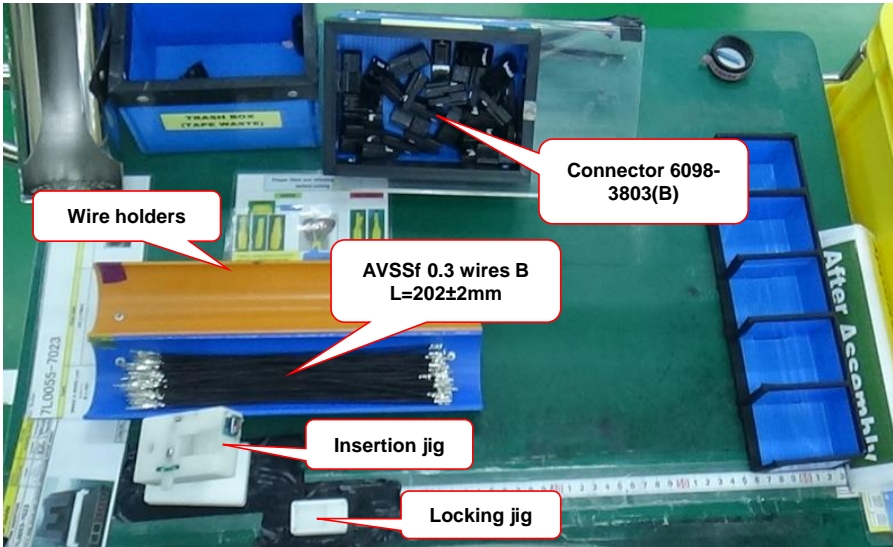
	WORK INSTRUCTION				Effectivity Date:		March 15, 2025		
	OFFLINE ASSEMBLY PROCESS				Validity Date:		n/a		
	Process Name/Title:		Model code/Part number: 311D / 7L0157-7022		Customer: TRQSS		Car Model: TOYOTA RAV4		
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.:		WI-ENG-PDE-1203		
				Revision No.:		1		Page No.: 1 of 6	

PARTS:		1. Connector 6098-3803 (B) 2. AVSSf 0.3 B L=202±2mm				JIG:		1. Insertion Jig 2. 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	Checked by	Reviewed by	Approved by
03/15/25	1	Change document purpose from pre-launch to mass pro.						A.Hernandez	J.Loterte	C. Villanueva	A. Arañes
02/24/25	0	Initial issue.						A.Hernandez	n/a	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change						Revised	Checked	Reviewed	Approved

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WORK INSTRUCTION

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Process Name/Title:

Model code/Part number:

311D / 7L0157-7022

Customer:

TRQSS

Car Model:

TOYOTA RAV4

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

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n/a

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PARTS:	1. Connector 6098-3803 (B)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	n/a Connector Setting to Insertion jig 6098-3803 (B)	<div><div><div>Insertion jig</div><div>Holes</div><div>Visual reference</div><div>Push button</div></div><div><div>Insertion jig orientation</div><div>I-Mark</div><div>CONNECTOR ORIENTATION</div></div><div><div><div><div>↑</div><div>L</div><div>Press</div></div><div><div>↑</div><div>R</div><div>Press</div></div><div><div>↓</div><div>L</div><div>Release</div></div></div><div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the Connector 6098-3803 (B) into jig using right hand and release the lock.</div><div><div>3. Check the holes/terminal slot for B-B wires.</div></div></div></div></div>	n/a	<div><div>Connector Orientation Illustration</div><div><div>I-mark is align</div><div>2 Holes are open</div><div>GOOD</div></div><div><div>I-mark is not align</div><div>All holes are open</div><div>NG</div></div><div><div>1. Use the provided jig per model</div><div>2. No wrong orientation of connector</div></div></div>

