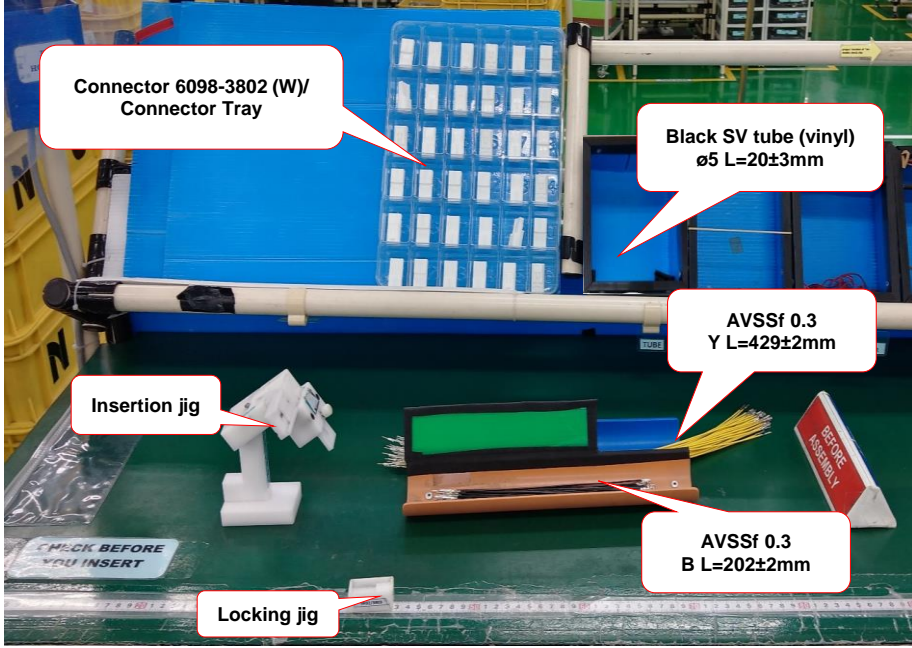



	WORK INSTRUCTION				Effectivity Date:		September 12, 2024	
	OFFLINE ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 310B / 7M0530-7020C		Customer: TRJ		Car Model: TOYOTA RAV4	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.: WI-ENG-PDE-110		Revision No.: 5		Page No.: 1 of 7	

PARTS:		1. Connector 6098-3802 (W); AVSSf 0.3 B L=202±2mm; Y L=429±2mm ;Black SV tube (vinyl) ø5 L=20±3mm		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 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>		1. No missing parts/tools 2. No excess parts/tools	

Revision History				Prepared by		Reviewed by		Approved by		Noted by	
09/12/24	5	Change table lay-out illustration. Additional Black SV tube (Vinyl) in Parts page no. 1. Improve quality pointers in process no. 3. Inclusion of Wire insertion to black SV tube (Vinyl) process, Measurement process and Visual inspection/Quality Checkpoints.		A. Hernandez	C. Villanueva	A. Arañes	n/a	 A. Hernandez	 C. Villanueva	 A. Arañes	n/a
08/16/22	4	Additional table lay-out. Change document title from 'Kitting assembly process' to 'Offline assembly process'. Improve work procedure and illustration in process no.4. Improve quality pointers and notes in process no.1 ; no.2 and no.4.		M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
05/18/21	3	Removal of validity date. Apply some improvements.		M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes				
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted	Est. Date:		July 02, 2018	

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PARTS:		1. Connector 6098-3802 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Offline Connector setting to insertion jig 6098-3802 (W)	<div><div><div>INSERTION JIG</div><div></div><div></div><div>CONNECTOR ORIENTATION</div><div></div><div></div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6098-3802 (W) into jig using right hand and release the lock. <i>Note: Follow the connector orientation.</i></div><div>3. Push the guide using left thumb. The slot for B-wire will be opened.</div></div></div>		n/a	<div>Important reminders and note/s: 1. Please follow the connector orientation.</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> <div><div>Connector Orientation Illustration</div><div><div></div></div></div>

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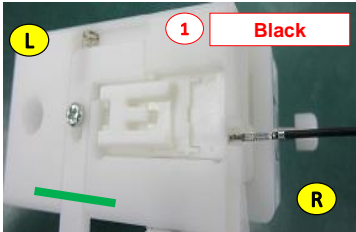
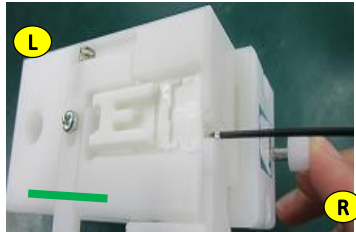





