



WORK INSTRUCTION1

Effectivity Date:

June 11, 2024

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

320B / 7L0057-7022

Customer: TRQSS

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-287

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

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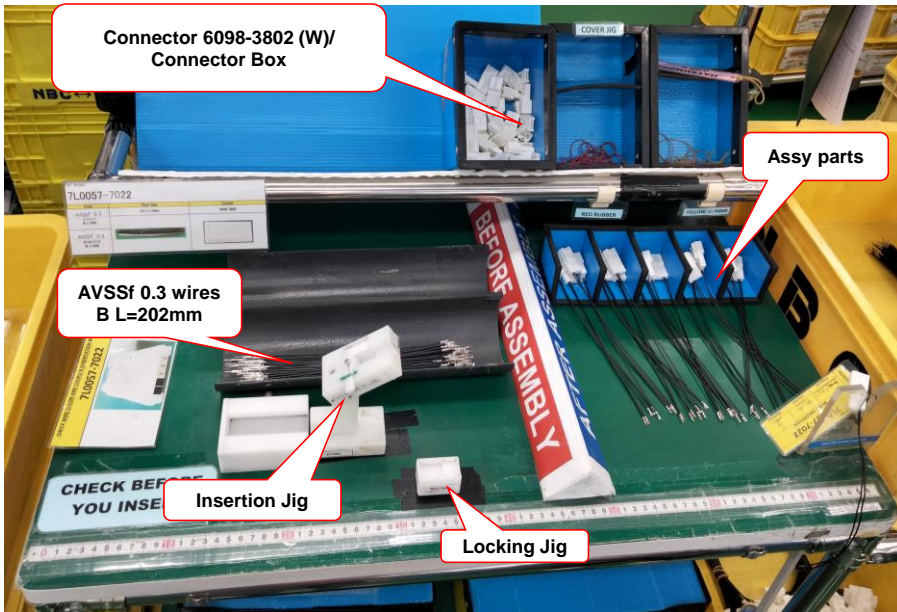
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PARTS:

1. Connector 6098-3802 (W) / Connector Box;

JIG:

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


Revision History

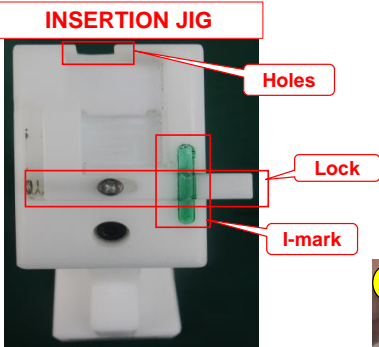
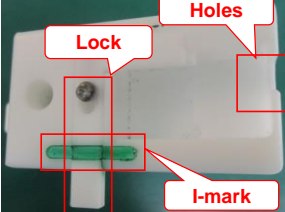
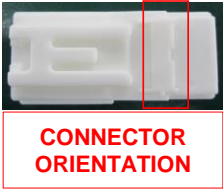
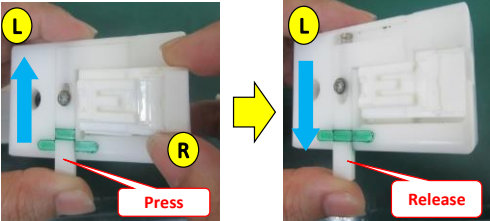
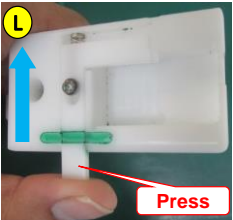
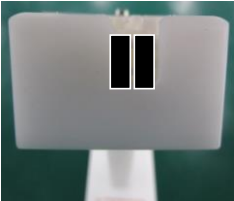
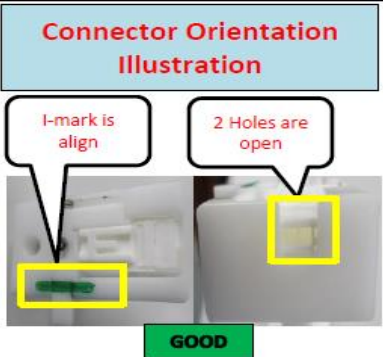

								Prepared by	Reviewed by	Approved by	Noted by
06/11/24	1	Inclusion of car model "TOYOTA-RAV 4" and all improvements (Table lay-out; important reminders and note/s; Document references; Measurement; Visual inspection/Quality checkpoints). Improve work procedure/illustration on process 1 connector lock and change assembly process name from kitting assembly to offline assembly.	D.Castillo	C. Villanueva	A. Arañes	n/a					
06/15/21	0	Exclude from production work instruction (WI-PRO-ASY-147). Initial issue	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes					
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	June 15, 2021			

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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><div></div><div></div><div></div><div></div><div><div>1. Press the lock of insertion jig using left thumb.</div></div><div><div>2. Insert the connector 6098-3802 (W) into jig using right hand and release the lock using left hand. Note: Follow the connector orientation.</div></div><div><div>3. Check the holes/terminal slot for B-B wires.</div></div></div>		n/a	<div><div></div><div></div><div><div>1. Use the provided jig per model</div><div>2. No wrong orientation of connector</div><div>3. No wrong use of connector</div><div>4. No damaged connector</div></div></div>	

