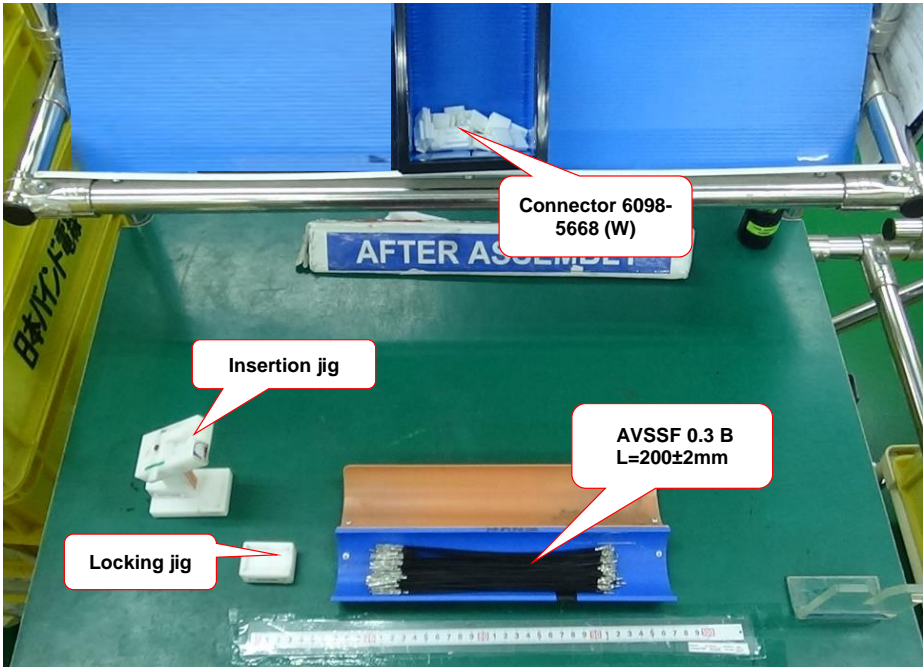
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	OFFLINE ASSEMBLY PROCESS			Validity Date:	n/a		
	Process Name/Title:			Document No.:	WI-ENG-PDE-898		
	Model code/Part number: 310D / 7N0189-7020A		Customer: TRJ	Car Model: TOYOTA RAV4	Revision No.: 0		
Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Page No.:	1 of 6		

PARTS:		Connector 6098-5668 (W), AVSSF 0.3 B wires L=200±2mm [2pcs.]		JIG:	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	Offline Table Lay-out	<div>TABLE LAY-OUT</div> 		<div><b>Safety Instruction</b> Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	<b>Document reference/s:</b> 1. Refer to <b>WI-PRO-CNC-017</b> 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
05/21/24	0	Initial issue. Transfer insertion to connector process to offline from taping assembly process.	A.Hernandez	C.Villanueva	A. Arañes	n/a	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: May 21, 2024



# WORK INSTRUCTION

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Purpose:

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☐ PRE-LAUNCH


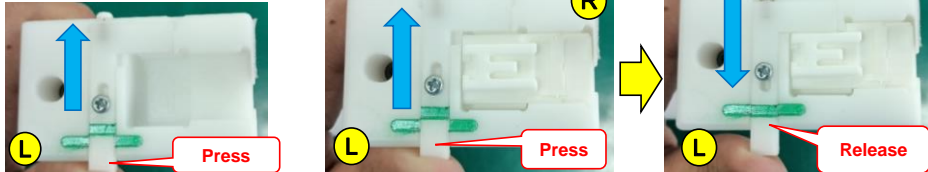

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PARTS:		1. Connector 6098-5668 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Offline Connector setting to insertion jig 6098-5668 (W)	<div><div>INSERTION JIG</div><div>Holes</div><div>Lock</div><div>I-mark</div><div>CONNECTOR ORIENTATION</div><div>INSERTION JIG ORIENTATION</div><div><div>Press</div><div>Press</div><div>Release</div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector <b>6098-5668 (W)</b> into jig using right hand then release the lock.</div><div></div><div>3. Check the holes/terminal slot for <b>B-B wires</b>.</div></div></div>		n/a	<div>CONNECTOR ORIENTATION ILLUSTRATION</div> <div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div><div>I-mark is not align</div><div>all holes are open</div><div>NG</div></div> <div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div>

