



## WORK INSTRUCTION

Process Name/Title:

## OFFLINE ASSEMBLY PROCESS

Model code/Part number:

177D / 7L0129-7020B

Customer:

TRQSS

Car Model:

TOYOTA COROLLA

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

September 12, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1048

Revision No.:

1

Page No.:

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## PARTS:

1. Connector 6189-0451 (W); TVSSf 0.3 G wires L=539±3mm; TVSSf 0.3 B/W wires L=539±3mm

JIG:

1. Insertion jig with switch cover  
2. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

OFFLINE

Table Lay-out

## TABLE LAY-OUT

Connector 6189-0451 (W/  
Connector TrayInsertion Jig with  
switch coverTVSSf 0.3 G wires  
L=539±3mmTVSSf 0.3 B/W  
wires L=539±3mm

Locking Jig

**Safety Instruction**Be sure to wear  
prescribed 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.**Document reference/s:**1. Refer to **WI-PRO-CNC-017** for Wire  
and Strip Length Tolerance1. No missing parts/tools  
2. No excess parts/tools

## Revision History

Prepared by

Reviewed by

Approved by

Noted by

09/12/24 1 Change status from Pre-launch to Masspro.

M. Ariola

C.  
Villanueva

A. Arañes

n/a

09/11/24 0 Initial issue.

M. Ariola

C.  
Villanueva

A. Arañes

n/a

Eff. Date Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

September 11, 2024

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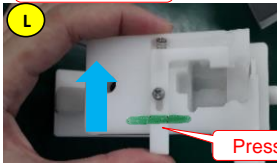
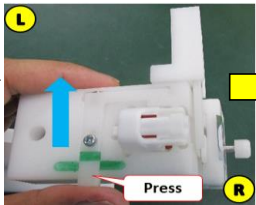
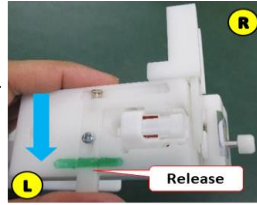
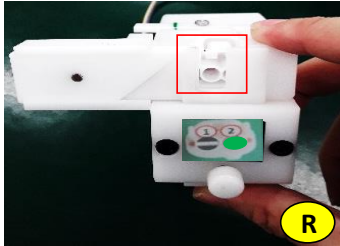
☒ MASSPRO

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PARTS:		1. Connector 6189-0451 (W)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	OFFLINE	<div><div>INSERTION JIG WITH SWITCH COVER</div><div><div><div>Insertion jig</div><div>Wire guide</div><div>Holes</div><div>Wire guide</div><div>G wires</div><div>Switch cover</div><div>B/W wires</div><div>Button</div></div><div><div>Connector Orientation</div></div></div><div><div><div><div>L</div><div>Press</div></div><div><div>1. Press the lock of insertion jig using left thumb.</div></div><div><div><div>L</div><div>Press</div><div>R</div></div><div><div>2. Insert the connector <b>6189-0451 (W)</b> into jig using right hand and release the lock.</div></div><div><div><div>L</div><div>Release</div><div>R</div></div><div><div>3. Push the guide using right hand. The slot for <b>B/W wire</b> will be open.</div></div><div><div><div>R</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>1 hole is open</div><div>GOOD</div></div><div><div><div>I-mark is NOT align</div><div>1 hole is open</div><div>NG</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></div>			

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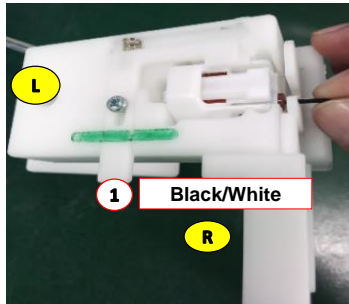

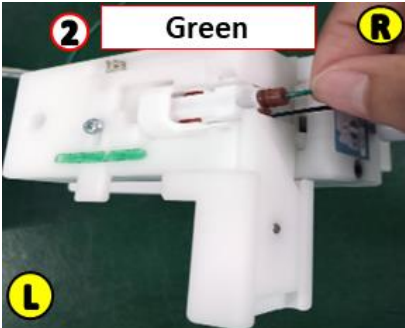
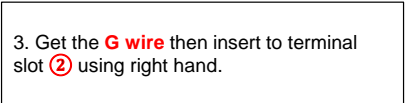
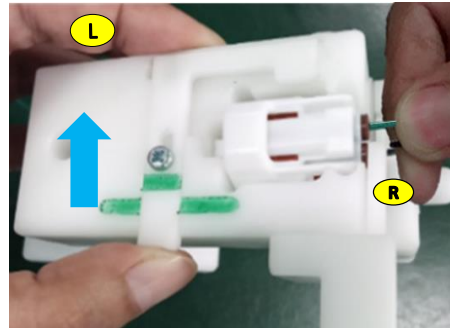
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PARTS:		1. TVSSf 0.3 B/W wire L=539±3mm 2. TVSSf 0.3 G wire L=539±3mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	OFFLINE  Wire insertion to Connector 6189-0451 (W)	<div><p>1. Get the <b>B/W wire</b> then insert to terminal slot ① using right hand.</p></div> <div><p>2. After insertion of <b>B/W wire</b> press the button using right hand. The slot for <b>G wire</b> will be open.</p></div> <div><p>3. Get the <b>G wire</b> then insert to terminal slot ② 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>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length Tolerance</p> <p>2. Refer to <b>GL-PRO-ASY-029</b> for Pull-Push procedure.</p> <p><b>Important reminder/ Note/s:</b></p> <p>1. Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push after insertion.</b> 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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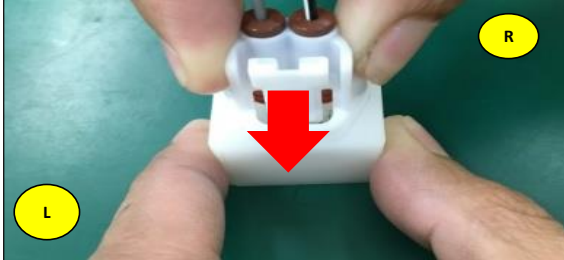







