

**WORK INSTRUCTION**Process Name/Title: **OFFLINE ASSEMBLY PROCESS**

Effectivity Date:

**September 8, 2023**Model code/Part number: **700B / 7N0039-7020A** Customer: **TRJ** Car Model: **TOYOTA-LAND CRUISER**

Validity Date:

**n/a**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

**WI-ENG-PDE-731**

Revision No.:

**0**

Page No.:

**1 of 6****PARTS:** 1. Connector 6098-3802 (W); AVSSf 0.3 B-V wire L=763±3mm

JIG:

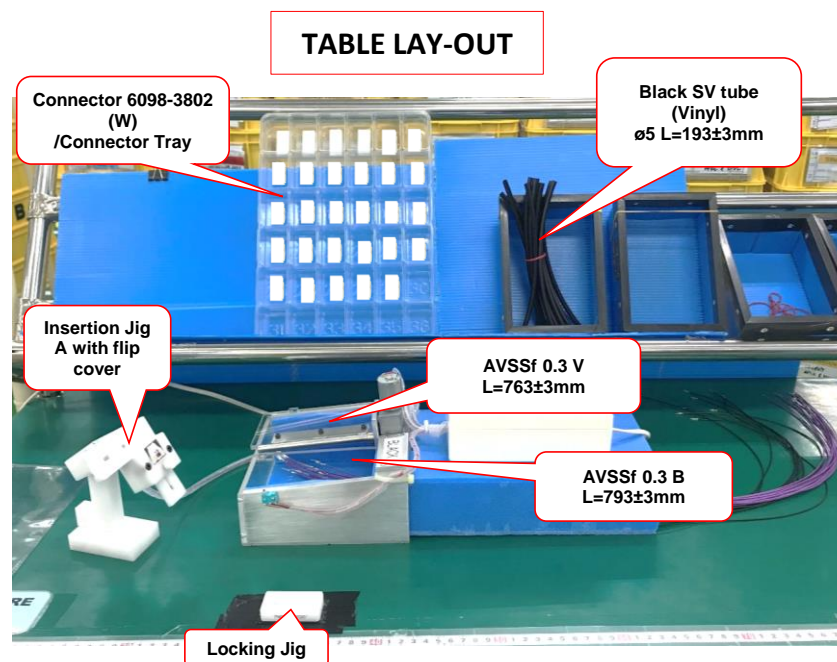
1. Insertion jig with switch cover
2. Locking jig

**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

1

n/a

Table lay-out

**Safety Instruction**

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

**Housekeeping**

1. Maintain and always practice 5's.
2. Personal things on the work place 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

**Document reference/s:**

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

**Revision History**

Prepared by

Reviewed by

Approved by

Noted by

09/8/23

0

Initial issue.  
Excluded process from **WI-ENG-PDE-715- TAPING ASSEMBLY PROCESS** due to new process distribution.

M. Ariola

J. Loterte

C. Villanueva

A. Arañes

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

September 8, 2023

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**

DCC Stamp



# WORK INSTRUCTION

## OFFLINE ASSEMBLY PROCESS

Process Name/Title:

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

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

September 8, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-731

Revision No.:

0

Page No.:

2 of 6

PARTS: 1. Connector 6098-3802 (W)

JIG:

1. Insertion jig with switch cover

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

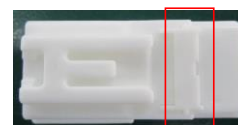
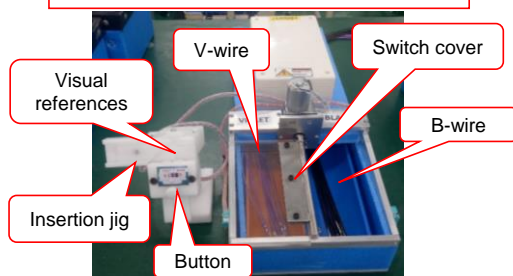
QUALITY POINTERS

2

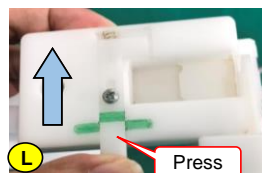
n/a

Connector setting to  
insertion jig 6098-3802  
(W)

