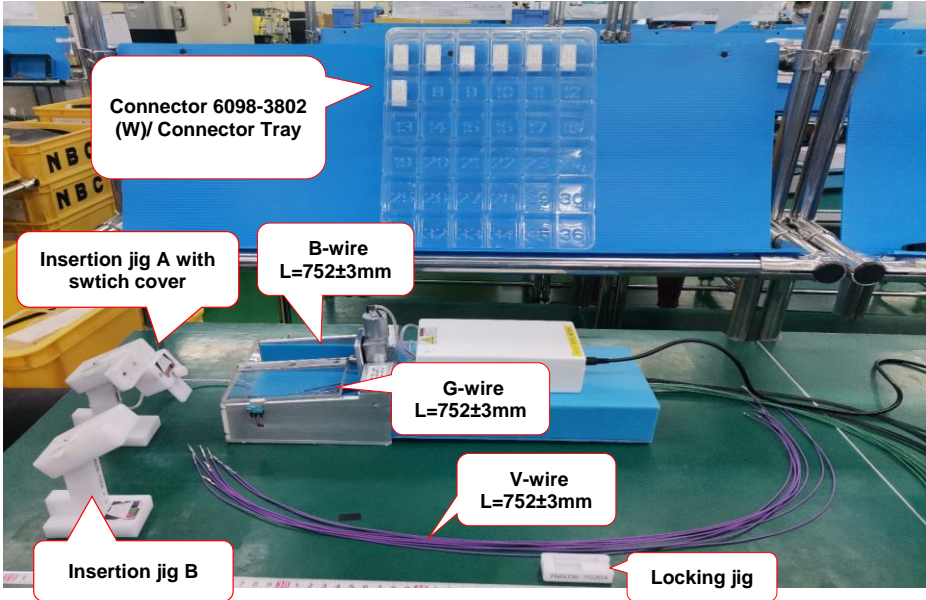
	WORK INSTRUCTION				Effectivity Date:	January 23, 2024	
	OFFLINE ASSEMBLY PROCESS				Validity Date:	n/a	
	Process Name/Title:		Model code/Part number: 700B / 7N0038-7020A	Customer: TRJ	Car Model: TOYOTA LAND-CRUISER	Document No.: WI-ENG-PDE-815	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.: 0	Page No.: 1 of 7

PARTS:		1. Connector 6098-3802 (W) 2. AVSSf 0.3 wires G-B-V L=752±3mm				JIG:		1. Insertion jig A with switch cover 2. Insertion jig B 3. Locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	n/a	<div style="text-align: center; border: 1px solid red; padding: 5px; margin-bottom: 10px;">TABLE LAY-OUT</div> 				<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>		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
01/23/24	0	Initial issue.				A.Hernandez	C.Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted
						Est. Date:	January 23, 2024		

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WORK INSTRUCTION

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

January 23, 2024

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700B / 7N0038-7020A

Customer: TRJ

Car Model: TOYOTA LAND-CRUISER

Validity Date:

n/a

Document No.:

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

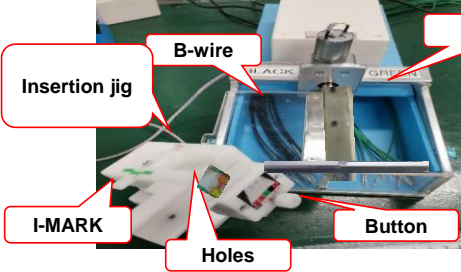
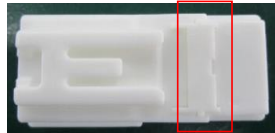
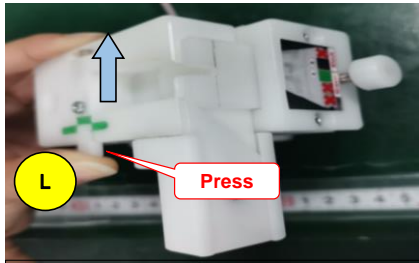

