



WORK INSTRUCTION

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

April 23, 2025

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

559D / 7N0238-7020C

Customer: TRJ

Car Model: TOYOTA HI-ACE

Document No.:

WI-ENG-PDE-1254

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Revision No.:

0

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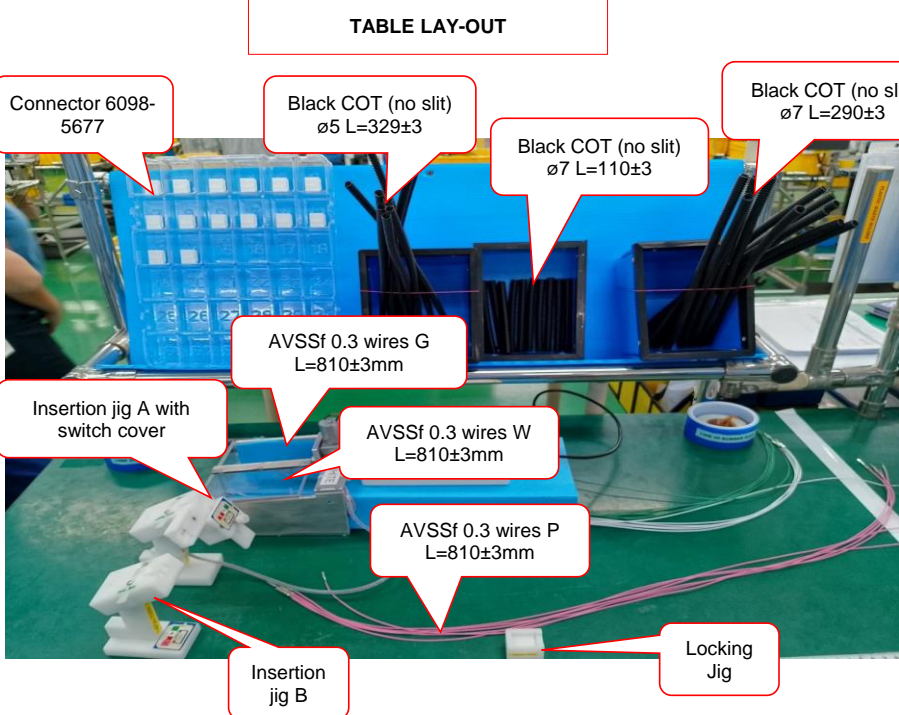
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PARTS:

1, Connector 6098-5677; Black COT (no slit) $\phi 5$ L=329 \pm 3; Black COT (no slit) $\phi 7$ L=110 \pm 3; Black COT (no slit) $\phi 7$ L=290 \pm 3; AVSSf 0.3 wires G L=810 \pm 3mm; AVSSf 0.3 wires W L=810 \pm 3mm ; AVSSf 0.3 wires P L=810 \pm 3mm

JIG:

1. Insertion jig with switch cover
2. Insertion jig
3. Locking Jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	Offline Table-Lay-out	<p>TABLE LAY-OUT</p> 	<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<ol style="list-style-type: none">1. No missing parts/tools2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved	Prepared by	Checked by	Reviewed by	Approved by
04/23/25	0	Initial issue.	A.Hernandez	J.Loterte	C.Villanueva	A.Arañes	A.Hernandez	J.Loterte	C.Villanueva	A.Arañes

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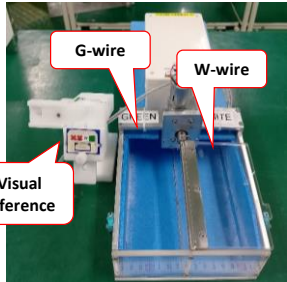
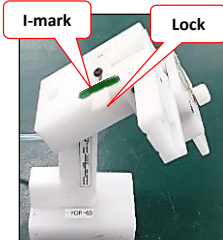
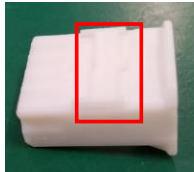
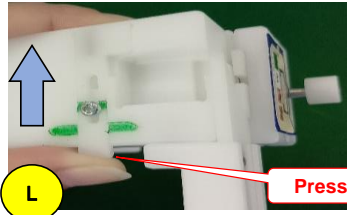
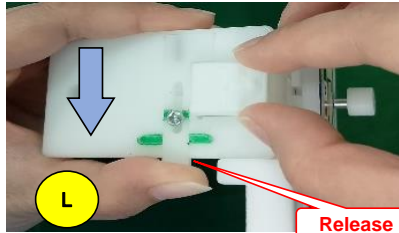

