


	WORK INSTRUCTION						Effectivity Date:		February 05, 2024	
	TAPING ASSEMBLY PROCESS						Validity Date:		n/a	
	Process Name/Title:						Document No.:		WI-ENG-PDE-791	
	Model code/Part number: 311D / 7L0153-7022			Customer: TRQSS		Car Model: TOYOTA-RAV4		Revision No.:		0
Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO										


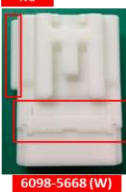
PARTS:	1. AVSSf 0.3 Black wires L=768±3mm 2. AVSSf 0.3 Violet wires L=768±3mm 3. Black Corrugated tube ø5 L=169±3mm (no slit)						JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION					TOOLS/PPE	QUALITY POINTERS
1	n/a	<div style="display: flex; align-items: center; justify-content: center;"> </div> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> <p>1. Get the Black Corrugated tube ø5 L=169±3mm (no slit) using right hand then insert the Violet wire and Black wire using both hands.</p> </div>					<div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> <p>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> </div> <div style="border: 1px dashed red; padding: 5px;"> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>	<p>1. No wrong usage of parts. 2. No deformed terminal</p> <p>Document references: 1. Refer to WI-PRO-CNC-017 for Wire Strip lenght tolerance.</p>

Revision History								Prepared by	Reviewed by	Approved by	Noted by
02/05/2024	0	Initial issue						D. Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	February 05, 2024			

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PARTS:	1. Assy Parts 2. Connector 6098-3802 (W)			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	n/a	Wire insertion to connector 6098-3802 (W)		n/a	<div>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</div> <div>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.</div> <div>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</div> <div><div>CONNECTOR ILLUSTRATION</div><div><div>GOOD</div><div>NG</div><div></div><div></div><div>6098-3802 (W)</div><div>6098-5668 (W)</div></div></div>

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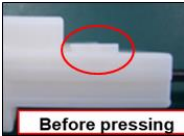



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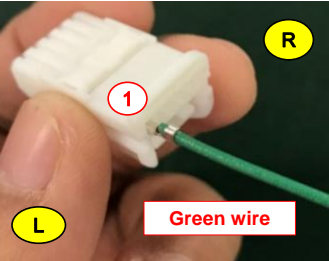

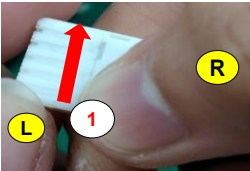
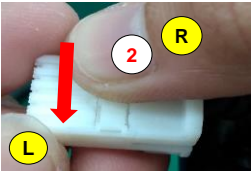
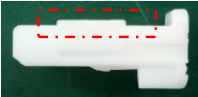


PARTS:	1. Assy Parts	JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE QUALITY POINTERS
3	n/a Connector lock	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div> <div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div> <div><p>3. Press the lower parts of connector using right hand while left hand holding the middle.</p></div> <div><p>4. Press the upper part of connector using right hand while left hand holding the middle.</p></div> <div><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></div>	<div>LOCKING JIG</div>  <div><p>Before pressing</p><p>After pressing</p></div> <div><div>GOOD <p>Full Lock</p></div><div>NG <p>Half Lock</p></div></div> <p>1. Use the provided jog per model 2. No unlocked/half-locked connector</p> <p>Important reminders/Note/s: 1. Manual locking jig may caused damaged connector lock.</p> <p>Document references: 1. Refer to GL-PRO-ASY-017 for the verification of connector lock.</p>



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PARTS: 1. Connector 6098-3810 (W) 2. AVSSf 0.3 wires Green L=659±3mm		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	n/a	<div>  <p>CONNECTOR ORIENTATION</p> </div> <div>  <p>VISUAL REFERENCE</p> </div> <div>  <p>WIRE FACING</p> </div> <div>  <p>Green wire</p> </div> <div> <p>1. Get the connector 6098-3810 (W) then hold the Green wire and insert to terminal slot 1 of connector using right hand. Conduct 2x push pull after wire insertion.</p> </div>	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
5	Connector lock	<div>  <p>LOCKING JIG</p> </div> <div> <p>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.</p> </div> <div>  <p>1</p> </div> <div>  <p>2</p> </div> <div> <p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p> </div> <div>  <p>Before Pressing</p> </div> <div>  <p>After Pressing</p> </div>	<div>  <p>LOCKING JIG</p> </div>	1. No wrong usage of parts 2. No deformed terminal Important reminders/Note/s: 1. Manual locking may cause damaged connector lock

