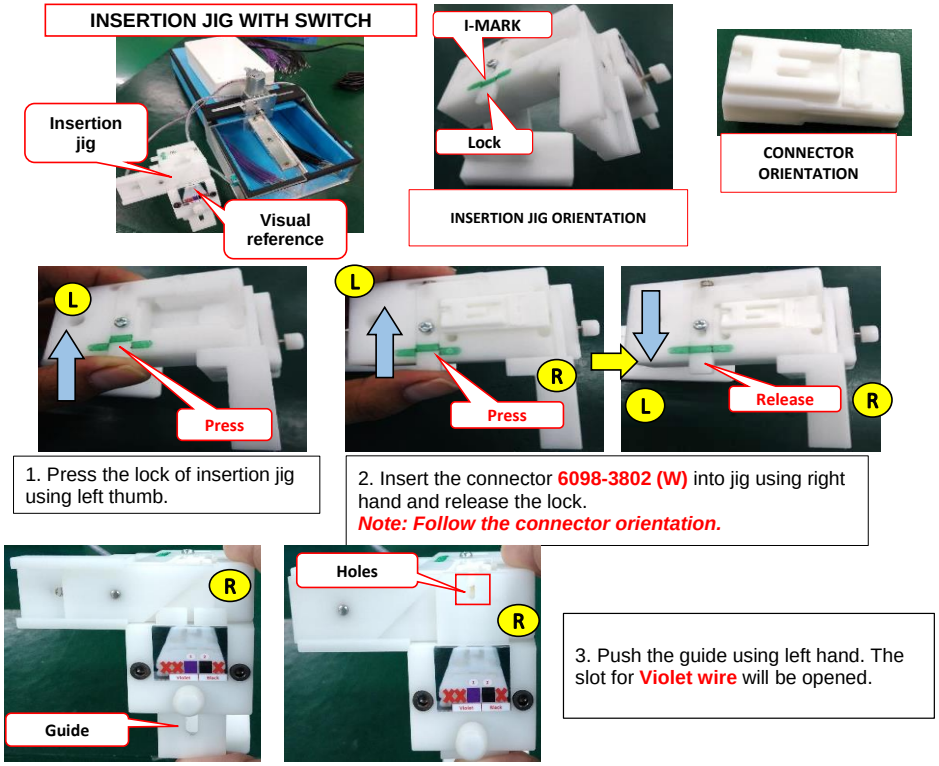
NBC	WORK INSTRUCTION			Effectivity Date:	March 12, 2024
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number: 310D / 7N0199-7020	Customer: TRJ	Car Model: TOYOTA-RAV4	Document No.:	WI-ENG-PDE-771
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 1	Page No.: 1 of 18

PARTS:	1. Connector 6098-3802 (W)	JIG:	1. Insertion jig with switch cover

NO.	PROCESS NAME		⚠1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	n/a	Connector setting to insertion jig 6098-3802 (W)			



1. Press the lock of insertion jig using left thumb.

2. Insert the connector **6098-3802 (W)** into jig using right hand and release the lock.
Note: Follow the connector orientation.

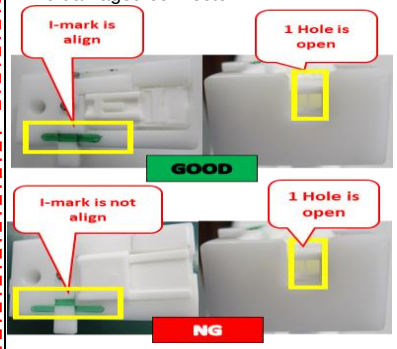
3. Push the guide using left hand. The slot for **Violet wire** will be opened.

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

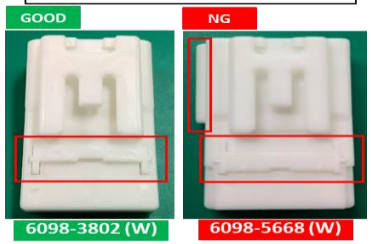
Housekeeping
1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

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

1. Use the provided jig per model
2. No wrong orientation of connector
3. No wrong use of connector
4. No damaged connector



CONNECTOR ILLUSTRATION



Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
03/12/24	1	Changed purpose from Pre-launch to Masspro. Improved Work Procedure/Illustration on pages 1 to 14.	M. Ariola	C.Villanueva	A. Arañes	n/a
01/03/24	0	Initial issue	M. Ariola	C.Villanueva	A. Arañes	n/a

Prepared by	Reviewed by	Approved by	Noted by
M. Ariola	C.Villanueva	A. Arañes	n/a
Est. Date:	January 3, 2024		

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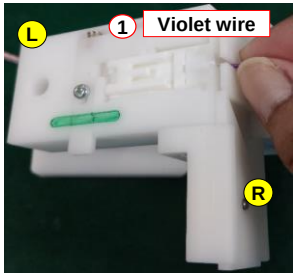
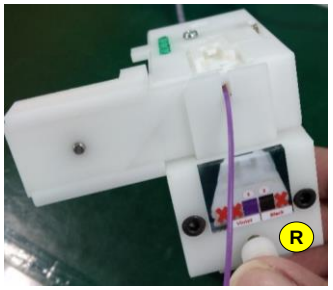
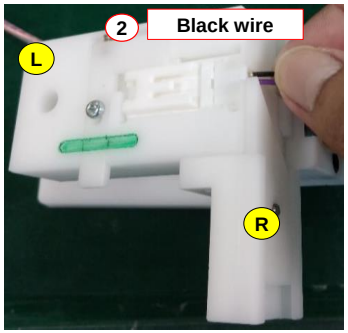
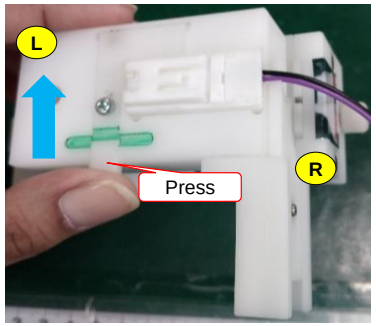
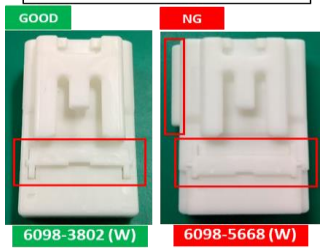
	Model code/Part number: 310D / 7N0199-7020	Customer: TRJ	Car Model: TOYOTA-RAV4	Document No.:	WI-ENG-PDE-771	
	Purpose: ☐PROTOTYPE ☐PRE-LAUNCH ■MASSPRO			Revision No.:	1	Page No.: 2 of 18

