



WORK INSTRUCTION

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

September 25, 2024

Validity Date:

n/a

Model code/Part number:

373D / 7N0173-7020

Customer: TRJ

Car Model:

TOYOTA RAV4

Document No.:

WI-ENG-PDE- 630

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

2

Page No.:

1 of 5

PARTS:

1. Parts: AVSSf 0.3 wires Y-OR L=471±2mm; Connector 7283-1020-60 (G)

JIG:

1. Insertion jig with Switch cover
2. Pushing jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

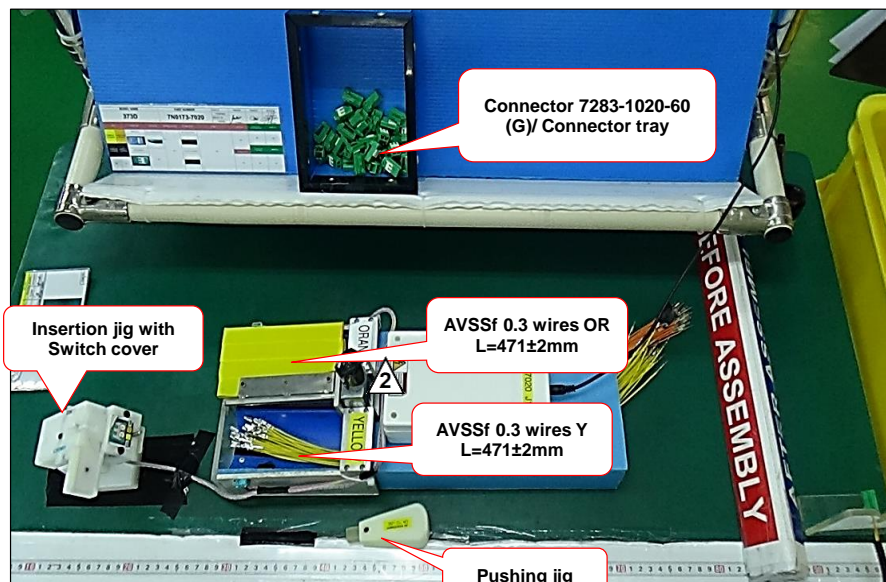
QUALITY POINTERS

1

OFF-LINE

Table Lay-out

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 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.

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

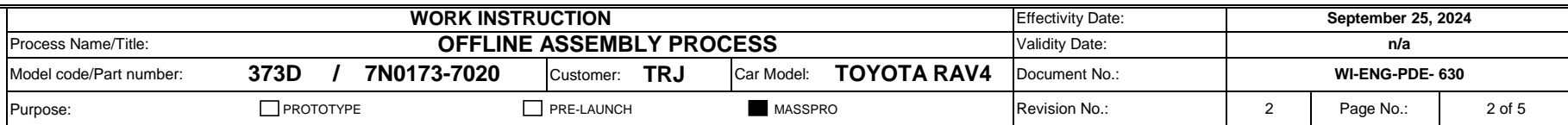
Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
09/25/24	2	Crisscross of switch cover improvement. Improvement of Visual Inspection/Quality Pointers	A. Hernandez	C. Villanueva	A. Arañes	n/a				
05/20/23	1	Work instruction improvement from Genba check audit. Transfer Wire Insertion to Black SV tube (Vinyl) ø5 L=24±2mm process to Taping assembly process to prevent missing SV tube (Vinyl).	D.Castillo	J. Loterte	C. Villanueva	A. Arañes				
01/31/23	0	Excluded from WI-ENG-PDE-606 to offline process. Inclusion of Table lay-out (Page 1). Insertion jig (Page 2-3) and Quality pointers (Page 5)	D.Castillo	J. Loterte	C. Villanueva	A. Arañes	A. Hernandez	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	January 31, 2023		

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☐ PRE-LAUNCH


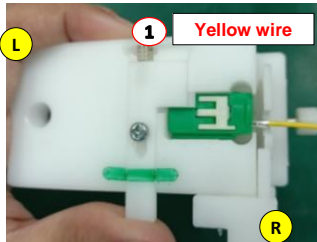
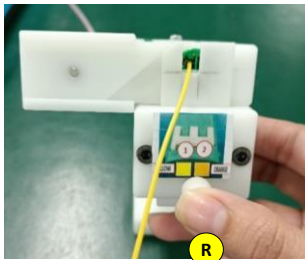
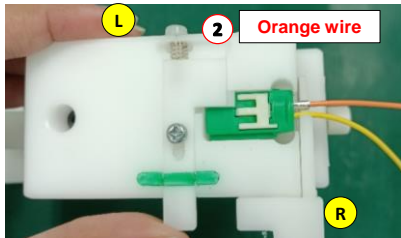
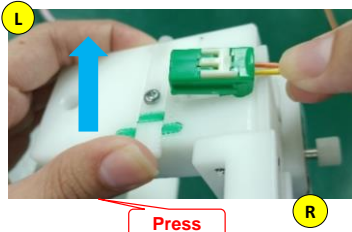
☒ MASSPRO

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PARTS:		1. AVSSf 0.3 wires Y-OR L=471±2mm 2. Connector 7283-1020-60 (G)		JIG:	1. Insertion jig withc Switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	OFF-LINE Wie insertion to connector 7283-1020-60 (G)	<div><div><p>Wire Facing</p></div><div><p>1. Hold the insertion jig using left hand. Get the Yellow wire and insert to connector using right hand.</p></div><div><p>2. Press the button using right thumb. slot for Orange wire will be open.</p></div><div><p>3. Get the Orange wire and insert to connector 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>N/A</div> <div><p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing.</p><p>Important reminders/Note/s:</p><p>1. Please hold the wire near terminal during insertion.</p><p>2. Make sure wires are properly inserted.</p><p>Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</p><p>Document References:</p><p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</p><p>2. Refer to GL-PRO-ASY-028 for Pull-Push procedure.</p></div>			

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PARTS: 1. Assy parts

JIG:

1. Pushing jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

OFF-
LINE

Connector Lock

Connector lock sequence

Upper Lock

Lower lock

1

1. Hold the connector using left hand and then place it on the table. Get the pushing jig and hit the upper lock of the connector and then push down to lock.

2

2. Hit the lower lock of the connector and then push down to lock.

2

2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.

Before Pressing

After Pressing

PUSHING JIG



Important reminders/Note/s:
1. **MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR.**

1. Use the provided jig per connector
2. No unlock/half-locked connector

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PARTS:

1. Assy parts

JIG:

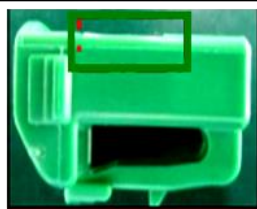
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2

VISUAL INSPECTION/QUALITY CHECKPOINTS

OFFLINE INSERTION

7N0173-7020



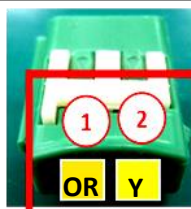
GOOD



GOOD



NO GOOD



NO GOOD



GOOD



NO GOOD

① No Unlock/
Halflock
Connector

② No Wrong Insert

③ No Terminal Backing Out

④ No Deformed Terminal

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