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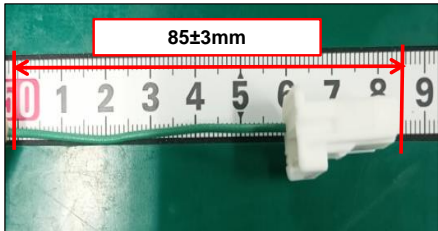
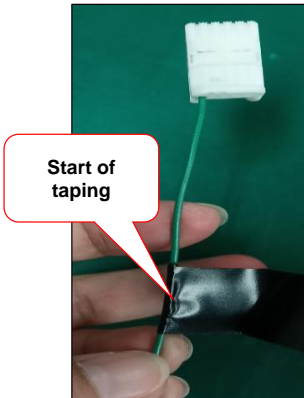
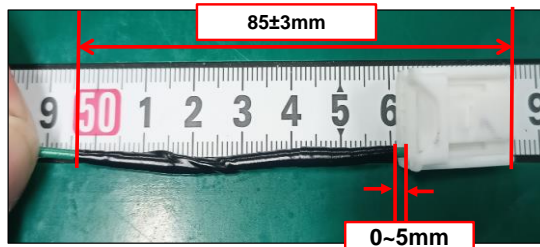
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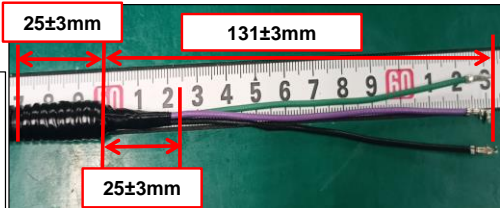

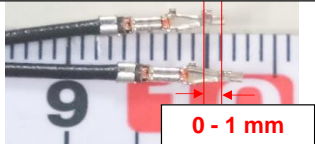
PARTS:		1. Black tape [1pc]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	n/a	Half wrap taping		<div>MEASURING TAPE</div> 	1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension
		 <div>1. Hold the wire using left hand, Measure from wire up to end of connector 85±3mm using both hands.</div>  <div>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. <i>(Taping must be 1/2 shifting)</i></div>  <div>3. After taping, check the measurement and tape condition.</div>			

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PARTS: 1. Assy parts 2. Black Corrugated tube ø5 L=459±3mm (no slit) 3. Black tape [1pc]		JIG:	1. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	Wire Insertion to Black Corrugated tube ø5 L=459±3mm (no slit)	 <p>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.</p>  <p>2. Get the Corrugated tube ø5, L=459±3mm using right hand then insert to B-V-G wires using both hands.</p>  <p>3. After insertion, remove the terminal cover jig using right hand.</p>		1. No wrong usage of parts. 2. No deformed terminal
8	n/a Taping 2 COT to wire near terminal	 <p>1. Hold the assy parts using left hand. Get Black tape using right hand and start pre-taping.</p>  <p>2. Measure from COT to terminal tip 131±3mm using both hands and continue the taping process.</p>  <p>3. After taping, check the measurement and taping condition.</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 Important reminders/Notes/: 1. Please use calibrated/verified measuring tape when getting the measurement. Document references: 1. Refer to WI-PRO-ASY-001 for Taping process  <p>0 - 1 mm</p>

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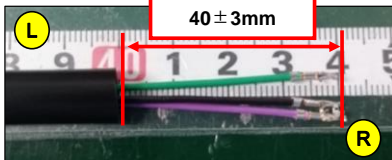

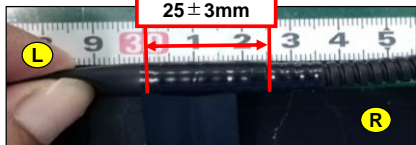
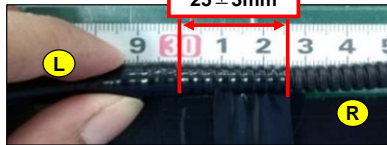


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PARTS:		1. Assy parts 2. Black tape [1pc]		3. Black VM tube (Sunprene) Ø9 L=112±3mm		JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
9		Wire insertion to Black VM tube (Sunprene) Ø9 L=112±3mm	<div></div> <div>1. Get the Black VM tube (Sunprene) Ø9 L=112±3mm using right hand then insert the B-G-V wires.</div>				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
10	n/a	Taping 3 Black Corrugated tube to Balck VM tube (Sunprene)	<div><div></div><div>1. Measure from end of VM tube (Sunprene) up to terminal pointed tip 40±3mm using both hands.</div></div> <div><div></div><div>Start of taping</div><div>2. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.</div></div> <div><div></div><div>3. Confirm measurement of 25±3mm from end of tape up to end of tube then continue the taping process using both hands.</div></div> <div><div></div><div>4. Confirm measurement of 25±3mm from end of tube up to end of tape then continue the taping process using both hands.</div></div> <div><div></div><div>5. After taping, check the measurement, terminal appearance and taping condition.</div></div>			<div>MEASURING TAPE</div> <div></div>	<i>Important reminders/Notes/:</i> 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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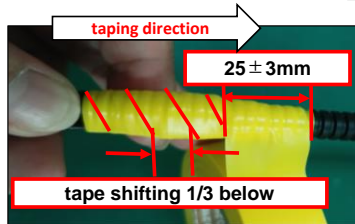