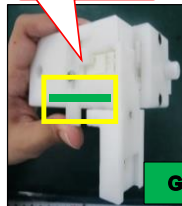
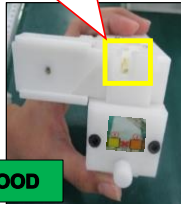
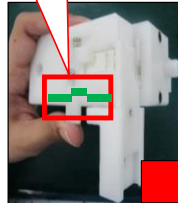

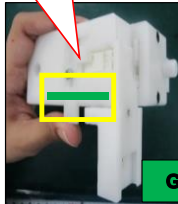
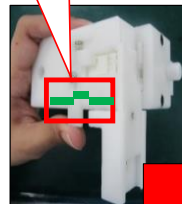
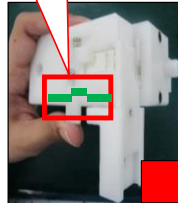

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PARTS:		1. Connector 6098-5677 (W)		JIG:	1. Insertion Jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Offline Connector setting to insertion jig 6098-5677(W)	<div><div>INSERTION JIG ILLUSTRATION</div><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></div><div>2. Insert the connector 6098-5677 (W) into jig using right hand and release the lock. <i>Note: Follow the connector orientation.</i></div><div></div><div>3. Push the guide using left hand. The slot for W wire will be opened.</div></div> <div>n/a</div> <td><div>Connector Orientation Illustration</div><div></div><div>1 hole is open</div><div></div><div>GOOD</div><div></div><div>I-mark is not align</div><div>All holes were open</div><div></div><div>NG</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> <div>1 hole is open</div> <div></div> <div>GOOD</div> <div></div> <div>I-mark is not align</div> <div>All holes were open</div> <div></div> <div>NG</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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TRJ

Car Model:

TOYOTA HI-ACE

Purpose:



PROTOTYPE



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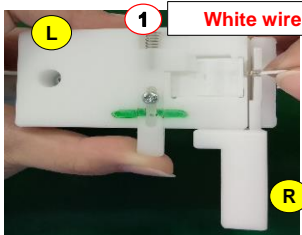
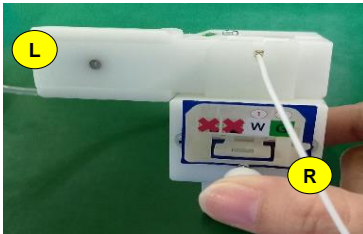
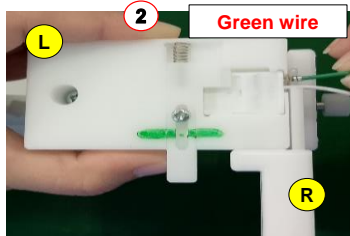
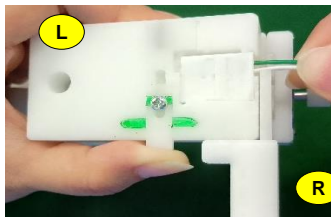
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PARTS:		1. Wire avssf 0.3 W-G L=810mm 2. Connector 6098-5677 (W)		JIG:	1. Insertion Jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Offline Wire insertion to connector 6098-5677(W)	<div><div><p>Visual reference</p></div><div><p>Wire facing</p></div><div><p>1. Hold the insertion jig using left hand. Get the Yellow wire and insert to connector using right hand. Conduct 2x push-pull after wire insertion.</p></div><div><p>2. Press the button using right thumb. Slot for Green wire will be open.</p></div><div><p>3. Get the Green wire and insert to connector using right hand. Conduct 2x push-pull after wire insertion.</p></div><div><p>4. After insertion, push the lock using left thumb and then hold the wires and gently pull-out the connector from jig using right hand.</p></div></div> <td>n/a</td> <td><p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. 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. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p></td>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. 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. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p>

