



## WORK INSTRUCTION

Process Name/Title:

## OFFLINE ASSEMBLY PROCESS

Effectivity Date:

August 15, 2024

Model code/Part number:

177D / 7L0129-7020A

Customer:

TRQSS

Car Model:

TOYOTA COROLLA

Document No.:

WI-ENG-PDE-1004

Purpose:

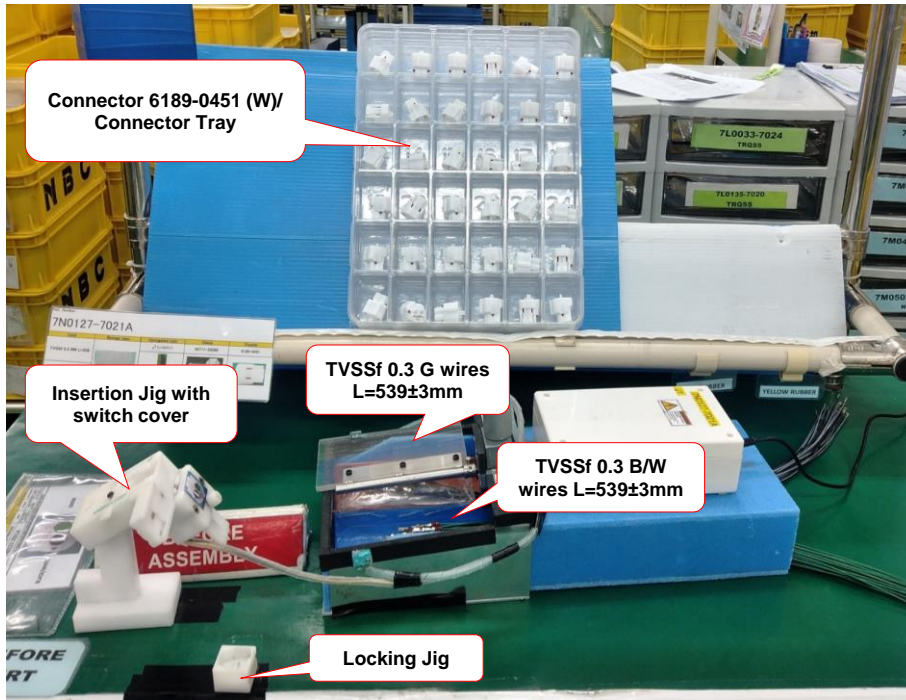
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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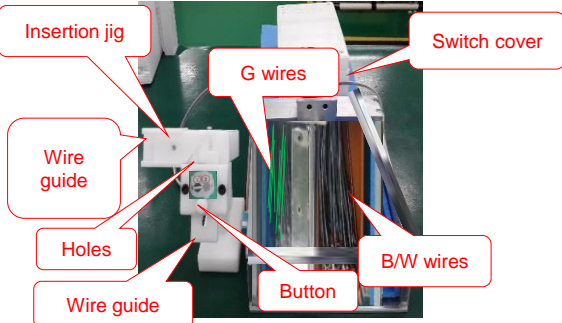
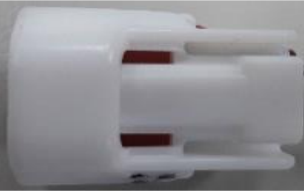
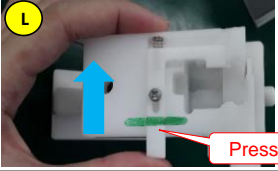
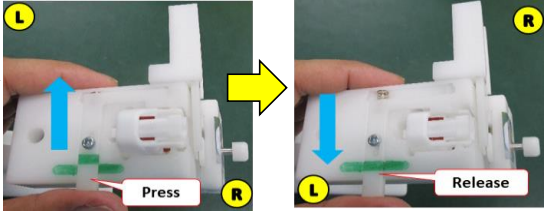
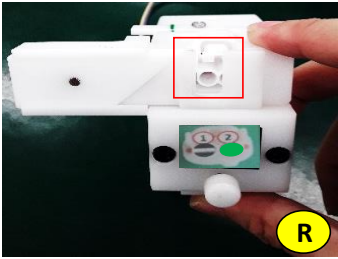

