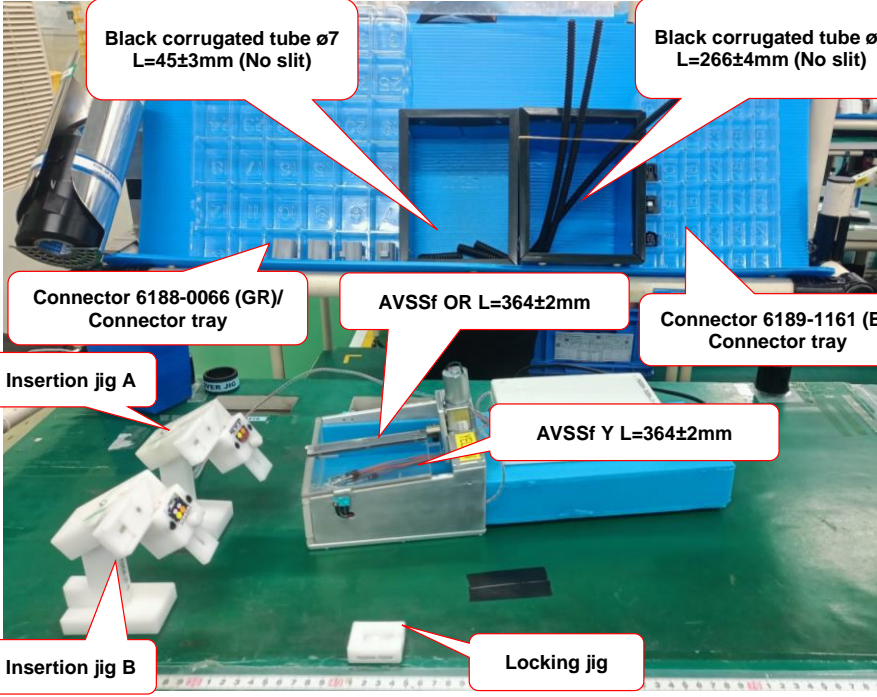
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	OFFLINE ASSEMBLY PROCESS					Validity Date:		n/a				
	Process Name/Title:		Model code/Part number: 930B / 7N0204-7020Ca			Customer: TRJ		Car Model: TOYOTA-4 RUNNER		Document No.: WI-ENG-PDE-879		
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:		1	Page No.:

PARTS:			1. All parts: Connector 6188-0066 (GR); AVSSf Y-OR L=364±2mm; Black corrugated tube ø7 L=45±3mm (No slit); Black corrugated tube ø5 L=266±4mm (No slit); Connector 6189-1161 (B)					JIG:		1. Insertion jig with switch cover 2. Insertion jig 3. Locking jig			
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION					TOOLS/PPE		QUALITY POINTERS		
1		Offline		<div>TABLE LAY-OUT</div> 					<div><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		<div><b>Document references:</b> 1. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip length tolerance.</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>		


Revision History								Prepared by		Reviewed by		Approved by		Noted by	
04/30/24		1		Change from Pre-launch to Masspro.				D.Castillo		C. Villanueva		A. Arañes		n/a	
04/26/24		0		Initial issue				D.Castillo		C. Villanueva		A. Arañes		n/a	
Eff. Date		Rev. No		Details of Change				Revised		Reviewed		Approved		Noted	

