



## WORK INSTRUCTION

## OFFLINE ASSEMBLY PROCESS

Effectivity Date:

November 24, 2023

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

382D / 7N0185-7020B

Customer: TRJ

Car Model: TOYOTA-CAMRY

Document No.:

WI-ENG-PDE-765

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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## PARTS:

1. All parts: Connector 6098-3802 (W)
2. AVSSf 0.3 B wires L=637±3mm
3. Black Corrugated tube (no slit) ø5 L=474±4mm

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

n/a

TABLE LAY-OUT

## TABLE LAY-OUT

Connector 6098-3802  
(W) Connector TrayBlack Corrugated tube  
ø5 L=474±4mm (no slit)

Insertion jig

Locking jig

AVSSf 0.3 B wires  
L=637±3mm

## 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

Prepared by

Reviewed by

Approved by

Noted by

11/24/23 0 Initial issue

A.Hernandez C.Villanueva A. Arañes n/a

A.Hernandez

C.Villanueva

A. Arañes

n/a

Eff. Date Rev. No Details of Change

Revised Reviewed Approved Noted

Est. Date:

November 24, 2023

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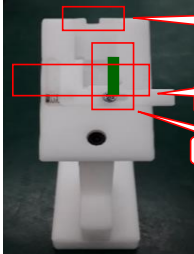
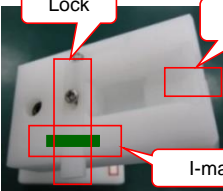

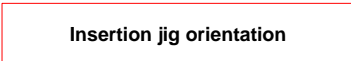
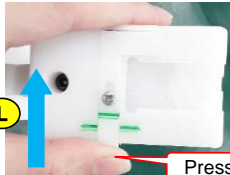
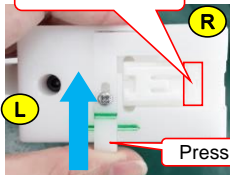
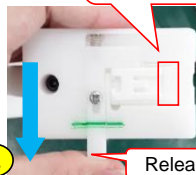



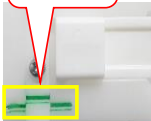



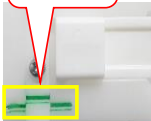

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PARTS:	1. Connector 6098-3802 (W)			JIG:	1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	n/a	<div><div><div>Insertion jig</div><div></div></div><div><div>Lock</div><div></div></div><div><div>Connector orientation</div><div></div></div><div><div>Insertion jig orientation</div><div></div></div></div> <div><div><div></div><div></div><div></div></div><div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Get the connector 6098-3802 (W) and insert into jig using right hand and release the lock using left hand.</div></div><div><div></div><div>3. Check the holes/terminal slot for B/B wires.</div></div></div> <div>n/a</div> <td><div><div>Connector Orientation Illustration</div><div><div><div>I-mark is align</div></div><div><div>2 Holes are open.</div></div></div><div><div><div>I-mark is not</div></div><div><div>All Holes are open.</div></div></div><div><div>1. Use provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div></div></div></td>			<div><div>Connector Orientation Illustration</div><div><div><div>I-mark is align</div></div><div><div>2 Holes are open.</div></div></div><div><div><div>I-mark is not</div></div><div><div>All Holes are open.</div></div></div><div><div>1. Use provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div></div></div>	

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PARTS:	2. Black Corrugated tube ø5 L=474±4mm (no slit)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	n/a  Wire Insertion to Black Corrugated tube ø5 L=474±4mm (no slit)	<div></div> <div>1. Get the <b>Black corrugated tube ø5 L=474±4mm (no slit)</b> using left hand and get <b>B-B wires</b> using right hand then insert.</div>	n/a	1. No wrong usage of parts. 2. No deformed terminal

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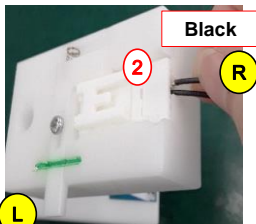
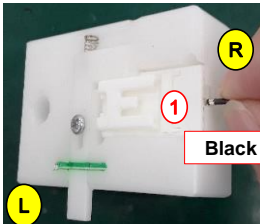

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PARTS:	1. AVSSf 0.3 B L=637±3mm [2 pcs]		JIG:	1.Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	n/a  Wire insertion to connector 6098-3802 (W)	<div><div><div>Wire Terminal Facing</div><div>Connector Facing</div></div><div><div>Black</div><div>Black</div><div>Black</div><div>1. Get the first <b>Black wire</b> and insert to <b>Slot 3</b> of connector using right hand. <b>Note : Insertion should be left to right.</b></div><div>2. Get the second <b>Black wire</b> and insert to <b>Slot 4</b> of connector using right hand.</div><div><div>3. After insertion, push the lock using left thumb, hold the wires and gently pull out the connector from jig using right hand.</div></div></div><div>n/a</div><td><div>1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing</div><div><b>Important reminder's/Note:</b> <b>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b> <b>Please hold the wire near terminal.</b></div><div><b>Document references:</b> <b>1. Refer to WI-PRO-CNC-017 for Wire Strip lenght tolerance.</b> <b>Refer to GL PRO-ASY-029 for pull-push-pull-push procedure</b></div></td></div>	<div>1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing</div> <div><b>Important reminder's/Note:</b> <b>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b> <b>Please hold the wire near terminal.</b></div> <div><b>Document references:</b> <b>1. Refer to WI-PRO-CNC-017 for Wire Strip lenght tolerance.</b> <b>Refer to GL PRO-ASY-029 for pull-push-pull-push procedure</b></div>	

