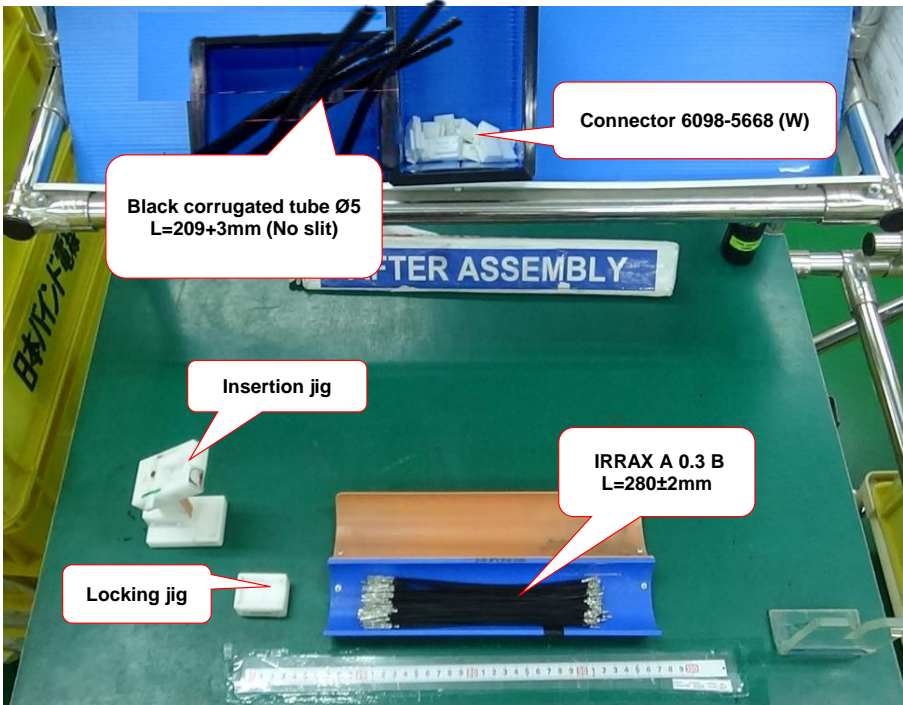
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	Process Name/Title: OFFLINE ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 310D / 7N0247-7020		Customer: TRJ	Car Model: TOYOTA-RAV 4	Document No.: WI-ENG-PDE-1246		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	1 of 6

PARTS:	1. Black Corrugated tube ø5 L=209±3mm (No slit) 2. IRRAX A ROPE-LAY 0.3 B wires L=280±2mm [2pcs.]	3. Connector 6098-5668 (W)	JIG:	1. Insertion jig 2. Locking jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	OFFLINE Table Lay-out	<div>TABLE LAY-OUT</div> 	<div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<div>Document reference/s:</div> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>




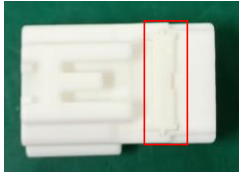
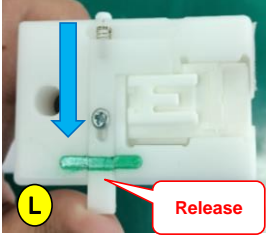
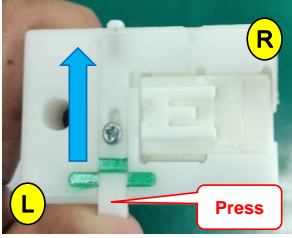
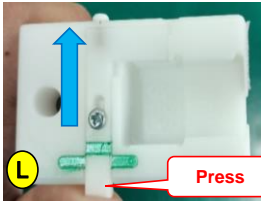