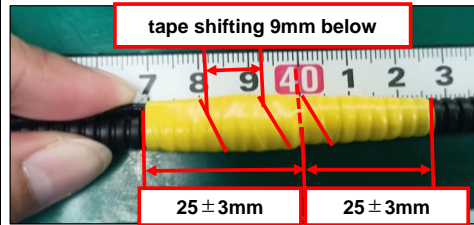

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	n/a	Y-taping			
		<div><div><p>No gap between the tubes and wires</p></div><div><p>1. Fix the tubes and wires.</p></div></div> <div><div><p>Do not exert excessive force during pulling & winding of tape.</p><p>Start of taping</p></div><div><p>2. Start taping at the middle of combined tubes and wires, then wind the tape to left side (width must be 25mm)</p></div></div> <div><div><p>taping direction</p><p>25 ± 3mm</p><p>tape shifting 1/3 below</p></div><div><p>3. Wind the tape 1/3 shifting until it reach the other side of the tubes and wires (must be 25±3mm)</p></div></div> <div><div><p>tape shifting 1/2 below</p><p>taping direction</p></div><div><p>4. Wind the tape 1/2 shifting</p></div></div> <div><div><p>tape shifting 9mm below</p><p>25 ± 3mm</p><p>25 ± 3mm</p></div><div><p>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.</p></div></div>		<div><p>MEASURING TAPE</p></div>	<p>Important reminders/Note/s:</p> <p>1. Use <u>yellow</u> tape for easy visualization of tape shifting, but actual should be <u>BLACK TAPE</u>. 2. Please use calibrated/verified measuring tape when getting the measurement.</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-out tape</p>

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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. Temporary Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
12	n/a	Clamp Setting				<div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div> <div>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>82711-52090 (W)</div></div><div><div>NG</div><div>82711-12A80 (W)</div></div></div> <div><div>BAND CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>82711-34490 (B)</div></div><div><div>NG</div><div>82711-16830 (B)</div></div></div>

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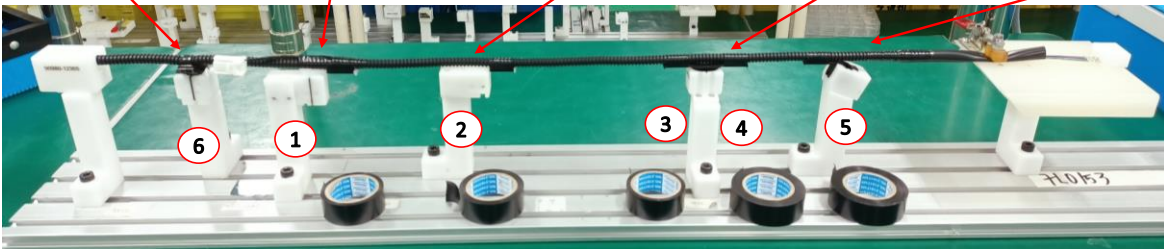
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PARTS:		1. Assy parts		JIG:	1. Temporary Clamp assembly jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
13	n/a	Clamp assembly	<div><div> 82711-34490 (B)</div><div> 82711-52090 (W)</div><div> 82711-3A540 (W)</div><div> 82711-48210 (B)</div><div> 82711-33650 (B)</div><div></div></div>				<div>1. No wrong use of parts</div> <div>2. No wrong use of tape</div> <div>3. No damaged clamp</div> <div>4. No wrong clamp position</div>
			<div>1. Put the assy into jig. <i>(See above picture for the correct setting)</i>. 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.</div>				
			<div>2. On clamp location 1, hold the tape then make 3 windings of tape then cut the tape using both hands. Proceed to clamp location 2.</div>				
			<div>3. On clamp location 2, hold the tape then make 3 windings of tape then cut the tape using both hands. Proceed to clamp location 3 and 4.</div>				
			<div>4. On clamp location 3 and 4, hold the tape then make 3 windings of tape then cut the tape using both hands. Proceed to Clamp location 5.</div>				
			<div>5. On clamp location 5, hold the tape then make 3 windings of tape then cut the tape using both hands. Proceed to clamp location 6.</div>				

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

82711-34490 (B)	82711-52090 (W)	82711-3A540 (W)	82711-48210 (B)	82711-33650 (B)

6. Initially tighten the band clamp on location 6 using both hands. Get the bando gun using right hand then cut the band clamp using both hands.

