
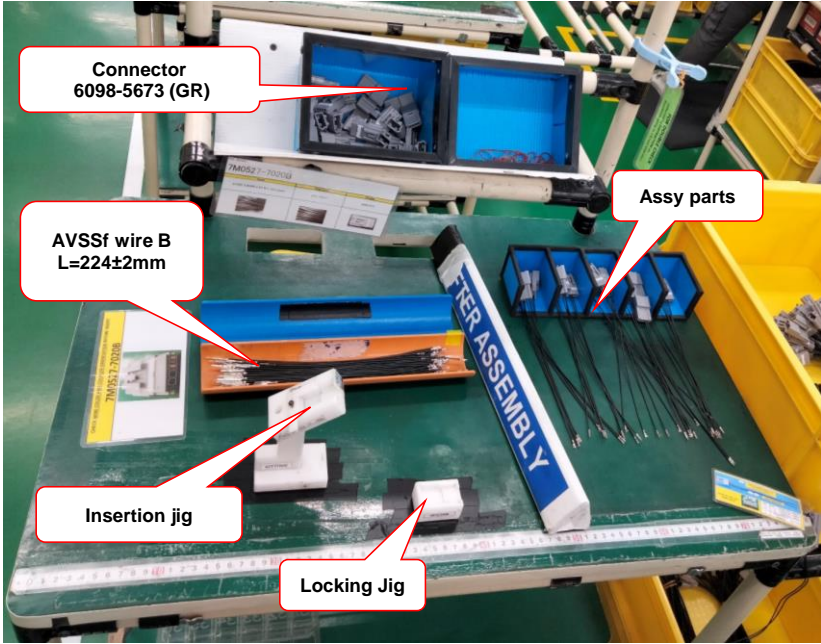


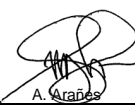


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|---|---|--|----------------------|-------------------------------|-------------------|--|-----------------------|------------------|
|  | WORK INSTRUCTION | | | | Effectivity Date: | | July 05, 2024 | |
| | Process Name/Title: OFFLINE ASSEMBLY PROCESS | | | | Validity Date: | | n/a | |
| | Model code/Part number: 310D / 7M0527-7020B | | Customer: TRJ | Car Model: TOYOTA RAV4 | Document No.: | | WI-ENG-PDE-106 | |
| | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO | | | | Revision No.: | | 5 | Page No.: 1 of 6 |

| | | | | | | | |
|--------|--------------|---|--|--|-----------|---|---|
| PARTS: | | 1. Connector 6098-5673 (GR); AVSSf wire B L=224±2mm | | | 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>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> | <div>Document reference/s:</div> <p>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 |
|------------------|---------|---|-------------|---------------|--------------|-----------|--|--|--|----------|
| | | | | | | |  D. Castillo |  C. Villanueva |  A. Arañes | n/a |
| 07/05/24 | 5 | Inclusion of Car model "TOYOTA-RAV 4" and Measurement. Improved Visual inspection/Quality checkpoints. | D. Castillo | C. Villanueva | A. Arañes | n/a | | | | |
| 5/20/23 | 4 | Inclusion of Table lay-out and quality check points; improve important reminders/note/s; change process name/title from kitting assembly to offline assembly. | J. Loterte | C. Villanueva | A. Arañes | n/a | | | | |
| 4/20/21 | 3 | Remove validity date. | D. Castillo | C. Villanueva | A. Shimamura | A. Arañes | | | | |
| Eff. Date | Rev. No | Details of Change | | Revised | Reviewed | Approved | Noted | Est. Date: October 23, 2019 | | |

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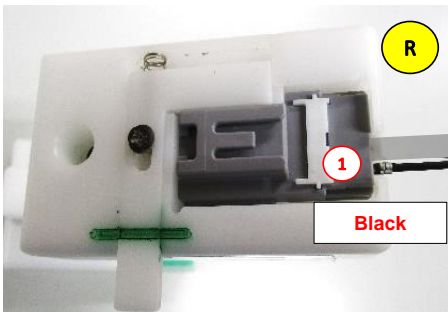
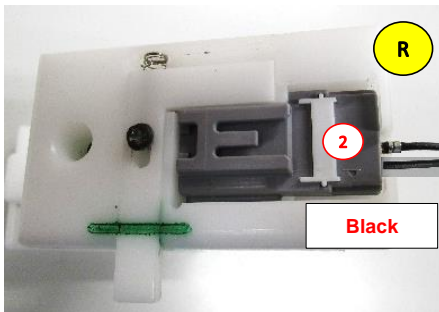
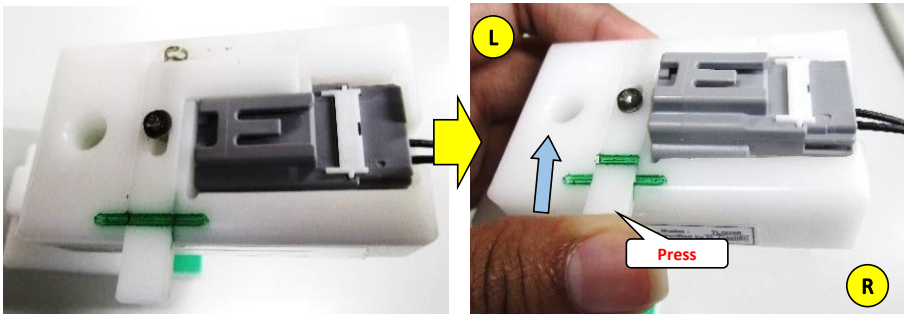
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| | | | | | |
|--------|--------------|---|--|-----------|---|
| PARTS: | | 1. AVSSf wire B L=224±2mm | | JIG: | 1. Insertion jig |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 3 | Offline | <div><div>WIRE FACING</div></div> <div><div>1. Get the first Black wire and insert to Slot 1 of connector using right hand. Note: Insertion should be left to right.</div></div> <div><div>2. Get the second Black wire and insert to Slot 2 of connector using right hand.</div></div> <div><div>3. After insertion, press the lock button using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</div></div> | | n/a | <p>Important reminders/Note/s:</p> <p>1. Make sure wires are properly inserted.</p> <p>Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-CNC-017 for wire and strip length tolerance.</p> <p>1. No loose insertion 2. No wrong dimension 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> |

