



WORK INSTRUCTION

Process Name/Title: TAPING ASSEMBLY PROCESS

Effectivity Date:

October 01, 2024

Model code/Part number: 320B / 7L0052-7024A

Customer: TRQSS

Car Model: TOYOTA-RAV4

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-1065B

Revision No.:

1

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PARTS:

1. Assy parts; Black tape [2pcs.]; Yellow tape [1pc.]

JIG:

1. Insertion jig

3. Terminal cover jig

2. Locking jig

4. Spot Taping jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

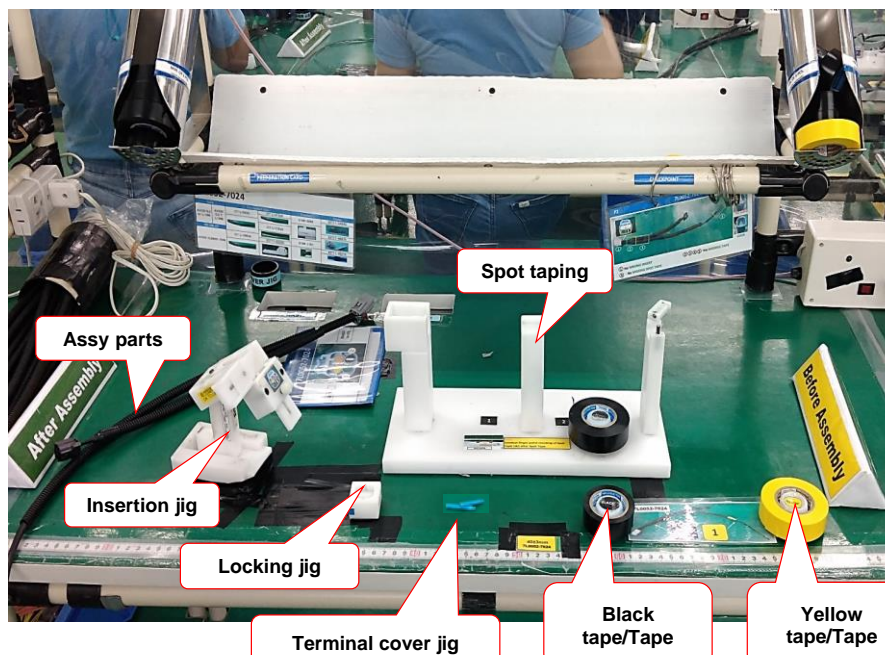
QUALITY POINTERS

1

P2

Table Lay-out

Table Lay-out



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.

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

Revision History

Revision History							Prepared by	Reviewed by	Approved by	Noted by
							 A. Hernandez	 C. Villanueva	 A. Arañes	
10/01/24	1	Change from Pre-launch to Masspro.	A. Hernandez	C. Villanueva	A. Arañes	n/a				
09/24/24	0	Initial issue.	A. Hernandez	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted	Est. Date: September 24, 2024		

