

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**

Effectivity Date:

May 24, 2024Model code/Part number: **100B / 7M0593-7021**Customer: **TRJ**Car Model: **LEXUS UX**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-444B

Revision No.:

2

Page No.:

1 of 9**PARTS:** 1. All parts; Assy parts; AVSSf 0.3 B-B wires L=749±3mm; Black Corrugated tube (w/slit) ø5 L=410±4mm; Black tape [1pc]

JIG:

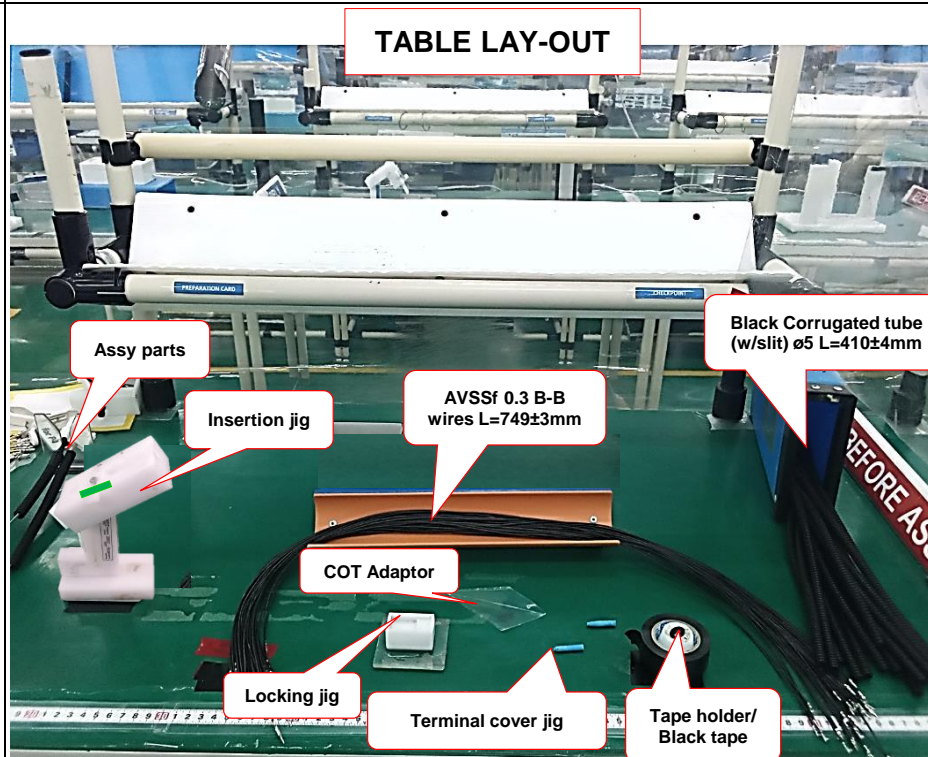
1. Insertion jig
2. Locking jig
3. Terminal cover jig

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

1

P2

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

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/24/24	2	Transfer to New format. Inclusion of Car model "LEXUS UX".	A. Hernandez	C. Villanueva	A. Arañes	n/a				
02/15/23	1	Improve work procedure/illustration on process no. 5 connector lock; Inclusion of Quality Checkpoints.	M. Ariola	J. Loterte	Villanueva C.	A. Arañes				
03/05/22	0	Initial Issue	M. Ariola	J. Loterte	Villanueva C.	A. Arañes				

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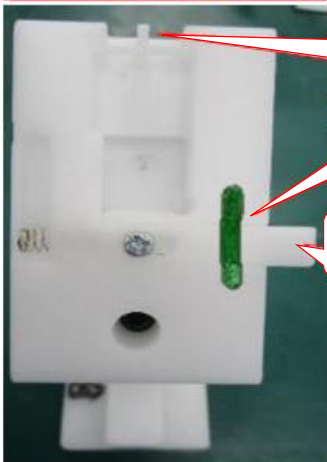

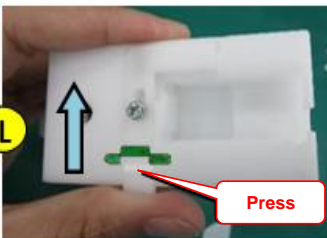

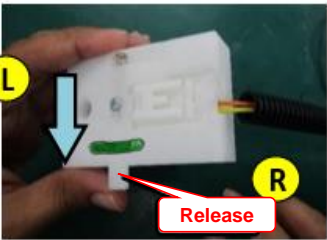
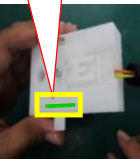
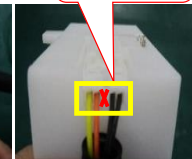
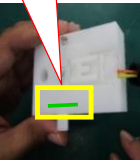