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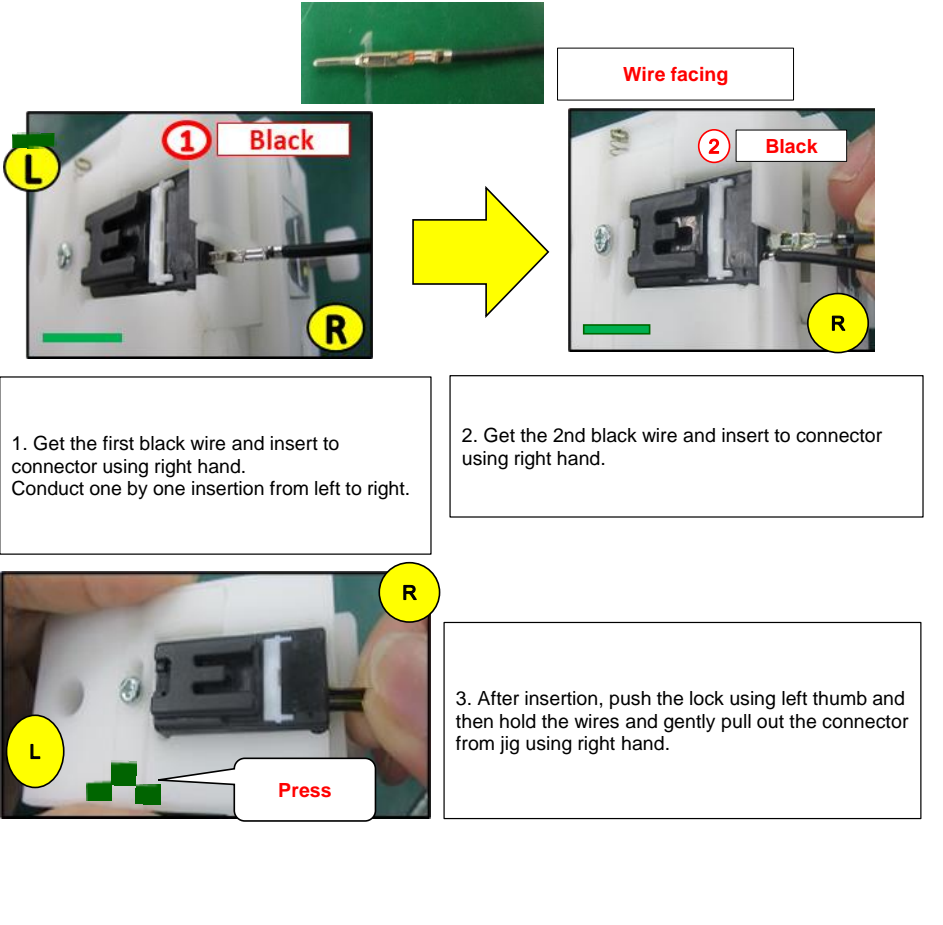
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PARTS:	1. AVSSf 0.3 B L=202±2mm [2 pcs.]			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a Wire insertion to connector 6098-3803 (B)	<div data-bbox="542 389 1482 1318"><p>1. Get the first black wire and insert to connector using right hand. Conduct one by one insertion from left to right.</p><p>2. Get the 2nd black wire and insert to connector using right hand.</p><p>3. 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>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 deform terminal 5. No wrong wire facing</p> <p>Document references:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</p>

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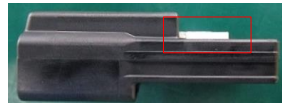
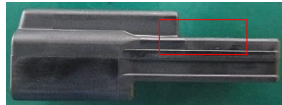


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PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	n/a	Connector Lock	<div>LOCKING JIG</div> 	<div>1. No Unlock and half-locked</div> <div>2. Use provided jig tools per model to avoid damaged lock.</div> <div>Important reminders/Note/s:</div> <div>1. Manual locking may cause damaged connector</div> <div>Document references:</div> <div>1.Refer WI-PRO-KIT-001 Proper locking and checking of connector lock</div> <div><div><div>Before pressing</div></div><div><div>After pressing</div></div><div><div><div>GOOD</div><div>Full Lock</div></div><div><div>NG</div><div>Half Lock</div></div></div></div>

