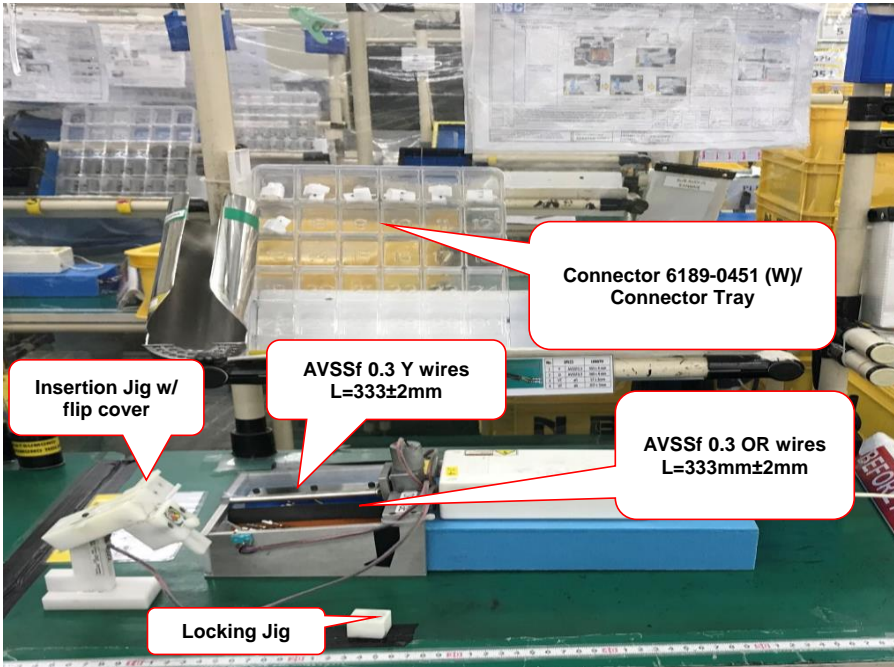



	WORK INSTRUCTION			Effectivity Date:	October 22, 2024			
	OFFLINE ASSEMBLY PROCESS			Validity Date:	n/a			
	Process Name/Title:			Document No.:	WI-ENG-PDE-1129			
	Model code/Part number:	310B / 7M0522-7021B	Customer:	TRJ	Car Model:	TOYOTA-RAV 4		
Purpose:				<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO	Revision No.:	1	Page No.:	1 of 6

PARTS:	1. Connector 6189-0451 (W); AVSSf 0.3 wires Y L=333±2mm; AVSSf 0.3 wires OR L=333±2mm			JIG:	1. Insertion jig w/ switch cover 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	OFFLINE	Table lay-out	<div style="border: 1px solid red; padding: 5px; text-align: center; margin-bottom: 10px;">Table Lay-out</div> 	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> 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 missing parts/tools 2. No excess parts/tools

Revision History						Prepared by	Reviewed by	Approved by	Noted by
10/22/24	1	Change from Pre-launch to Masspro.	A. Hernandez	C. Villanueva	A. Arañes	N/A	 A. Hernandez	 C. Villanueva	 A. Arañes
10/17/24	0	Initial Issue.	A. Hernandez	C. Villanueva	A. Arañes	N/A			
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted			
						Est. Date:	October 17, 2024		

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WORK INSTRUCTION

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☐ PROTOTYPE

☐ PRE-LAUNCH

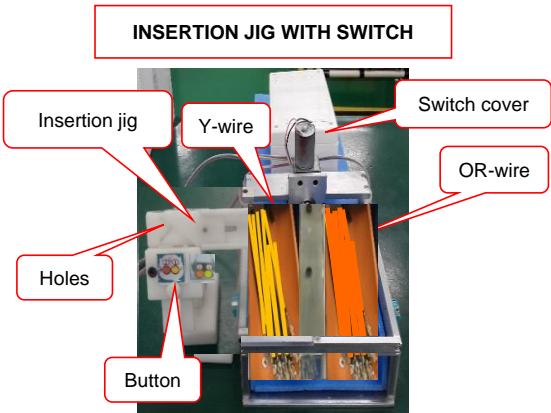
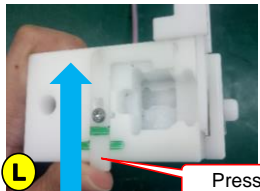
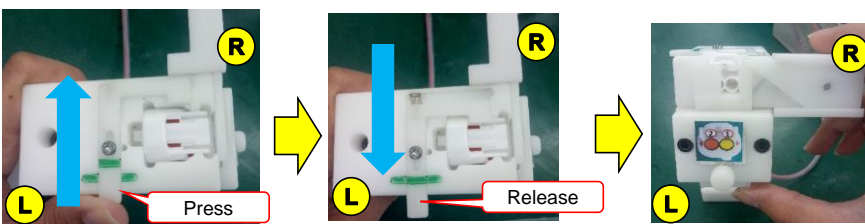
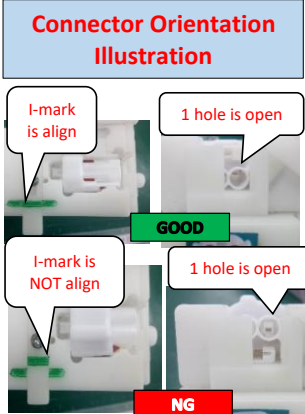
☒ MASSPRO