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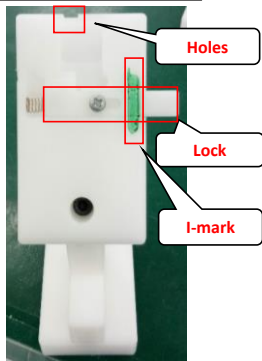




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PARTS:		1. Connector 6098-5677 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Offline Connector Setting to Insertion jig 6098-5677 (W)	<div><div>Insertion Jig</div><div>Insertion Jig Orientation</div><div>Connector Orientation</div><div>GOOD</div><div>NG</div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6098-5677 (W) into jig using right hand and release the lock.</div><div>3. Check the holes/terminal slot for P wire.</div></div>		n/a	<div>Connector Orientation Illustration</div> <div>I-mark is align</div> <div>2 Holes are widely open</div> <div>I-mark is align</div> <div>2 holes are partially open.</div> <div>1. Use provided jig per model</div> <div>2. No wrong usage of parts</div> <div>3. No wrong orientation of connector</div> <div>4. No damaged connector</div>

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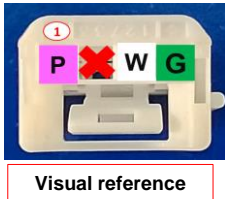

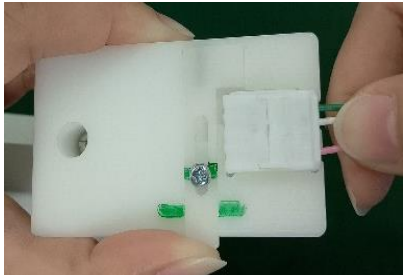
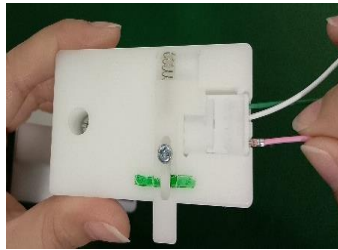
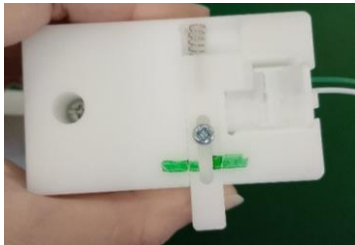
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PARTS:		1. Assy Parts 2. Wire avssf 0.3 P L=810mm		JIG:	1. Insertion Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Offline Wire insertion to connector 6098-5677(W)	<div><p>Visual reference</p><p>Wire facing</p><p>1. Hold the insertion jig using left hand. Get the Pink wire and insert to connector using right hand. Conduct 2x push-pull after wire insertion.</p><p>3. After insertion, push the lock using left thumb and then hold the wires and gently pull-out the connector from jig using right hand.</p></div>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. 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. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p>

