



## WORK INSTRUCTION

Process Name/Title:

## OFFLINE ASSEMBLY PROCESS

Effectivity Date:

June 21, 2024

Model code/Part number:

373D / 7N0174-7020B

Customer:

TRJ

Car Model:

TOYOTA-RAV4

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-915

Revision No.:

1

Page No.:

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PARTS: 1. Assy parts: Black SV tube (Vinyl) Ø5 L=108±3mm; Blue tape (19mm)

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

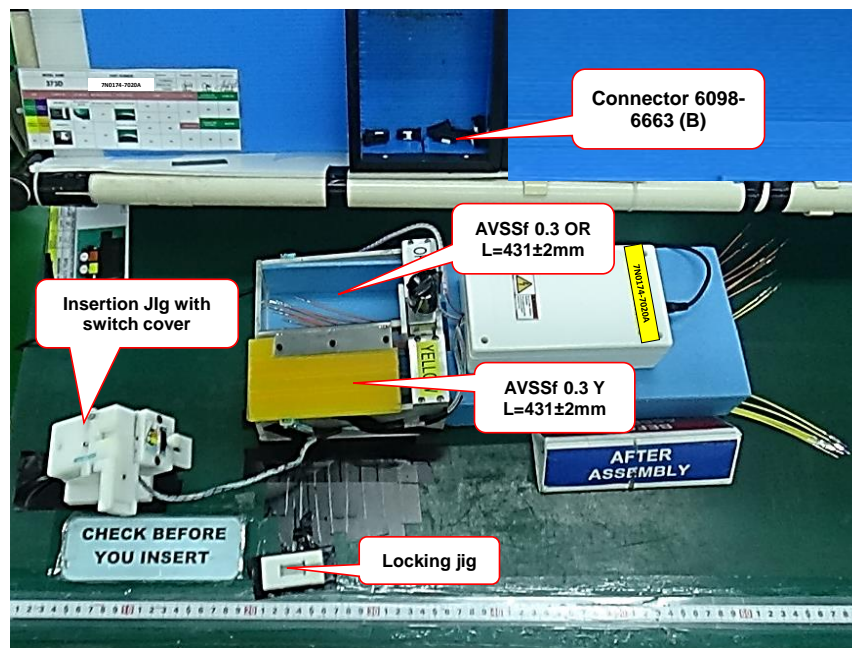
QUALITY POINTERS

1

n/a

Table Lay-out

## Table Lay-out

**Safety Instruction**

Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)

**Housekeeping**

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

**Alert level**

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. No missing parts/tools
2. No excess parts/tools

## Revision History

Prepared by

Reviewed by

Approved by

Noted by

06/21/24 1 Change from Pre-Launch to Masspro. Remove the Wire insertion to Black corrugated tube process.

A. Hernandez C. Villanueva A. Arañes n/a

06/18/24 0 Initial issue

A. Hernandez C. Villanueva A. Arañes n/a

Eff. Date Rev. No Details of Change

Revised Reviewed Approved Noted

Est. Date:

June 18, 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	<p>Connector setting to insertion jig 6098-6663 (B)</p> <p><b>INSERTION JIG WITH SWITCH COVER</b></p> <p>I-mark Lock Push button Visual reference Lower wire guide Insertion jig orientation Connector Orientation</p> <p>Visual reference Lower wire guide Push button I-mark Lock Insertion jig orientation Connector Orientation</p> <p>Press Release</p> <p>1. Press the insertion jig lock using left hand.</p> <p>2. Get the Connector <b>6098-6663 (B)</b> and insert to insertion jig using right hand. Release the lock after insertion. <b>Note: Follow the connector orientation.</b></p> <p>3. Press the lower wire guide using right hand. Slot for <b>Yellow wire</b> will be opened.</p> <p>Hole Push</p>		n/a	<p><b>Connector Orientation Illustration</b></p> <p>I-mark is align 1 hole is open GOOD</p> <p>I-mark is NOT align 1 hole is open NG</p> <p>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p>

