



WORK INSTRUCTION  
TAPING ASSEMBLY PROCESS

Effectivity Date:	November 07, 2023		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-753		
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Process Name/Title:

Model code/Part number: 310D / 7N0189-7020

Customer: TRJ

Car Model: TOYOTA RAV4

Purpose: ☐ PROTOTYPE

☒ PRE-LAUNCH







☐ MASSPRO

PARTS:

1. Connector 6098-5668 (W)
2. IRRAX A ROPE-LAY 0.3 B 200±2mm
3. IRRAX A ROPE-LAY 0.3 B 200±2mm

JIG:

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	n/a	<p>Wire insertion to connector</p>  <p>Connector Facing</p>   <p>1. Hold the connector <b>6098-5668 (W)</b> then get the <b>Black wire L=200±2mm</b> and insert to terminal <b>slot 1</b> of connector using right hand. Conduct <b>2x</b> push pull after wire insertion.</p>   <p>2. Hold the connector <b>6098-5668 (W)</b> then get the <b>Black wire L=200±2mm</b> and insert to terminal <b>slot 2</b> of connector using right hand. Conduct <b>2x</b> push pull after wire insertion.</p> <p>Wire Terminal Facing</p> 	<p><b>Safety Instruction</b> Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing</p> <p><b>Important reminder's/Note:</b> <b>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. Please hold the wire near terminal.</b></p> <p><b>Document references:</b> <b>1. Refer to WI-PRO-CNC-017 for Wire Strip lenght tolerance. Refer to GL PRO-ASY-029 for pull-push-pull-push procedure</b></p>

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
11/07/23	0	Initial issue.	A.Hernandez	C.Villanueva	A. Arañes	n/a	A.Hernandez	C. Villanueva	A. Arañes	n/a
Est. Date:							November 07, 2023			

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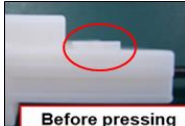



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PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	n/a	Connector lock	<div>LOCKING JIG</div> <div></div>	<div>1. Use the provided jig per model</div> <div>2. No unlocked/half-locked connector</div> <div><b>Important reminders/Note/s:</b></div> <div>1. <b>MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR LOCK</b></div> <div>2. <b>Use provided jig tool per model to avoid damaged lock.</b></div> <div><b>Document references:</b></div> <div>1. <b>Refer to GL-PRO-ASY-017 for the verification of connector lock.</b></div> <div><div><div><p>Before pressing</p></div><div><p>After pressing</p></div></div><div><div><div>GOOD</div><div><p>Full Lock</p></div></div><div><div>NG</div><div><p>Half Lock</p></div></div></div></div>

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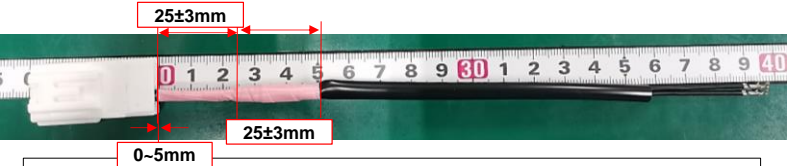



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PARTS:		1. Assy parts 2. Black SV tube (vinyl) $\phi 5$ t=0.5 L= 129 $\pm$ 3mm 3. Pink Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3		Wire insertion to Black SV tube (vinyl) $\phi 5$ t=0.5 L= 129 $\pm$ 3mm	 <p>1. Get the <b>Black SV tube (vinyl)</b> <math>\phi 5</math> t=0.5 L= 129<math>\pm</math>3mm using right hand then insert the Black wires.</p>	N/A	1. No wrong usage of parts. 2. No deformed terminal
	n/a	Taping 1 Black SV tube (vinyl) to Wire near Connector	 <p>1. Hold the SV tube (vinyl) using right hand and measure the end of the SV tube up to connector <b>25mm</b>.</p>  <p>2. Get the <b>PINK TAPE</b> and start taping using both hands. <i>Refer to WI-PRO-ASY-001.</i></p>  <p>3. After taping, check the dimension, taping condition and wire alignment.</p>	<p><b>MEASURING TAPE</b></p> 	<p>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension</p> <p><i>Note:</i> <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p>  <p><b>Wire alignment tolerance</b></p> 

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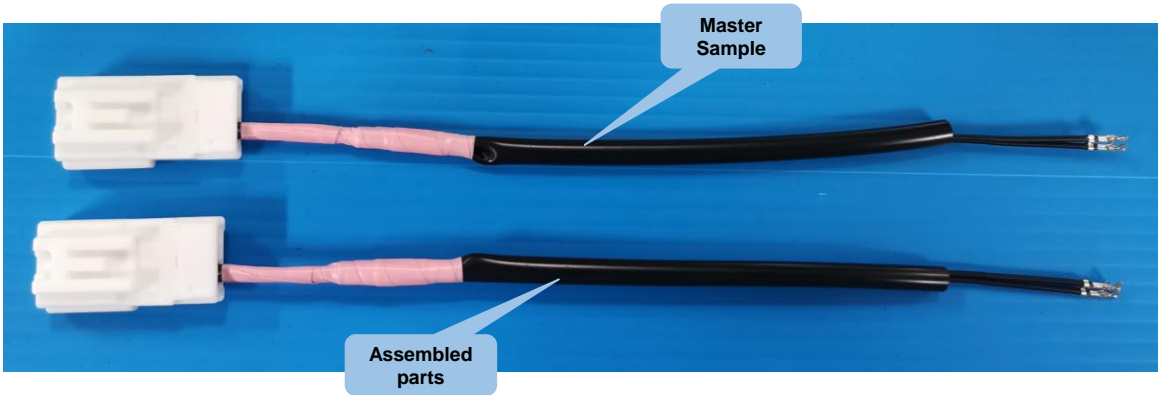

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PARTS:		1. Assy parts 2. Engineering sample		JIG:	n/a	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	n/a	Visual/By Two's Inspection	<div>1. Check the connector lock.</div> <div>2. Check the taping condition.</div> <div>3. Check the terminal appearance. Make sure no deformed terminal.</div> <div><div>ACTUAL PRODUCT</div></div> <div><div>4. Compare to Master Sample by tapping.</div><div><div>Master Sample</div><div>Assembled parts</div></div></div>			<div>1. No skip checking during inspection.</div> <div>ENGINEERING SAMPLE</div> <div></div>

1. No skip checking during inspection.

ENGINEERING SAMPLE



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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	n/a	Measurement	<div><div>MEASURING TAPE</div></div>	<p><b>Important reminders/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 WI-PRO-ASY-056 for Sub assembly Hatsomono, Nakamono, and Owarimono Inspection.</p> <p>1. No wrong dimension</p>

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PARTS:

n/a

JIG:

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### QUALITY CHECKPOINTS

n/a

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①



GOOD



NO GOOD

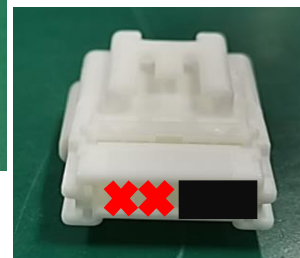


②

③



GOOD



NO GOOD

②

No Missing Tape

③

No Deformed Terminal

①

No Unlock/Halflock Connector

④

No Wrong Insert

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