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PARTS:		1. Assy parts 2. AVSSf 0.3 B-B wires L=749±3mm [2pcs.]		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Connector setting to insertion jig (assy parts) 6098-3802 (W)	<div><div><div>INSERTION JIG</div></div><div><div>Connector orientation</div></div><div></div><div></div><div>1. Press the lock of insertion jig using left thumb.</div><div></div><div>2. Insert the connector 6098-3802 (W) (assy parts) to insertion jig using right hand then release the lock using left hand.</div><div>3. Check the insertion jig if there is holes allotted to B-B wires.</div></div>		n/a	<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> <div><div>Connector Orientation Illustration</div><div><div><div>I-mark is align</div></div><div><div>B/B Slot</div></div></div><div>GOOD</div><div><div><div>I-mark is align</div></div><div><div>B/B Slot</div></div></div><div>NG</div></div>

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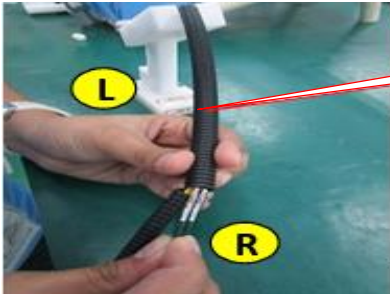
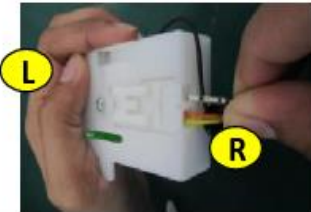




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PARTS:		1. Assy parts 2. AVSSf 0.3 B-B wires L=749±3mm [2pcs.]		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	Wire insertion to assy parts	<div></div> <div>1. Get the B-B wires L=749±3mm and insert to COT Ø7 L=163±3mm (assy parts) using right hand.</div>	n/a	1. No wrong use of parts 2. No damaged terminal Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip lenght tolerance.
4		Wire insertion to connector 6098-3802 (W)	<div><div></div><div><p>Wire facing</p></div></div> <div>1. Hold the insertion jig using left hand and insert the 1st B wire using right hand.</div> <div>2. Hold the insertion jig using left hand and insert the 2nd B wire using right hand.</div> <div><div></div><div></div><div>3. After insertion, press the lock using left hand and remove the connector from jig using right hand.</div></div>		1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing Important reminders/note/s: 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 2. Please hold the nera terminal during insertion. 3. Insertion must be from left to right. Document reference/s: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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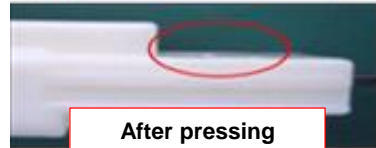


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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2	Connector Lock		<div><div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div><div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div></div> <div><div><p>Right thumb-middle Left thumb-middle</p></div><div><p>Right thumb-middle Left thumb-middle</p></div></div>	<div><div>LOCKING JIG</div></div> <div>1. No unlocked/half-locked connector</div> <div><p>Before pressing</p><p>After pressing</p><div><div>GOOD</div><p>Full Lock</p><div>NG</div><p>Half Lock</p></div><p>Important reminders/note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</p></div>

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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2	Connector Lock (Continuation)	<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> 	<p>Important reminders/note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED LOCK.</p> <p>1. No unlocked/half-locked connector</p>

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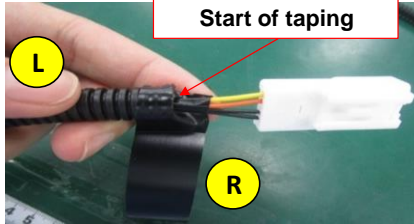
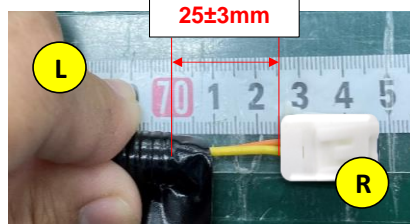
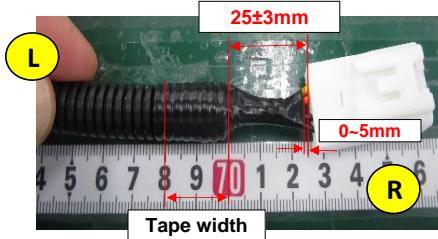

