



## WORK INSTRUCTION

## OFFLINE ASSEMBLY PROCESS

Effectivity Date:

November 24, 2023

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

382D / 7N0186-7020B

Customer: TRJ

Car Model: TOYOTA-CAMRY

Document No.:

WI-ENG-PDE-767

Purpose:

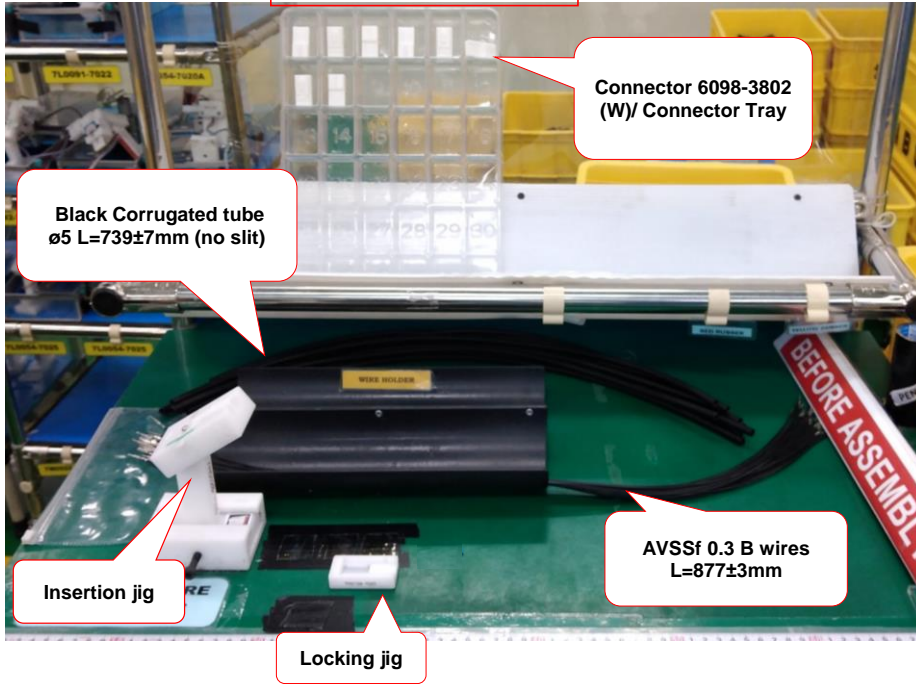
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

0

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PARTS:		1. All parts: Connector 6098-3802 (W) 2. AVSSf 0.3 B wires L=877±3mm 3. Black Corrugated tube (no slit) ø5 L=739±7mm		JIG:	1. Locking jig 2. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	n/a	<p><b>TABLE LAY-OUT</b></p> 		<p><b>Safety Instruction</b> Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p><b>Document reference/s:</b> 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	Reviewed by
				Approved by	Noted by
11/24/23	0	Initial issue		A. Hernandez	C. Villanueva
Eff. Date	Rev. No	Details of Change		Revised	Reviewed
				Approved	Noted
				Est. Date:	November 24, 2023

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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>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></div>		n/a	<div><div>Connector Orientation Illustration</div><div><div></div><div></div></div><div><div></div><div></div></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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<b>PARTS:</b>		1. Assy parts 2. Black Corrugated tube $\varnothing 5$ L=739 $\pm$ 7mm (no slit)		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
3	n/a	<div>Wire Insertion to Black Corrugated tube <math>\varnothing 5</math> L=739<math>\pm</math>7mm (no slit)</div> <div></div> <div>1. Get the <b>Black corrugated tube <math>\varnothing 5</math> L=739<math>\pm</math>7mm (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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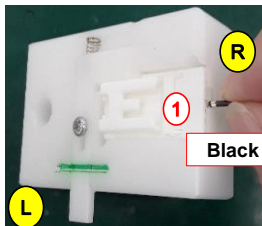
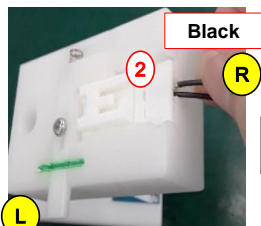