7. After taping, **CONDUCT POINT CHECKING** before removing the harness from jig.

PROPER CUTTING POSITION OF BANDO GUN

IMPROPER CUTTING POSITION OF BANDO GUN

BANDO GUN ALIGNMENT

PERPENDICULARITY

Fixed setting of band clamp cutter: 1~ 2

BANDO GUN ILLUSTRATION

GOOD NG

FLAT NOSEPIECE EXTENDED NOSEPIECE

0 ~ 2mm

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DCC Stamp



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

February 05, 2024

Model code/Part number:

311D

/

7L0153-7022

Customer: TRQSS

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-791

Purpose:



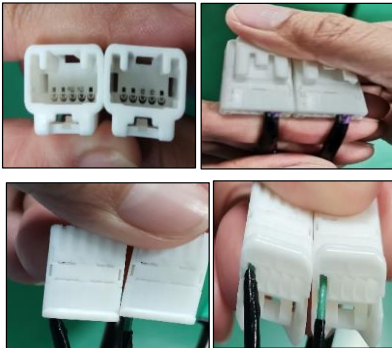







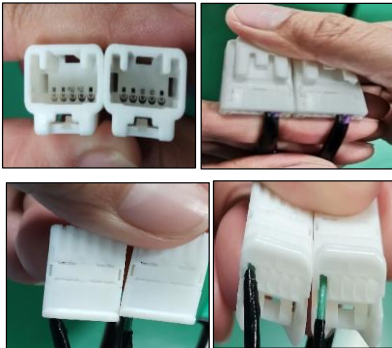







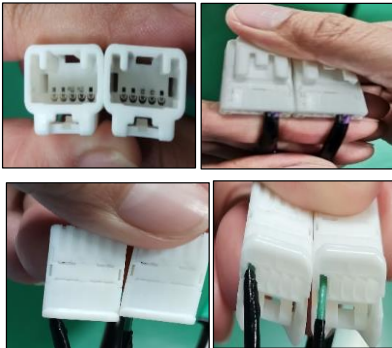







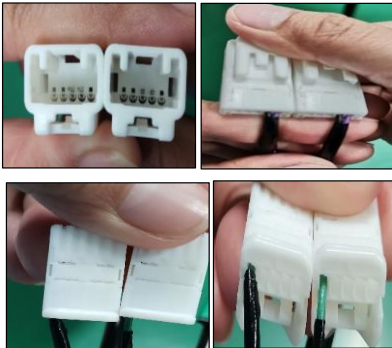







