



WORK INSTRUCTION

Process Name/Title: OFFLINE ASSEMBLY PROCESS

Effectivity Date:

June 3, 2024

Validity Date:

n/a

Model code/Part number: 700B / 7N0039-7020B Customer: TRJ Car Model: TOYOTA-LAND CRUISER

Document No.:

WI-ENG-PDE-882

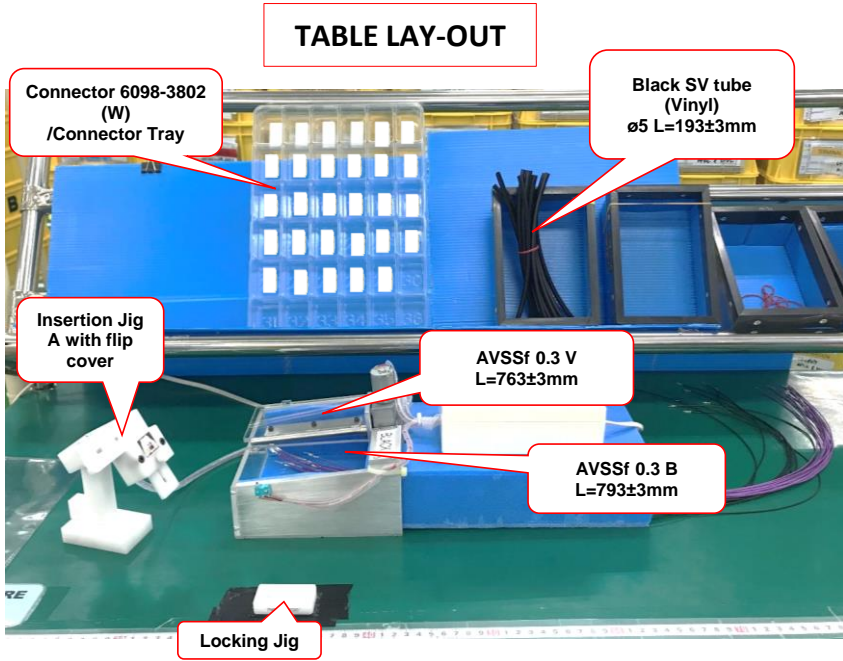
Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Connector 6098-3802 (W); AVSSf 0.3 B-V wire L=763±3mm				JIG:	1. Insertion jig with switch cover 2. Locking jig							
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS						
1	n/a	<div>TABLE LAY-OUT</div> 				<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	<div>1. No missing parts/tools 2. No excess parts/tools</div> <div>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div>						
Revision History										Prepared by	Reviewed by	Approved by	Noted by
06/03/24	1	Change pre-launch to mass pro.				A.Hernandez	C. Villanueva	A. Arañes	n/a	A.Hernandez	C. Villanueva	A.Arañes	n/a
05/09/24	0	Initial issue.				A.Hernandez	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	May 09, 2024		

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PARTS:	1. Connector 6098-3802 (W)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	n/a Connector setting to insertion jig 6098-3802 (W)	<div><div>INSERTION JIG WITH SWITCH COVER</div><div><div><div>Visual references</div><div>V-wire</div><div>Switch cover</div><div>B-wire</div><div>Insertion jig</div><div>Button</div></div><div><div>Connector Orientation</div></div></div><div><div><div><div>L</div><div>↑</div><div>Press</div></div><div>1. Press the lock of insertion jig using left thumb.</div></div><div><div><div>L</div><div>↑</div><div>R</div></div><div>2. Insert the connector 6098-3802 into jig using right hand and release the lock.</div></div><div><div><div>R</div><div>↓</div><div>Release</div></div><div>3. Push the guide using right hand. The slot for Black wire will be opened.</div></div></div><div><div><div>Guide</div></div><div><div>Hole</div></div></div></div> <td>n/a</td> <td><div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</div><div>CONNECTOR ILLUSTRATION</div><div><div>GOOD</div><div>6098-3802 (W)</div></div><div><div>NG</div><div>6098-5668 (W)</div></div></td>	n/a	<div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</div> <div>CONNECTOR ILLUSTRATION</div> <div><div>GOOD</div><div>6098-3802 (W)</div></div> <div><div>NG</div><div>6098-5668 (W)</div></div>