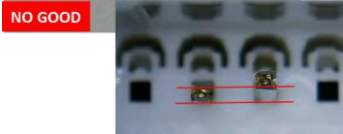
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PARTS:	1. AVSSf 0.3 B L=202±2mm 2. AVSSf 0.3 Y L=429±2mm		3. Connector 6098-3802 (W)	JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Offline	<div><div><p>Terminal facing</p></div><div><p>1. Get the B-wire and insert to terminal slot 1 using right hand.</p></div><div><p>2. After insertion of B-wire press the button using right hand. The slot for Y wire will be opened.</p></div><div><p>3. Get the Y-wire then insert to terminal slot 2 using right hand.</p></div><div><p>4. After insertion, push the lock using left thumb then hold the wire and gently pull out the connector from jig using right hand.</p></div></div>		n/a	<div><div><p>NO DEFORMATION ON TERMINAL</p></div><div><p>GOOD</p></div><div><p>DEFORMED TERMINAL</p></div><div><p>NO GOOD</p></div></div> <p>Important reminders and note/s:</p> <p>1. Please hold the wire near terminal.</p> <p>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.</p> <p>Do not exert extra force.</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</p>

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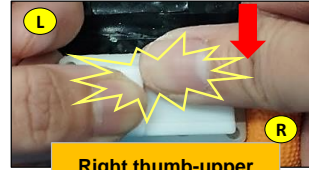
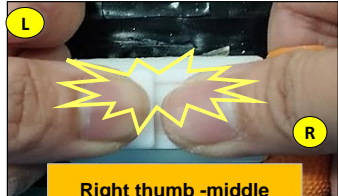
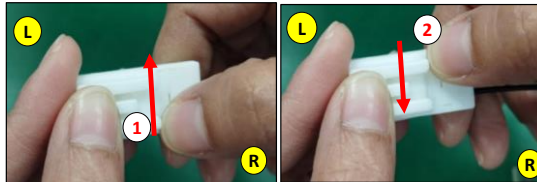


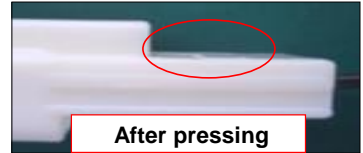

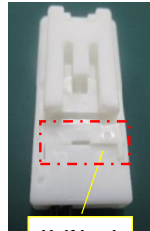
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PARTS:			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Offline Connector Lock	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div> <div><p>2. Press the 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 and note/s:</p> <p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR.</p> <p>1. Use the provided jig tool to lock the connector. 2. No unlock/half-locked connector</p> <div><p>Before pressing</p><p>After pressing</p></div> <div><div>GOOD <p>Full Lock</p></div><div>NG <p>Half Lock</p></div></div>

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PARTS:		1. Assy parts 2. Black SV tube (Vinyl) $\phi 5$ L=20 \pm 3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Offline	<div><div></div><div>1. Get the vinyl tube $\phi 5$ L=20\pm3mm using right hand and insert Y wire using left hand.</div><div></div><div>2. Continue to insert B wire using left hand.</div><div></div></div>		n/a	1. No wrong usage of parts 2. No deformed terminal 3. No missing parts

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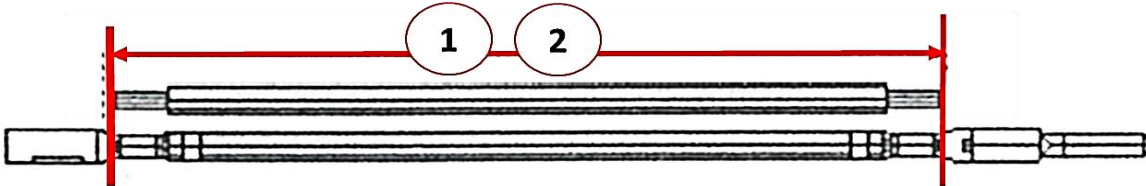

