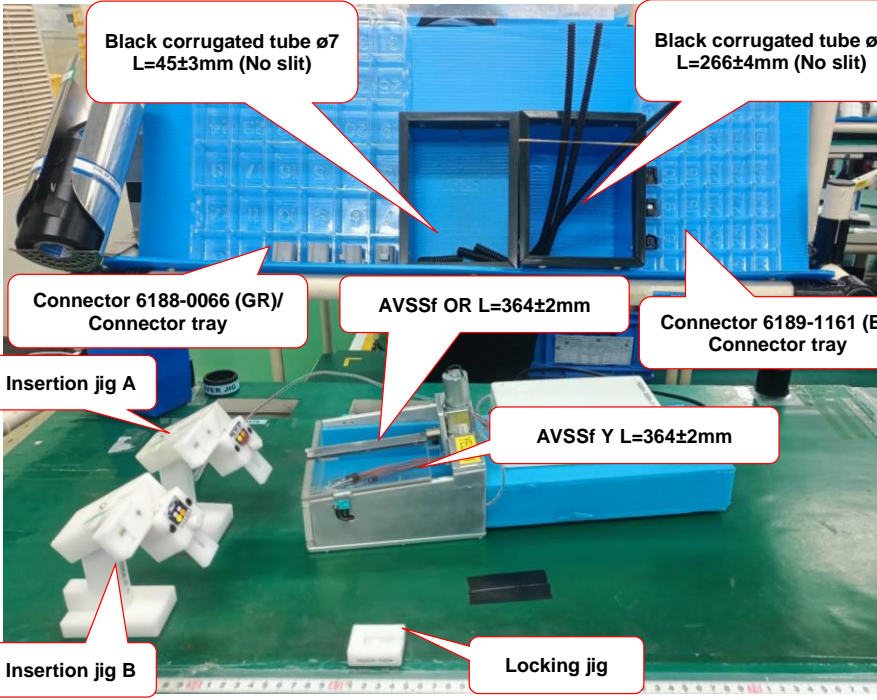
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	Process Name/Title: OFFLINE ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 930B / 7N0204-7020A		Customer: TRJ	Car Model: TOYOTA-4 RUNNER	Document No.:	WI-ENG-PDE-828		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	1 of 8


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	n/a	<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 references:</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>	

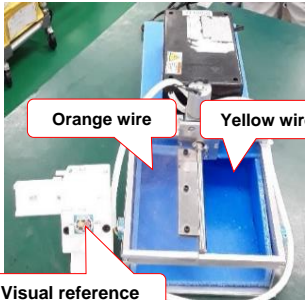
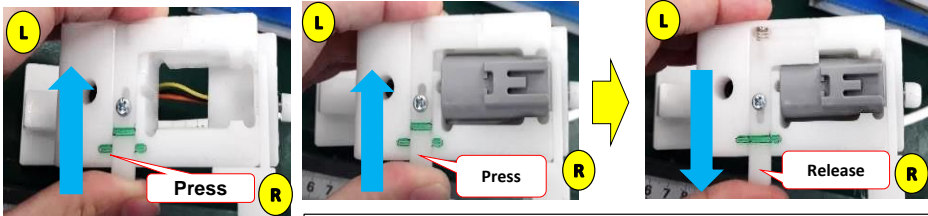
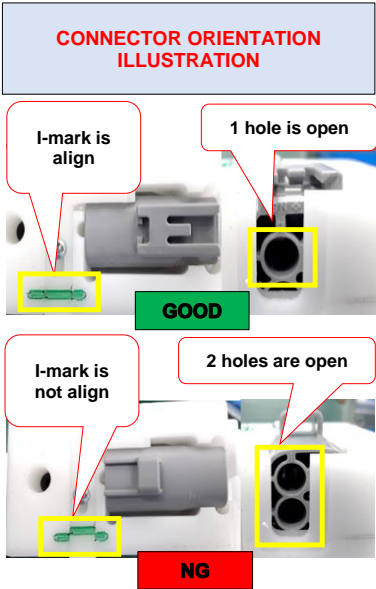
Revision History								Prepared by	Reviewed by	Approved by	Noted by
02/06/24	0	Initial issue				D.Castillo	C. Villanueva	A. Arañes	n/a		
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	February 06, 2024

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	Process Name/Title:		Model code/Part number: 930B / 7N0204-7020A		Customer: TRJ	Car Model: TOYOTA-4 RUNNER		Document No.:	WI-ENG-PDE-828	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		0	Page No.:	2 of 8	

