



## WORK INSTRUCTION

Process Name/Title:

## OFFLINE ASSEMBLY PROCESS

Effectivity Date:

February 28, 2024

Validity Date:

n/a

Model code/Part number:

310D / 7N0190-7020A

Customer: TRJ

Car Model: TOYOTA RAV4

Document No.:

WI-ENG-PDE-858

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

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## PARTS:

1. Connector 6098-6663(B)
2. AVSSf 0.3 wires Y-OR L=431±2mm
3. Black Corrugated tube ø5 L=360±3mm (no slit)

JIG:

1. Insertion jig with switch cover
2. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

n/a

Table Lay-out

## Table Lay-out

Connector 6098-6663  
(B)AVSSf 0.3 wires Y  
L=431±2mmBlack Corrugated tube ø5  
L=360±3mm (no slit)AVSSf 0.3 wires  
OR L=431±2mm

Insertion jig

Locking jig

## Safety Instruction

Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.).

## Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

## Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. No missing parts/tools
2. No excess parts/tools

## Revision History

Prepared by

Reviewed by

Approved by

Noted by

02/28/24 0 Initial issue

A.Hernandez C.Villanueva A. Arañes n/a

A.Hernandez

C.Villanueva

A. Arañes

n/a

Eff. Date Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

February 28, 2024

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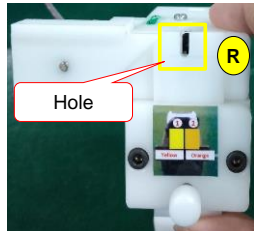
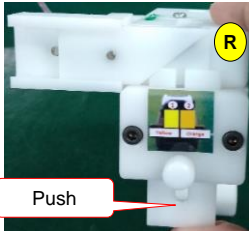
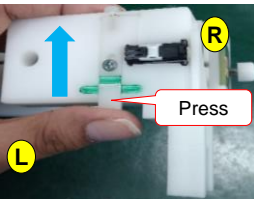
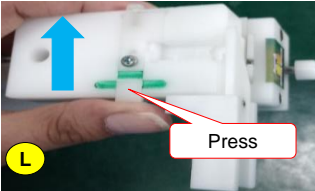
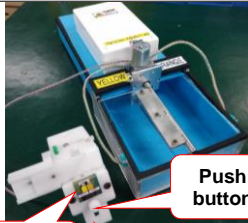
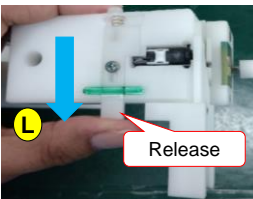

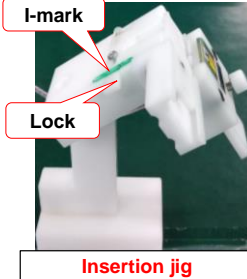

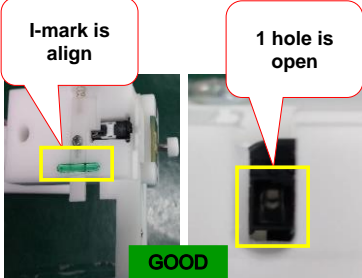

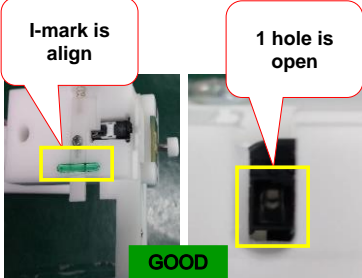
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Connector 6098-6663(B)		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	n/a  Connector setting to insertion jig 6098-6663 (B)	<div><div><b>INSERTION JIG WITH SWITCH</b></div><div></div><div></div><div><p>1. Press the insertion jig lock using left hand.</p><p>2. Get the Connector <b>6098-6663 (B)</b> and insert to insertion jig using right hand. Release the lock after insertion. <b>Note: Follow the connector orientation.</b></p><p>3. Press the lower wire guide using right hand. Slot for <b>Yellow wire</b> will be opened.</p></div></div> <div>n/a</div> <td><div><b>Connector Orientation Illustration</b></div><div></div></td>	<div><b>Connector Orientation Illustration</b></div> <div></div>	