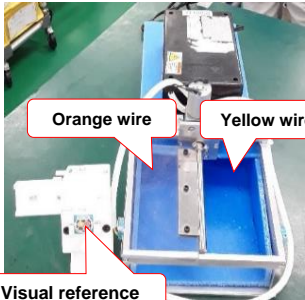
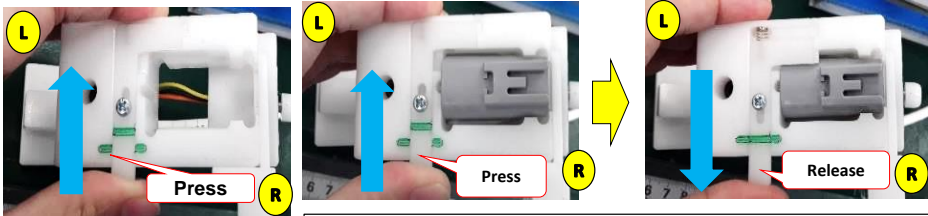
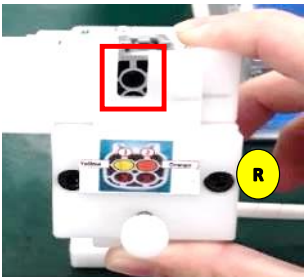
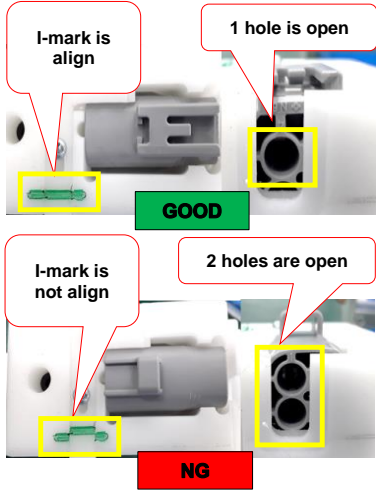
Est. Date:		April 26, 2024	
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	Process Name/Title: <b>OFFLINE ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>930B / 7N0204-7020Ca</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-4 RUNNER</b>	Document No.:	<b>WI-ENG-PDE-879</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	2 of 9

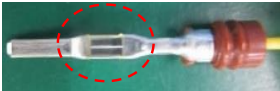

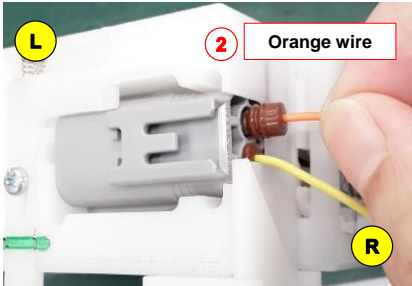
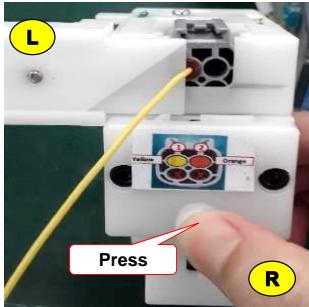
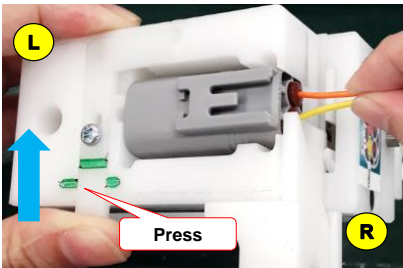
<b>PARTS:</b>		1. Connector 6188-0066 (GR)		JIG:	1. Insertion jig with switch cover	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
2	Offline Connector setting to insertion jig 6188-0066 (GR)	<div><p>Insertion jig with switch cover</p><p>Orange wire</p><p>Yellow wire</p><p>I-mark</p><p>Lock</p><p>Visual reference</p><p>INSERTION JG ORIENTATION</p><p>CONNECTOR ORIENTATION</p></div> <div><p>Press</p><p>Press</p><p>Release</p><p>1. Press the lock using left hand.</p><p>2. Get the connector <b>6188-0066 (GR)</b> using right hand and insert to insertion jig. Release the lock after insertion.</p><p>3. Push the lower wire guide upward using right hand. Slot for <b>Yellow wire</b> will be opened.</p></div> <div>n/a</div> <div><p><b>CONNECTOR ORIENTATION ILLUSTRATION</b></p><p>I-mark is align</p><p>1 hole is open</p><p>GOOD</p><p>I-mark is not align</p><p>2 holes are open</p><p>NG</p><p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p><p><b>Important reminders/Note/s:</b> <b>1. Follow the connector orientation</b></p></div>				

