



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

310D

/

7N0198-7020

Customer: TRJ

Car Model:

TOYOTA-RAV 4

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

March 12, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-769

Revision No.:

1

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PARTS: 1. Connector 6098-3802 (W)

JIG:

1. Insertion jig

NO.

PROCESS NAME

1

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

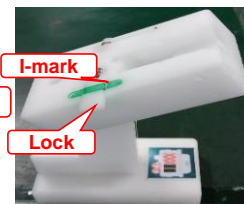
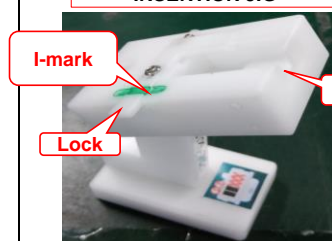
QUALITY POINTERS

1

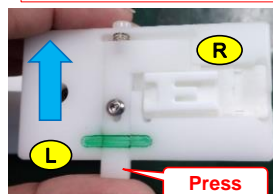
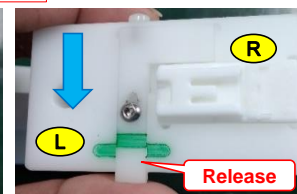
P1

Connector setting to
insertion jig 6098-3802
(W)

INSERTION JIG

CONNECTOR
ORIENTATION

INSERTION JIG

1. Press the lock of insertion jig
using left thumb.2. Insert the connector **6098-3802 (W)** into jig using right hand
then release the lock.**Note: Follow the connector orientation**3. Check the holes/terminal slot for **B-B wires**.**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.

Connector Orientation Illustration

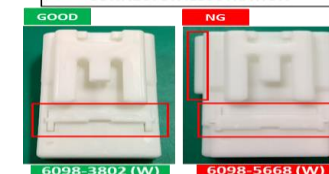


GOOD



NG

CONNECTOR ILLUSTRATION

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

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
03/11/24	1	Changed purpose from Pre-launch to Masspro. Improve Work procedure/Illustration on pages 1 to 9.	M. Ariola	C. Villanueva	A. Arañes	n/a	M. Ariola	C. Villanueva	A. Arañes	n/a
12/01/23	0	Initial Issue.	M. Ariola	C. Villanueva	A. Arañes	n/a	M. Ariola	C. Villanueva	A. Arañes	n/a

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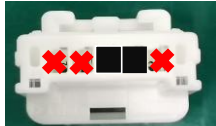


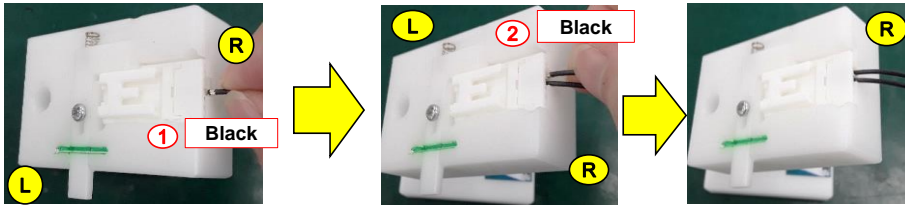

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PARTS:	1. Black corrugated tube $\phi 5$ L=605 \pm 3mm (no slit) 2. AVSSf 0.3 Black Wires L=768 \pm 3mm			JIG:	1. Insertion jig
NO.	PROCESS NAME	 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Connector setting to insertion jig 6098-3802 (W)	<div></div> <div>1. Hold the wires using left hand, Get the Black corrugated tube $\phi 5$ L=605\pm3mm (no slit) using right hand then insert the B-B wires using left hand.</div>		n/a	1. No wrong use of parts 2. No deformed terminals.
3	P1 Wire insertion to connector 6098-3802 (W)	<div><div><div>VISUAL REFERENCE</div></div><div><div>CONNECTOR ORIENTATION</div></div><div><div>WIRE TERMINAL ORIENTATION</div></div><div></div><div>1. Get the first Black wire and insert to Slot 1 of connector using right hand. Note : Insertion should be left to right.</div><div>2. Get the second Black wire and insert to Slot 2 of connector using right hand.</div><div><div>3. After insertion, push the lock using left thumb, hold the wires and gently pull out the connector from jig using right hand.</div></div></div> <div>n/a</div> <td>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 Important reminder's/Note: 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. Document references: 1. Refer to WI-PRO-CNC-017 for Wire Strip lenght tolerance. Refer to GL PRO-ASY-029 for pull-push-pull-push procedure</td>		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 Important reminder's/Note: 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. Document references: 1. Refer to WI-PRO-CNC-017 for Wire Strip lenght tolerance. Refer to GL PRO-ASY-029 for pull-push-pull-push procedure	