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P2	<p>Taping 1 Black corrugated tube (no slit) to wire near connector</p> <div><p>Start of taping</p></div> <div><p>25±3mm</p></div> <div><p>25±3mm 0~5mm Tape width</p></div> <div><p>1. Hold the COT using left hand and start taping using right hand.</p><p>2. Measure from end of corrugated tube up to connector 25mm then continue the taping process.</p><p>3. After taping, check the measurement and taping condition.</p></div>		<p>Measuring tape</p> 	<p>Important reminders/note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 1. Please refer to WI-PRO-ASY-001 for taping procedure.</p> <p>1. No flip out tape 2. No tape peeling 3. No loose tape 4. No wrong use of tape 5. No wrong dimension</p>

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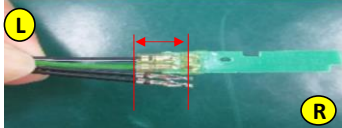
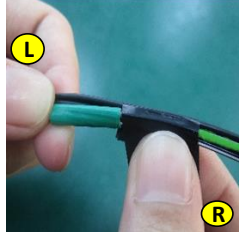
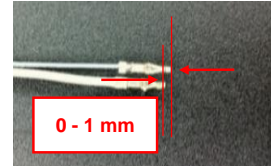
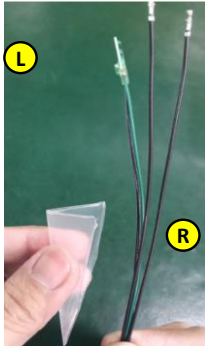
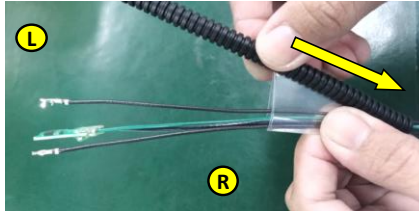

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PARTS:		1. Assy parts 2. Black tape 3. Black Corrugated tube (w/slit) $\phi 5$ L=410 \pm 4mm		JIG:	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	Spot Taping	 1. Align the terminal pointed tip of hotmelted wires to B-B wires . 		n/a	1. No wrong use of tape <div>Wire alignment tolerance </div>
8	P2 Wire insertion to Black Corrugated tube (w/slit) $\phi 5$ L=410 \pm 4mm	 1. Hold the COT adaptor using left hand and insert the wires using right hand. 		<div>COT Adaptor </div>	1. No wrong use of parts 2. No wires left in between the COT with slit

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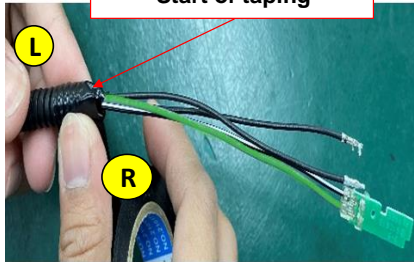
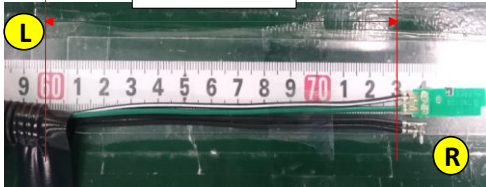


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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P2	<p>Taping 2 Black corrugated tube (with slit) to wire near terminal and hotmelted wire</p> <p>Start of taping</p>  <p>1. Hold the corrugated tube using left hand and conduct pre-taping between COT and wires using right hand.</p> <p>131±3mm</p>  <p>2. Measure from COT up to the hotmelted wire 131mm and continue the taping process.</p> <p>tape width</p>  <p>3. After taping, check the measurement and taping condition.</p> <p>139±3mm</p>		<p>Measuring tape</p> 	<p>Important reminders/note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s:</p> <p>1. Please refer to WI-PRO-ASY-001 for taping procedure.</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p>

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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS

P2

7M0593-7021



GOOD



NO GOOD

TAPE WIDTH /
25 3±MM COT TO CONNECTOR

TAPE WIDTH /
131±3MM COT TO
HOTMELT
139±3MM COT TO
TERMINAL

① No **WRONG INSERT**
No **UNLOCKED/HALFLOCKED**
NO **TBO**

② No **MISSING COT**
③ No **MISSING TAPE**

Proper
alignment of
B-B wires and
hotmelt

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