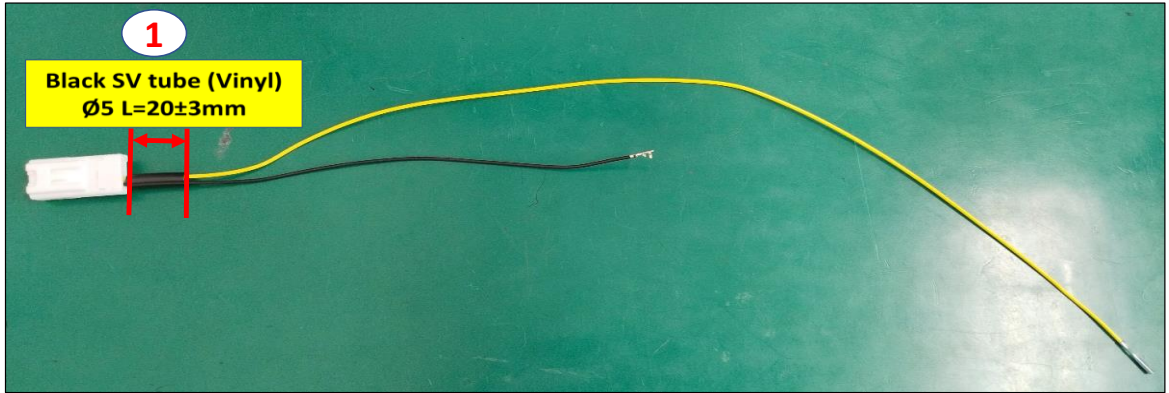
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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	Offline Measurement	<p>Note:</p> <ol style="list-style-type: none">1. Measurement point: End of core wire to the end of core wire2. Terminal is reference only.    <p>Black SV tube (Vinyl) Ø5 L=20±3mm</p>		<p>Measuring tape</p>	<ol style="list-style-type: none">1. No wrong usage of parts2. No deformed terminal <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

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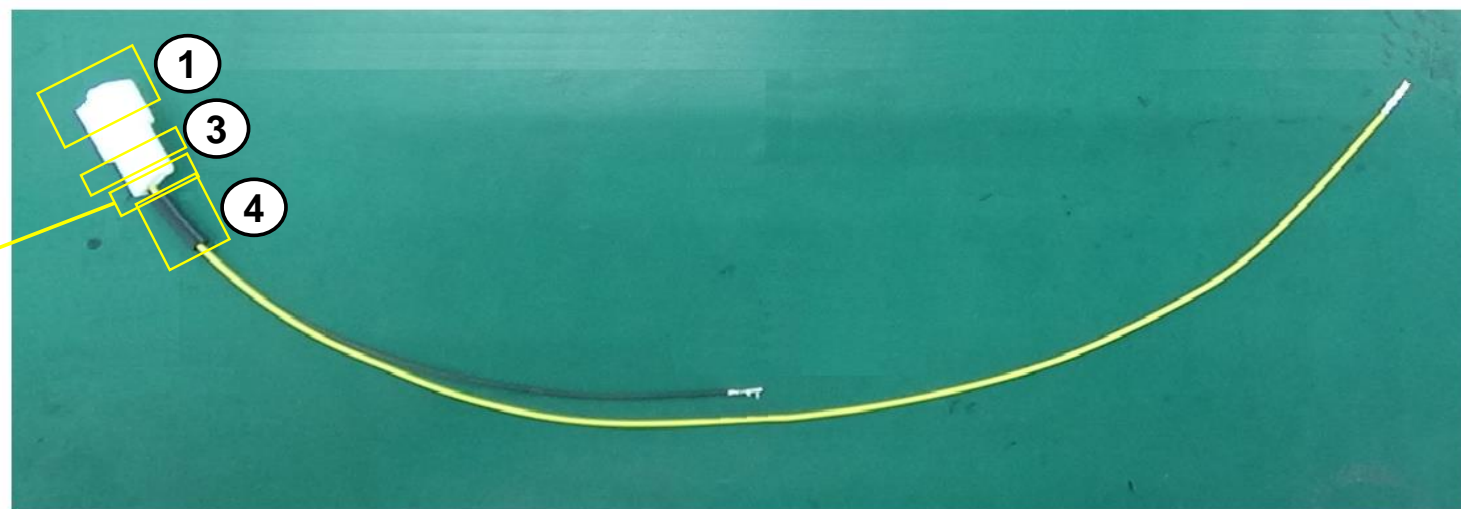
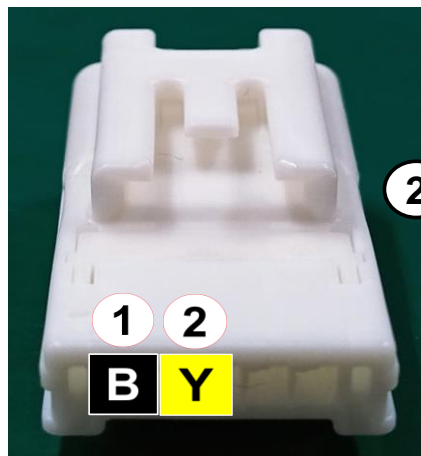
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/QUALITY CHECKPOINT****OFFLINE INSERTION****7M0530-7020C****1 No Deformed Terminal****3 No Unlocked/Halflocked Connector****2 No Wrong Insert****4 No Missing Black SV tube (Vinyl)**

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