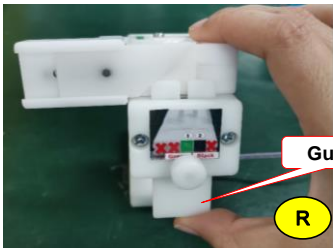
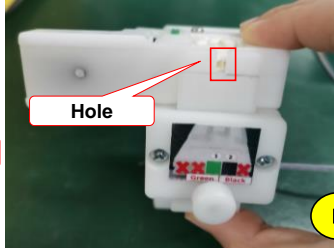
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PARTS:		1. Connector 6098-3802 (W)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	n/a	<p>Connector setting to insertion jig 6098-3802 (W)</p> <p>INSERTION JIG WITH SWITCH COVER</p>  <p>CONNECTOR ORIENTATION</p>   <p>Press</p> <p>1. Press the lock of insertion jig using left thumb.</p>  <p>Release</p> <p>2. Insert the connector 6098-2220 (W) into jig using right hand and release the lock. Note: Follow the connector orientation.</p>  <p>Guide</p> <p>3. Push the guide using left hand. The slot for G wire will be opened.</p>  <p>Hole</p>		N/A	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p>Important reminders/Note/s:</p> <p>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.</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p>

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WORK INSTRUCTION

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

January 23, 2024

Process Name/Title:

Model code/Part number:

700B / 7N0038-7020A

Customer: TRJ

Car Model: TOYOTA LAND-CRUISER

Validity Date:

n/a

Document No.:

WI-ENG-PDE-815

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH




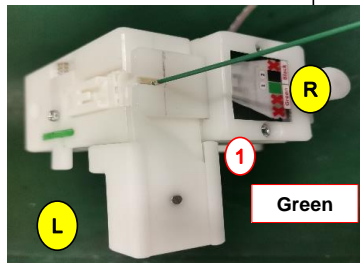
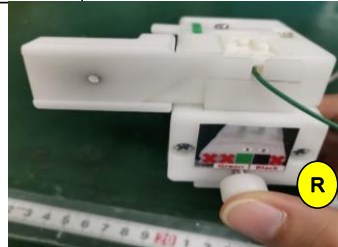
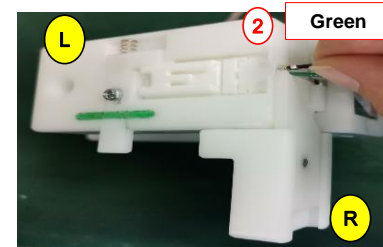
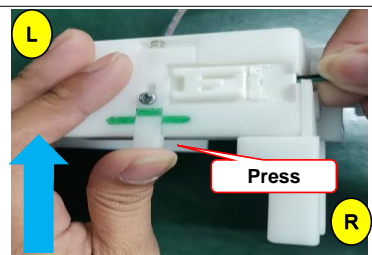
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PARTS:		1. Connector 6098-3802 (W) 2. AVSSf 0.3 G L=752±3mm 3. AVSSf 0.3 B L=752±3mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a Wire insertion to connector 6098-3802 (W)	<div><div><p>Visual reference</p></div><div><p>Connector Facing</p></div><div><p>Wire Terminal Facing</p></div><div><p>1. Get the first Green wire and insert to Slot 1 of connector using right hand.</p></div><div><p>2. Press the button using right thumb and slot for Black wire will be open.</p></div><div><p>3. Get the first Black wire and insert to Slot 2 of connector using right hand.</p></div><div><p>4. After insertion, push the lock using left thumb, hold the wires and gently pull out the connector from jig using right hand.</p></div></div> <td>N/A</td> <td><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: 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.</p><p>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</p></td>		N/A	<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: 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.</p> <p>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</p>

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WORK INSTRUCTION

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700B / 7N0038-7020A

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Document No.:

WI-ENG-PDE-815

Purpose:

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☐ PRE-LAUNCH

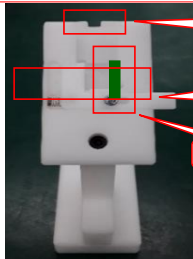
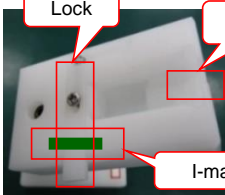