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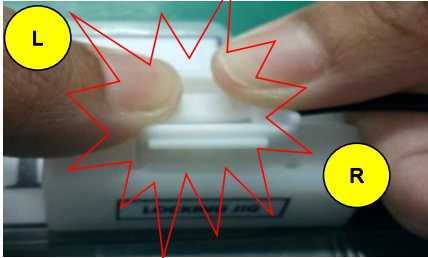
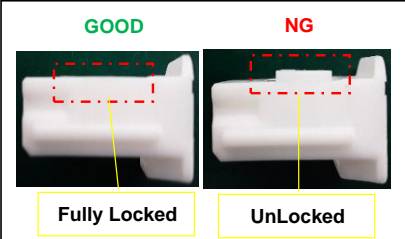
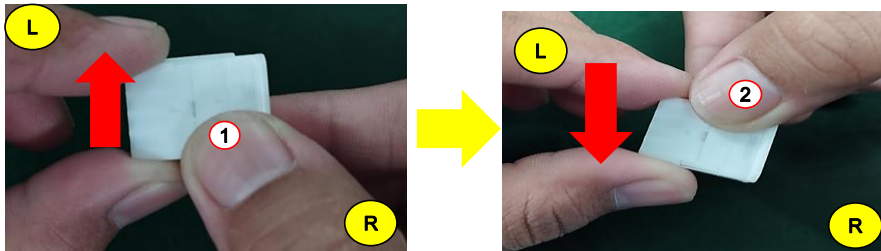
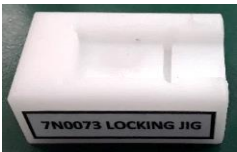
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PARTS:	1. Assy parts			JIG:	1. Locking Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	Offline Connector Lock	<div></div> <div><p>1. Put the connector into locking jig using right hand then press 2x to lock. Touch the connector lock to confirm if properly pressed.</p></div> <div></div> <div></div> <div><p>2. 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:</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. Assy Parts 2. Black Corrugated tube $\varnothing 5$ L=329 \pm 3mm (no slit) 3. Black Corrugated tube $\varnothing 7$ L=110 \pm 3mm (no slit)		4. Black Corrugated tube $\varnothing 7$ L=290 \pm 3mm (no slit)	JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	Offline	Wire Insertion to Black Corrugated tube $\varnothing 5$ L=329 \pm 3mm (no slit)	<div></div> <div>1. Get the P-W-G wire using right hand then insert the Black Corrugated tube $\varnothing 5$ L=329\pm3mm using right hand.</div>		n/a	1. No wrong use of parts 2. No deformed terminal
8		Wire Insertion to Black Corrugated tube $\varnothing 7$ L=110 \pm 3mm (no slit)	<div></div> <div>1. Get the P-W-G wire using right hand then insert the Black Corrugated tube $\varnothing 7$ L=110\pm3mm using right hand.</div>		n/a	1. No wrong use of parts 2. No deformed terminal
9		Wire Insertion to Black Corrugated tube $\varnothing 7$ L=290 \pm 3mm (no slit)	<div></div> <div>1. Get the P-W-G wire using right hand then insert the Black Corrugated tube $\varnothing 7$ L=290\pm3mm using right hand.</div>		n/a	1. No wrong use of parts 2. No deformed terminal

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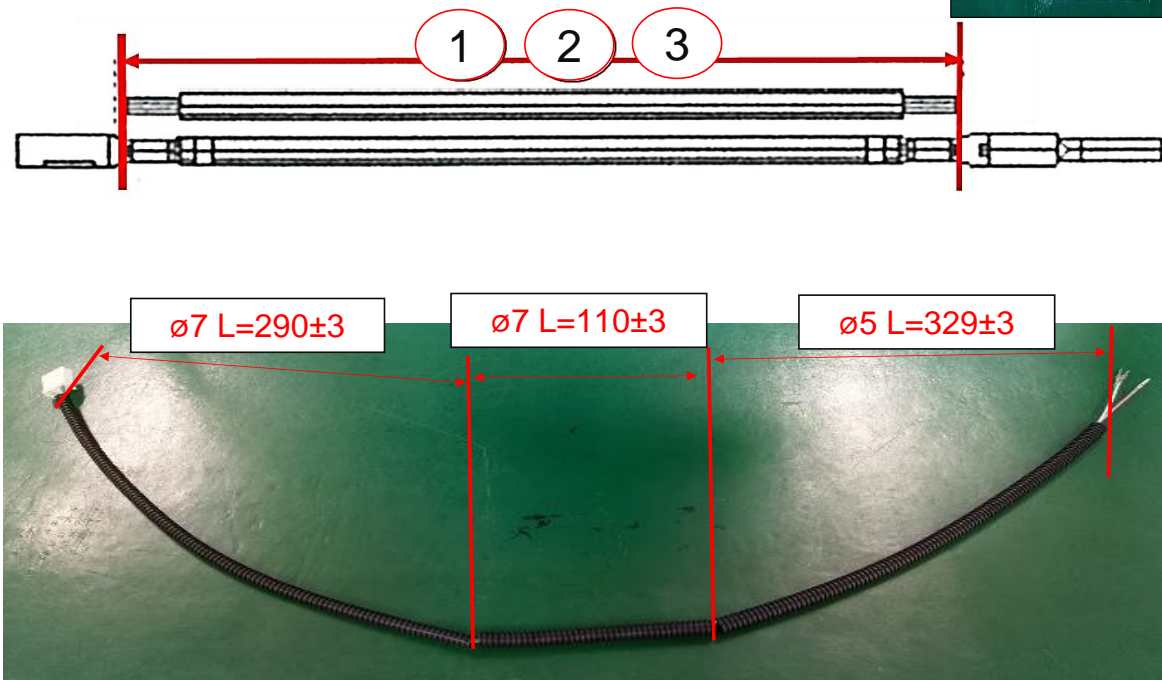