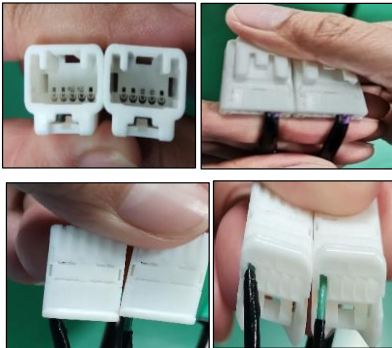







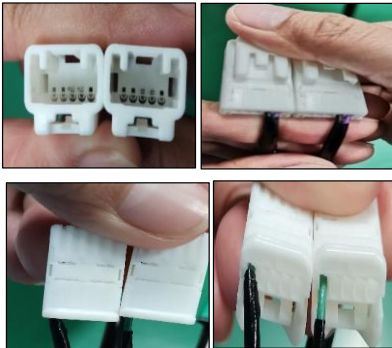







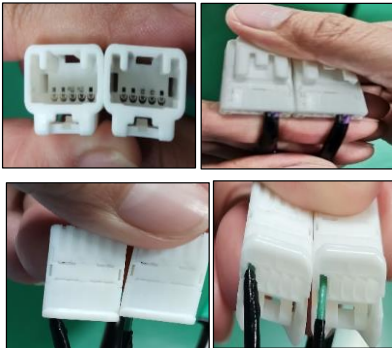







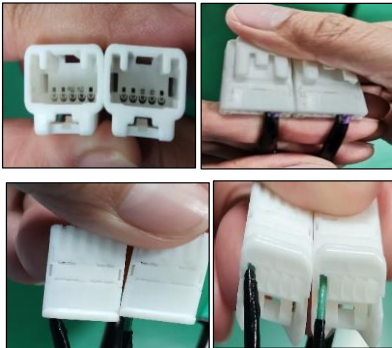







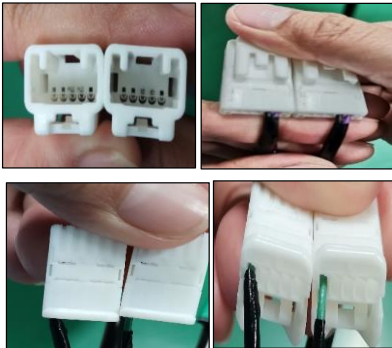







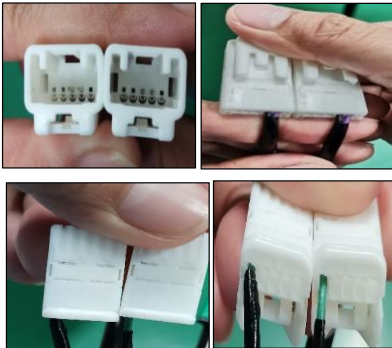







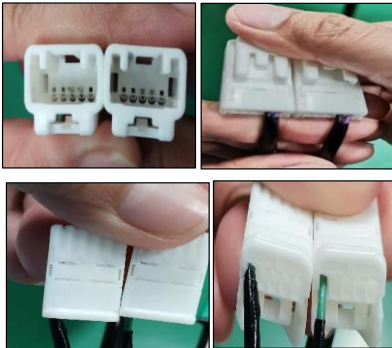







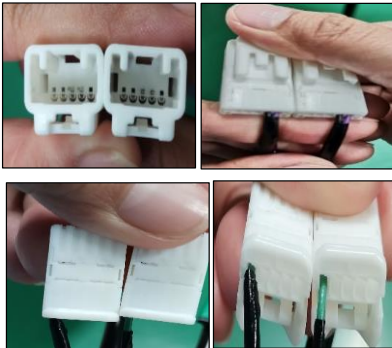







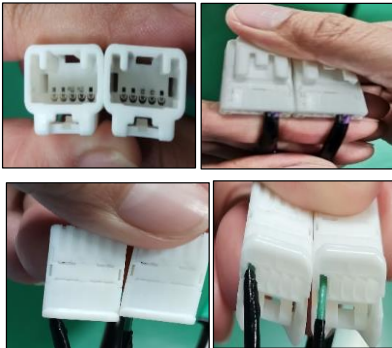







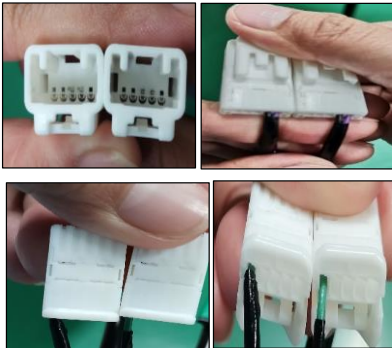







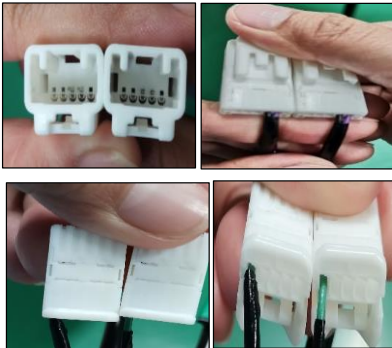







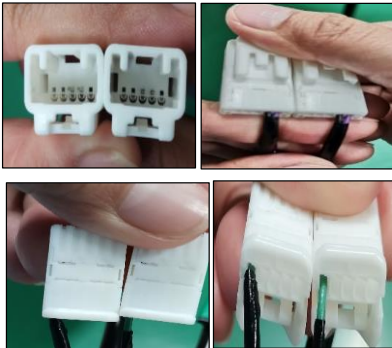







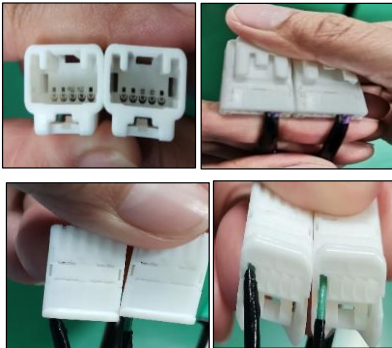







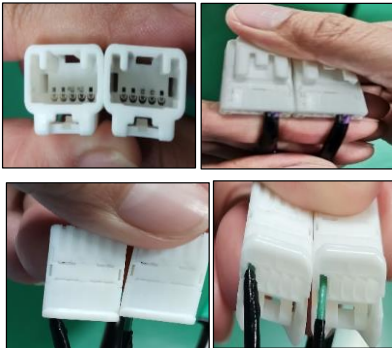







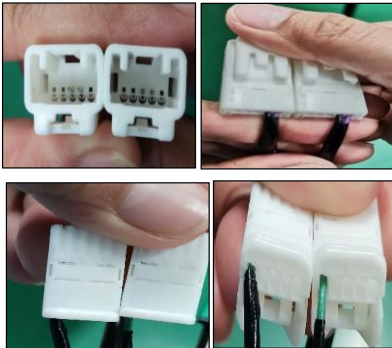







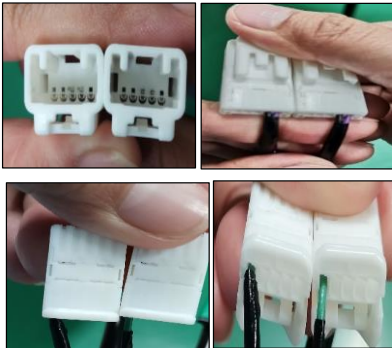







