



WORK INSTRUCTION

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

February 28, 2024

Model code/Part number:

310D / 7N0193-7020A

Customer: TRJ

Car Model: TOYOTA RAV4

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-859

Revision No.:

0

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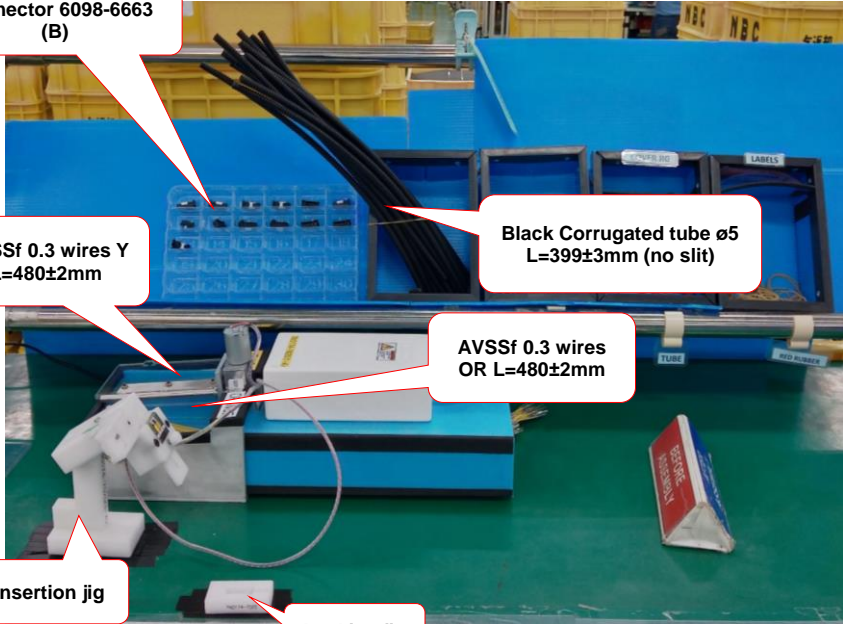
PARTS:

1. Connector 6098-6663(B)
2. AVSSf 0.3 wires Y-OR L=480±2mm

3. Black Corrugated tube ø5 L=399±3mm (no slit)

JIG:

1. Insertion jig with switch cover
2. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	n/a	Table Lay-out 	<p>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<ol style="list-style-type: none">1. No missing parts/tools2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
02/28/24	0	Initial issue	A.Hernandez	C.Villanueva	A. Arañes	n/a	A.Hernandez	C.Villanueva	A. Arañes	n/a
Est. Date:							February 28, 2024			

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PARTS:	1. Connector 6098-6663(B)		JIG:	1. Insertion jig with Switch Cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	n/a	Connector Settings	n/a	<div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</div> <div><div>Connector Orientation Illustration</div><div><div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div></div><div><div>I-mark is NOT align</div><div>1 hole is open</div><div>NG</div></div></div></div>

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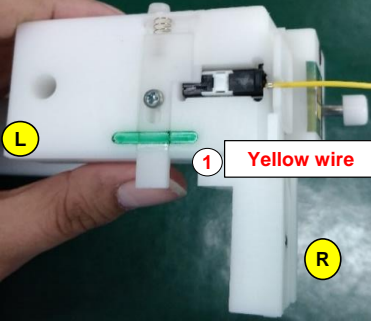
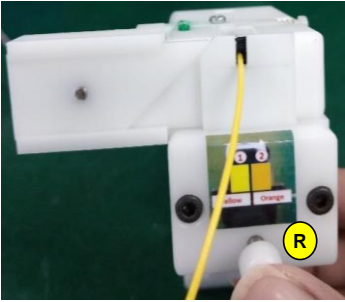
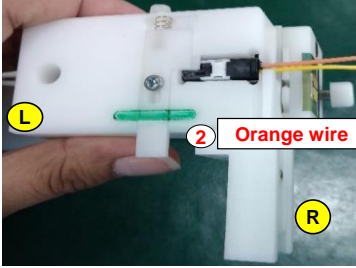
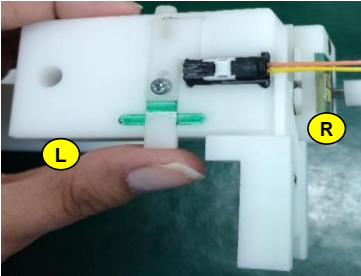
☒ MASSPRO

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PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a Wire insertion to connector 6098-6663 (B)	<div data-bbox="781 387 1182 435"> Wire facing</div> <div data-bbox="568 448 943 770"> 1 Yellow wire</div> <div data-bbox="1055 461 1400 762"> 2 Orange wire</div> <div data-bbox="584 938 943 1206"> 2 Orange wire</div> <div data-bbox="1039 917 1400 1193"> 2 Orange wire</div> <div data-bbox="544 1214 976 1319"><p>1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot 1 using right hand.</p><p>3. Get the Orange wire then insert to terminal slot 2 using right hand.</p></div> <div data-bbox="1016 802 1420 900"><p>2. Press the button using right thumb. The slot for Orange wire will be opened.</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>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.</p>

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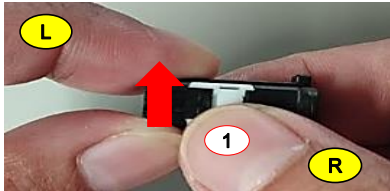
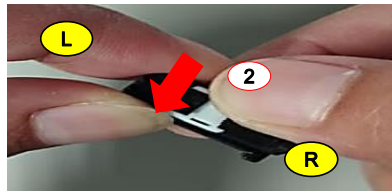




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PARTS:		1. Assy parts 2.Black Corrugated tube ø5 L=399±3mm (no slit)		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Connector lock n/a	<div></div> <div></div> <div></div> <div>1. Put the connector into locking jig using right hand then press to lock 2x using both hands.</div> <div>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</div> <div></div> <div>BEFORE PRESSING</div> <div></div> <div>AFTER PRESSING</div>		<div>LOCKING JIG</div> 	<p>Important reminders/Note/s:</p> <p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <p>1. Use the provided jig per connector 2. No unlock/half-locked connector</p>
5	Wire insertion to Black corrugated tube ø5 L=399±3mm (no slit)	 <div>1. Get the Black Corrugated tube ø5 L=399±3mm (no slit) using right hand then insert the Y-OR wires using left hand.</div>			<p>1. No wrong use of parts 2. No deformed terminal</p>

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PARTS:

n/a

JIG:

n/a

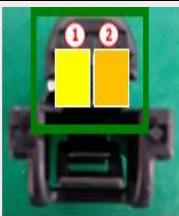
QUALITY CHECKPOINTS

n/a

7N0193-7020A



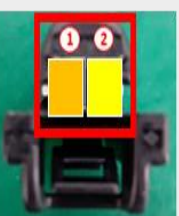
GOOD



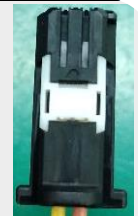
GOOD



NO GOOD



NO GOOD



GOOD



NO GOOD

- 1 No Unlock/Halflock Connector
- 2 No Wrong Insert
- 3 No Terminal Backing Out
- 4 No Deformed Terminal

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