PARTS:		1. Connector 6188-0066 (GR)		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 6188-0066 (GR)	<div><p>Insertion jig with switch cover</p><p>Orange wire Yellow wire</p><p>I-mark Lock</p><p>Visual reference</p><p>INSERTION JG ORIENTATION</p><p>CONNECTOR ORIENTATION</p></div> <div><p>Press Press Release</p><p>1. Press the lock using left hand.</p><p>2. Get the connector 6188-0066 (GR) 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 Yellow wire will be opened.</p></div>	n/a	<div><p>CONNECTOR ORIENTATION ILLUSTRATION</p><p>I-mark is align 1 hole is open</p><p>I-mark is not align 2 holes are open</p><p>GOOD NG</p></div> <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>Important reminders/Note/s: 1. Follow the connector orientation</p>		

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OFFLINE ASSEMBLY PROCESS

Effectivity Date:

February 6, 2024

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

Customer:

TRJ

Car Model:

TOYOTA-4 RUNNER

Document No.:

WI-ENG-PDE-828

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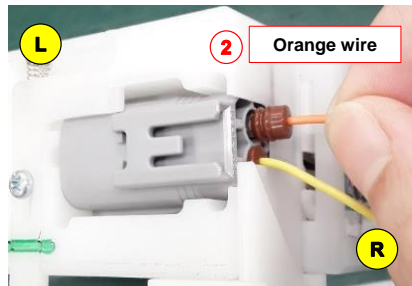
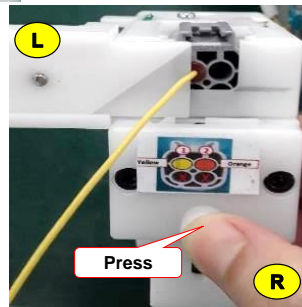
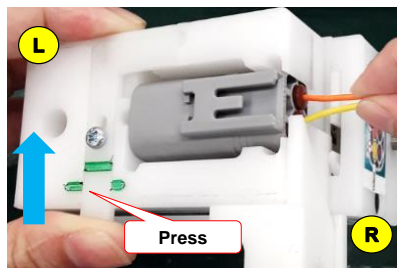
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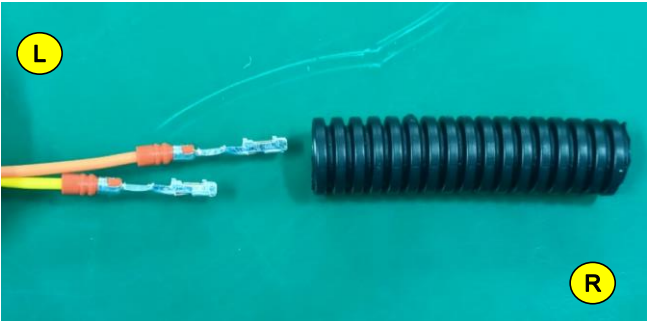


PARTS:		1. AVSSf Y-OR L=364±2mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a	<div><div><div>WIRE FACING</div></div><div><div>1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot 1 using 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><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></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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	WORK INSTRUCTION				Effectivity Date:	February 6, 2024		
	Process Name/Title: OFFLINE ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 930B / 7N0204-7020A		Customer: TRJ	Car Model: TOYOTA-4 RUNNER	Document No.:	WI-ENG-PDE-828		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	4 of 8

PARTS:		1. Assy parts 2. Black corrugated tube $\varnothing 7$ L=45 \pm 3mm (No slit)		3. Black corrugated tube $\varnothing 5$ L=266 \pm 4mm (No slit)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
4	Wire insertion to Black corrugated tube $\varnothing 7$ L=45 \pm 3mm (No slit)	 <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> 1. Get the Black corrugated tube $\varnothing 7$ L=45\pm3mm (No slit) using right hand and insert Yellow wire and Orange wire by using left hand. </div>		n/a		1. No wrong use of parts 2. No deformed terminal	
5	Wire insertion to Black corrugated tube $\varnothing 5$ L=266 \pm 4mm (No slit)	 <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> 1. Get the Black Corrugated Tube $\varnothing 5$ L=266\pm4mm (No Slit) using left hand and insert Yellow wire and Orange wire by using left hand. </div>  <div style="display: flex; justify-content: space-around; margin-top: 10px;"> <div style="border: 1px solid black; padding: 2px;"> $\varnothing 7$ L= 45\pm3mm </div> <div style="border: 1px solid black; padding: 2px;"> $\varnothing 5$ L= 266\pm4mm </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:

February 6, 2024

Validity Date:

n/a

Model code/Part number:

930B

/

7N0204-7020A

Customer:

TRJ

Car Model:

TOYOTA-4 RUNNER

Document No.:

WI-ENG-PDE-828

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

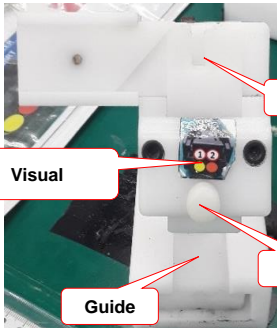
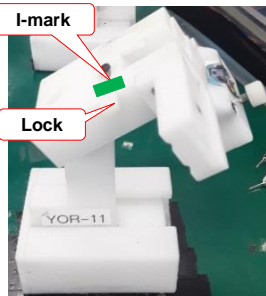

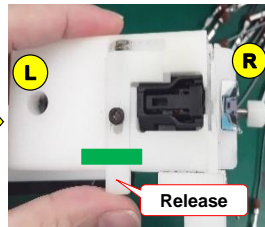
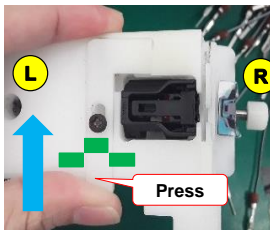
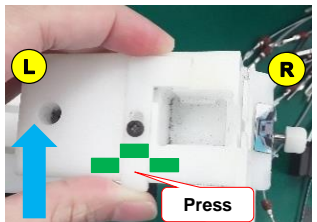



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PARTS:	1. Connector 6189-1161 (B)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	n/a	<div>Connector setting to insertion jig 6189-1161 (B)</div> <div><div><div>INSERTION JIG</div></div><div><div>INSERTION JIG ORIENTATION</div></div><div><div>CONNECTOR ORIENTATION</div></div></div> <div><div></div><div><div>1. Press the lock using left thumb.</div><div>2. Get the connector 6189-1161 (B) using right hand and insert to insertion jig. Release the lock after insertion.</div><div>3. Push the lower wire guide upward using right hand. Slot for Yellow wire will be opened.</div></div><div></div></div>	n/a	<div>CONNECTOR ORIENTATION ILLUSTRATION</div> <div><div>I-mark is align</div><div>1 hole is open</div></div> <div><div>I-mark is not align</div><div>1 hole is open</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>Important reminders/Note/s: 1. Follow the connector orientation</div>

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February 6, 2024

Model code/Part number:

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

Customer:

TRJ

Car Model:

TOYOTA-4 RUNNER

Document No.:

WI-ENG-PDE-828

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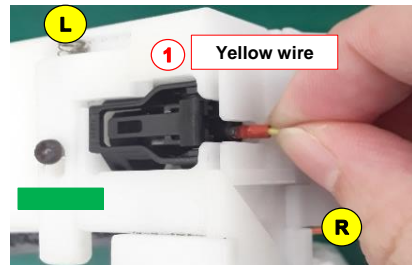
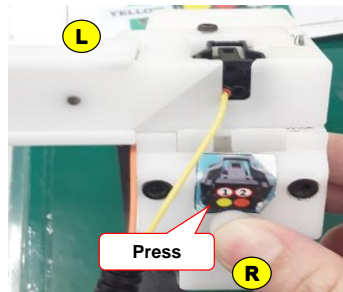
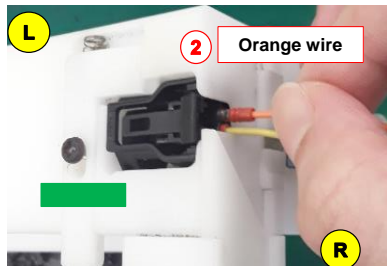
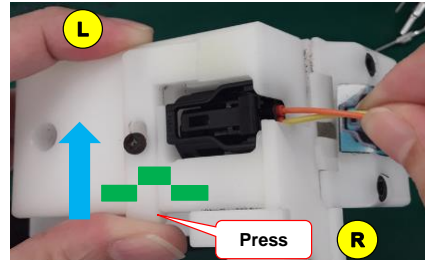
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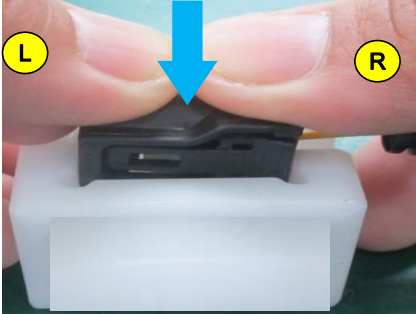
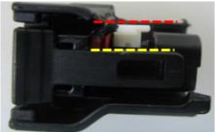





PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	n/a	<div><div><div>WIRE FACING</div></div><div><div><div>Yellow wire</div></div><div><div><div>Press</div></div><div><div><div>Orange wire</div></div><div><div><div>Press</div></div><div><div><p>1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot 1 using right hand.</p></div><div><p>2. Press the button using right thumb. The slot for Orange wire will be opened.</p></div><div><p>3. Get the Orange wire then insert to terminal slot 2 using right hand.</p></div><div><p>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.</p></div></div></div></div></div></div></div>	n/a	<div><div><p>1. No loose insertion</p><p>2. No wrong insertion</p><p>3. One by one insertion</p><p>4. No deformed terminal</p><p>5. No wrong wire facing</p></div><div><p>Important reminders/Note/s:</p><p>1. Please hold the wire near terminal.</p><p>2. Make sure wires are properly inserted.</p><p>Conduct Pull-Push-Pull-Push after insertion.</p><p>Do not exert extra force.</p></div><div><p>Document references:</p><p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p><p>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p></div></div>

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	Model code/Part number: 930B / 7N0204-7020A		Customer: TRJ	Car Model: TOYOTA-4 RUNNER	Document No.:	WI-ENG-PDE-828		
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PARTS:	1. Assy parts			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	n/a	<div><div>1. Put the connector into locking jig using both hands and then press 2x. 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><div>LOCKING JIG</div></div>	<div>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</div> <div>1. Use the provided jig tool to lock the connector. 2. No unlock/half-locked connector 3. No damaged lock</div>

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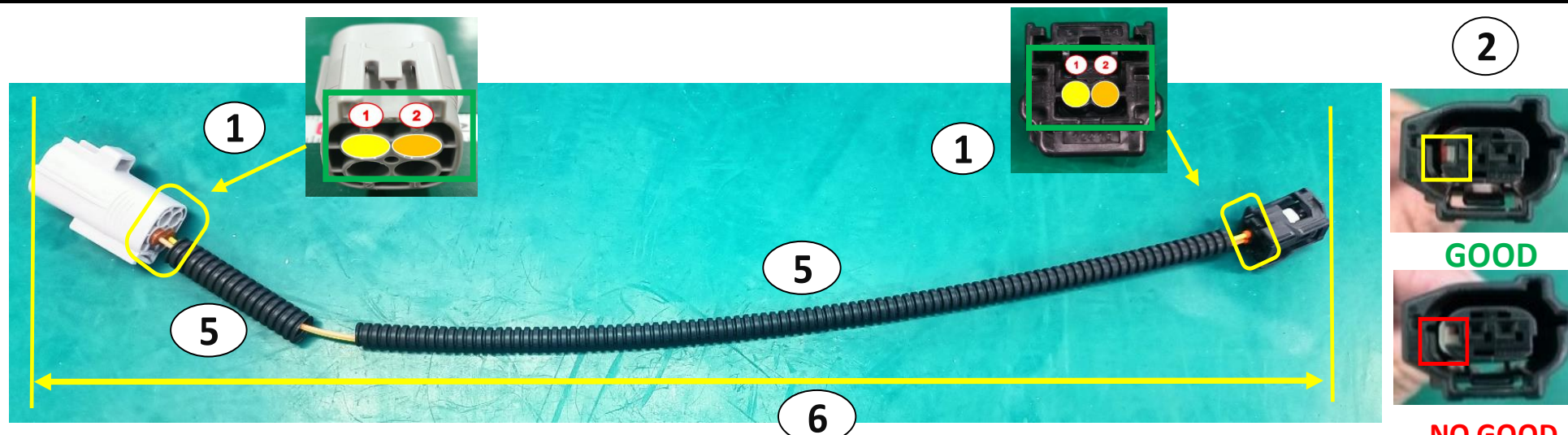
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PARTS:

n/a

JIG:

n/a

QUALITY CHECKPOINTS**OFFLINE INSERTION****7N0204-7020A****1 No Wrong insert****3 No Terminal Backing Out****5 No Missing COT****2 No Unlock/Half Lock Connector****4 No Deform terminal****6 Check the Alignment**

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