PARTS:	1. Connector 6098-3802 (W) 2. AVSSf 0.3 wires Violet L=768±3mm 3. AVSSf 0.3 wires Black L=768±3mm	JIG:	1. Insertion jig with switch cover

NO.	PROCESS NAME		⚠1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	n/a	Wire insertion to connector 6098-3802 (W)	 Wire  1. Hold the insertion jig using left hand. Get the Violet wire then insert to terminal slot **1** using right hand.  2. Press the button using right thumb. The slot for Black wire will be opened.  3. Get the Black wire then insert to terminal slot **2** using right hand.  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.	n/a	1. No wrong use of connector 2. No damaged connector 3. No wrong insertion of wires 4. No loose insertion 5. One by one insertion 6. No deformed terminal 7. No wrong wire facing ***Important reminder's/Note:*** ***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.*** ***Document references:*** ***1. Refer to WI-PRO-CNC-017 for Wire Strip lenght tolerance.*** ***2. Refer to GL PRO-ASY-029 for pull-push-pull-push procedure*** CONNECTOR ILLUSTRATION 

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	WORK INSTRUCTION				Effectivity Date:	March 12, 2024	
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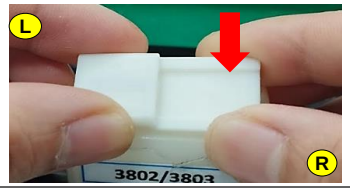
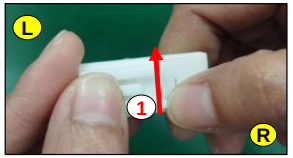
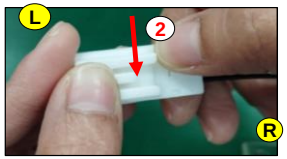
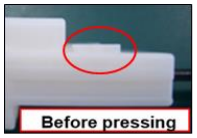
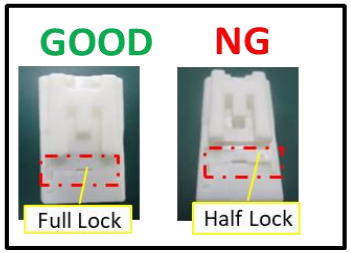
	Model code/Part number: 310D / 7N0199-7020	Customer: TRJ	Car Model: TOYOTA-RAV4		Document No.:	WI-ENG-PDE-771	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO				Revision No.:	1	Page No.: 3 of 18

PARTS:	1. Assy Parts	JIG:	1. Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	n/a	Connector lock	 1. Load the connector into the jig holding both side of the connector, tip first.  2. Press the lower part of connector to fully insert into the locking jig. **Right thumb-Lower** **Left thumb-middle** 3. Press the lower parts of connector using right hand while left hand holding the middle. **Right thumb-upper** **Left thumb-middle** 4. Press the upper part of connector using right hand while left hand holding the middle. **Right thumb-middle** **Left thumb-middle** 5. Lift then press the connector in the middle using left and right hand.   6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.	**LOCKING JIG** 	1. Use the provided jog per model 2. No unlocked/half-locked connector ***Important reminders/Note/s:*** ***1. Manual locking jig may caused damaged connector lock.*** ***Document references:*** ***1. Refer to GL-PRO-ASY-017 for the verification of connector lock.***  

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	WORK INSTRUCTION				Effectivity Date:	March 12, 2024	
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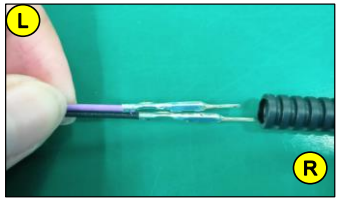
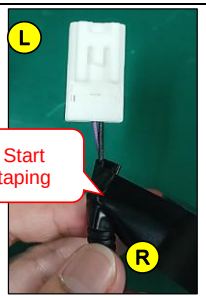
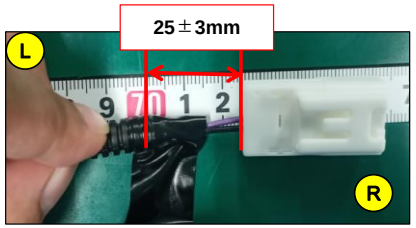
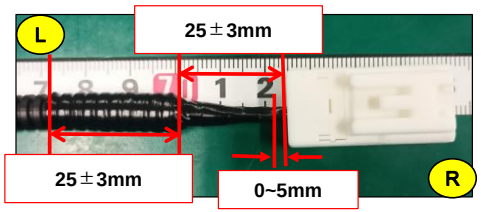
	Model code/Part number: 310D / 7N0199-7020	Customer: TRJ	Car Model: TOYOTA-RAV4		Document No.:	WI-ENG-PDE-771	
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO		Revision No.:	1	Page No.: 4 of 18