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	Process Name/Title: OFFLINE ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 930B / 7N0204-7020Ca		Customer: TRJ	Car Model: TOYOTA-4 RUNNER	Document No.:	WI-ENG-PDE-879		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	3 of 9

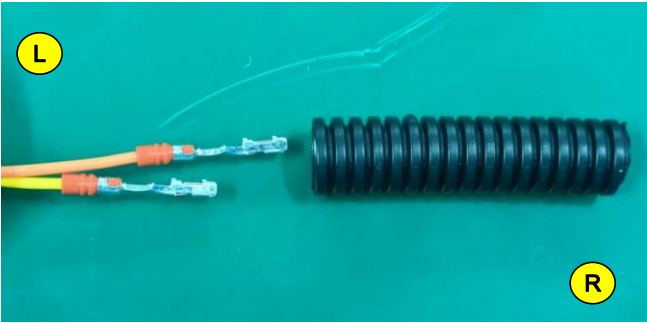

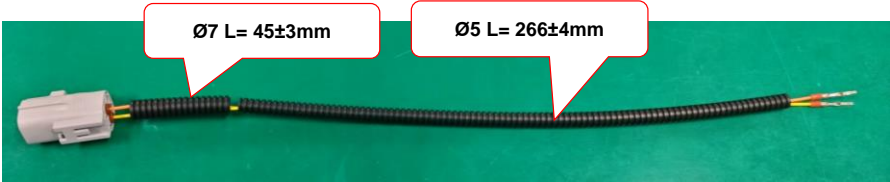
PARTS:	1. AVSSf Y-OR L=364±2mm			JIG:	1. Insertion jig with switch cover		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
3	Offline  Wire Insertion to connector 6188-0066 (GR)	<div><div>WIRE FACING</div></div> <div><div>1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot 1 using right hand.</div></div> <div><div>2. Orange wire</div><div>3. Get the Orange wire then insert to terminal slot 2 using right hand.</div></div> <div><div>Press</div><div>2. Press the button using right thumb. The slot for Orange wire will be opened.</div></div> <div><div>Press</div><div>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.</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>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.</div> <div>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</div>		

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	Process Name/Title: <b>OFFLINE ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>930B / 7N0204-7020Ca</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-4 RUNNER</b>	Document No.:	<b>WI-ENG-PDE-879</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	4 of 9

<b>PARTS:</b>	1. Assy parts 2. Black corrugated tube ø7 L=45±3mm (No slit) 3. Black corrugated tube ø5 L=266±4mm (No slit)			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
4	Offline	Wire insertion to Black corrugated tube ø7 L=45±3mm (No slit)	<div><div>1. Get the Black corrugated tube ø7 L=45±3mm (No slit) using right hand and insert Yellow wire and Orange wire by using left hand.</div></div>	n/a	1. No wrong use of parts 2. No deformed terminal
5		Wire insertion to Black corrugated tube ø5 L=266±4mm (No slit)	<div><div>1. Get the Black Corrugated Tube ø5 L=266±4mm (No Slit) using left hand and insert Yellow wire and Orange wire by using left hand.</div></div> <div></div>	n/a	1. No wrong use of parts 2. No deformed terminal

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## WORK INSTRUCTION

Process Name/Title:

## OFFLINE ASSEMBLY PROCESS

Effectivity Date:

April 30, 2024

Validity Date:

n/a

Model code/Part number:

930B

/

7N0204-7020Ca

Customer:

TRJ

Car Model:

TOYOTA-4 RUNNER

Document No.:

WI-ENG-PDE-879

Purpose:

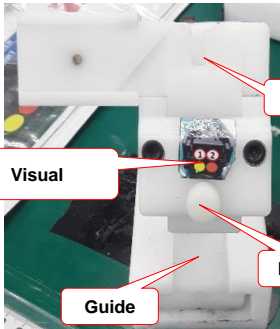
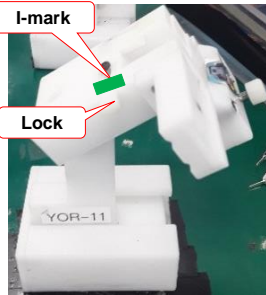