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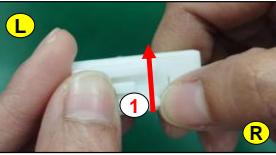

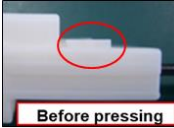
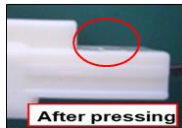


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PARTS:	1. Assy Parts			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	n/a Connector lock	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div> <div><p>2. 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 thumb-middle Left</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><b>LOCKING JIG</b></div> 	<p>1. Use the provided jog per model 2. No unlocked/half-locked connector</p> <p><b>Important reminders/Note/s:</b></p> <p><b>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR LOCK</b> <b>2. Use provided jig tool per model to avoid damaged lock.</b></p> <p><b>Document references:</b></p> <p><b>1. Refer to GL-PRO-ASY-017 for the verification of connector lock.</b></p> <div><p>Before pressing</p><p>After pressing</p></div> <div><div><b>GOOD</b> <p>Full Lock</p></div><div><b>NG</b> <p>Half Lock</p></div></div>

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PARTS:

n/a

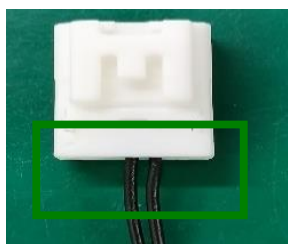
JIG:

n/a

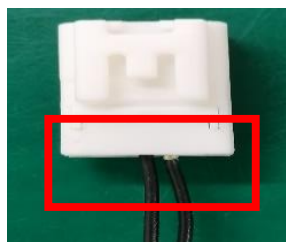
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## OFFLINE INSERTION

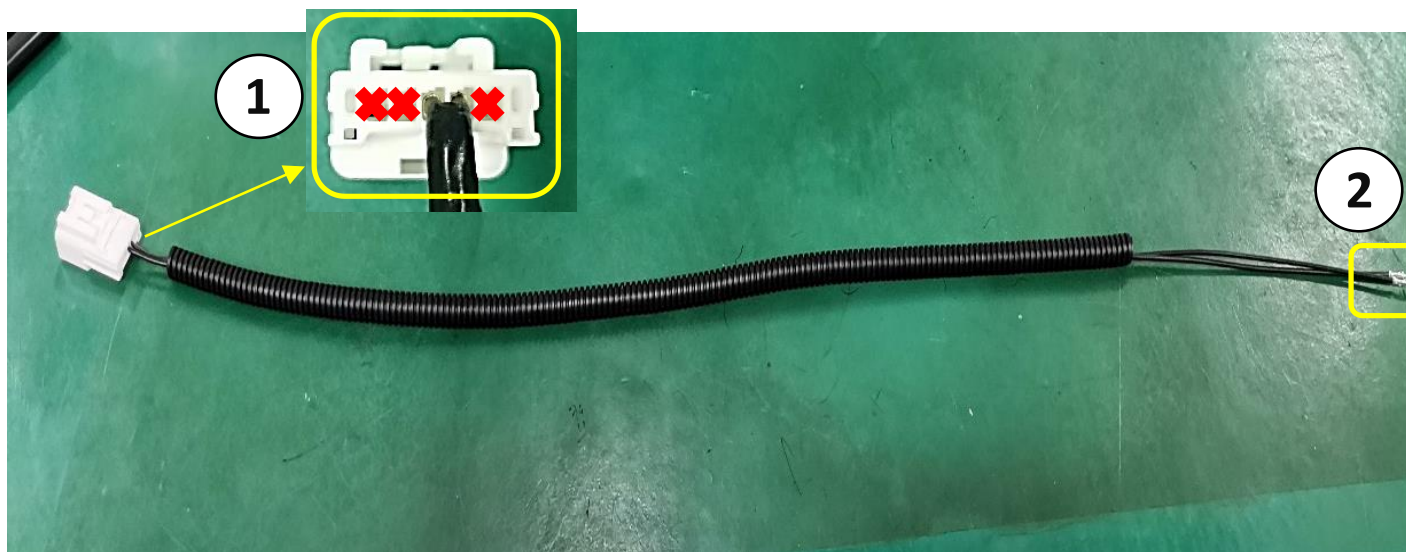
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GOOD



NO GOOD



1

No Unlock/Halflock Connector

2

No Deformed Terminal



GOOD



NO GOOD

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