PARTS:	1. Assy parts 2. Black Corrugated tube ø5 L=144±3mm (no slit) 3. Black tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	n/a	Wire Insertion to Black Corrugated tube ø5 L=144±3mm (no slit)	 2. Get the **Black Corrugated tube ø5 L=144±3mm (no slit)** using right hand then insert the Violet wire and Black wire using both hands.	n/a	1. No wrong usage of parts. 2. No deformed terminal
5		Taping 1 Black Corrugated tube to wire near connector	 1. Get the **Black tape**, hold the assy parts using left hand then start taping using both hands.  2. Measure the end of COT up to edge of connector **25±3mm then continue the taping process using both hands.**  3. After taping, check the measurement and taping condition.	**MEASURING TAPE** 	***Important reminders/Notes/:*** ***1. Please use calibrated/verified measuring tape when getting the measurement.*** 1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension

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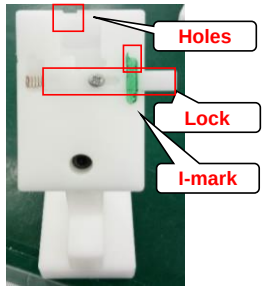
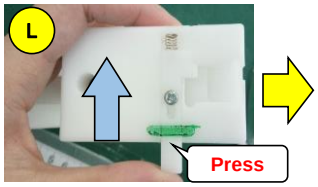
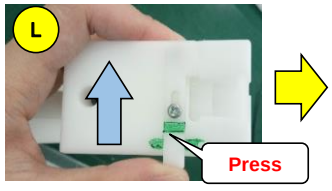
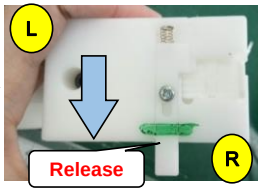
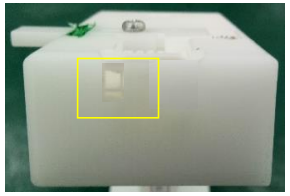
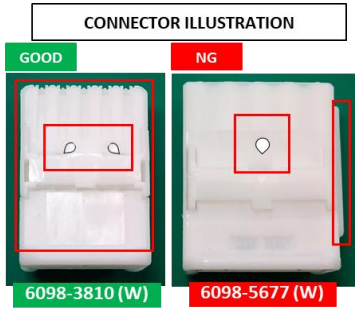
	Purpose: ☐PROTOTYPE ☐PRE-LAUNCH ■MASSPRO			Revision No.: 1	Page No.: 5 of 18

PARTS:	1. Connector 6098-3810 (W)			JIG:	1. Insertion jig
NO.	**PROCESS NAME**		**⚠1 WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
6	n/a	Connector setting to insertion jig 6098-3810(W)	  1. Press the lock of insertion jig using left thumb.   2. Insert the connector **6098-3810** into jig using right hand and release the lock.  3. Check the holes/terminal slot for **B wires.**	n/a	1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector 

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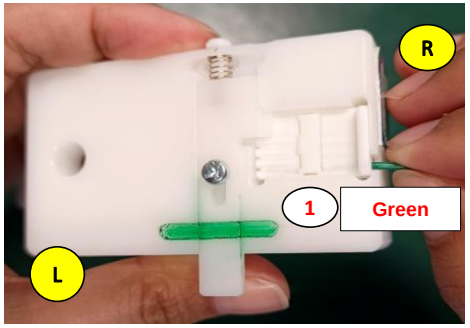
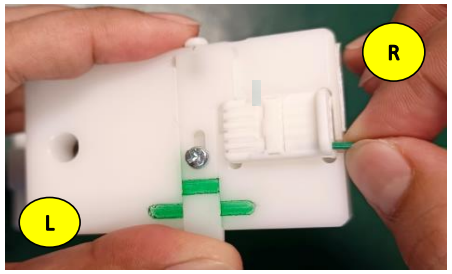
	Model code/Part number: 310D / 7N0199-7020	Customer: TRJ	Car Model: TOYOTA-RAV4		Document No.:	WI-ENG-PDE-771		
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO		Revision No.:	1	Page No.:	6 of 18

PARTS:	1. Connector 6098-3810 (W) 2. AVSSf 0.3 wires Green L=659±3mm			JIG:	n/a
NO.	**PROCESS NAME**		**1 WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
7	n/a	Wire insertion to Connector 6098-3810 (W)	 CONNECTOR ORIENTATION WIRE FACING  1. Get the **Green wire** and insert to **Slot 1** of connector using right hand. Conduct **2x** push pull after wire insertion.  2. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.	n/a	1. No wrong use of connector 2. No damaged connector 3. No wrong insertion of wires 4. No loose insertion 5. One by one insertion 6. No deformed terminal 7. No wrong wire facing ***Important reminder's/Note:*** ***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.*** ***Document references:*** ***1. Refer to WI-PRO-CNC-017 for Wire Strip lenght tolerance.*** ***2. Refer to GL PRO-ASY-029 for pull-push-pull-push procedure***

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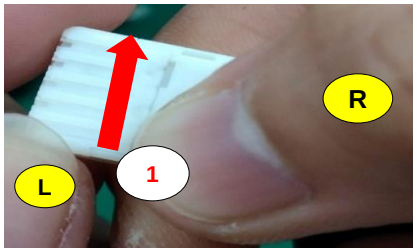
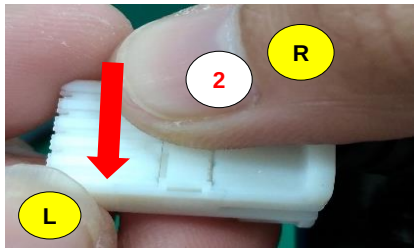
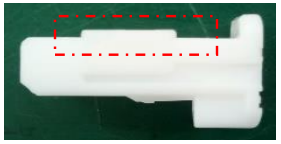
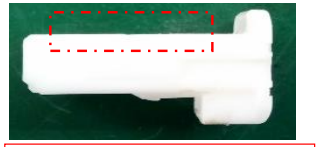
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 1	Page No.: 7 of 18

PARTS:	1. Assy parts	JIG:	1. Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	n/a	Connector lock	 1. Put the connector into locking jig using right hand then press **2x** using both hands. Touch the connector lock to confirm if properly locked.   2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.  **Before Pressing**  **After Pressing**	**LOCKING JIG** 	***Important reminders/Note/s:*** ***1. Manual locking may cause damaged connector lock*** 1. No wrong usage of parts 2. No deformed terminal