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PARTS:		1. Connector 6189-0451 (W)		JIG:	1. Insertion jig w/switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	OFFLINE	<div><p>INSERTION JIG WITH SWITCH</p><p>CONNECTOR ORIENTATION</p><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the connector 6189-0451 (W) into jig using right hand and release the lock.</p><p>3. Push the wire guide upward, slot for Yellow wire will be open.</p></div>		N/A	<div><p>Connector Orientation Illustration</p><p>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p></div>

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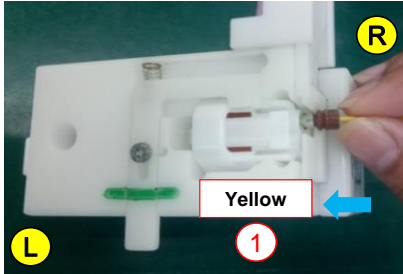
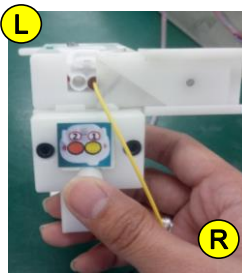
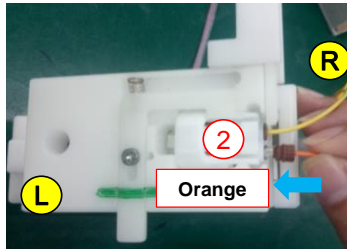
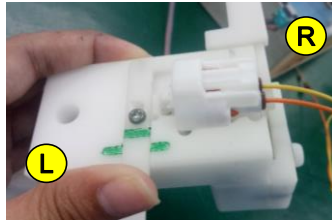
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. AVSSf 0.3 wires Y L=333±2mm 2. AVSSf 0.3 wires OR L=333±2mm		JIG:	1. Insertion jig w/switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	OFFLINE	Wire Insertion to Connector 6189-0451 (W)	<div><p>TERMINAL FACING</p></div> <div><p>1. Hold the insertion jig using left hand, get Yellow wire using right hand and insert to connector.</p></div> <div><p>2. Press the button after insertion. Slot for Orange wire will be open.</p></div> <div><p>3. Hold the insertion jig using left hand, get Orange wire using right hand and insert to connector.</p></div> <div><p>4. Press the insertion jig lock using left hand and slowly remove the harness from jig using right hand.</p></div>	N/A	<p>Important reminders/note/s:</p> <p>1. Insertion of wire must be from left to right.</p> <p>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-CNC-017 for wire and strip length tolerance.</p> <p>2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p>

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WORK INSTRUCTION

OFFLINE ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

310B / 7M0522-7021B

Customer: TRJ

Car Model: TOYOTA-RAV 4

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

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PARTS:

1. Assy part

JIG:

1. Locking

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

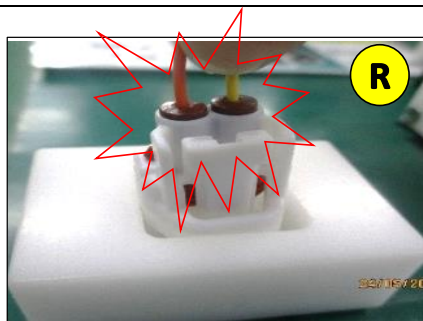
TOOLS/PPE

QUALITY POINTERS

4

OFFLINE

Connector Lock



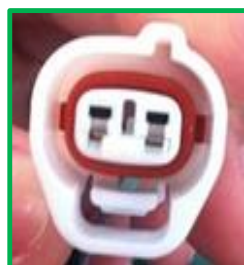
1. Put the connector into locking jig using right hand then press 2x to lock. Touch the connector lock to confirm if properly pressed.