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PARTS:		1. Assy parts		JIG:	1. Locking Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	OFFLINE	<div><div><div>1. Put the connector into locking jig using right hand. Then press to lock 2x using both hands.</div></div><div><div></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>AFTER PRESSING</div></div><div><div><div>GOOD</div><div>NG</div></div><div>Check the double lock deformation</div></div></div></div></div>		<div>LOCKING JIG</div> 	<p><b>Important reminder/ Note/s:</b></p> <p>1. Manual locking may cause damaged connector lock.</p> <p>1. No wrong usage of parts 2. No deformed terminal</p>

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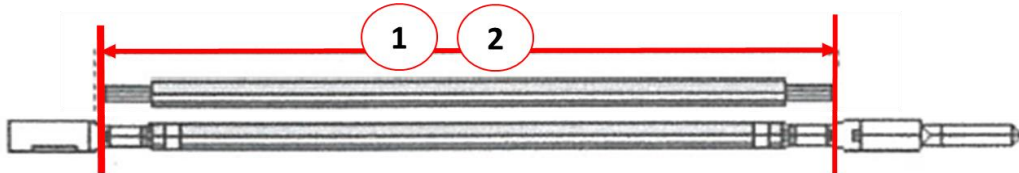


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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	OFFLINE	<p>Note:</p> <p>1. Measurement point: End of core wire to the end of core wire</p> <p>2. Terminal is reference only.</p> 	<div>MEASURING TAPE</div> 	<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated /verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection.</p>
				1.No wrong dimension

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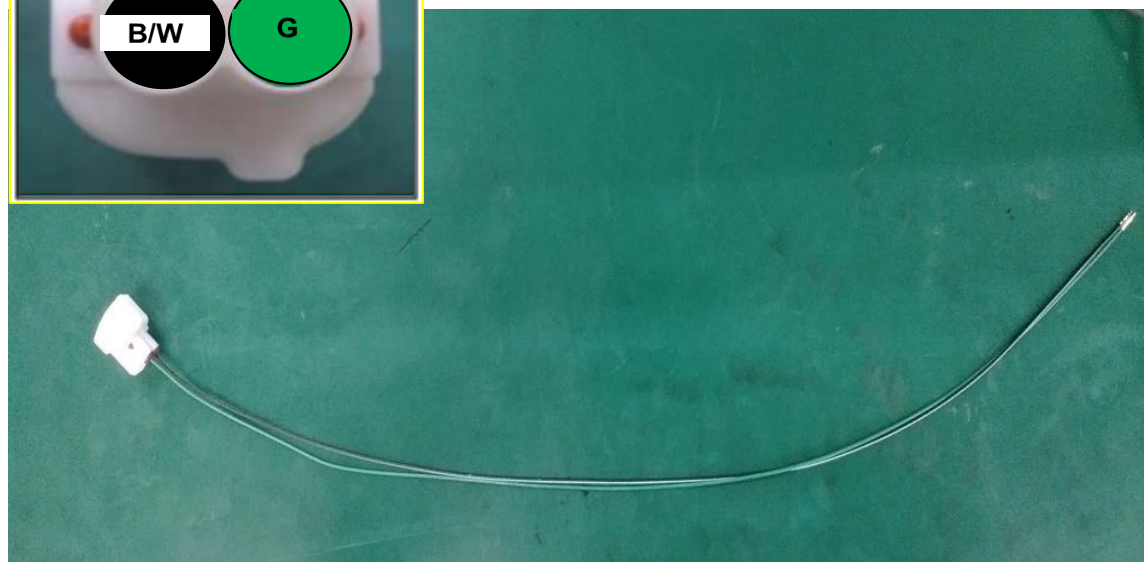
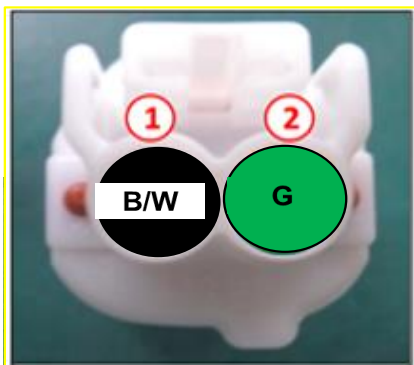
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7L0129-7020B**

① No Unlocked/Half-locked connector

② No Wrong Insert

③ No Terminal Backing Out

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