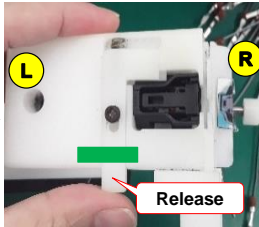
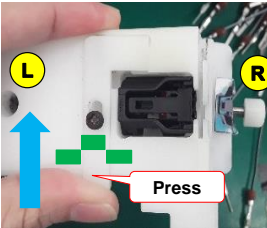
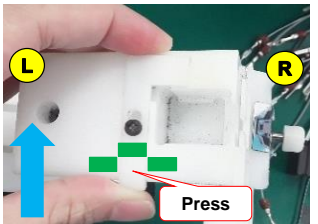
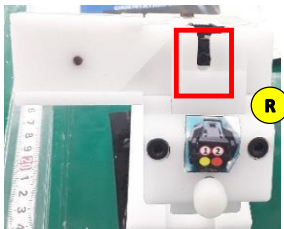


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1

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PARTS:		1. Connector 6189-1161 (B)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	Offline Connector setting to insertion jig 6189-1161 (B)	<div><div>INSERTION JIG</div><div>INSERTION JIG ORIENTATION</div><div>CONNECTOR ORIENTATION</div></div> <div></div> <div></div>		n/a	<div><div>CONNECTOR ORIENTATION ILLUSTRATION</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> <div><b>Important reminders/Note/s:</b> <b>1. Follow the connector orientation</b></div>

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Process Name/Title:

**OFFLINE ASSEMBLY PROCESS**

Effectivity Date:

**April 30, 2024**

Validity Date:

n/a

Model code/Part number:

**930B**

/

**7N0204-7020Ca**

Customer:

**TRJ**

Car Model:

**TOYOTA-4 RUNNER**

Document No.:

**WI-ENG-PDE-879**

Purpose:


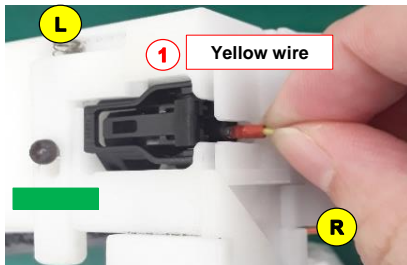
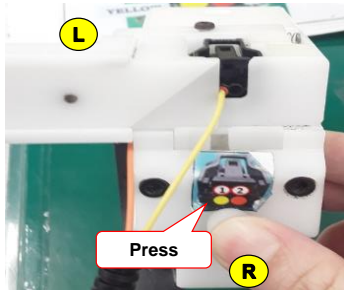
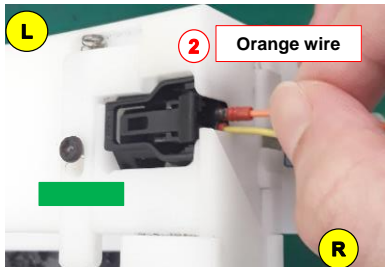
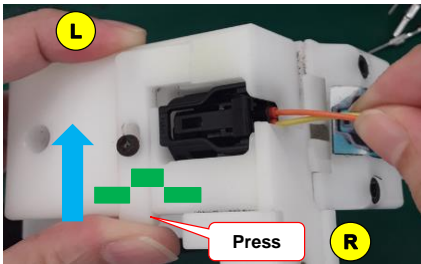
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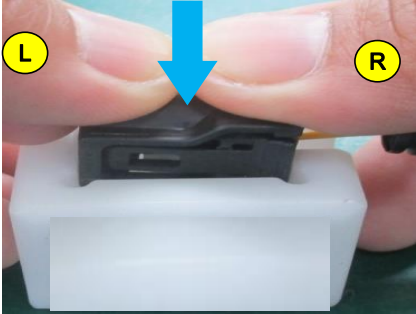
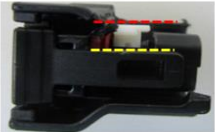





PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	Offline	<div><div><div>WIRE FACING</div></div><div><div><div>1 Yellow wire</div></div><div><div><div>Press</div></div><div><div><div>2 Orange wire</div></div><div><div><div>Press</div></div></div><div><div>1. Hold the insertion jig using left hand. Get the <b>Yellow wire</b> then insert to terminal slot <b>1</b> using right hand.</div><div>2. Press the button using right thumb. The slot for <b>Orange wire</b> will be opened.</div><div>3. Get the <b>Orange wire</b> then insert to terminal slot <b>2</b> using right hand.</div><div>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.</div></div></div></div></div></div>		n/a	<div>1. No loose insertion</div> <div>2. No wrong insertion</div> <div>3. One by one insertion</div> <div>4. No deformed terminal</div> <div>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> <b>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b></div>

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	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>April 30, 2024</b>		
	Process Name/Title: <b>OFFLINE ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>930B / 7N0204-7020Ca</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-4 RUNNER</b>	Document No.:	<b>WI-ENG-PDE-879</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	7 of 9


<b>PARTS:</b>	1. Assy parts			JIG:	1. Locking jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
8	Offline Connector lock	<div><div>1. Put the connector into locking jig using both hands and then press <b>2x</b>. Check the connector if properly locked.</div><div><div>Connector lock appearance</div><div><div><div>Unlock Condition</div></div><div><div>Half Lock Condition</div></div><div><div>Full Lock Condition</div></div></div><div><div><div>BEFORE PRESSING</div></div><div><div>AFTER PRESSING</div></div></div></div></div>		<div><b>LOCKING JIG</b></div> 	<b>Important reminders/Note/s:</b> <b>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b>  1. Use the provided jig tool to lock the connector. 2. No unlock/half-locked connector 3. No damaged lock

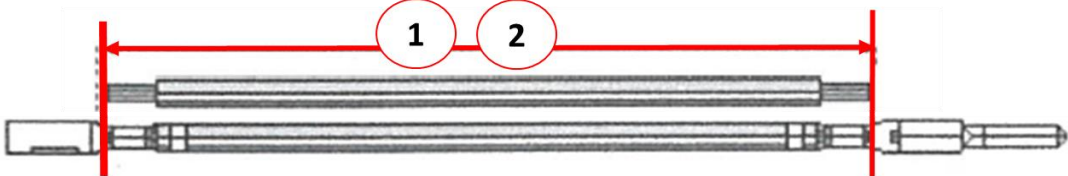
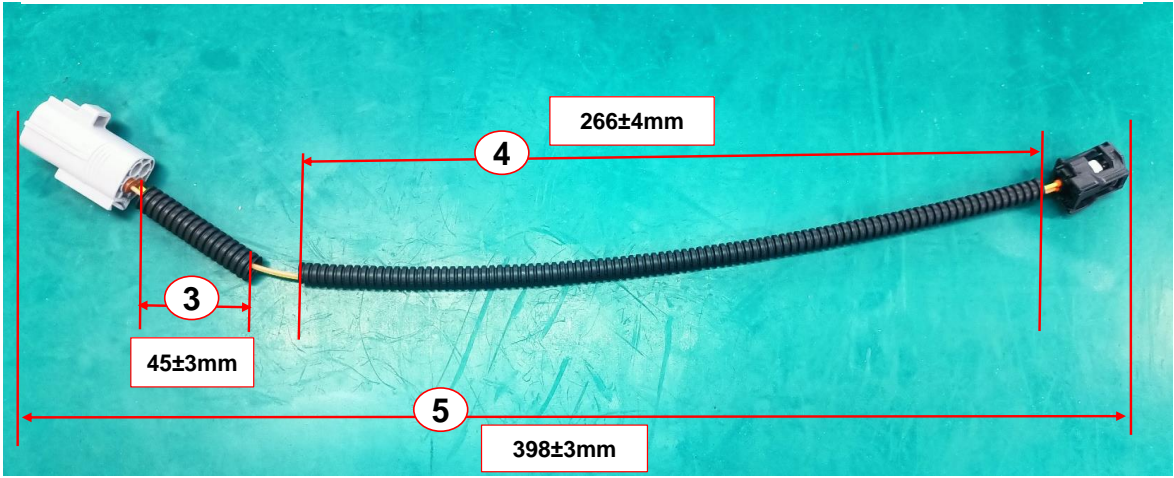