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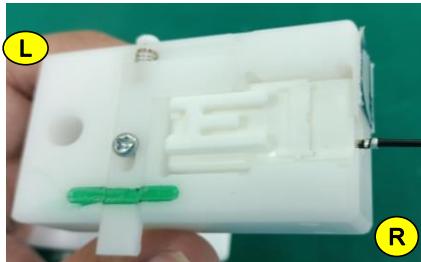
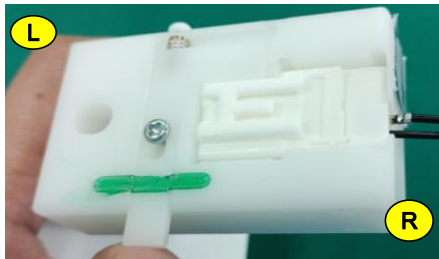

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PARTS:	1. AVSSf 0.3 B wires L=200±2mm [2pcs.]		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Offline  Wire insertion to Connector 6098-5668 (W)	<div><div>WIRE FACING</div></div> <div><div><div>1. Get the <b>1st B wire</b> then insert to connector using right hand.</div></div><div><div>2. Get the <b>2nd B wire</b> then insert to connector using right hand.</div></div><div><div>3. After insertion, push the lock button using left thumb then hold the wires and gently pull out the connector from jig using right hand.</div></div></div> <td>n/a</td> <td><p><b>Document reference/s:</b></p><p>1. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length Tolerance</p><p><b>Important reminders/note/s:</b></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 deformed terminal 5. No wrong wire facing</p></td>	n/a	<p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length Tolerance</p> <p><b>Important reminders/note/s:</b></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 deformed terminal 5. No wrong wire facing</p>

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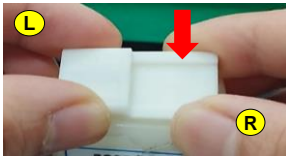



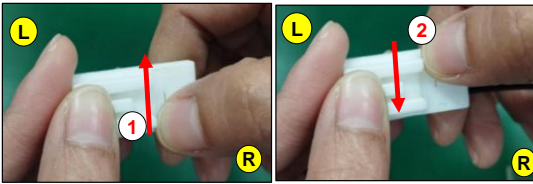





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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Offline Connector lock	<div><div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div><div><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 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>		<div>LOCKING JIG</div> 	<div><p>Before pressing</p><p>After pressing</p></div> <div><div><p>Full Lock</p></div><div><p>Half Lock</p></div></div>

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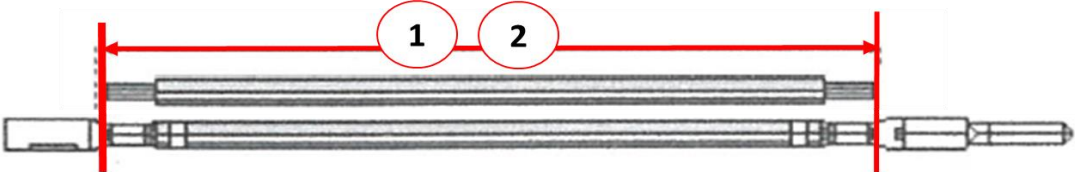


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Offline	Connector lock	<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><div>MEASURING TAPE</div></div>	<div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.  2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div>
			<div></div> <div><div>3</div><div>CONNECTOR TO TERMINAL 230±3mm</div></div>	<div>1. No wrong dimension</div>

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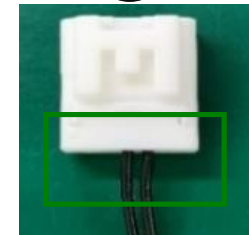
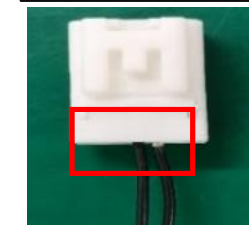
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PARTS:

n/a

JIG:

n/a

**VISUAL INSPECTION/QUALITY CHECKPOINTS****Offline****7N0189-7020****①****GOOD****NO GOOD****① No Unlock/Halflock Connector****②****② No Terminal Backing Out****③ No Wrong Insert****④****No Deformed Terminal****②****GOOD****NO GOOD**

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