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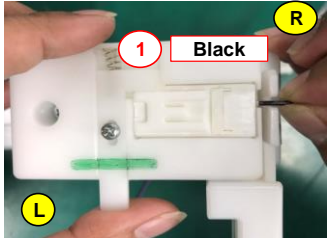
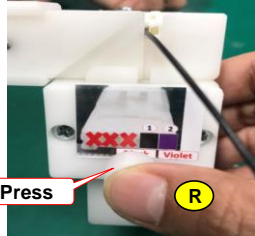
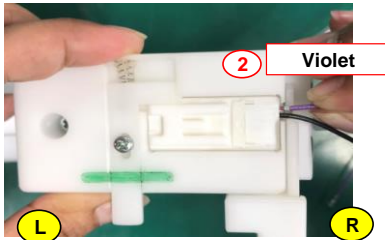
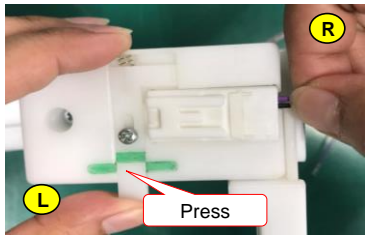
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PARTS:	1. AVSSf 0.3 B-V wire L=763±3mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	n/a Wire insertion to insertion jig 6098-3802 (W)	<div><p>Wire facing</p></div> <div><p>1. Get the Violet wire then insert to terminal slot ① using right hand.</p></div> <div><p>Press</p><p>2. After insertion of Violet wire press the button using right hand. The slot for Black wire will be opened.</p></div> <div><p>2 Violet</p><p>3. Get the Black wire then insert to terminal slot ② using right hand.</p></div> <div><p>Press</p><p>4. After insertion, press 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 deformed 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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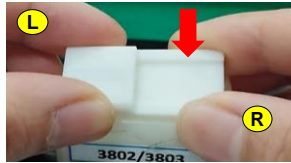



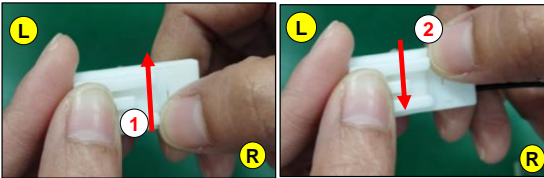





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PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	n/a	Connector lock		
<div><div><div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div><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></div><div><p>Right thumb-upper Left thumb-middle</p></div><div><p>Right thumb-middle Left thumb-middle</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></div><div><div><p>Before pressing</p></div><div><p>After pressing</p></div><div><div><p>GOOD Full Lock</p></div><div><p>NG Half Lock</p></div></div><p>Important reminders/Note/s: 1. Manual locking may cause damaged connector lock</p><p>1. Use the provided jig tool to lock the connector. 2. No unlock/half-locked connector</p></div></div>				

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PARTS:		1. Assy parts 2. Black SV tube (Vinyl) ø5 L=193±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	n/a	<div><div><div></div><div>Get Black SV tube (Vinyl) ø5 L=193±3mm using right hand then insert Black and Violet wire using left hand.</div></div><div></div></div>		n/a	1. No wrong use of parts 2. No deformed terminal