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	Model code/Part number: <b>930B / 7N0204-7020Ca</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-4 RUNNER</b>	Document No.:	<b>WI-ENG-PDE-879</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	8 of 9

<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>	
9	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><b>MEASURING TAPE</b></div> <div></div>	<div><b>Important reminders and note/s:</b> 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.</div> <div><b>Document reference/s:</b> 1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div>	1. No wrong dimension

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**WORK INSTRUCTION**

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**OFFLINE ASSEMBLY PROCESS**

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**930B****/ 7N0204-7020Ca**

Customer:

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**TOYOTA-4 RUNNER**

Document No.:

**WI-ENG-PDE-879**

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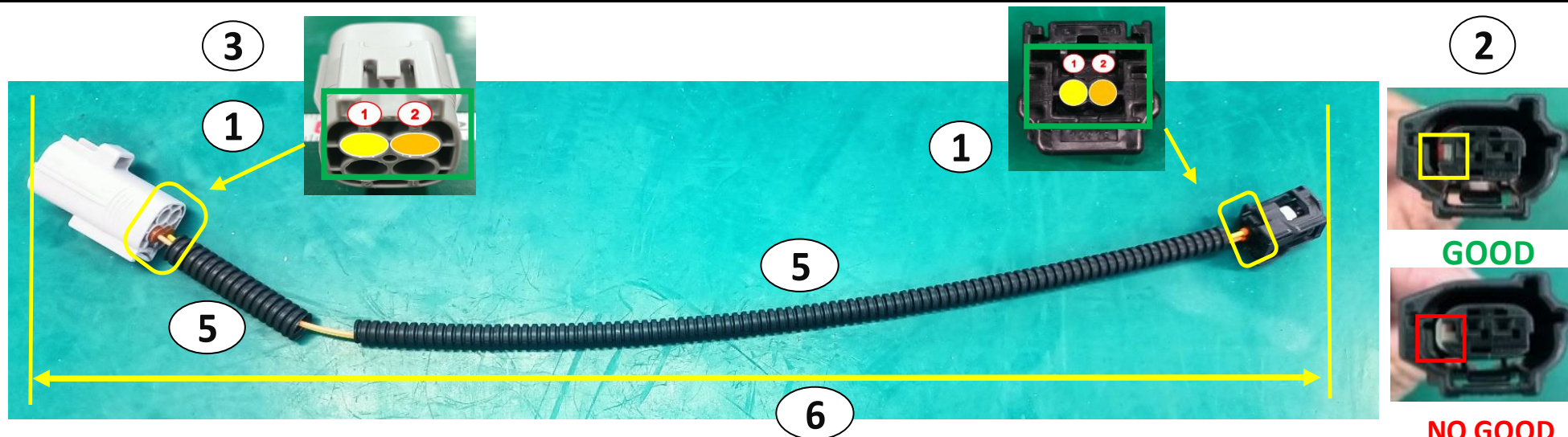
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**PARTS:**

1.. Assy parts

JIG:

n/a

**VISUAL INSPECTION****OFFLINE INSERTION****7N0204-7020C****1 No Wrong insert****3 No Terminal Backing Out****5 No Missing COT****2 No Unlock/ Half Lock Connector****4 No Deformed terminal****6 Check the Alignment**

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