



WORK INSTRUCTION

OFFLINE ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

311D/ 7L0156-7021

Customer:

TRQSS

Car Model:

TOYOTA-RAV 4

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

July 02, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-931

Revision No.:

0

Page No.:

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PARTS: Connector 6098-3802 (W); AVSSF 0.3 B wires L=203±2mm [2pcs]

JIG:

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

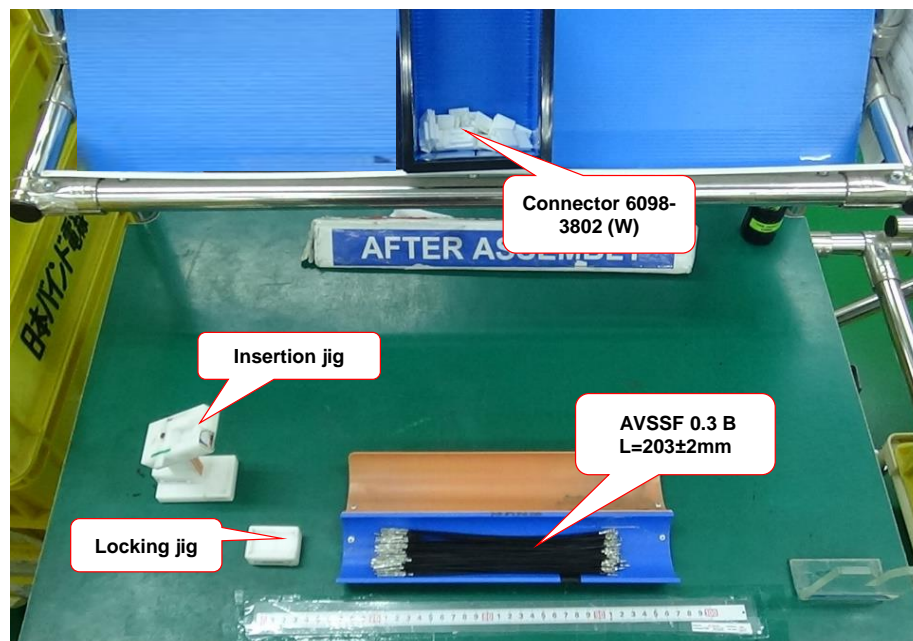
QUALITY POINTERS

1

Offline

Table Lay-out

TABLE LAY-OUT

**Safety Instruction**

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

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

Document reference/s:

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

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

Revision History

| Eff. Date | Rev. No | Details of Change | Revised | Reviewed | Approved | Noted | Prepared by | Reviewed by | Approved by | Noted by |
|-----------|---------|-------------------|-------------|--------------|-----------|-------|-------------|--------------|-------------|----------|
| 07/02/24 | 0 | Initial issue. | A.Hernandez | C.Villanueva | A. Arañes | n/a | A.Hernandez | C.Villanueva | A. Arañes | n/a |

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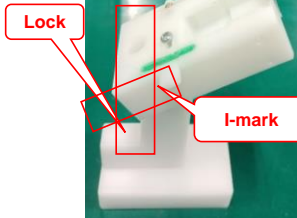
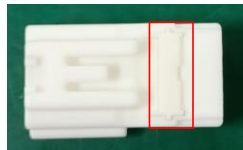
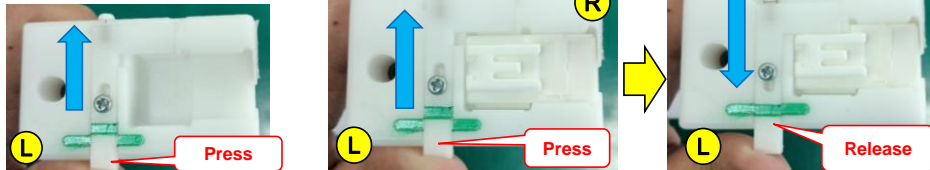