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PARTS:	1. AVSSf 0.3 B L=877±3mm [2 pcs]		JIG:	1.Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	n/a  Wire insertion to connector 6098-3802 (W)	<div><div></div><div></div><div>Wire Terminal Facing</div><div></div><div>Connector Facing</div></div> <div><div></div><div></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><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>n/a</div> <div><div>1. No wrong orientation of connector</div><div>2. No wrong use of connector</div><div>3. No damaged connector</div><div>4. No wrong insertion of wires</div><div>5. No loose insertion</div><div>6. No wrong insertion</div><div>7. One by one insertion</div><div>8. No deformed terminal</div><div>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></div>		

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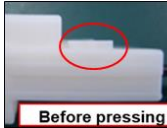



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		Car Model:	TOYOTA-CAMRY
Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO

PARTS:	1. Assy Parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	n/a	<div><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></div></div> <div><div>LOCKING JIG</div></div> <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>GOOD NG</div><div><p>Full Lock</p><p>Half Lock</p></div></div></div>		

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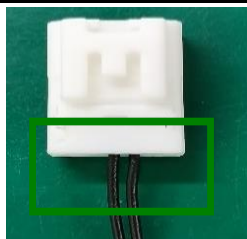
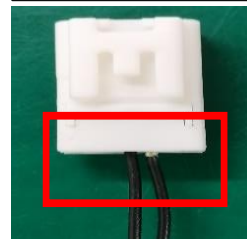
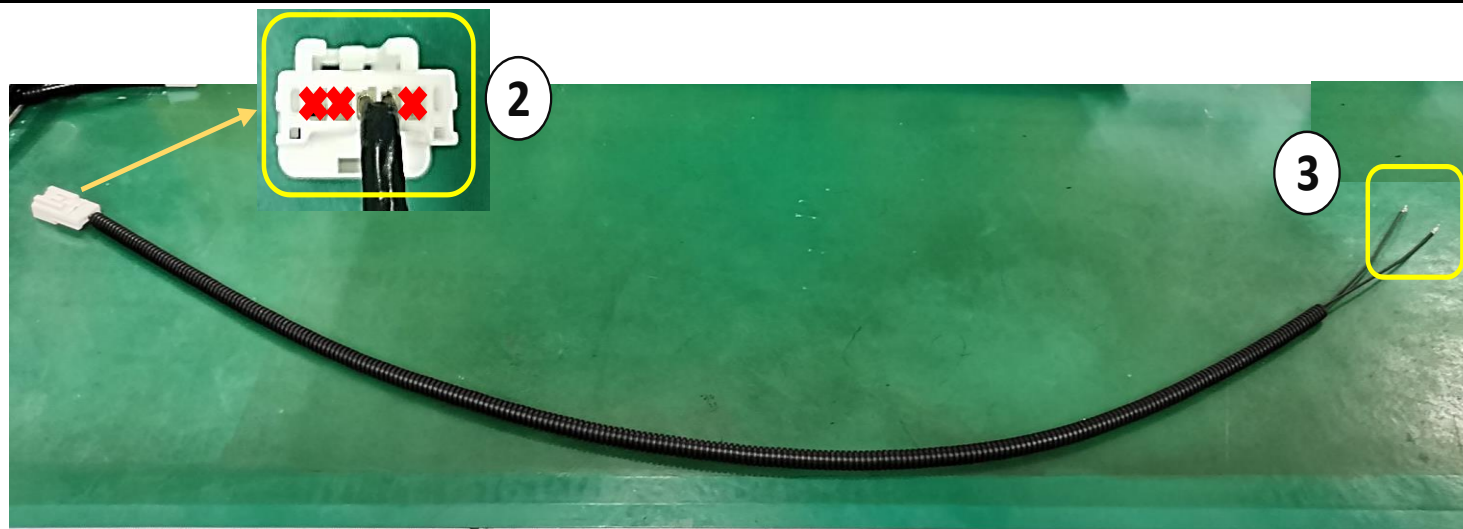
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PARTS:

n/a

JIG:

n/a

**QUALITY CHECKPOINTS****OFFLINE INSERTION****7N0186-7020B****GOOD****GOOD****NO GOOD****NO GOOD**

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

② No **Wrong Insert** (on 1 connector)

③ No **Deformed Terminal**

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