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☐ PRE-LAUNCH

☒ MASSPRO

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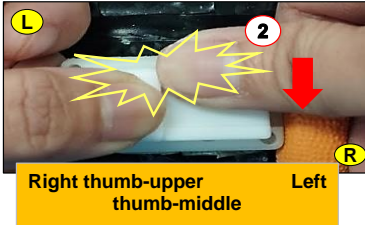



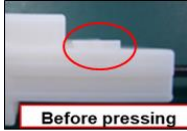



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PARTS:	1. Assy Parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1 Connector lock	<div><div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div><div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div><div><div><p>Right thumb-Lower Left thumb-middle</p></div><div><p>Right thumb-upper thumb-middle Left</p></div><div><p>Right thumb-middle Left thumb-middle</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>1. Use the provided jig per model 2. No unlocked/half-locked connector</div> <div>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR LOCK</div> <div>Document references: 1. Refer to GL-PRO-ASY-017 for the verification of connector lock.</div> <div><div><p>Before pressing</p></div><div><p>After pressing</p></div><div><div><p>GOOD Full Lock</p></div><div><p>NG Half Lock</p></div></div></div>

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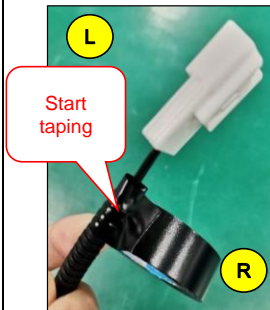
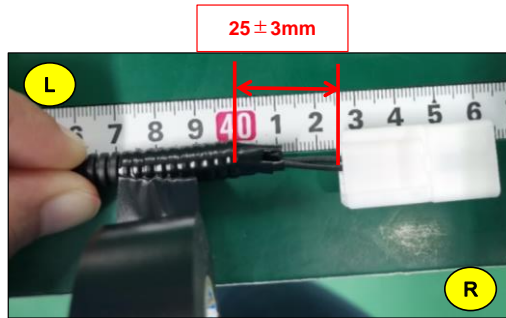
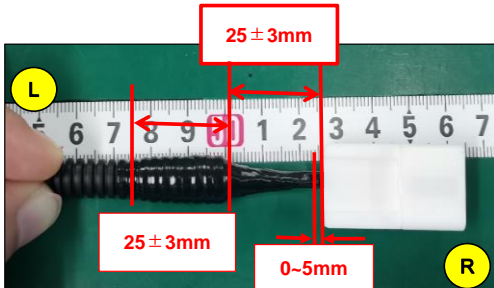

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1 Taping 1 Corrugated tube to wire near Connector	<div><p>1. Hold the COT using left hand, get Black tape using right hand then start taping process using both hands.</p></div> <div><p>2. Hold the corrugated tube using left hand and measure from end of COT up to connector 25±3mm</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>		MEASURING TAPE 	Important reminders/Note/s: 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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Car Model:

TOYOTA-RAV4

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PROTOTYPE



PRE-LAUNCH



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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) $\varnothing 9$ L=120 \pm 3mm 3. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1 Taping 2 Corrugated tube to wire near terminal	<p>1. Hold the assy parts using left hand. Get the Black tape using right hand then start taping process using both hands.</p> <p>2. Measure from end of COT up to terminal pointed tip 131\pm3mm then continue the taping process using both hands</p> <p>3. After taping, check the measurement and taping condition.</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>Important reminders/Notes/:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p>
7	Wire insertion to Black VM tube (Sunprene) $\varnothing 9$ L=120 \pm 3mm	<p>1. Get the the Black VM tube (Sunprene) $\varnothing 9$ L=120\pm3mm using right hand then insert the B-B wires using left hand.</p>		n/a	<p>1. No wrong use of parts 2. No deformed terminals.</p>

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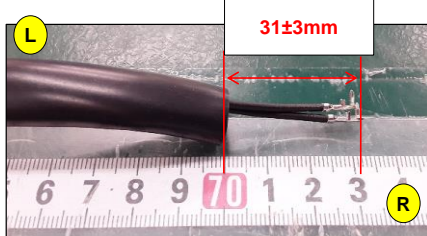