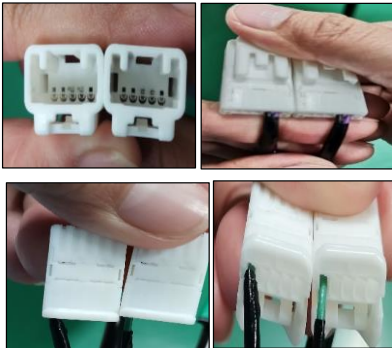







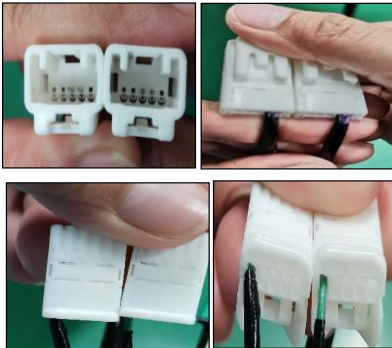







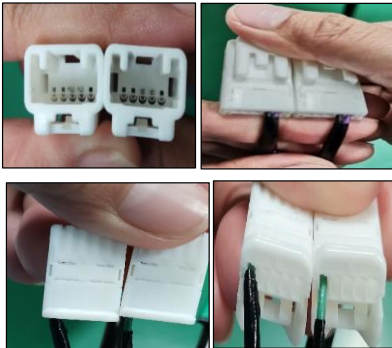







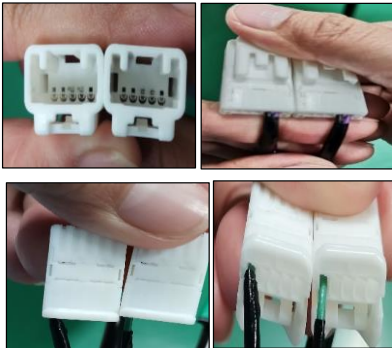







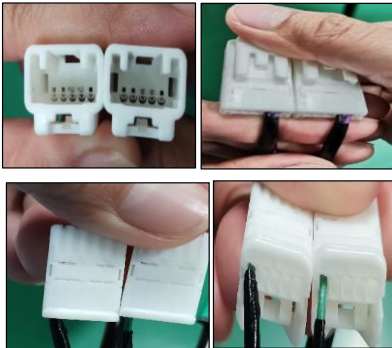







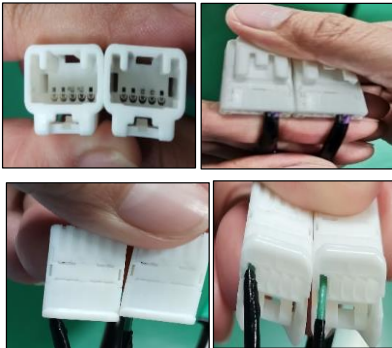







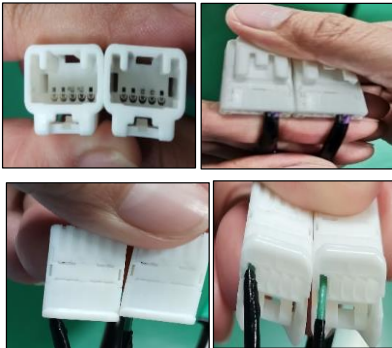







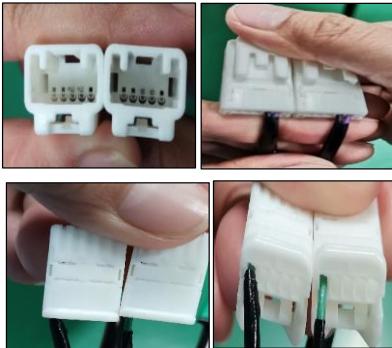







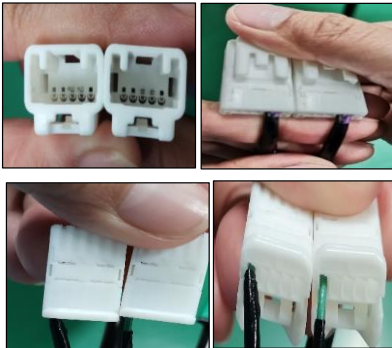







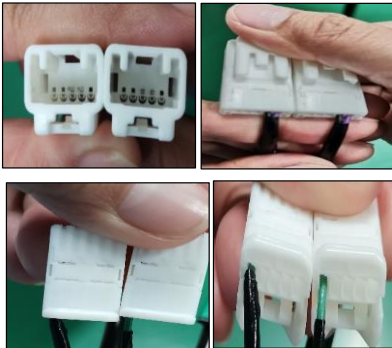







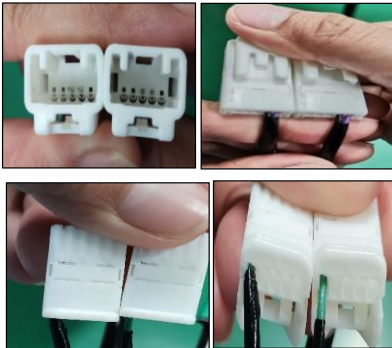







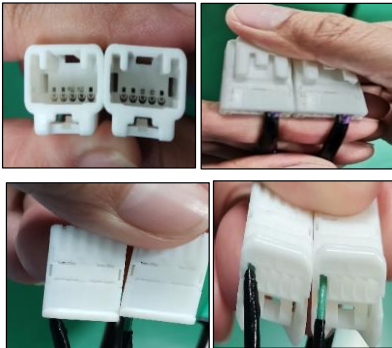







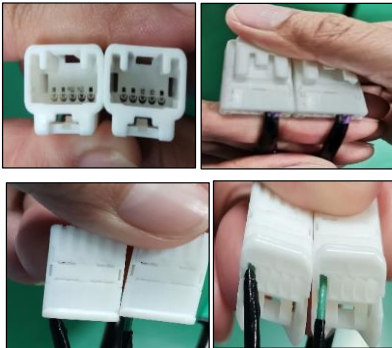







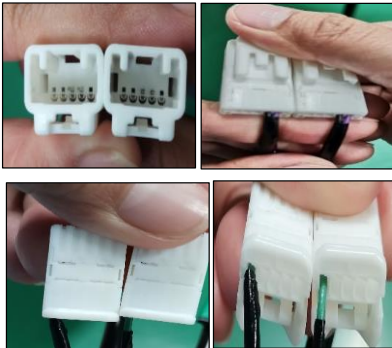







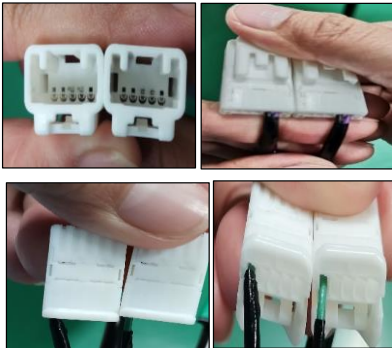







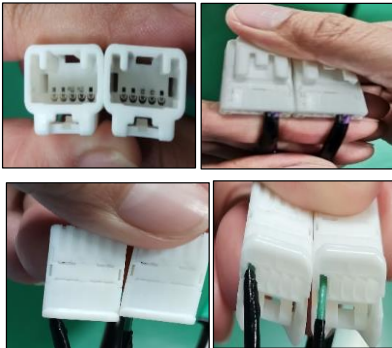