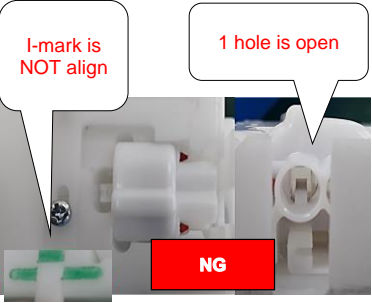
PARTS:		1. Connector 6189-0451 (W); TVSSf 0.3 G wires L=539±3mm; TVSSf 0.3 B/W wires L=539±3mm				JIG:		1. Insertion jig with switch cover 2. Locking jig					
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS					
1	OFFLINE	<div>TABLE LAY-OUT</div> 				<div><b>Safety Instruction</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 reference/s:</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	
08/15/24 0 Initial issue. Separate Connector setting and wire insertion to connector process from Taping assembly process due to process improvement. Aligned switch cover to insertion jig.						D.Castillo		C. Villanueva		A. Arañes		n/a	
Eff. Date Rev. No Details of Change						Revised		Reviewed		Approved		Noted	
						Est. Date:		August 15, 2024					

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<b>PARTS:</b>	1. Connector 6189-0451 (W)			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	<div><div>INSERTION JIG WITH SWITCH COVER</div><div></div><div><div>Connector Orientation</div></div><div><div>1. Press the lock of insertion jig using left thumb.</div></div><div><div>2. Insert the connector <b>6189-0451 (W)</b> into jig using right hand and release the lock.</div></div><div><div>3. Push the guide using right hand. The slot for <b>B/W wire</b> will be open.</div></div></div>			n/a	<div>Connector Orientation Illustration</div> <div><div>GOOD</div></div> <div><div>NG</div></div> <div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</div>		

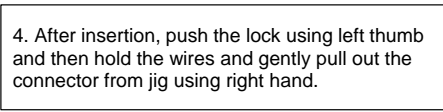
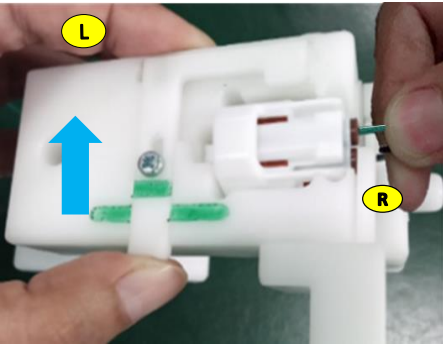
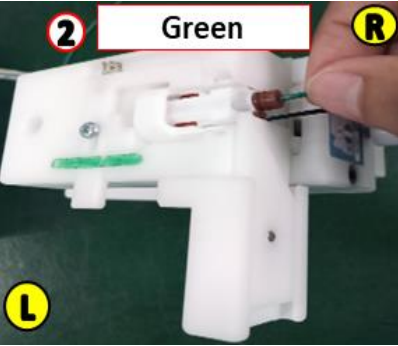
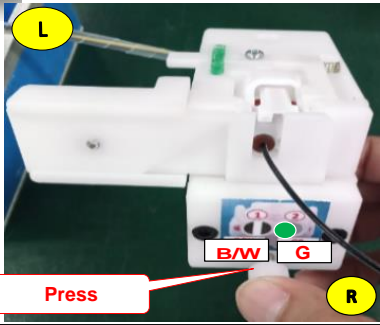

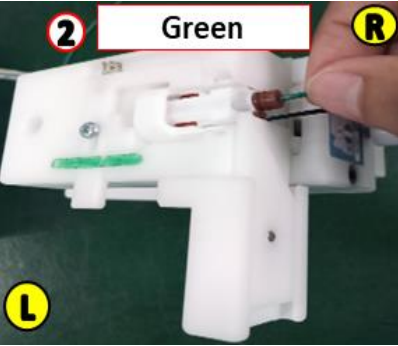
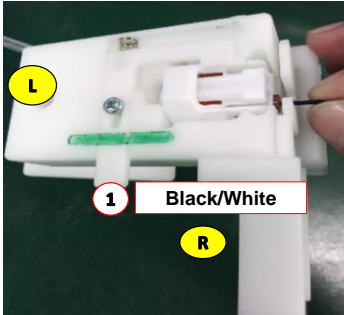
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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	3 of 6