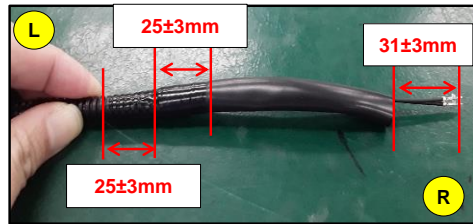

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PARTS:		1. Assy parts 3. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1 Taping 3 COT to VM tube (Sunprene)	<div><div></div><div><p>1. Hold the assy parts using left hand. Measure from VM tube (Sunprene) tube to terminal pointed tip 31±3mm.</p></div><div><div></div><div><p>2. Hold the assy parts using left hand. Get the Black tape and start taping using right hand.</p></div><div><div></div><div><p>3. After taping, check the measurement and taping condition.</p></div></div></div><div><div>MEASURING TAPE</div></div></div>		<p>Important reminders/Notes/:</p> <p>1. 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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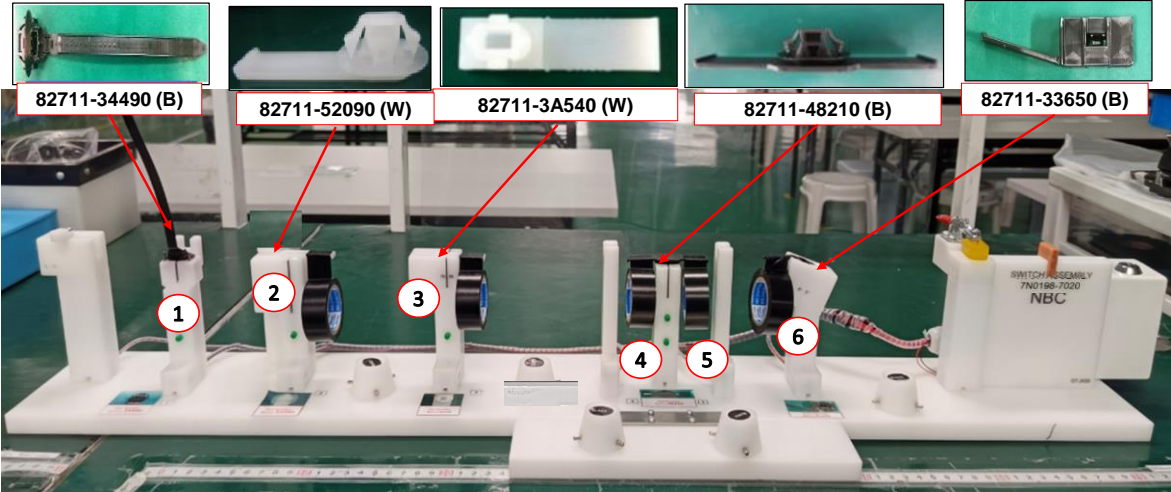
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PARTS:		1. Clamp 82711-52090 (W) 2. Clamp 82711-48210 (B) 3. Clamp 82711-34490 (B) 4. Clamp 82711-3A540 (W) 5. Clamp 82711-33650 (B) 6. Black tape [5 pcs.]		JIG:	1. Temporary Clamp assembly jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1 Clamp Setting	<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>1. Get 1pc. of clamp 82711-34490 (B) using right hand and set to clamp location 1 using both hands.</div><div>2. Get 1pc. of clamp 82711-52090 (W) using right hand and set to clamp location 2 using both hands.</div><div>3. Get 1pc. of clamp 82711-3A540 (W) using right hand and set to clamp location 3 using both hands.</div><div>4. Get 1pc. of clamp 82711-48210 (B) using right hand and set to clamp location 4 and 5 using both hands.</div><div>5. Get 1pc. of clamp 82711-33650 (B) using right hand and set to clamp location 6 using both hands.</div><div>6. Initially attach Black tape to clamp location 2, 3, 4, 5 and 6 using both hands.</div></div>			<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><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><div>GOOD</div><div>82711-34490 (B)</div></div><div><div>NG</div><div>82711-16830 (B)</div></div></div></div></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	
10	P1	<div>Clamp assembly</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. 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. Continue the process if the sequence light on location 2 was ON.</div> <div>BANDO GUN ALIGNMENT</div> <div>PERPENDICULARITY</div> <div>NG</div> <div>OK</div> <div>NG</div> <div>Fixed setting of band clamp cutter: 1~2</div> <div>PROPER CUTTING POSITION OF BANDO GUN</div> <div>GOOD</div> <div>IMPROPER CUTTING POSITION OF BANDO GUN</div> <div>NG</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>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> <div>0 ~ 2mm</div> <div>BANDO GUN ILLUSTRATION</div> <div>GOOD</div> <div>NG</div> <div>FLAT NOSEPIECE</div> <div>EXTENDED NOSEPIECE</div>	