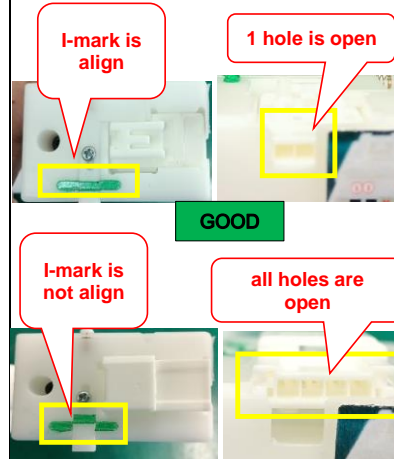
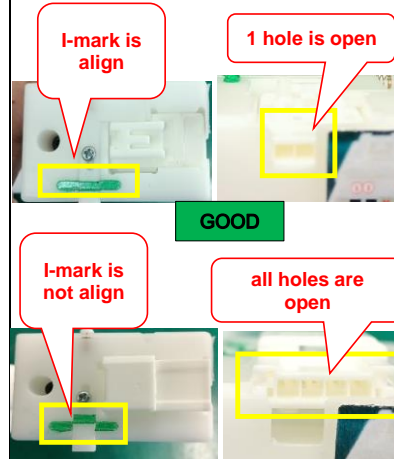
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|--------|---------------------------|---|--|-----------|---|
| PARTS: | | 1. Connector 6098-3802 (W) | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 2 | Offline Connector Setting | <div><div>INSERTION JIG</div><div><div>Holes</div></div><div><div>Lock</div><div>I-mark</div></div><div>CONNECTOR ORIENTATION</div><div></div><div>INSERTION JIG ORIENTATION</div><div><div>L</div><div>Press</div><div>R</div><div>Press</div><div>L</div><div>Release</div></div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6098-5668 (W) into jig using right hand then release the lock.</div><div></div><div>3. Check the holes/terminal slot for B-B wires.</div></div> <td>n/a</td> <td><div>CONNECTOR ORIENTATION ILLUSTRATION</div><div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div><div>I-mark is not align</div><div>all holes are open</div><div>NG</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></td> | | n/a | <div>CONNECTOR ORIENTATION ILLUSTRATION</div> <div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div><div>I-mark is not align</div><div>all holes are open</div><div>NG</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> |

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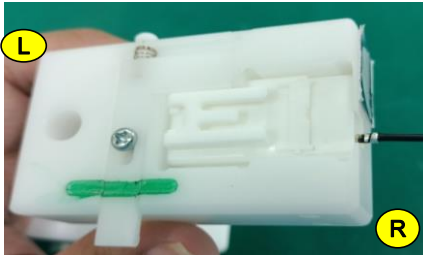


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|--------|--|--|-----------|---|
| PARTS: | 1. AVSSf 0.3 B wires L=203±2mm [2pcs] | | JIG: | 1. Insertion Jig |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
| 3 | Offline Wire Insertion to Connector | <div><div>WIRE FACING</div></div> <div><div><div>1. Get the 1st B wire then insert to connector using right hand.</div></div><div><div>2. Get the 2nd B wire then insert to connector using right hand.</div></div><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></div> <td>n/a</td> <td><p>Document reference/s:</p><p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p><p>Important reminders/note/s:</p><p>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p><p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p></td> | n/a | <p>Document reference/s:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>Important reminders/note/s:</p> <p>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> |

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☐ PROTOTYPE

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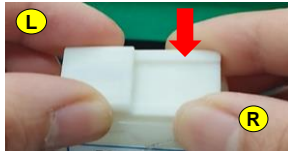



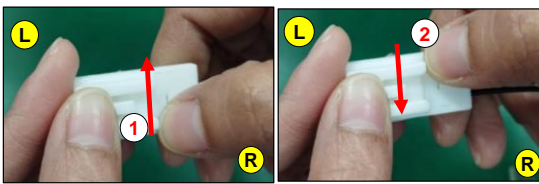





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|--------|---------------------------|---|--|--|
| PARTS: | 1. Assy parts | | JIG: | 1. Locking jig |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
| 4 | Offline Connector lock | <div><p>1. Load the connector 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>  | <p>1. No Unlock and half-locked 2. Use provided jig tools per model to avoid damaged lock.</p> <p>Important reminders/note/s: 1. MANUAL LOCKING MAY CAUSED DAMAGED LOCK 2. Use provided jig tool per model to avoid damaged lock.</p> <p>Document reference/s: 1. Refer to GL-PRO-ASS-017 for the Verification of Coupler lock</p> <div><p>Before pressing</p><p>After pressing</p></div> <div><div><p>GOOD</p><p>Full Lock</p></div><div><p>NG</p><p>Half Lock</p></div></div> |