<b>PARTS:</b>	1. TVSSf 0.3 B/W wire L=539±3mm 2. TVSSf 0.3 G wire L=539±3mm			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>
3	OFFLINE Wire insertion to Connector 6189-0451 (W)	<div><p>1. Get the <b>B/W wire</b> then insert to terminal slot ① using right hand.</p><p>2. After insertion of <b>B/W wire</b> press the button using right hand. The slot for <b>G wire</b> will be open.</p><p>3. Get the <b>G wire</b> then insert to terminal slot ② using right hand.</p><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>		n/a	<p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length Tolerance</p> <p>2.Refer to <b>GL-PRO-ASY-029</b> for Pull-Push procedure.</p> <p><b>Important reminder/ Note/s:</b></p> <p>1. Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> 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>

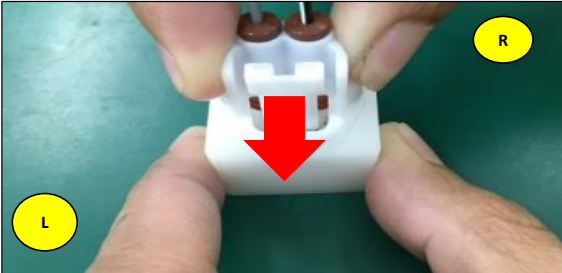
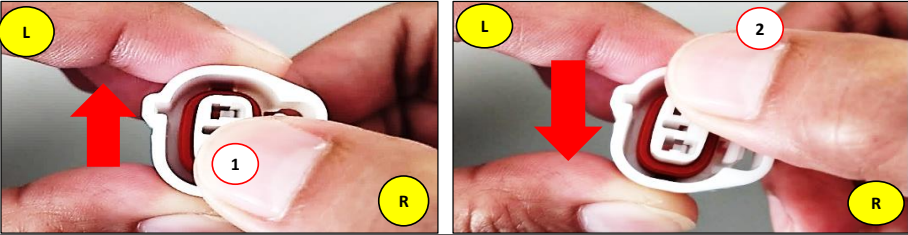
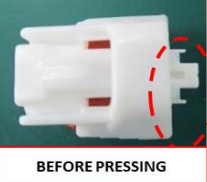
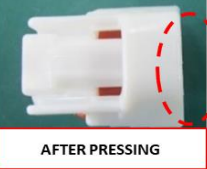




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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	4 of 6

PARTS:	1. Assy parts			JIG:	1. Locking Jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
4	OFFLINE Connector Lock	<div><p>1. Put the connector into locking jig using right hand. Then press to lock 2x using both hands.</p></div> <div><p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div> <div><p>BEFORE PRESSING</p><p>AFTER PRESSING</p><div><p>GOOD</p><p>NG</p><p>Check the double lock deformation</p></div></div> <td><div>LOCKING JIG</div></td> <td colspan="3"><p><b>Important reminder/ Note/s:</b></p><p>1. Manual locking may cause damaged connector lock.</p><p>1. No wrong usage of parts 2. No deformed terminal</p></td>		<div>LOCKING JIG</div> 	<p><b>Important reminder/ Note/s:</b></p> <p>1. Manual locking may cause damaged connector lock.</p> <p>1. No wrong usage of parts 2. No deformed terminal</p>		

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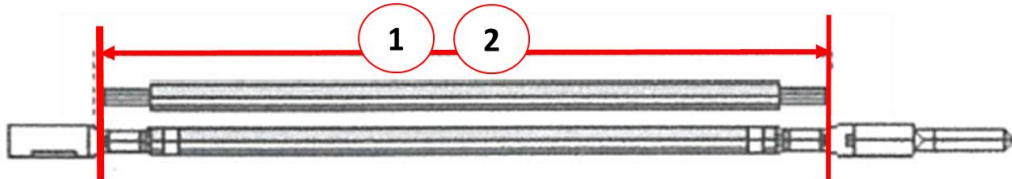


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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	OFFLINE	Measurement	<div><p>Note:</p><p>1. Measurement point: End of core wire to the end of core wire</p><p>2. Terminal is reference only.</p></div> <div></div> <div></div> <div><div>MEASURING TAPE</div></div>	<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated /verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection.</p>	
			1.No wrong dimension		

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**PARTS:**

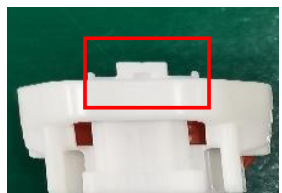
1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7L0129-7020A**

①

**GOOD****NO GOOD**

③

**GOOD****NO GOOD**① No **Unlocked/ Half-Locked Connector**② No **Wrong Insert**③ No **Terminal Backing Out**

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