BEFORE PRESSING



AFTER PRESSING



GOOD



NG

2. Check the double lock deformation

LOCKING JIG



1. No Unlock and half-locked
2. Use provided jig tools per model to avoid damaged lock.

Important reminders/Note/s:

1. Manual locking may cause damaged connector

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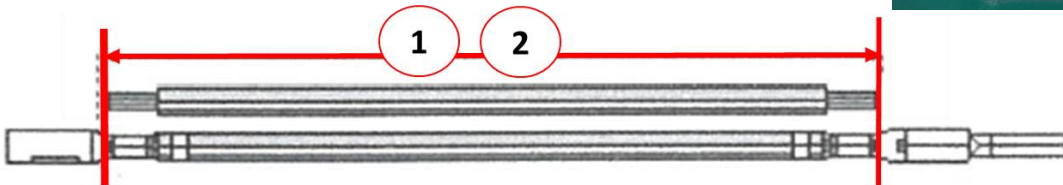

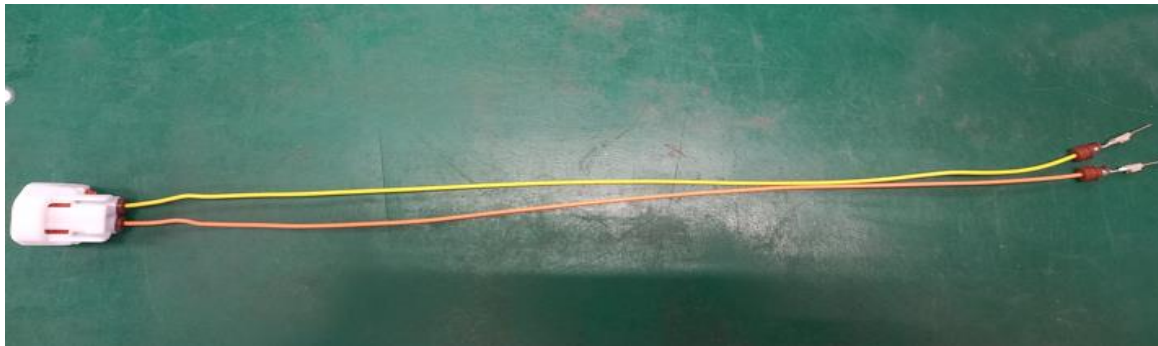
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy part		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	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.   	MEASURING TAPE	<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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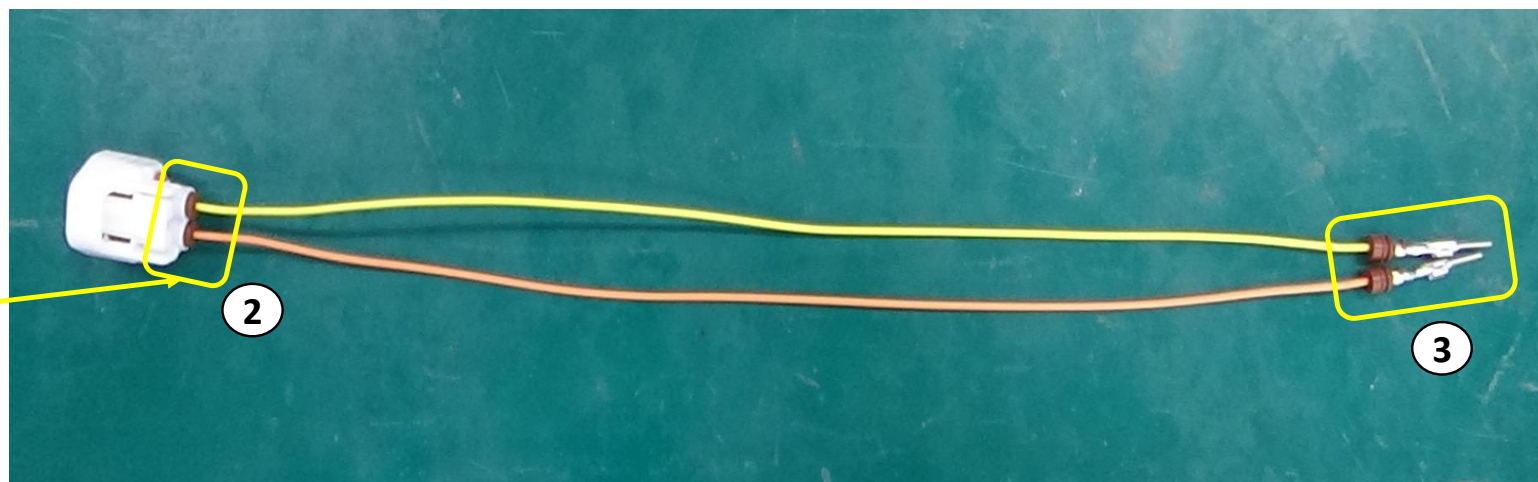
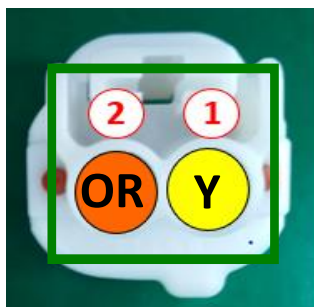
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PARTS:

1. Assy part

JIG:

n/a

VISUAL INSEPTION/ QUALITY CHECKPOINTS**OFFLINE INSERTION****7M0522-7021B****1** No Unlocked/ Half-locked**2** No Wrong Insert**3** No Deformed Terminal**4** No Terminal Backing Out

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