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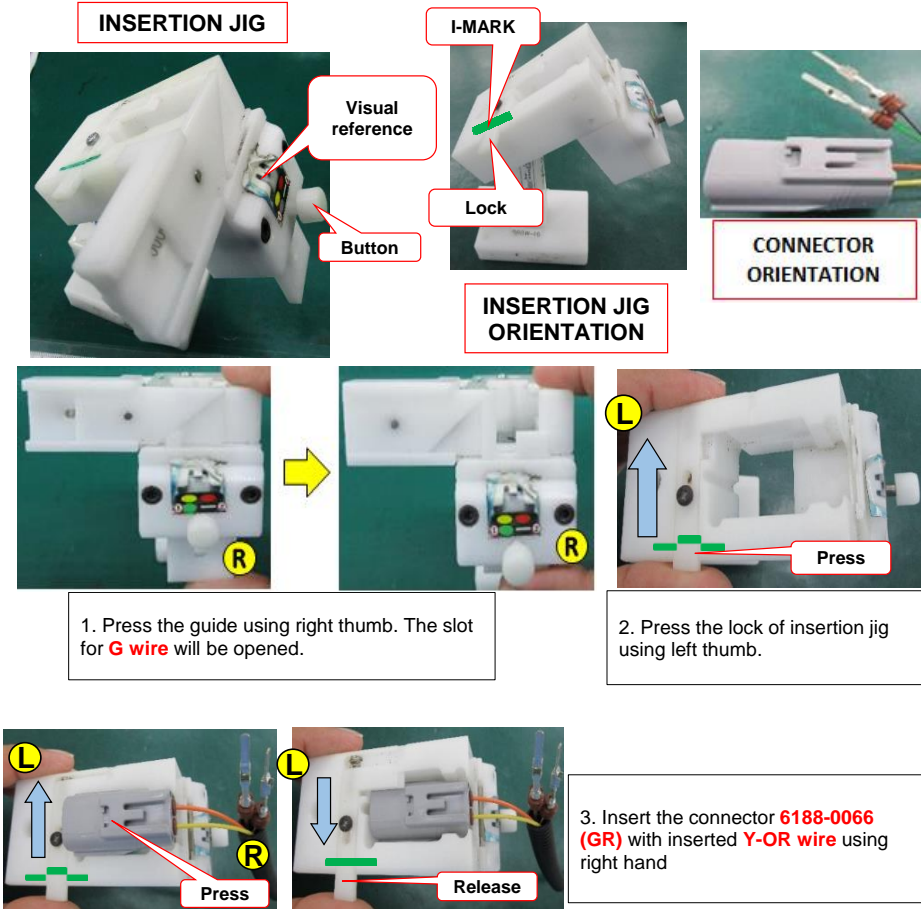
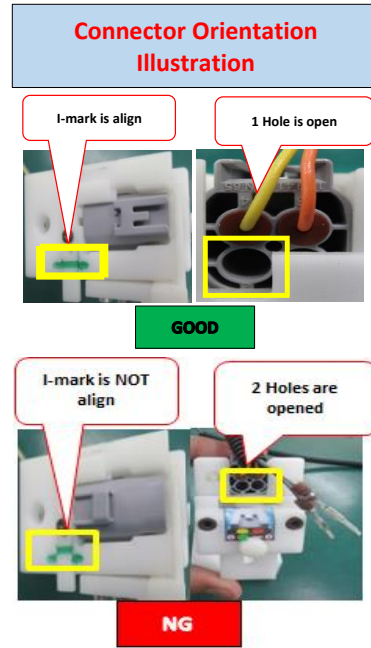
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PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2	<p>Connector setting to insertion jig 6188-0066 (GR) (Assy parts)</p>  <p>1. Press the guide using right thumb. The slot for G wire will be opened.</p> <p>2. Press the lock of insertion jig using left thumb.</p> <p>3. Insert the connector 6188-0066 (GR) with inserted Y-OR wire using right hand</p>		n/a	<p>Connector Orientation Illustration</p>  <p>GOOD</p> <p>I-mark is align 1 Hole is open</p> <p>NG</p> <p>I-mark is NOT align 2 Holes are opened</p> <p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p> <p>Important reminders/Note/s: 1. Follow the connector orientation</p>

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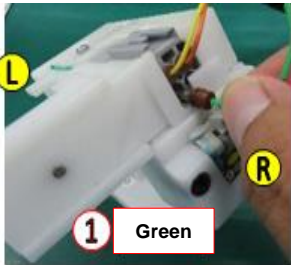

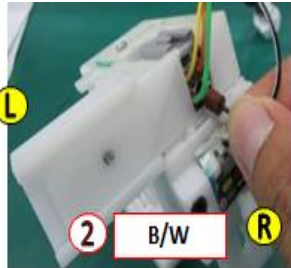
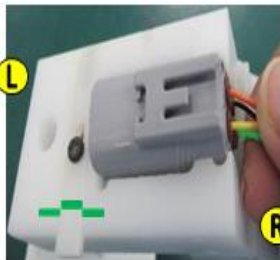
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2	<div>Wire insertion to connector 6188-0066 (GR)</div> <div><div><div>TERMINAL FACING</div></div><div><div><div>1 Green</div></div><div>1 Hold the G wire then insert to terminal slot 1 using right hand.</div></div><div><div><div>R</div></div><div>2. Press the button using right thumb. The slot for B/W wire will be opened.</div></div><div><div><div>2 B/W</div></div><div>3. Hold the B/W wire then insert to terminal slot 2 using right hand.</div></div><div><div><div>L</div><div>R</div></div><div>4. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</div></div></div> <div>n/a</div> <div><div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div><div>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.</div><div>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div></div>		

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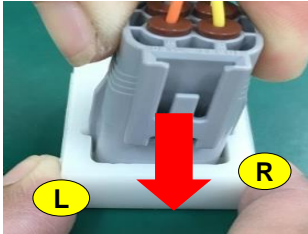


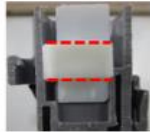



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PARTS:		1. Assy parts		JIG:	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Connector Lock	<div><p>1. Put the connector into locking jig using right hand then press 2x. Touch the connector lock to confirm if properly locked.</p><p>Before pressing</p><p>After pressing</p><div><p>Coupler Cross Sectional View</p><div><p>NG</p><p>Unlock</p></div><div><p>NG</p><p>Half Lock Condition</p></div><div><p>GOOD</p><p>Full Lock Condition</p></div></div></div>	<p>LOCKING JIG</p> 	<p>Important reminders /Note/s:</p> <p>1.MANUAL LOCKING MAY CAUSED DAMAGED LOCK</p> <p>1. Use the provided locking jig per model 2. No unlock/half-locked connector</p>