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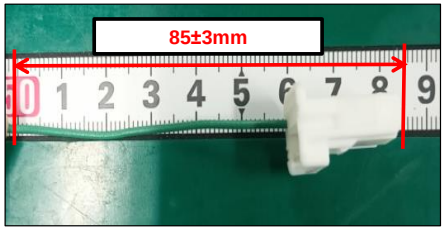
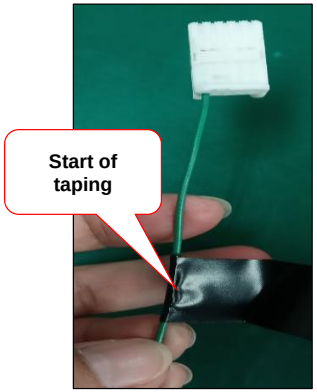
	Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	1	Page No.:	8 of 18

PARTS:	1. Assy parts 2. Black tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	n/a	Half wrap taping	 1. Hold the wire using left hand, Measure from wire up to end of connector L=**85±3mm** using both hands.  2. Get the **Black tape**. Start pre-taping make **1 winding** of tape then conduct **1/2 shifting** until you reach the edge of the connector. Make **2 windings** of tape before end of tape. ***(Taping must be 1/2 shifting)*** 3. After taping, check the measurement and tape condition.	**MEASURING TAPE** 	1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension

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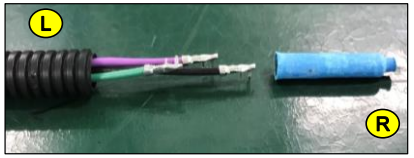
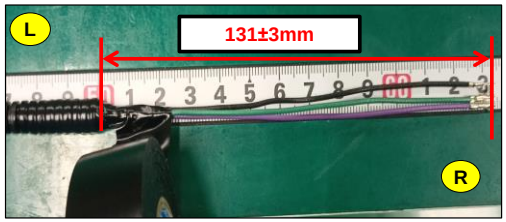
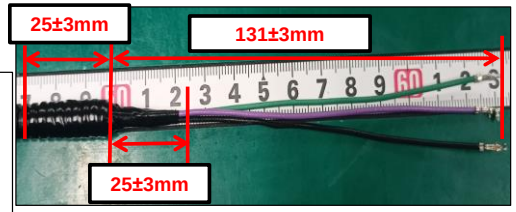
	WORK INSTRUCTION				Effectivity Date:	March 12, 2024	
	Process Name/Title:	TAPING ASSEMBLY PROCESS			Validity Date:	n/a	
	Model code/Part number: 310D / 7N0199-7020	Customer: TRJ	Car Model: TOYOTA-RAV4		Document No.:	WI-ENG-PDE-771	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO				Revision No.:	1	Page No.: 9 of 18

PARTS:	1. Assy parts 2. Black Corrugated tube ø5 L=461±3mm (no slit) 3. Black tape	JIG:	1. Terminal cover jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	n/a	Wire Insertion to Black Corrugated tube ø5 L=461±3mm (no slit)	 1. Combine the **B-V-G wires** using both hands. Get the terminal cover jig using right hand then insert to **B-V-G wires** both hands. 2. Get the Corrugated tube **ø5, L=461±3mm** using right hand then insert to **B-V-G wires** using both hands.  3. After insertion, remove the terminal cover jig using right hand.	**Terminal cover Jig** 	1. No wrong usage of parts. 2. No deformed terminal
11		Taping 2 COT to wire near terminal	 1. Hold the assy parts using left hand. Get **Black tape** using right hand and start pre-taping.  2. Measure from COT to Connector **131±3mm** using both hands and continue the taping process.  3. After taping, check the measurement and taping condition.	**MEASURING TAPE** 	***Important reminders/Notes/:*** ***1. Please use calibrated/verified measuring tape when getting the measurement.*** 1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension

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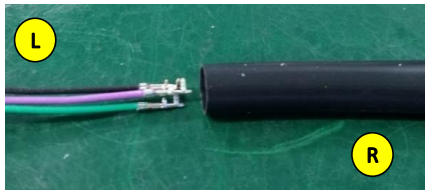
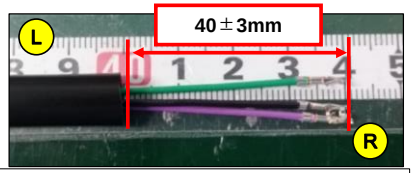
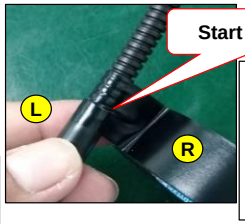
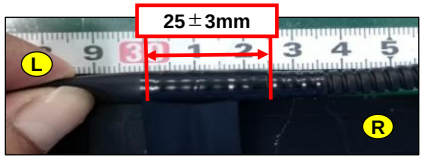
	WORK INSTRUCTION				Effectivity Date:	March 12, 2024		
	Process Name/Title:	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 310D / 7N0199-7020	Customer: TRJ	Car Model: TOYOTA-RAV4		Document No.:	WI-ENG-PDE-771		
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO		Revision No.:	1	Page No.:	10 of 18

PARTS:	1. Assy parts 2. Black tape 3. Black VM tube (Sunprene) Ø9 L=112±3mm			JIG:	n/a
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
12	n/a	Wire insertion to Black VM tube (Sunprene) Ø9 L=112±3mm	 1. Get the Black VM tube (Sunprene) **Ø9 L=112±3mm** using right hand then insert the **B-G-V wires.**		1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension-out tape
13	n/a	Taping 3 Black Corrugated tube to Balck VM tube (Sunprene)	 **40±3mm** 1. Measure from end of VM tube (Sunprene) up to terminal pointed tip **40±3mm** using both hands.  **Start of taping** 2. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.  **25±3mm** 3. Confirm measurement of **25±3mm** from end of tape up to end of tube then continue the taping process using both hands. **25±3mm** 4. Confirm measurement of **25±3mm** from end of tube up to end of tape then continue the taping process using both hands. **25±3mm** **40±3mm** **25±3mm** 5. After taping, check the measurement, terminal appearance and taping condition.	**MEASURING TAPE** 	***Important reminders/Notes/:*** ***1. Please use calibrated/verified measuring tape when getting the measurement.*** 1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension

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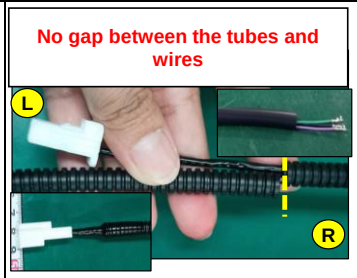
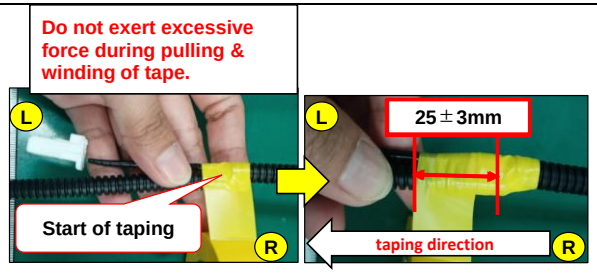
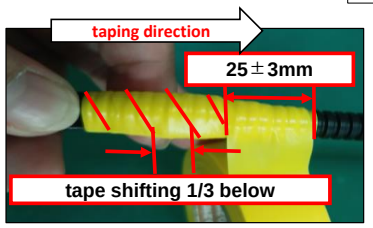
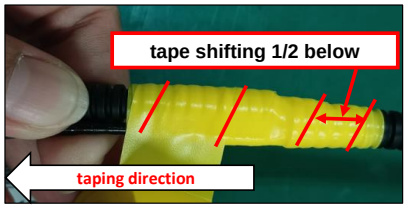
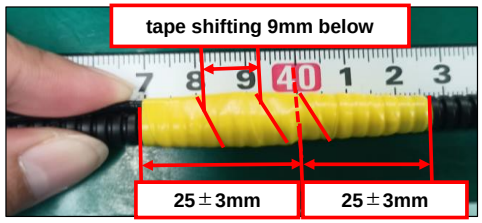
	WORK INSTRUCTION				Effectivity Date:	March 12, 2024		
	Process Name/Title:	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 310D / 7N0199-7020	Customer: TRJ	Car Model: TOYOTA-RAV4		Document No.:	WI-ENG-PDE-771		
	Purpose: ☐PROTOTYPE	☐PRE-LAUNCH	■MASSPRO		Revision No.:	1	Page No.:	11 of 18

PARTS:	1. Assy parts 2. Black tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
14	n/a	Y-taping	 1. Fix the tubes and wires.  2. Start taping at the middle of combined tubes and wires, then wind the tape to left side **(width must be 25mm)**  3. Wind the tape **1/3 shifting** until it reach the other side of the tubes and wires **(must be 25±3mm)**  4. Wind the tape **1/2 shifting**  5. Wind the tape **1/2 shifting** going to other side of tubes and wires then cut the tape. After taping, check the measurement and taping condition.	**MEASURING TAPE** 	***Important reminders/Note/s:*** ***1. Use yellow tape for easy visualization of tape shifting, but actual should be BLACK TAPE.*** ***2. Please use calibrated/verified measuring tape when getting the measurement.*** 1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension-out tape

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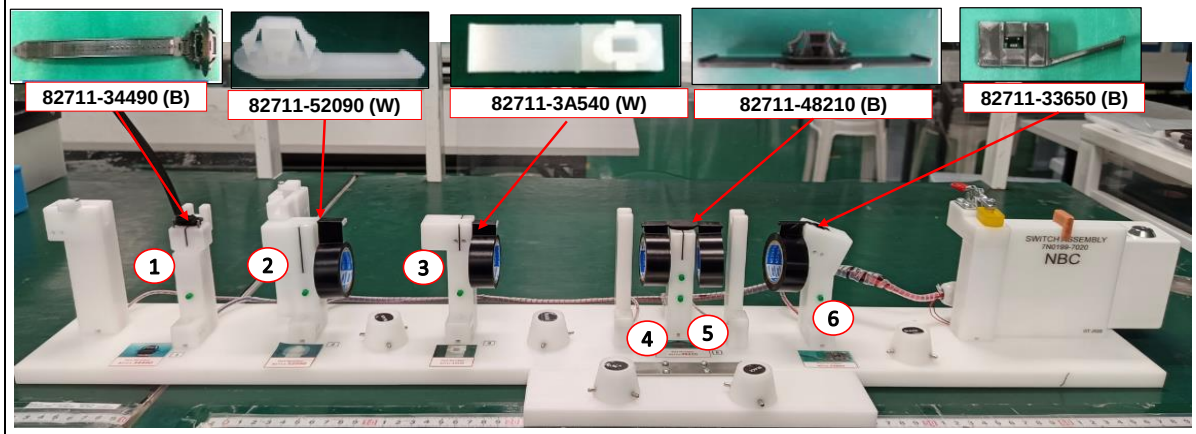
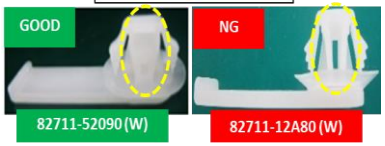
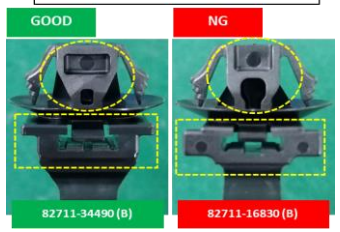
NBC	WORK INSTRUCTION			Effectivity Date:	March 12, 2024
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number: 310D / 7N0199-7020	Customer: TRJ	Car Model: TOYOTA-RAV4	Document No.:	WI-ENG-PDE-771
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1 — Page No.: 12 of 18