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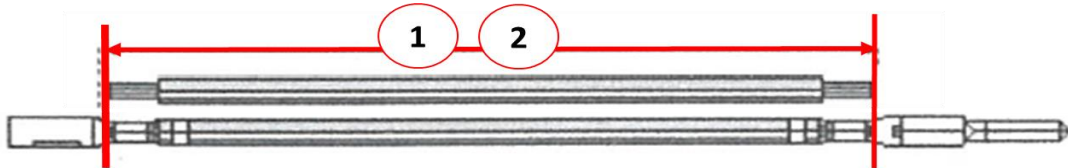


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PARTS:	1. Assy parts		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
5	n/a	Measurement	<div>Note: 1. Measurement point: End of core wire to the end of core wire 2. Terminal is reference only.</div> <div></div> 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

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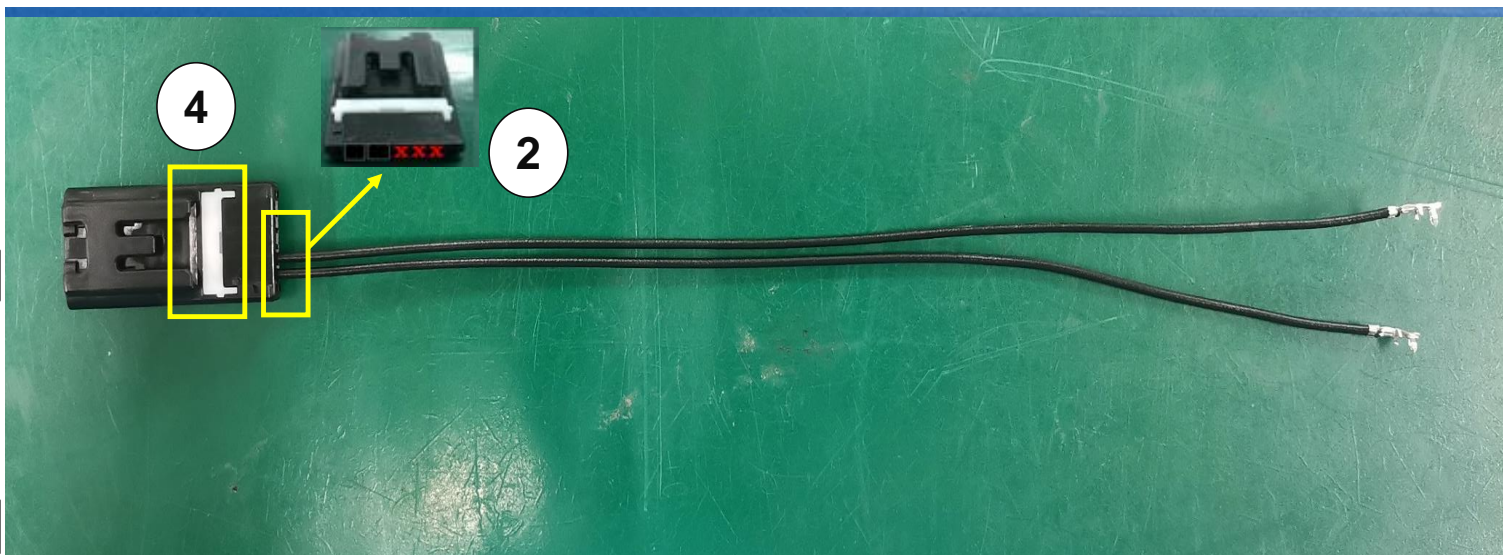
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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**OFFLINE INSERTION****7L0157-7022****1****GOOD****NO GOOD****4****2****3****GOOD****NO GOOD****1** No **Unlock** connector**3** No **Terminal Backing Out****2** No **Wrong** insert**4** No **Deform** terminal**5** Check the **Alignment**

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