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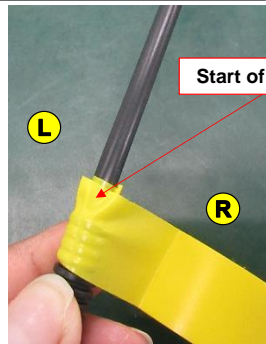


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PARTS:		1. Assy parts 2. Yellow tape 20mm	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2 Taping 3 Corrugated tube to VM tube (Sunprene)	 <p>1. Measure from end of COT up to hotmelted wire 176mm using both hands.</p>  <p>2. Fix the COT and sunprene tube using both hands. Make sure no gap in between.</p>  <p>3. Get the Yellow tape using right hand then start taping process using both hands.</p>  <p>4. After taping, check the dimension and taping condition.</p>	<div>MEASURING TAPE</div> 	<p>Important reminders and Note/s:</p> <ol style="list-style-type: none">1. Use YELLOW TAPE only2. Please use calibrated/verified measuring tape when getting the measurement. <p>Document reference/s:</p> <ol style="list-style-type: none">1. Refer to WI-PRO-ASY-001 for taping procedure. <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape

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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P2	Y-taping	<div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div></div> <div><div>MEASURING TAPE</div></div> <div><div>Y-TAPING ORIENTATION</div></div>	<p>Important reminders and Note/s:</p> <p>1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape	

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PARTS:

1. Assy parts
2. Black tape 20mm

JIG:

1. Spot taping jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

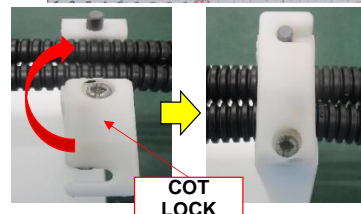
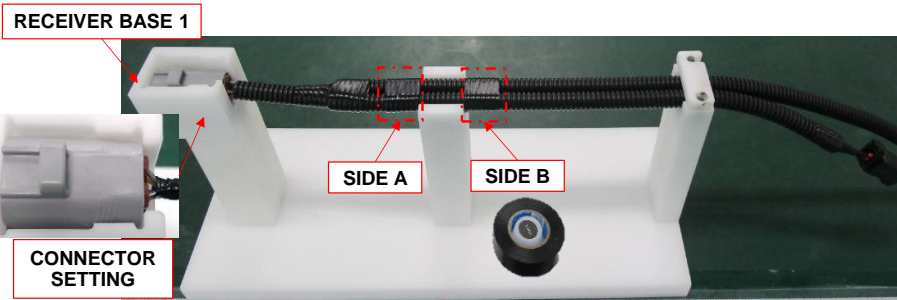
TOOLS/PPE

QUALITY POINTERS

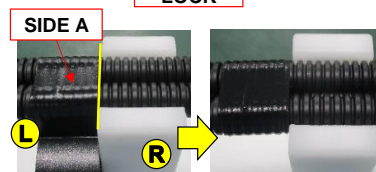
7

P2

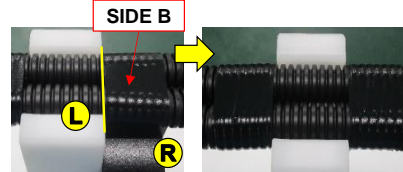
Spot taping



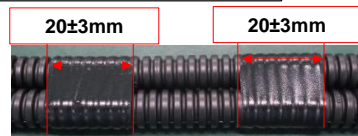
1. Get the assy parts then set into jig using both hands. **(See above picture for correct setting).** First, set the connector **6188-0066 (GR)** to **Receiver base**. Continue to set the **2 COT** in the **COT guide** then lock.



2. Hold the assy parts using left hand, get the **Black tape** then conduct **2 windings** of tape on **SIDE A** then cut using both hands.



3. Hold the assy parts using left hand, get the **Black tape** then conduct **2 windings** of tape on **SIDE B** then cut using both hands.



4. Check the measurement and taping condition.

MEASURING TAPE



Important reminders and Note/s:
1. Please use calibrated/verified measuring tape when getting the measurement.