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	Offline Measurement	<p>Note: 1. Measurement point: End of core wire to the end of core wire 2. Terminal is reference only.</p> 		<div>MEASURING TAPE</div> 	<p>1. No wrong dimension</p> <p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p>

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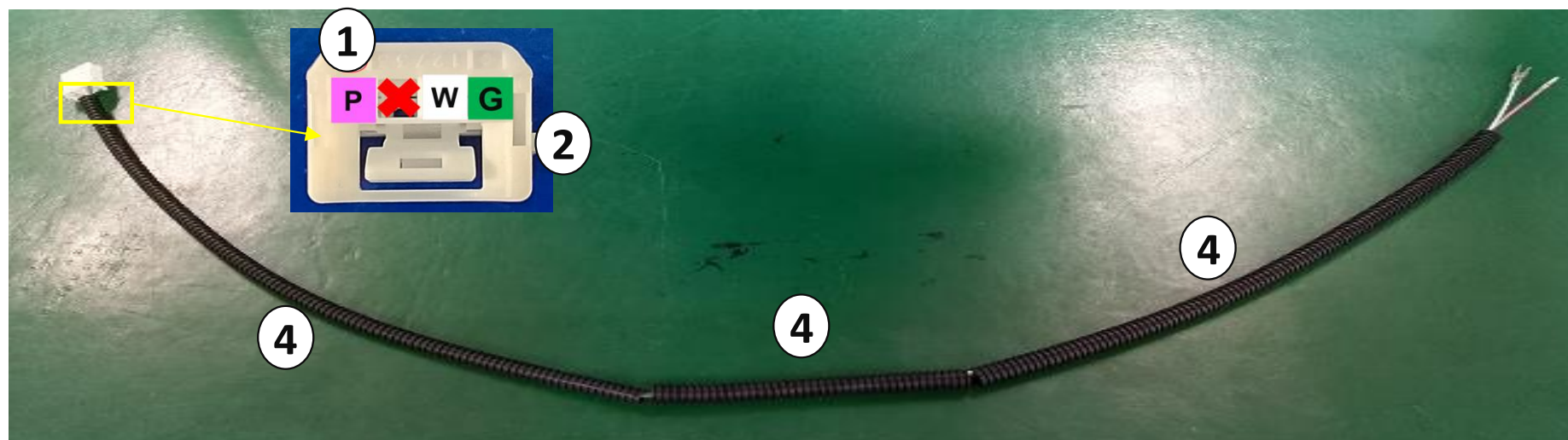
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PARTS:

1. Assy Parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**OFFLINE INSERTION****7N0238-7020C****① No Unlocked/
Half-locked connector****③ No Wrong Used of COT****⑤ No Deformed terminal****② No Wrong Insert****④ No Missing COT****⑥ No Terminal backing
out**

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