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NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	P1	Clamp assembly (Continuation)		<div><div><div></div><div></div><div></div><div></div><div></div></div><div></div><div><div><div>3. On clamp location 2, hold the tape then make 3 windings of tape then cut the tape using both hands. Continue the process if the sequence light on location 3 was ON.</div><div>4. On clamp location 3, hold the tape then make 3 windings of tape then cut the tape using both hands. Continue the process if the sequence light on location 4 was ON.</div><div>5. On clamp location 4, hold the tape then make 3 windings of tape then cut the tape using both hands. Continue the process if the sequence light on location 5 was ON.</div></div><div><div>6. On clamp location 5, hold the tape then make 3 windings of tape then cut the tape using both hands. Continue the process if the sequence light on location 6 was ON.</div><div>7. On clamp location 6, hold the tape then make 3 windings of tape then cut the tape using both hands. Continue the process if the sequence light on location 6 was ON.</div><div>8. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</div></div></div></div> <div><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. 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</div><div><div>BANDO GUN ILLUSTRATION</div><div><div>GOOD</div><div>NG</div></div><div><div>FLAT NOSEPIECE</div><div>EXTENDED NOSEPIECE</div></div></div></div>	

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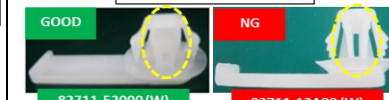
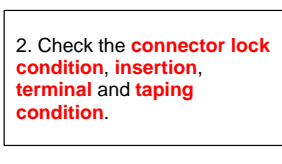








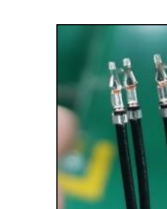
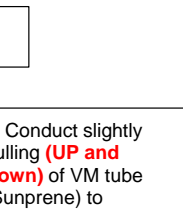
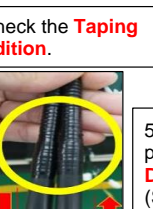

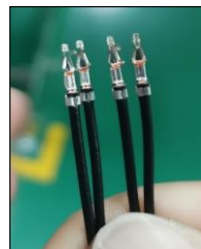
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PARTS:		1. Assy parts 2. Engineering sample		JIG:	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1	Visual/By Two's Inspection	<div><p>ACTUAL PRODUCT</p></div> <div><p>ENGINEERING SAMPLE</p></div> <div><p>1. No skip checking during inspection.</p><p>ENGINEERING SAMPLE</p><p>Important reminders/Note/s:</p><p>1. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).</p><p>CLAMP ILLUSTRATION</p><p>GOOD 82711-52090 (W) NG 82711-12A80 (W)</p><p>CONNECTOR ILLUSTRATION</p><p>GOOD 6098-3802 (W) NG 6098-5668 (W)</p></div> <div><p>2. Check the connector lock condition, insertion, terminal and taping condition.</p></div> <div><p>3. Check the Taping condition.</p></div> <div><p>4. Check the presence of clamp attachment, taping condition.</p></div> <div><p>5. Conduct slightly pulling (UP and Down) of VM tube (Sunprene) to confirm the presence of tape.</p></div> <div><p>6. Check the terminal. Must no deformed terminal.</p></div>		

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

March 11, 2024

Validity Date:

n/a

Model code/Part number:

310D

/

7N0198-7020

Customer:

TRJ

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-769

Purpose:



PROTOTYPE



PRE-LAUNCH



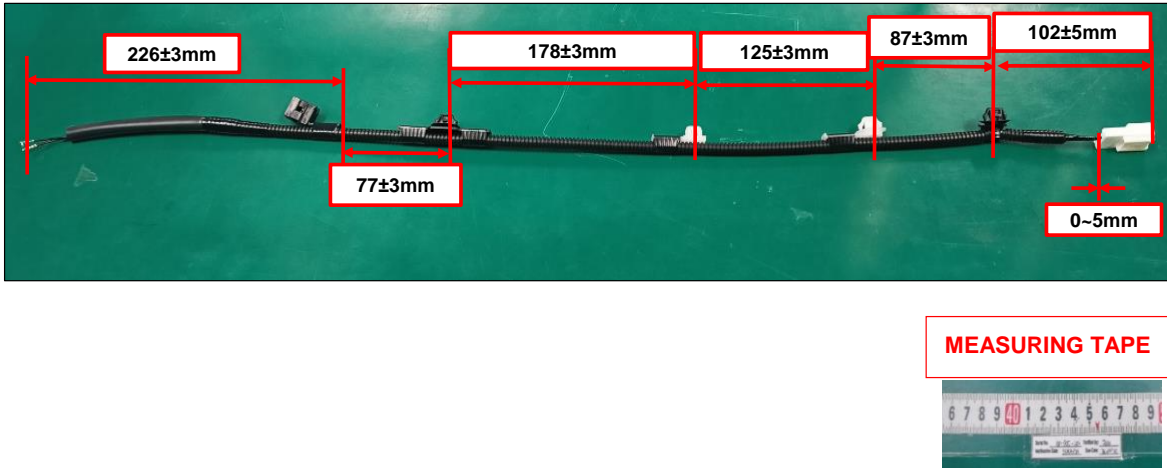
MASSPRO

Revision No.:

1

Page No.:

11 of 12

PARTS:		n/a		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
12	P1	Measurement			1. No wrong dimension <i>Important reminders/Note/s:</i> 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.

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☒ MASSPRO

Revision No.:

1

Page No.:

12 of 12

PARTS:

n/a

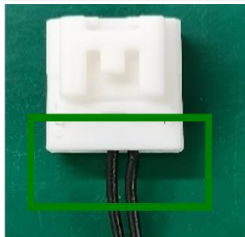
JIG:

n/a

QUALITY CHECKPOINTS

n/a

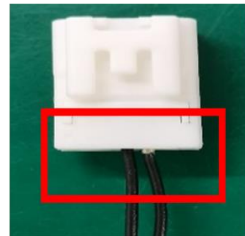
7N0198-7020



GOOD



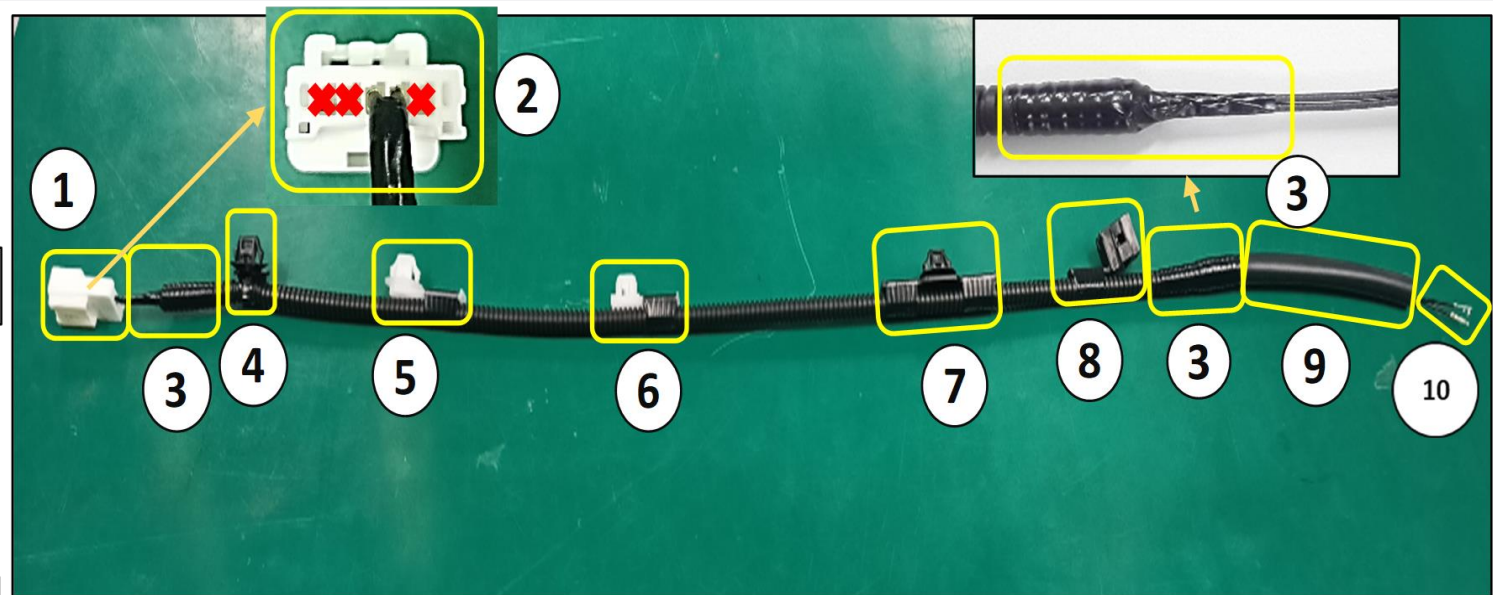
GOOD



NO GOOD



NO GOOD



1 No Unlock/Halflock Connector (on 1 Connector)

2 No Wrong Insert

3 No Missing Tape

9 No Missing VM tube (Sunprene)

10 No Deformed Terminal

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