1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No missing tape
5. No wrong dimension
6. No wrong use of tape

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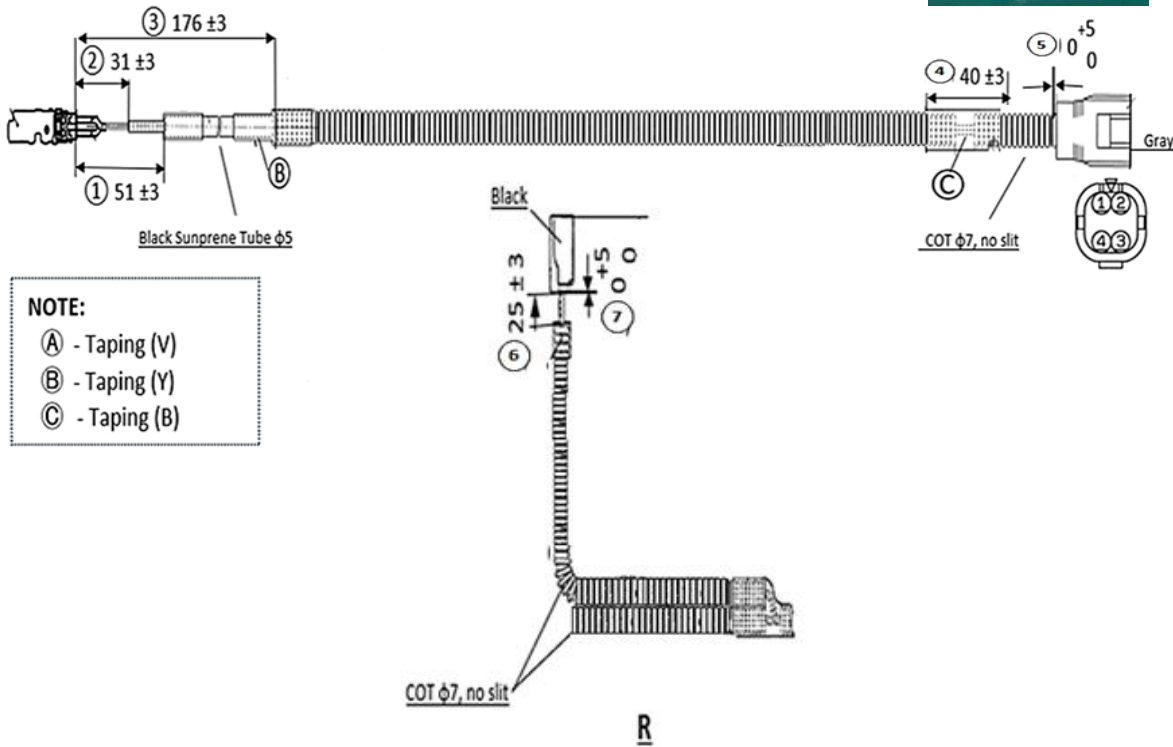
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P2	Measurement	<div></div>		<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>

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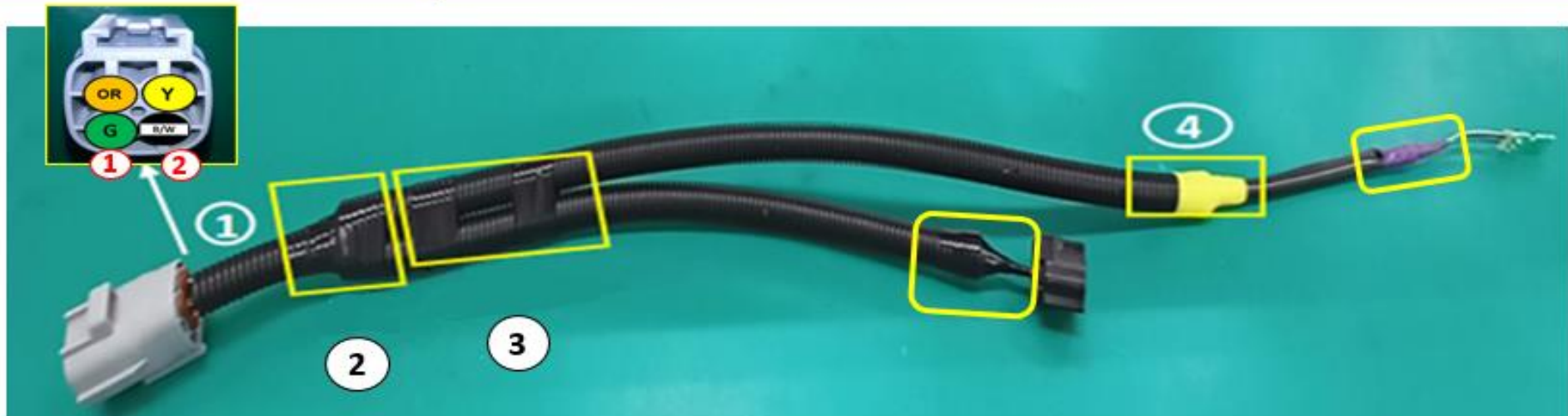
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1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P2****7L0052-7024A****① No Wrong Insert****③ No Missing Spot tape (BLACK)****② No Missing Tape/ Wrong Facing of Connector (Y-taping)****④ No Missing tape/ Wrong Color of tape (YELLOW)**

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