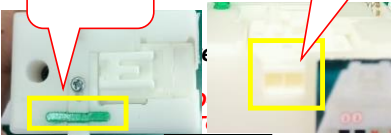
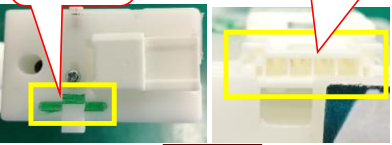
Revision History						Prepared by	Checked by	Reviewed by	Approved by
04/11/25	0	Initial issue.		D.Castillo	J. Loterte	C. Villanueva	A. Arañes		
Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved	Est. Date:	April 11, 2025	

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	Model code/Part number: <b>310D / 7N0247-7020</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-RAV 4</b>	Document No.: <b>WI-ENG-PDE-1246</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	2 of 6


<b>PARTS:</b>		1. Connector 6098-5668 (W)		JIG:	1. Insertion jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
2	OFFLINE Connector setting to insertion jig 6098-5668 (W)	<div><div><b>INSERTION JIG</b></div><div><b>CONNECTOR ORIENTATION</b></div><div><b>INSERTION JIG ORIENTATION</b></div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector <b>6098-5668 (W)</b> into jig using right hand then release the lock.</div><div><div>3. Check the holes/terminal slot for <b>B-B wires.</b></div></div></div> <div><div><b>GOOD</b></div><div><b>NG</b></div></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>	n/a			

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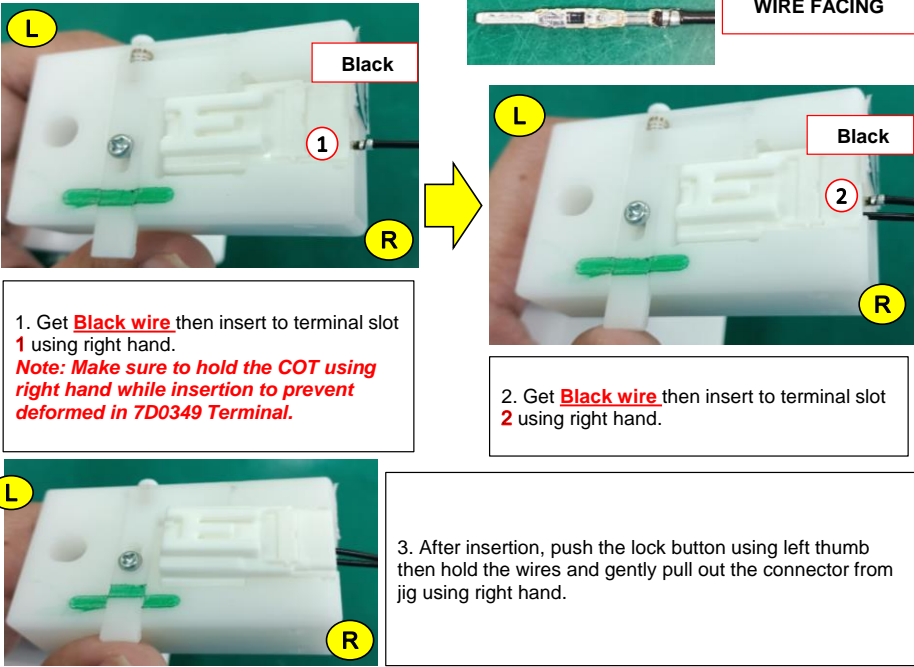
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	Process Name/Title:		Model code/Part number: <b>310D / 7N0247-7020</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-RAV 4</b>	Document No.:	<b>WI-ENG-PDE-1246</b>			
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:	0	Page No.:

<b>PARTS:</b>		1. Black Corrugated tube $\phi 5$ L=209 $\pm$ 3mm (No slit) 2. IRRAX A ROPE-LAY 0.3 B wires L=280 $\pm$ 2mm [2pcs.]				JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>				<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
3	Wire Insertion to Black Corrugated tube $\phi 5$ L=209 $\pm$ 3mm (no slit)	<div>  <div>           1. Get 2pcs <b>IRRAX A ROPE-LAY 0.3 B wire L=280<math>\pm</math>2mm</b> using right hand and get the Black Corrugated tube <math>\phi 5</math> L=209<math>\pm</math>3mm (no slit) using left hand and insert to wires.         </div> </div>				n/a	<b>Document reference/s:</b> 1. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length Tolerance  1. No wrong usage of parts 2. No deformed terminal
4	Wire insertion to connector 6098-5668 (W)	<div>  <div> <b>WIRE FACING</b> </div> <div>           1. Get <b>Black wire</b> then insert to terminal slot <b>1</b> using right hand.  <b>Note: Make sure to hold the COT using right hand while insertion to prevent deformed in 7D0349 Terminal.</b> </div> <div>           2. Get <b>Black wire</b> then insert to terminal slot <b>2</b> using right hand.         </div> <div>           3. After insertion, push the lock button using left thumb then hold the wires and gently pull out the connector from jig using right hand.         </div> </div>				n/a	<b>Document reference/s:</b> 1. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length Tolerance  <b>Important reminders/note/s:</b> 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.  1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing

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**WORK INSTRUCTION**

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**TOYOTA-RAV 4**

Document No.:

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Purpose:



PROTOTYPE



PRE-LAUNCH







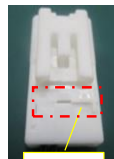
MASSPRO

Revision No.:

0

Page No.:

4 of 6

PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	OFFLINE	Connector lock		<div>LOCKING JIG</div> <div></div>	<div>1. No Unlock and half-locked 2. Use provided jig tools per model to avoid damaged lock.</div> <div><b>Important reminders/note/s:</b> <b>1. MANUAL LOCKING MAY CAUSED DAMAGED LOCK</b> <b>2. Use provided jig tool per model to avoid damaged lock.</b></div> <div><div><div><div>Before pressing</div></div><div><div>After pressing</div></div></div><div><div><div><div>Full Lock</div></div><div><div>Half Lock</div></div></div></div></div>

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PRE-LAUNCH



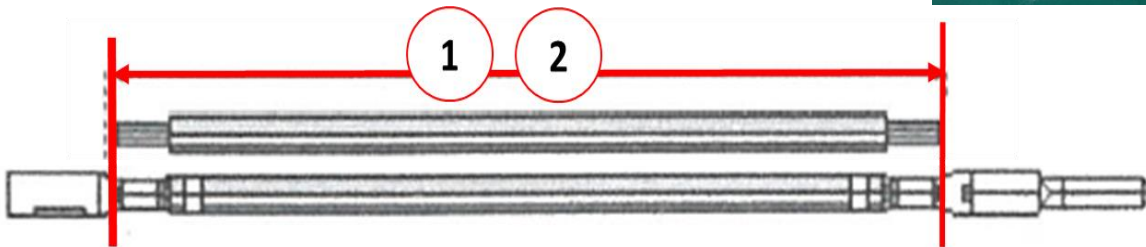


MASSPRO

Revision No.:

0

Page No.:

5 of 6

<b>PARTS:</b>		1. Assy parts	JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
6	OFFLINE	<p>Measurement</p> <p>Note: 1. Measurement point: End of core wire to the end of core wire 2. Terminal is reference only.</p>   <p><b>COT (NO SLIT) Ø5 L=209±3mm</b></p> 		<p><b>Important reminders and note/s:</b></p> <p><i>1. Please use calibrated /verified measuring tape when getting the measurement.</i></p> <p><i>2. For Hatsumono, Nakamono and Owarimono.</i></p> <p><b>Document reference/s:</b></p> <p><i>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection.</i></p> <p>1.No wrong dimension</p>

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Document No.:

**WI-ENG-PDE-1246**

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

0

Page No.:

6 of 6

**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7N0247-7020****① No Unlocked/Half-locked connector****② No Wrong Insert****③ No Terminal Backing Out****④ No Missing COT****⑤ No Deformed Terminal**

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