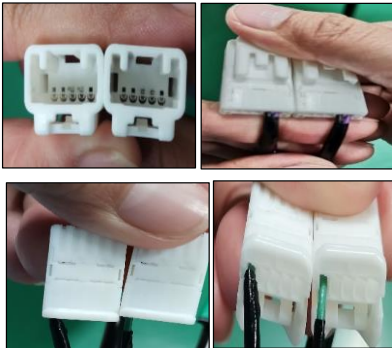







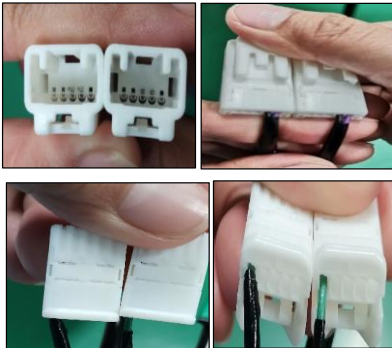







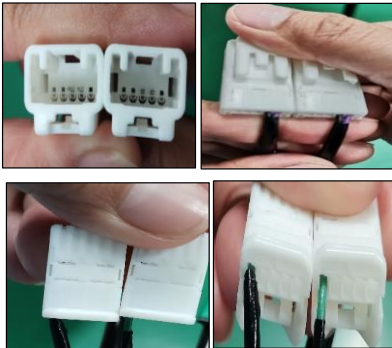







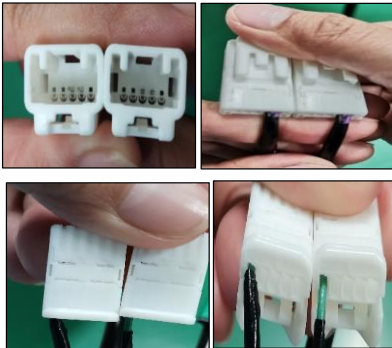
☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Revision No.:

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Page No.:

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PARTS:		1. Assy parts 2. Engineering sample		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
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DCC Stamp

**WORK INSTRUCTION**

Effectivity Date:

February 05, 2024

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

311D

/

7L0153-7022

Customer:

TRQSS

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-791

Purpose:



PROTOTYPE



PRE-LAUNCH




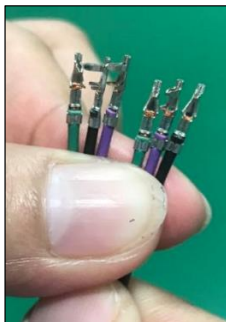



MASSPRO

Revision No.:

0

Page No.:

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PARTS:		1. Assy parts 2. Engineering sample		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
14	n/a	Visual/By Two's Inspection (Continuation)	 <div>ACTUAL PRODUCT</div>		1. No skip checking during inspection.
			<div></div> <div>4. Check the half-wrap taping and Y-taping condition.</div> <div>5. Conduct slightly pulling (UP and Down) of VM tube (Sunprene) to confirm the presence of tape.</div> <div>7. Check the terminal appearance. Must be no deformed terminal</div>		

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TAPING ASSEMBLY PROCESS

Effectivity Date:

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311D

/

7L0153-7022

Customer:

TRQSS

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-791

Purpose:

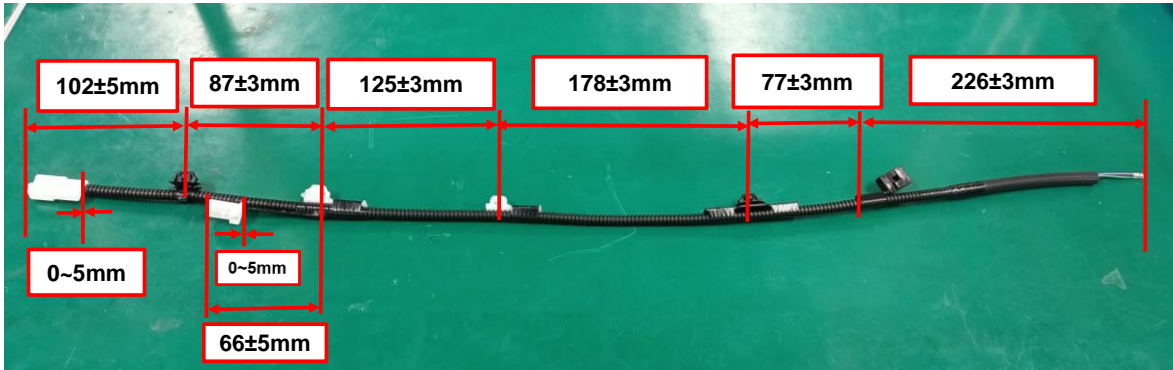

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Revision No.:

0

Page No.:

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PARTS:	n/a			JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
15	n/a	Measurement	<div><div>MEASURING TAPE</div></div>			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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TAPING ASSEMBLY PROCESS

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February 05, 2024

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311D**/****7L0153-7022**

Customer:

TRQSS

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-791

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Revision No.:

0

Page No.:

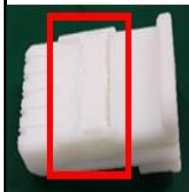
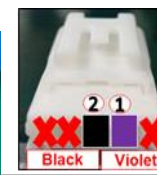
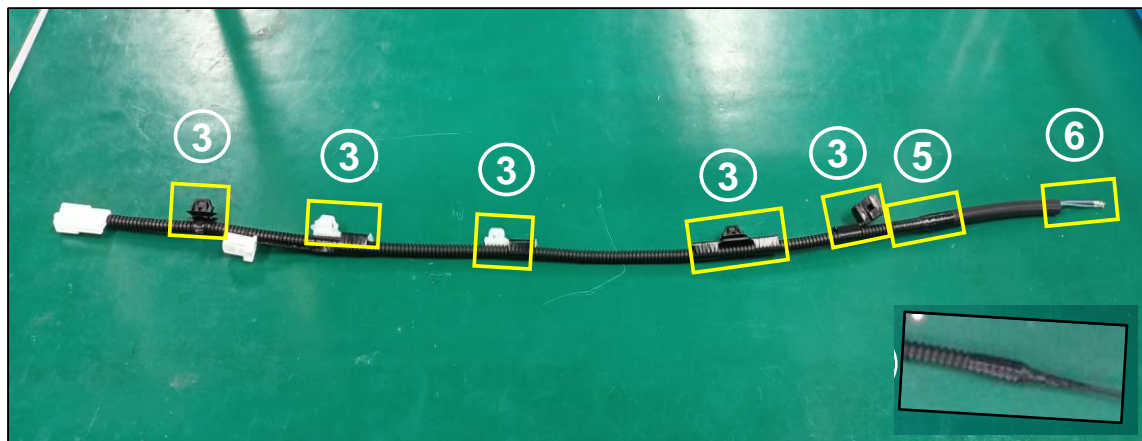
15 of 15

PARTS:

n/a

JIG:

n/a

QUALITY CHECKPOINTS**n/a****7L0153-7022****GOOD****GOOD****NO GOOD****NO GOOD****NO GOOD****GOOD****GOOD****NO GOOD****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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