PARTS:	1. Clamp 82711-52090 (W) 2. Clamp 82711-48210 (B) 3. Clamp 82711-34490 (B) 4. Clamp 82711-3A540 (W) 5. Clamp 82711-33650 (B) 6. Black tape [5 pcs.]	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		⚠1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
15	n/a	Clamp Setting	 1. Get 1pc. of clamp **82711-34490 (B)** using right hand and set to clamp location **1** using both hands. 2. Get 1pc. of clamp **82711-52090 (W)** using right hand and set to clamp location **2** using both hands. 3. Get 1pc. of clamp **82711-3A540 (W)** using right hand and set to clamp location **3** using both hands. 4. Get 1pc. of clamp **82711-48210 (B)** using right hand and set to clamp location **4 and 5** using both hands. 5. Get 1pc. of clamp **82711-33650 (B)** using right hand and set to clamp location **6** using both hands. 6. Initially attach **Black tape** to clamp location **2, 3, 4, 5 and 6** using both hands.		1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position ***Important reminders/Note/s:*** ***1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.*** CLAMP ILLUSTRATION  BAND CLAMP ILLUSTRATION 

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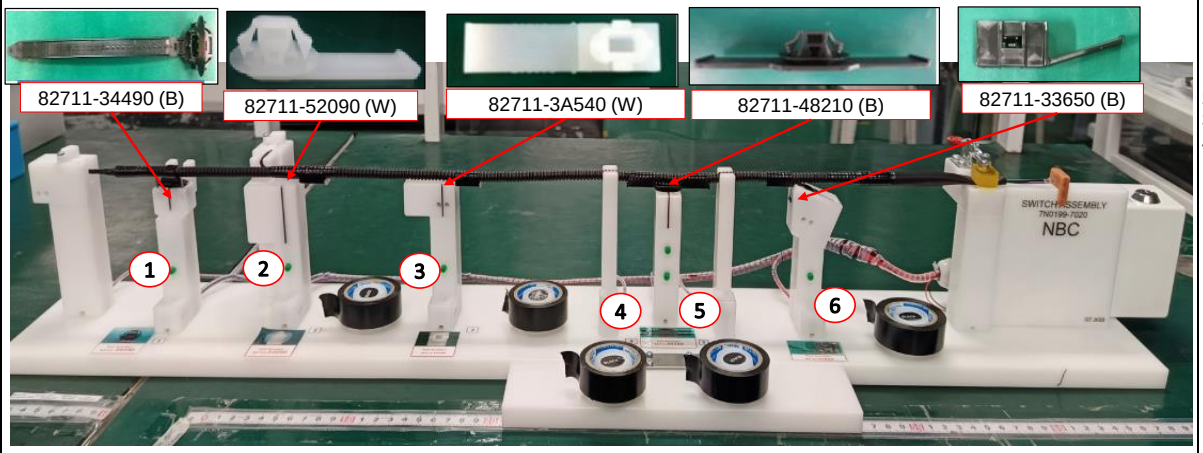
NBC	WORK INSTRUCTION			Effectivity Date:	March 12, 2024
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number: 310D / 7N0199-7020	Customer: TRJ	Car Model: TOYOTA-RAV4	Document No.:	WI-ENG-PDE-771
	Purpose: ☐PROTOTYPE ☐PRE-LAUNCH ■MASSPRO			Revision No.: 1	Page No.: 13 of 18

PARTS:	1. Assy parts	JIG:	1. Clamp assembly jig

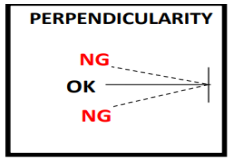
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
16	n/a	Clamp assembly			1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position ***Important reminders/Note/s:*** ***1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.*** ***2. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).*** ***3. Setting of band clamp cutter depends on the size of the COT/SV tube (Vinyl) ø5- 1~2, ø7- 3~4***



1. Put the assy into jig. ***(See above picture for the correct setting).*** First, set the connector **6098-3802 (W)** to **Receiver base 1.** Second, set the **B-B wires** together within stopper then press by toggle clamp.

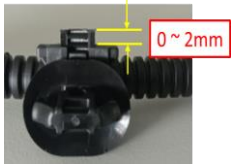
2. Initially tighten the band clamp on location **1** using both hands. Get the bando gun using right hand then cut the band clamp using both hands. Press the **SW button** after taping. Continue the process if the sequence light on **location 2** was **ON**.