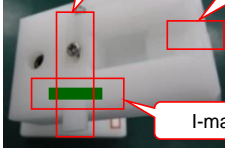
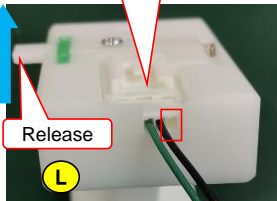
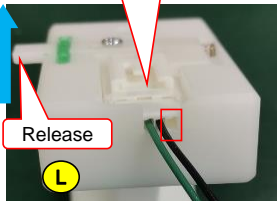
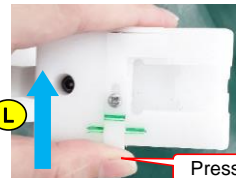
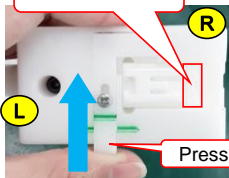
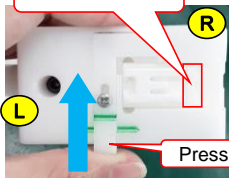


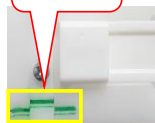
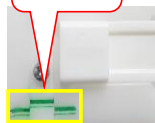
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PARTS:		1. Connector 6098-3802 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	n/a	<div><div><div><div><div>Insertion jig</div><div></div></div><div><div></div><div><div>Connector orientation</div><div></div></div></div><div><div><div>Insertion jig orientation</div><div></div></div><div><div><div>Connector Lock</div><div></div></div><div><div><div>Release</div><div></div></div></div><div><div><div>Press</div><div></div></div><div><div><div>Press</div><div></div></div><div><div><div>Connector Lock</div><div></div></div></div></div><div><div><div>1. Press the lock of insertion jig using left thumb.</div></div><div><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>3. Check the holes/terminal slot for V wires are open.</div></div></div></div></div></div></div></div></div></div></div>		n/a	<div><div><div>Connector Orientation Illustration</div><div><div><div>I-mark is align</div><div></div></div><div><div>3 Holes are open.</div><div></div></div></div><div><div><div>I-mark is not</div><div></div></div><div><div>All Holes are open.</div><div></div></div></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></div>

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**WORK INSTRUCTION****OFFLINE ASSEMBLY PROCESS**

Effectivity Date:

January 23, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

700B / 7N0038-7020A

Customer: TRJ

Car Model: TOYOTA LAND-CRUISER

Document No.:

WI-ENG-PDE-815

Purpose:




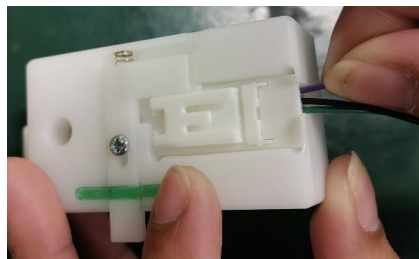

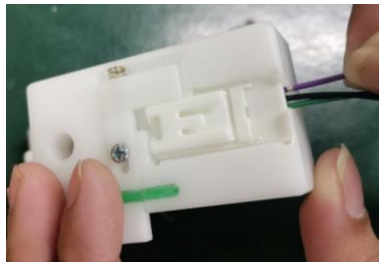
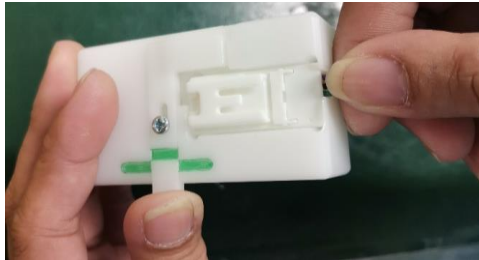
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. AVSSf 0.3 V L=752±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	n/a	<div><div> Visual reference</div><div> Connector Facing</div><div><div>Wire Terminal Facing</div></div></div>		N/A	<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>Important reminders/Note/s: 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 2. Please hold the wire near terminal</div> <div>Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</div>
		<div><div></div><div>1. Hold the insertion jig using left hand. Get the Violet wire and insert to connector using right hand.</div></div>			
		<div><div></div><div>2. After insertion, hold the wires and gently pull out the connector from jig using right hand.</div></div>			