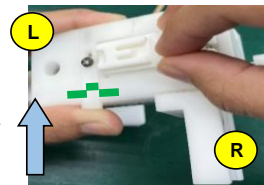
### INSERTION JIG WITH SWITCH COVER



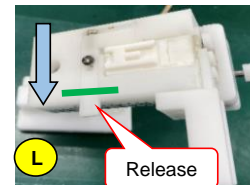
Connector Orientation



1. Press the lock of insertion jig using left thumb.



2. Insert the connector **6098-3802** into jig using right hand and release the lock.

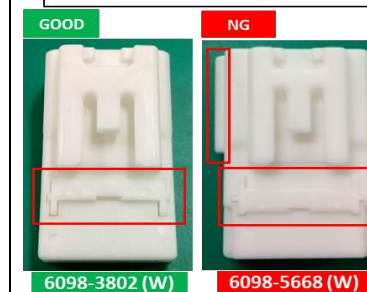


3. Push the guide using right hand. The slot for **Black wire** will be opened.

n/a

1. Use provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No damaged connector

### CONNECTOR ILLUSTRATION



**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)  
**MASTER COPY**

DCC Stamp



# WORK INSTRUCTION

## OFFLINE ASSEMBLY PROCESS

Effectivity Date:

September 8, 2023

Process Name/Title:

Model code/Part number:

700B

/ 7N0039-7020A

Customer: TRJ

Car Model: TOYOTA-LAND CRUISER

Document No.:

WI-ENG-PDE-731

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


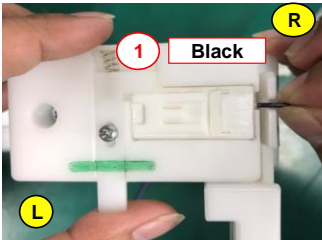
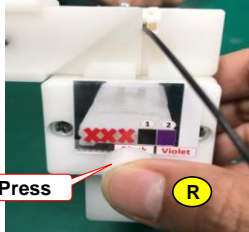
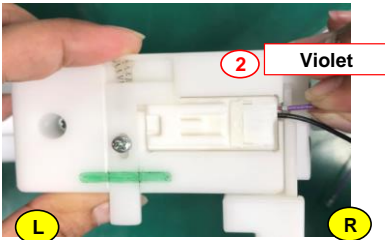
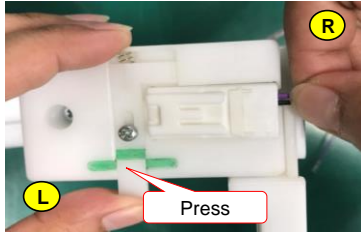
☒ MASSPRO

Revision No.:

0

Page No.:

3 of 6

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	<div>Wire insertion to insertion jig 6098-3802 (W)</div> <div><div><p>Wire facing</p></div><div><p>1. Get the <b>Black wire</b> then insert to terminal slot ① using right hand.</p></div><div><p>2. After insertion of Black wire press the button using right hand. The slot for <b>Violet wire</b> will be opened.</p></div><div><p>3. Get the <b>Violet wire</b> then insert to terminal slot ② using right hand.</p></div><div><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></div>	n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div><b>Important reminders/Note/s:</b> 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.</div> <div><b>Document references:</b> 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div>

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)  
**MASTER COPY**

DCC Stamp



# WORK INSTRUCTION

## OFFLINE ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number: **700B / 7N0039-7020A**

Customer: **TRJ**

Car Model: **TOYOTA-LAND CRUISER**

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

September 8, 2023

Validity Date:

n/a

Document No.:






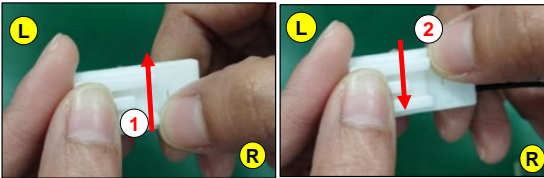

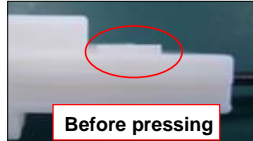


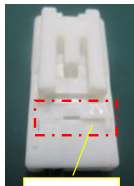
WI-ENG-PDE-731

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
4	n/a Connector lock	<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>LOCKING JIG</div> 	<div><p>Before pressing</p><p>After pressing</p></div> <div><div>GOOD</div><p>Full Lock</p><div>NG</div><p>Half Lock</p></div> <p><b>Important reminders/Note/s:</b> <b>1. Manual locking may cause damaged connector lock</b></p> <p>1. Use the provided jig tool to lock the connector. 2. No unlock/half-locked connector</p>

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)  
**MASTER COPY**

DCC Stamp

**WORK INSTRUCTION****OFFLINE ASSEMBLY PROCESS**

Effectivity Date:

**September 8, 2023**

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

**700B**

/

**7N0039-7020A**

Customer:

**TRJ**

Car Model:

**TOYOTA-LAND CRUISER**

Document No.:

**WI-ENG-PDE-731**

Purpose:



☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

Page No.:

5 of 6

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

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**

DCC Stamp



**WORK INSTRUCTION**Process Name/Title: **OFFLINE ASSEMBLY PROCESS**

Effectivity Date:

**September 8, 2023**

Validity Date:

n/a

Model code/Part number: **TM3 / 7N0039-7020A** Customer: **TRJ** Car Model: **TOYOTA-LAND CRUISER**

Document No.:

**WI-ENG-PDE-731**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

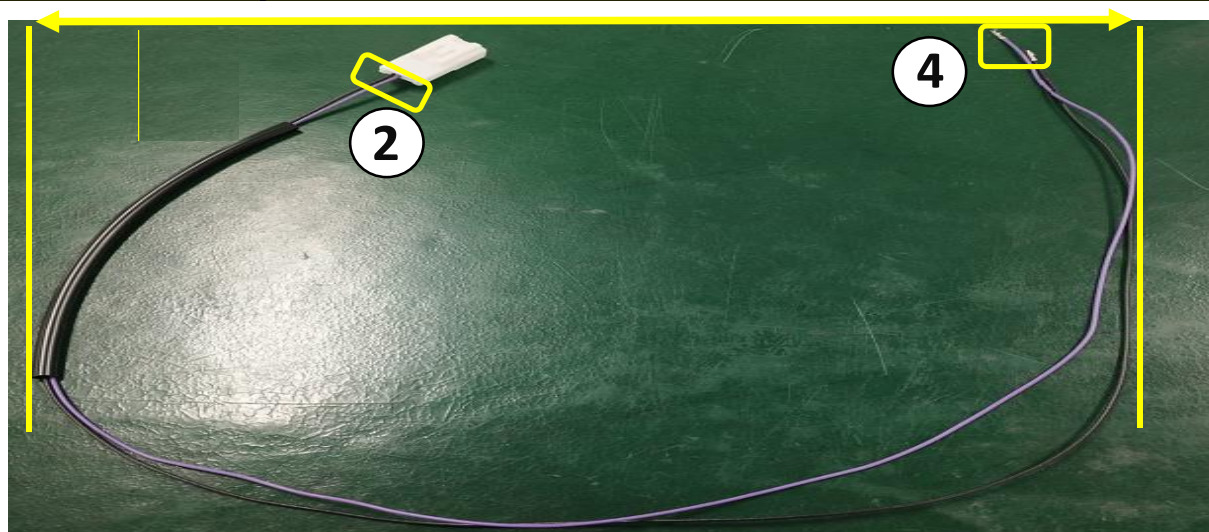
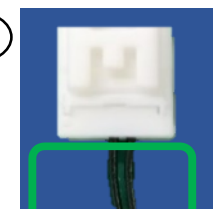
Page No.:

6 of 6

PARTS: n/a

JIG:

n/a

**QUALITY CHECKPOINTS****OFFLINE INSERTION****7N0039-7020A****1****GOOD****NO GOOD****2****4****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**

**CONFIDENTIAL:** Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

**NBC (Philippines)**  
**MASTER COPY**

DCC Stamp