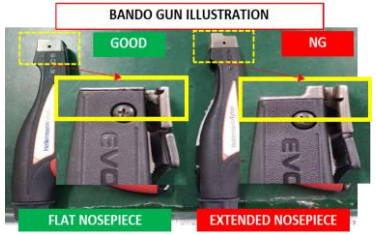
BANDO GUN ALIGNMENT



PROPER CUTTING POSITION OF BANDO GUN

IMPROPER CUTTING POSITION OF BANDO GUN





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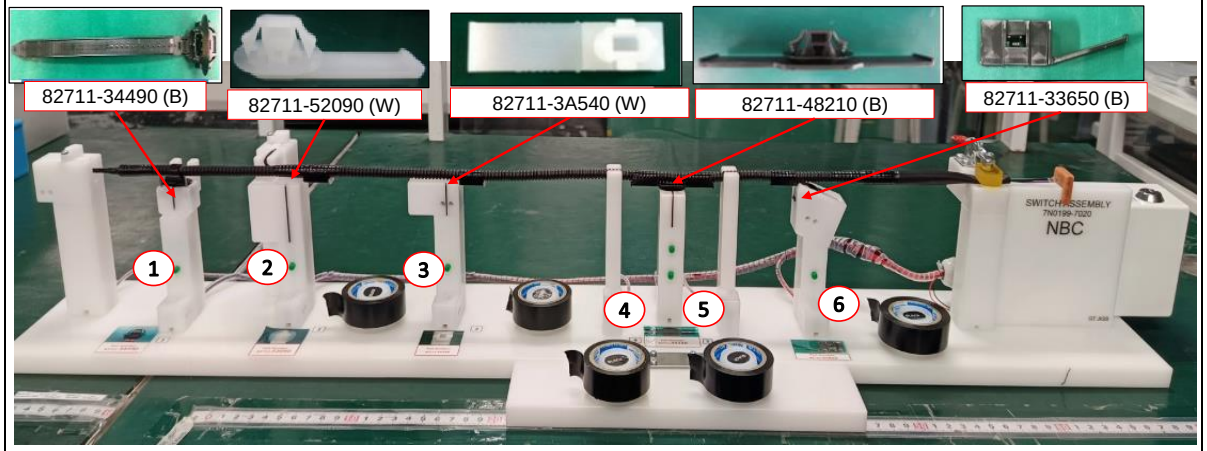
	Process Name/Title:	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 310D / 7N0199-7020	Customer: TRJ	Car Model: TOYOTA-RAV4		Document No.:	WI-ENG-PDE-771		
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO		Revision No.:	1	Page No.:	14 of 18

PARTS:	1. Assy parts	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		⚠1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
16	n/a	Clamp assembly (Continuation)	 3. On clamp location **2**, hold the tape then make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if the sequence light on **location 3** was **ON**. 4. On clamp location **3**, hold the tape then make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if the sequence light on **location 4** was **ON**. 5. On clamp location **4**, hold the tape then make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if the sequence light on **location 5** was **ON**. 6. On clamp location **5**, hold the tape then make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if the sequence light on **location 6** was **ON**. 7. On clamp location **6**, hold the tape then make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. **GO** sound will be heard. 8. After taping, **CONDUCT POINT CHECKING** before removing the harness from jig.		***1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.*** 1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position

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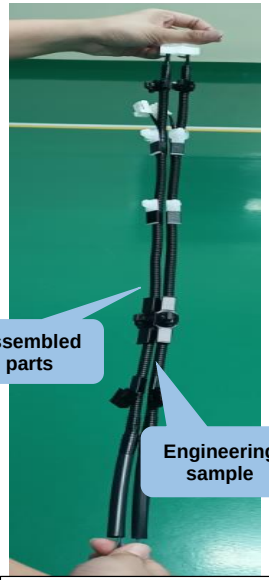
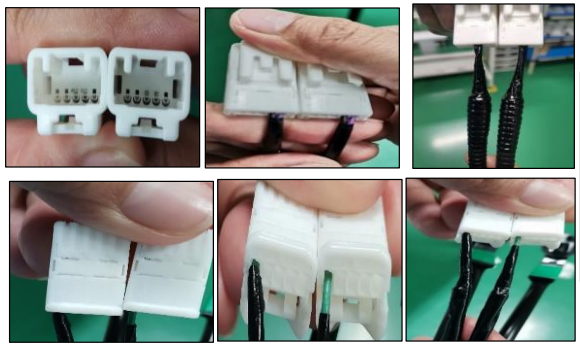
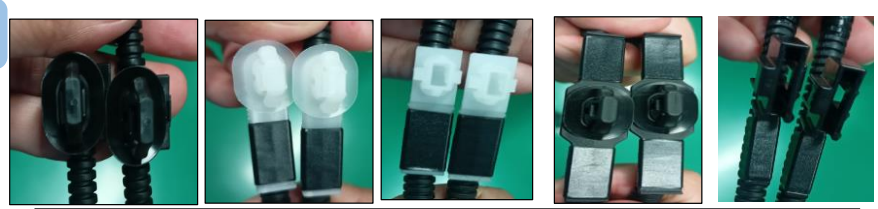
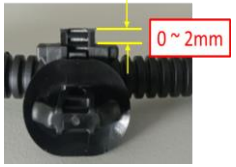
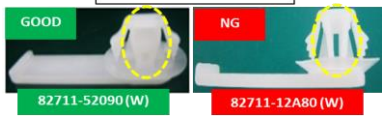
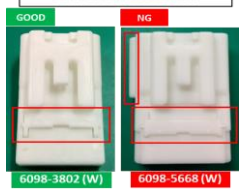
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number: 310D / 7N0199-7020	Customer: TRJ	Car Model: TOYOTA-RAV4	Document No.:	WI-ENG-PDE-771
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 1	Page No.: 15 of 18

PARTS:	1. Assy parts 2. Engineering sample	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
17	n/a	Visual/By Two's Inspection	 ACTUAL PRODUCT  Assembled parts Engineering sample 1. Conduct **alignment of harness (Engineering sample vs. Assembled parts)** using both hands.  2. Check the **connector lock condition**, **insertion**, **terminal** and **taping condition**.  3. Check the **presence of clamp attachment**, **taping condition and band clamp cut.** Conduct **bending of parts with wing-type clamp.**		1. No skip checking during inspection. **ENGINEERING SAMPLE** ***Important reminders/Note/s:*** ***1. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).***  CLAMP ILLUSTRATION  CONNECTOR ILLUSTRATION 

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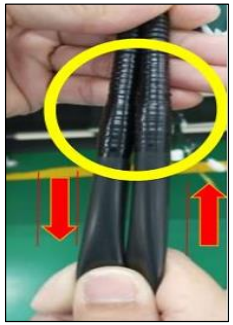
PARTS:	1. Assy parts 2. Engineering sample	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
17	n/a	Visual/By Two's Inspection (Continuation)	 ACTUAL PRODUCT 4. Check the **half-wrap taping and Y-taping condition.**  5. Conduct slightly pulling **(UP and Down)** of VM tube (Sunprene) to **confirm the presence of tape.** 7. Check the **terminal appearance**. Must be **no deformed terminal**		1. No skip checking during inspection.