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☐ PROTOTYPE

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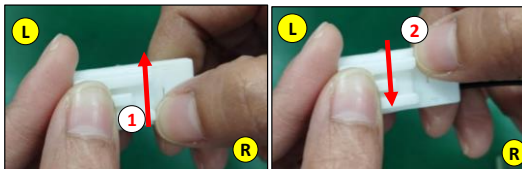



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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	n/a	Connector lock	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div> <div><p>2. 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 Left thumb-middle</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>LOCKING JIG</div> 	<div>1. Use provided locking jig per model. 2. No unlock/half-locked connector.</div> <div><p>Important reminder/Note/s:</p><p>1. Manual locking may cause damaged connector lock</p></div> <div><div><p>GOOD</p><p>Full Lock</p></div><div><p>NG</p><p>Half Lock</p></div></div>

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☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:

n/a

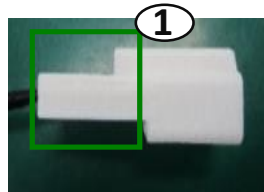
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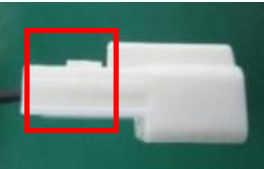
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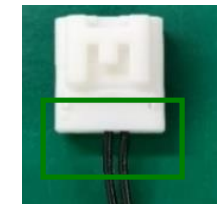
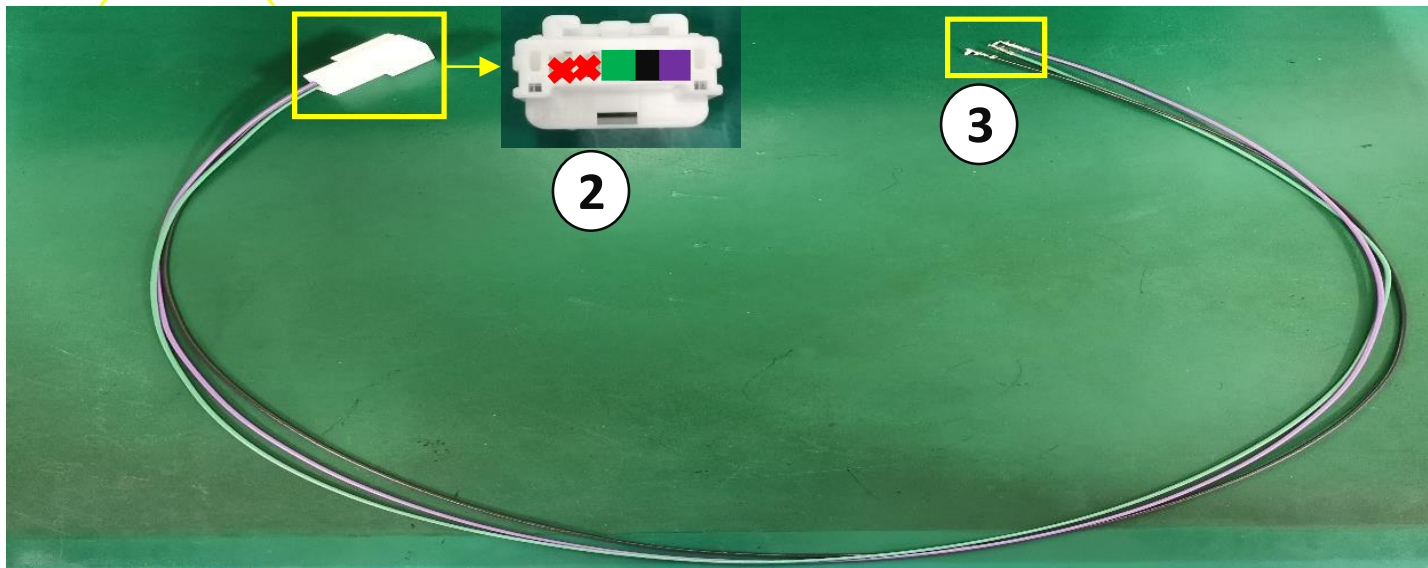
7N0038-7020A



GOOD



NO GOOD



GOOD



NO GOOD

1 No **Unlock/**
Halflocked Connector
(on connector)

2 No **Wrong Insert**
(on connector)

3 No **Deformed**
terminal

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