**WORK INSTRUCTION**

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310D/ 7N0192-7020

Customer:

TRJ

Car Model:

TOYOTA-RAV 4

Document No.:

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Purpose:






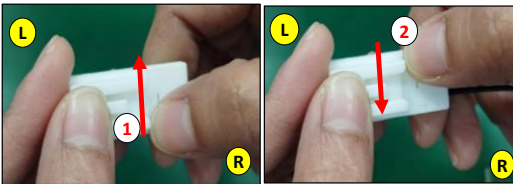



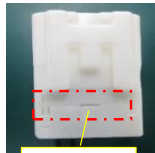
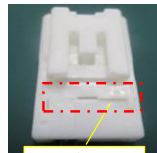
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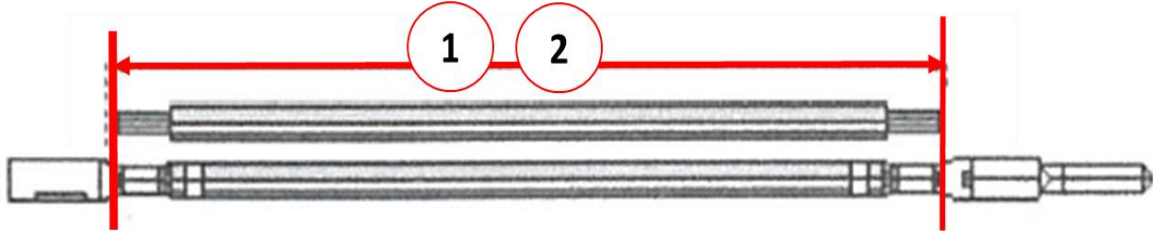

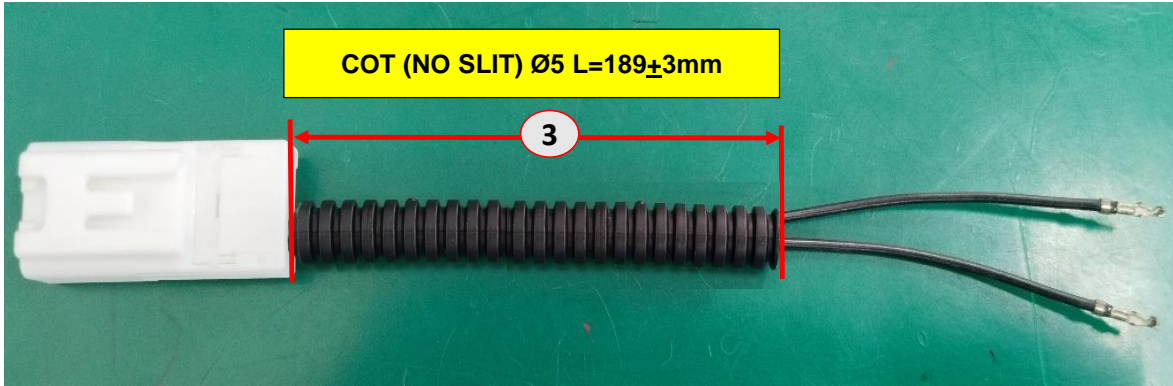
PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Offline Connector Lock	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div> <div><p>2. Press the lower part of connector to fully insert 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>LOCKING JIG</div> 	<p>Important reminders /Note/s; 1. MANUAL LOCKING MAY CAUSED DAMAGED LOCK</p> <p>Document reference/s; 1. Please refer to GL-PRO-ASS-017 for the verification of connector lock.</p> <p>1. Use the provided locking jig per model 2. No unlock/half-locked connector</p> <div><p>Before pressing</p><p>After pressing</p></div> <div><div>GOOD</div><p>Full Lock</p><div>NG</div><p>Half Lock</p></div>

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	Process Name/Title:			Model code/Part number:	310D/ 7N0192-7020	Customer:	TRJ	Car Model:	TOYOTA-RAV 4	Document No.:	WI-ENG-PDE-895	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:		0	Page No.:	5 of 6		

PARTS:	1. Assy parts			JIG:	n/a			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
6	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> <div></div>			<div>Measuring tape</div> <div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection.</div> <div>1. No wrong dimension</div>		

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Car Model:

TOYOTA-RAV 4

Document No.:

WI-ENG-PDE-895

Purpose:

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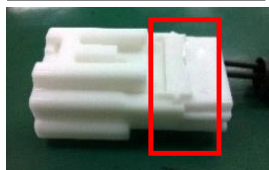
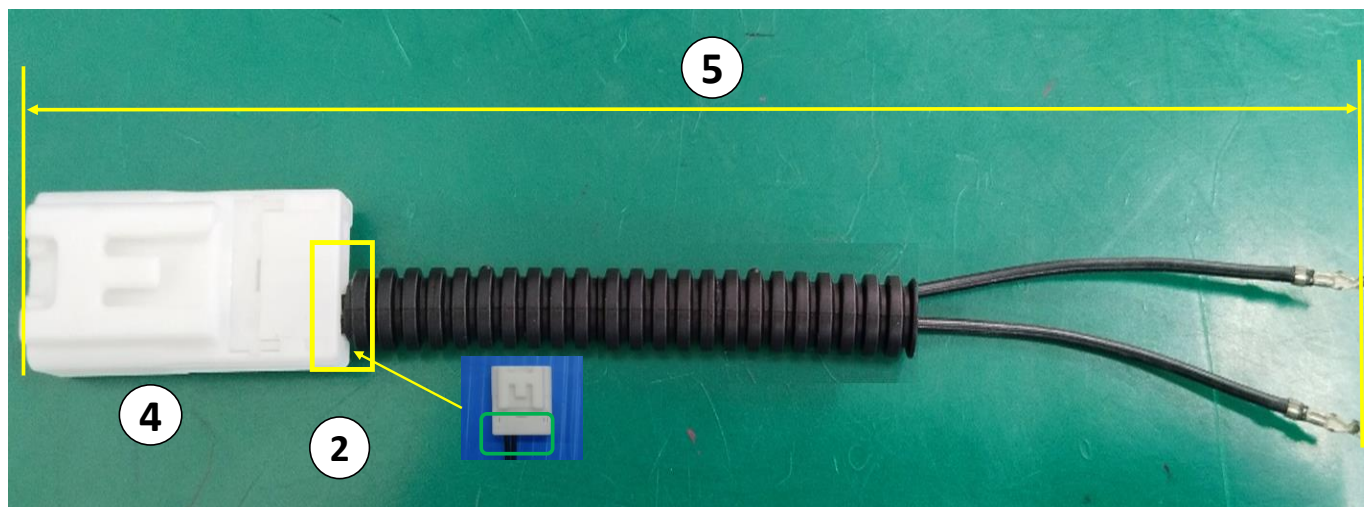
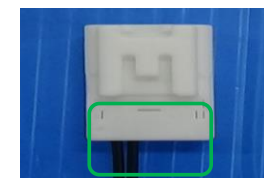
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**OFFLINE INSERTION****7N0192-7020****1****GOOD****NO GOOD****1****No Unlocked/Half-locked connector****2****No Wrong insert****5****4****2****3****No Terminal backing out****4****No Deformed terminal****3****GOOD****NO GOOD****5****Check the Alignment**

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