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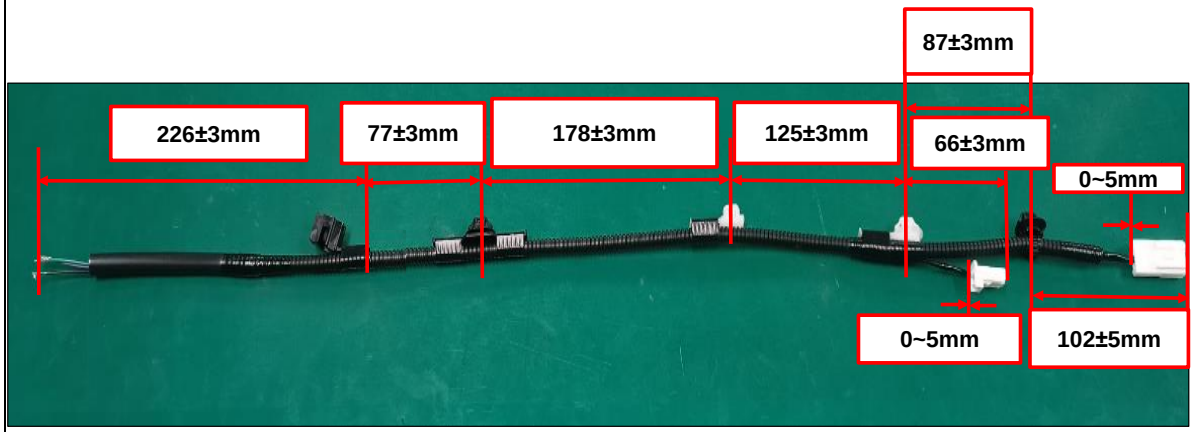
	WORK INSTRUCTION				Effectivity Date:	March 12, 2024		
	Process Name/Title:	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 310D / 7N0199-7020	Customer: TRJ	Car Model: TOYOTA-RAV4		Document No.:	WI-ENG-PDE-771		
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO		Revision No.:	1	Page No.:	17 of 18

PARTS:	n/a	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
18	n/a	Measurement	 MEASURING TAPE 		1. No wrong dimension ***Important reminders/Note/s:*** ***1. Please use calibrated/verified measuring tape when getting the measurement.*** ***2. For Hatsumono, Nakamono and Owarimono.***

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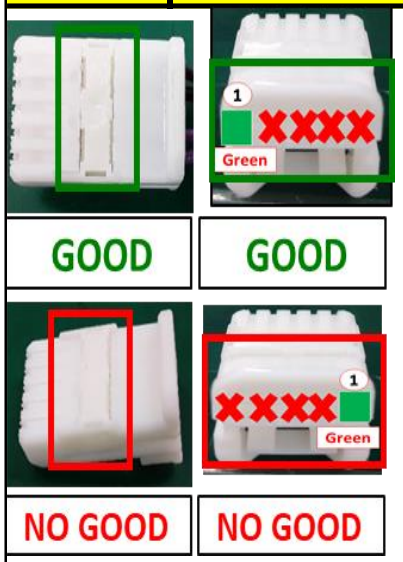
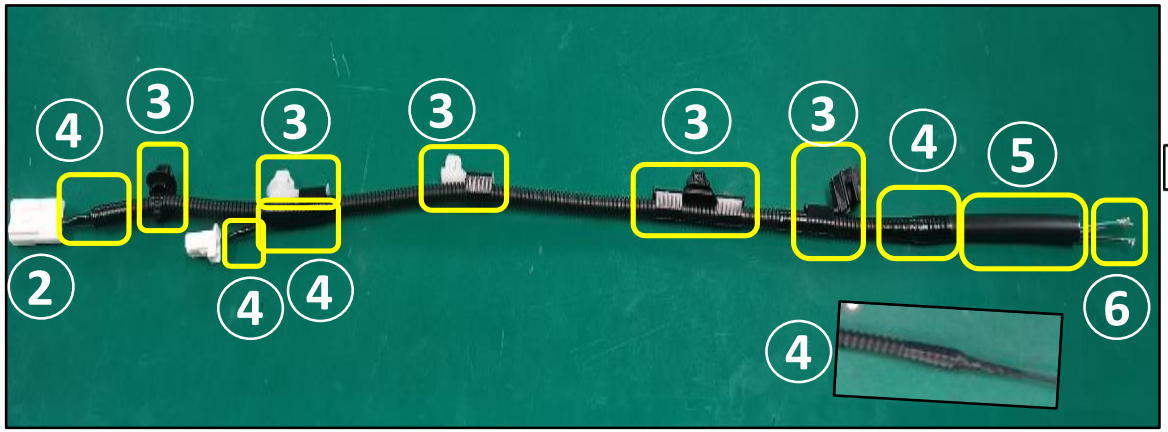
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 1	Page No.: 18 of 18

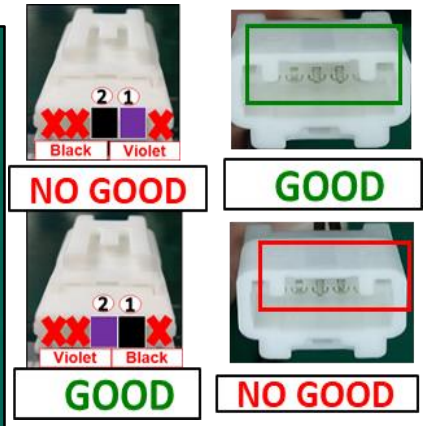
PARTS:	n/a	JIG:	n/a

QUALITY CHECKPOINTS

n/a 7N0199-7020







1. No Unlock/Halflock Connector (On 2 connectors)
2. No Wrong Insert (On 2 connectors)
3. No missing clamps
4. No Missing tape
5. No missing parts [VM tube (Sunprene)]
6. No deformed terminal

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