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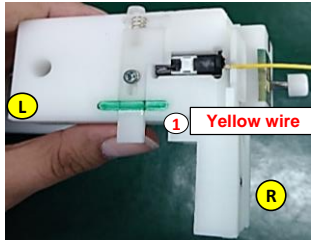
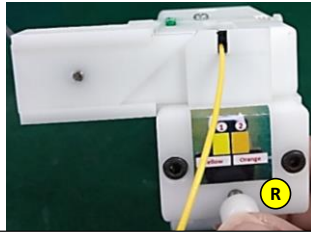
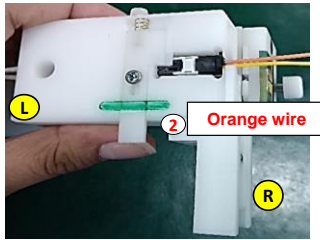
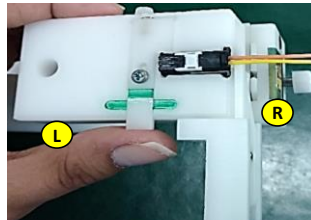
☒ MASSPRO

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PARTS:		1. AVSSf 0.3 wires Y-OR L=431±2mm		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a Wire insertion to connector 6098-6663 (B)	<div><p>Wire facing</p></div> <div><p>1. Hold the insertion jig using left hand. Get the <b>Yellow wire</b> then insert to terminal slot <b>1</b> using right hand.</p></div> <div><p>2. Press the button using right thumb. The slot for <b>Orange wire</b> will be opened.</p></div> <div><p>3. Get the <b>Orange wire</b> then insert to terminal slot <b>2</b> using right hand.</p></div> <div><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><b>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"><li>1. Please hold the wire near terminal.</li><li>2. Make sure wires are properly inserted.</li></ol> <p>Conduct <b>Pull-Push-Pull-Push</b> after insertion.</p> <p>Do not exert extra force.</p> <p><b>Document references:</b></p> <ol style="list-style-type: none"><li>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</li></ol> <ol style="list-style-type: none"><li>1. No loose insertion</li><li>2. No wrong insertion</li><li>3. One by one insertion</li><li>4. No deform terminal</li><li>5. No wrong wire facing.</li></ol>

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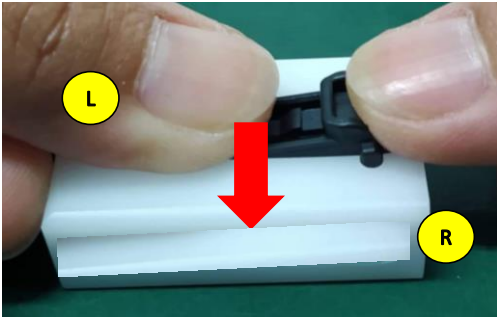
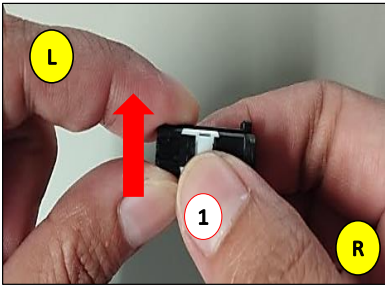
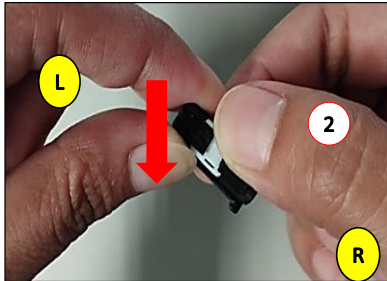
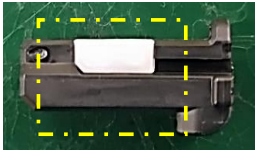
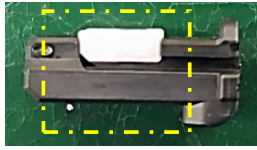

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### PARTS:

1. Assy parts
2. Black Corrugated tube  $\varnothing 5$  L=360 $\pm$ 3mm (no slit)

JIG:

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	n/a	<div><div></div><div><p>1. Put the connector into locking jig using right hand then press to lock <b>2x</b> using both hands.</p></div><div></div><div></div><div><p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div><div></div><div><p>AFTER PRESSING</p></div><div></div><div><p>BEFORE PRESSING</p></div></div>	<div><p>MEASURING TAPE</p></div> <div></div>	<p><b>Important reminders/Note/s:</b></p> <p><b>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b></p> <p>1. Use provided jig tool per model 2. No unlock/half-locked connector</p>

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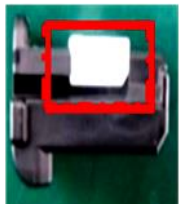
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PARTS:

n/a

JIG:

n/a

**VISUAL INSPECTION/QUALITY CHECKPOINTS****OFFLINE INSERTION****7N0174-7020B****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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