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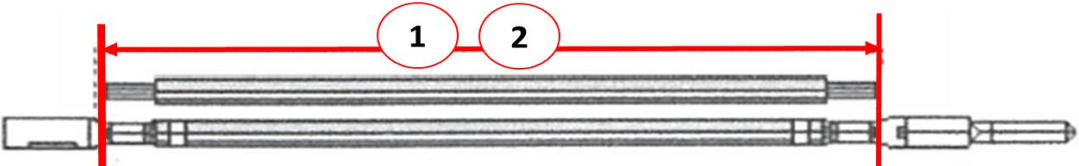

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|--------|---------------|------------------------------|--|--|---|
| PARTS: | 1. Assy parts | | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 5 | Offline | Measurement | <div>Note: 1. Measurement point: End of core wire to the end of core wire 2. Terminal is reference only.</div> <div></div> | <div>MEASURING TAPE</div> <div></div> | <div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s: 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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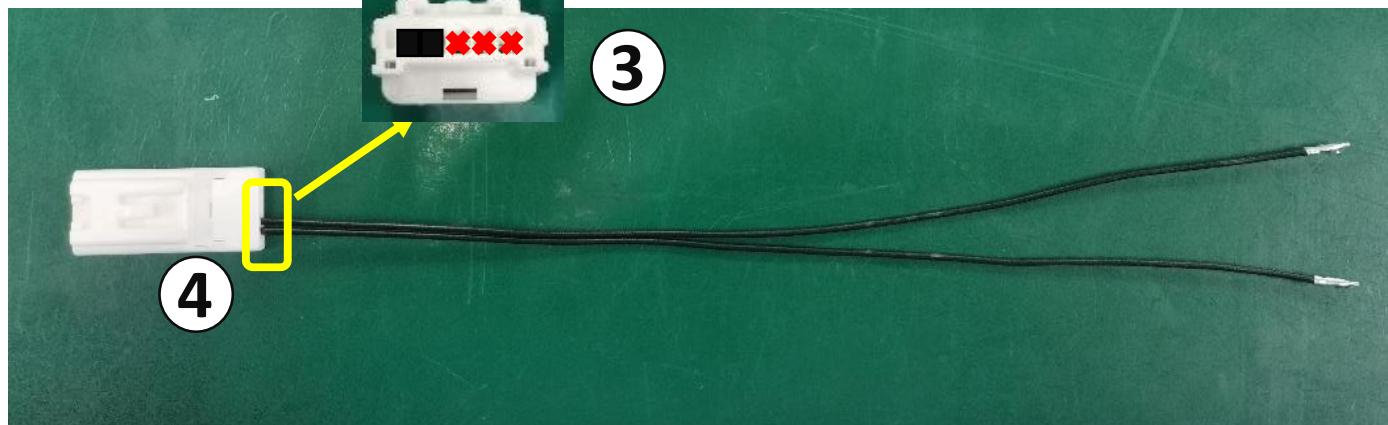
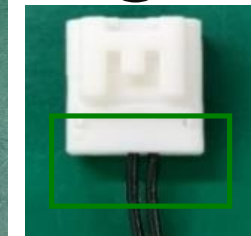
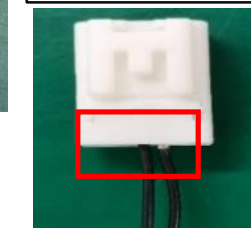
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PARTS: n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**Offline****7N0156-7021****①****GOOD****NO GOOD****① No Unlock/Halflock Connector****③****② No Terminal Backing Out****③ No Wrong Insert****④****No Deformed Terminal****②****GOOD****NO GOOD**

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