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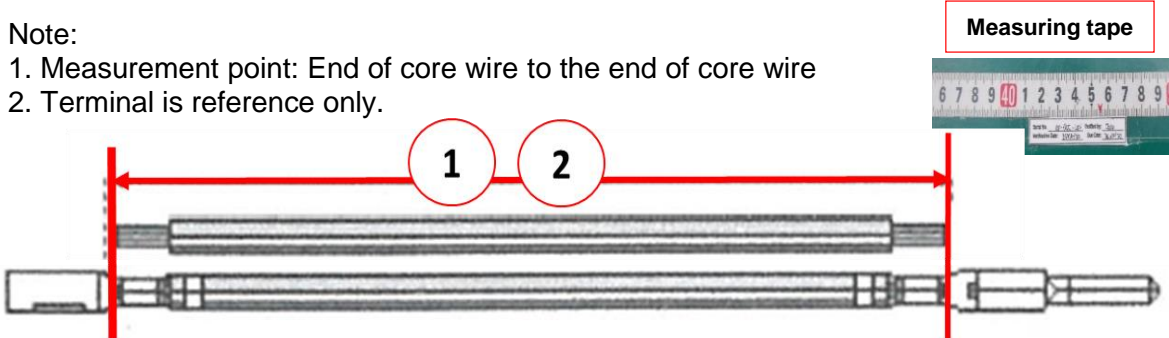
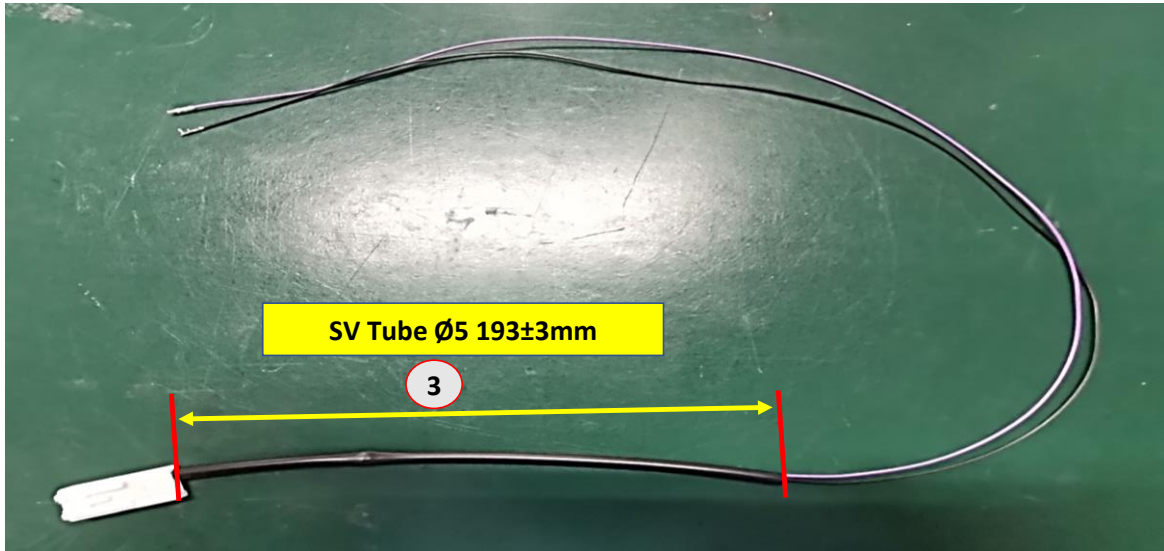

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PARTS:		n/a		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	n/a	Measurement	<p>Note:</p> <ol style="list-style-type: none">Measurement point: End of core wire to the end of core wireTerminal is reference only.  	<p>Measuring tape</p> 	<p>Important reminders and note/s:</p> <ol style="list-style-type: none">Please use calibrated/verified measuring tape when getting the measurement.For Hatsumono, Nakamono and Owarimono. <p>Document reference/s:</p> <ol style="list-style-type: none">Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection. <p>1. No wrong dimension</p>

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PARTS: n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS

OFFLINE INSERTION

7N0039-7020B

1



GOOD

2



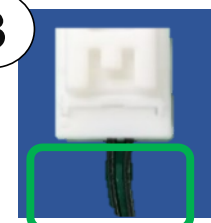
NO GOOD



4

2

3



GOOD



NO GOOD

1 No **Unlock connector**

3 No **Terminal Backing Out**

2 No **Wrong insert**

4 No **Deformed terminal**

5 **Check the alignment**

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