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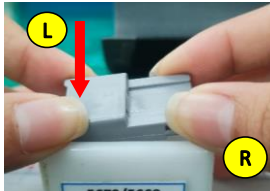
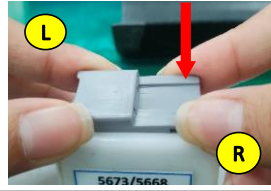



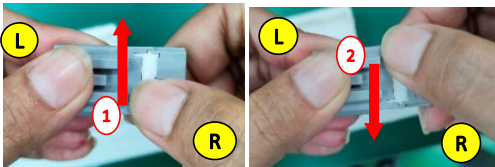

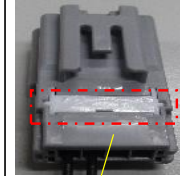


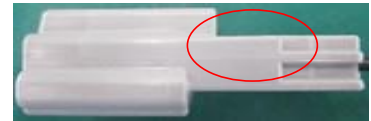
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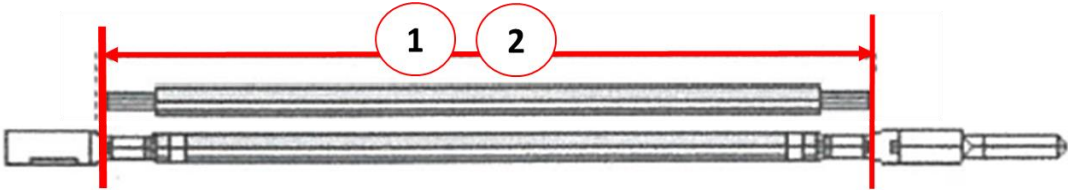


| PARTS: | | 1.Assy Parts | | JIG: | 1. Locking jig |
|--------|---------------------------|---|--|---|--|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 4 | Offline Connector Lock | <div><p>1. Load the connector into the jig holding both side of the connector, 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>LOCKING JIG</div>  | <div>1. Use the provided jig per connector</div> <div>2. No unlock/half-locked connector</div> <div><div>GOOD</div><p>Full Lock</p><div>NG</div><p>Half Lock</p></div> <div><p>Before pressing</p></div> <div><p>After pressing</p></div> <div>Important reminders/Note/s: 1. Manual locking may cause damaged lock.</div> <div>Document reference/s: 1. Refer to GL-PRO-ASY-017 for verification of connector lock.</div> |

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| | Model code/Part number: 310D / 7M0527-7020B | | Customer: TRJ | Car Model: TOYOTA RAV4 | Document No.: | WI-ENG-PDE-106 | | |
| | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO | | | | Revision No.: | 5 | Page No.: | 5 of 6 |

| | | | | | | | | |
|---------------|---------------------|-------------------------------------|--|------|------------------|--|--|--|
| PARTS: | 1.Assy Parts | | | JIG: | Locking jig | | | |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | | TOOLS/PPE | QUALITY POINTERS | | |
| 5 | Offline | Measurement | <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>MEASURING TAPE </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> | | |

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OFFLINE ASSEMBLY PROCESS

Effectivity Date:

July 05, 2024

Validity Date:

n/a

Model code/Part number:

310D / 7M0527-7020BCustomer: **TRJ**

Car Model:

TOYOTA RAV4

Document No.:

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PARTS:

1. Assy parts

JIG:

n/a

5

VISUAL INSPECTION/ QUALITY CHECKPOINTS**OFFLINE INSERTION****7M0527-7020B**

1

**GOOD****NO GOOD**

4



2



3

**GOOD****NO GOOD****1 No Unlocked/Half-locked connector****2 No Wrong insert****3 No Terminal Backing Out****4 No Deformed terminal**

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