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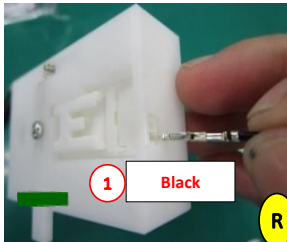
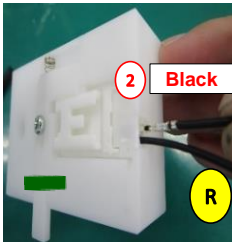
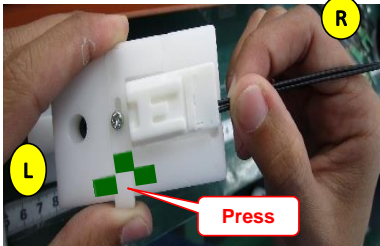
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PARTS:		1. AVSSf 0.3 wires B L=202mm [2pcs.]		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Offline	<div><div>WIRE FACING</div></div> <div><div>1 Black R</div></div> <div><div>2 Black R</div></div> <div><div>L R Press</div></div> <div>1. Get the 1st B wire then insert to connector using right hand.</div> <div>2. Get the 2nd B wire then insert to connector using right hand.</div> <div>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.</div>		n/a	<p>Important reminders and note/s;</p> <p>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 2. Insertion of wire must be from left to right.</p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</p>

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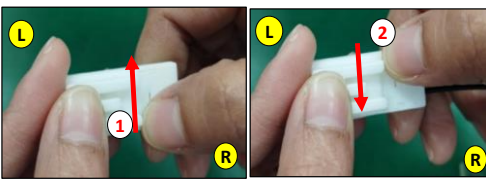


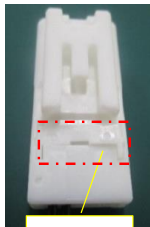


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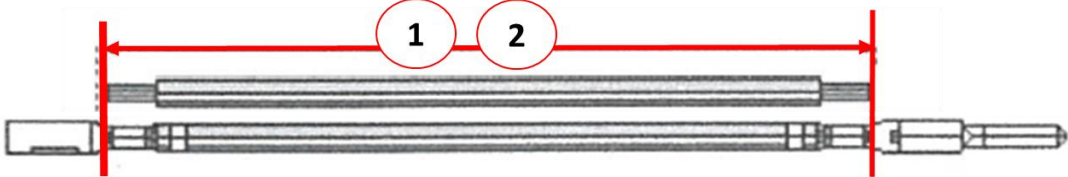


PARTS:	1.Assy Parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Offline Connector lock	<div><div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div><div><p>2. Press the lower part of connector to fully insert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

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	5 of 6

PARTS:	1.Assy Parts			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
5	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>MEASURING TAPE</div> <div></div>	<div>Important reminders and note/s:</div> <div>1.Please use calibrated /verified measuring tape when getting the measurement.</div> <div>2. For Hatsumono,Nakamono and Owarimono.</div> <div>Document reference/s:</div> <div>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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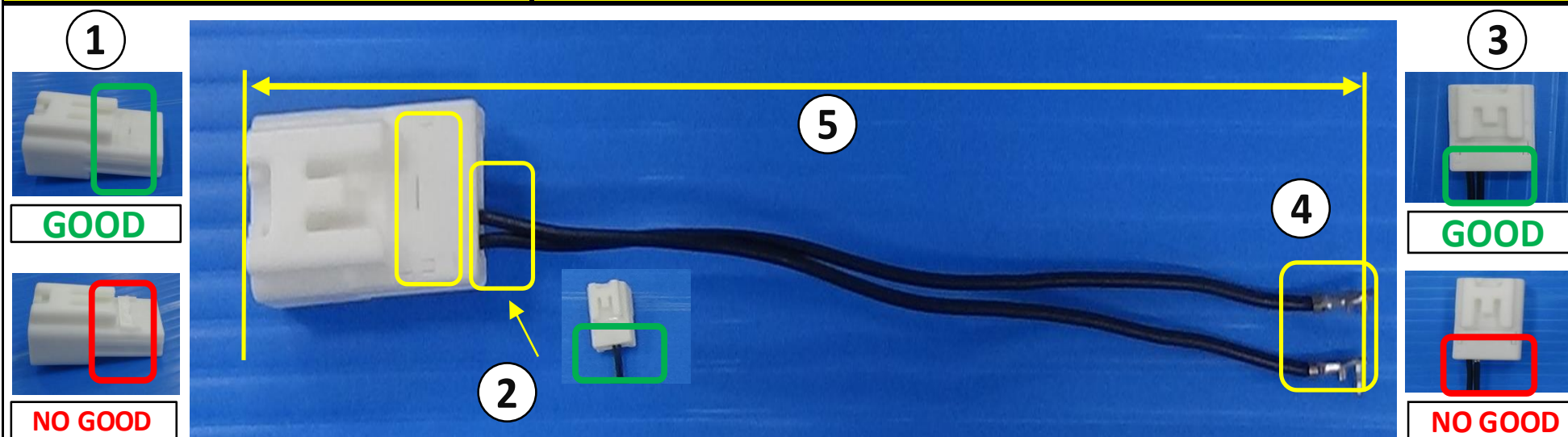
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION****OFFLINE INSERTION****7L0057-7022****1 No Unlock connector****3 No Terminal Backing Out****2 No Wrong insert****4 No Deform terminal****5 Check the Alignment**

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