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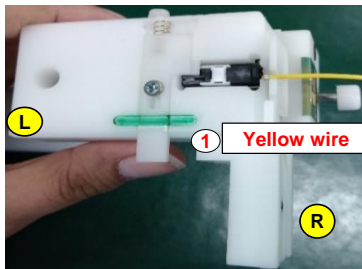
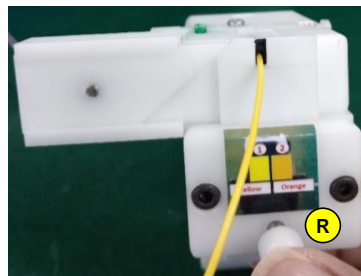
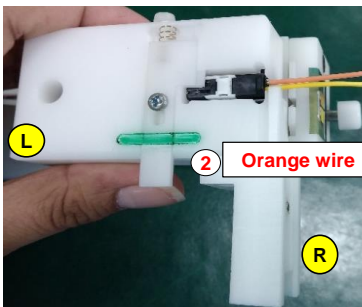
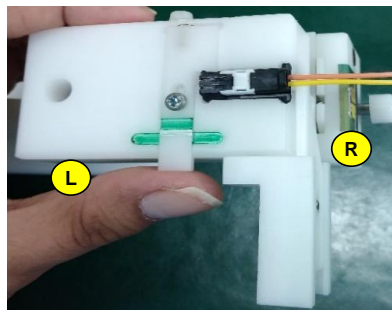
☒ MASSPRO

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PARTS:	1. AVSSf 0.3 wires Y-OR L=431±2mm		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	n/a  Wire insertion to connector 6098-6663 (B)	<div><div>Wire facing</div></div> <div><div>1 Yellow wire</div></div> <div><p>1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot 1 using right hand.</p></div> <div><div>R</div></div> <div><p>2. Press the button using right thumb. The slot for Orange wire will be opened.</p></div> <div><div>2 Orange wire</div></div> <div><p>3. Get the Orange wire then insert to terminal slot 2 using right hand.</p></div> <div><div>L</div></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>	n/a	<div><div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing.</div><div><b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal.</b> <b>2. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b></div><div><b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b></div></div>

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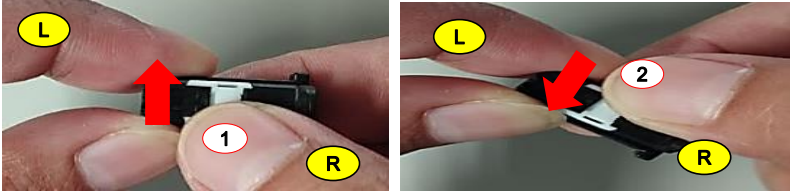




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PARTS:	1. Assy parts			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Connector lock  n/a	<div><p>1. Put the connector into locking jig using right hand then press to lock <b>2x</b> using both hands.</p></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><p>BEFORE PRESSING</p><p>AFTER PRESSING</p></div>		<div><p>LOCKING JIG</p></div>	<p><b>Important reminders/Note/s:</b></p> <p><b>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b></p> <p>1. Use the provided jig per connector 2. No unlock/half-locked connector</p>
5	Wire insertion to Black corrugated tube ø5 L=360±3mm (no slit)	 <p>1. Get the Black Corrugated tube <b>ø5 L=360±3mm (no slit)</b> using right hand then insert the <b>Y-OR wires</b> using left hand.</p>			<p>1. No wrong use of parts 2. No deformed terminal</p>

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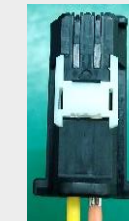
PARTS:

n/a

JIG:

**QUALITY CHECKPOINTS**

n/a

**7N0190-7020A****GOOD****GOOD****NO GOOD****NO GOOD****GOOD****NO GOOD**

- ① No **Unlock/Halflock Connector**
- ② No **Wrong Insert**
- ③ No **Terminal Backing Out**
- ④ No **Deformed Terminal**

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