



## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

April 23, 2025

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

559D / 7N0238-7020C

Customer: TRJ

Car Model: TOYOTA HI-ACE

Document No.:

WI-ENG-PDE-1253A

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

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## PARTS:

1. Assy parts; Connector 7286-4097 (W); Connector 7283-1027 (W; Black SV tube (vinyl) ø5 L= 248±3mm; Avssf 0.3 OR L=802±3; Avssf 0.3 Y L=802±3; Avssf 0.3 B-B L=595±3.

JIG:

1. Insertion jig with switch cover  
2. Insertion jig  
3. Pushing Jig 4. Terminal cover jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

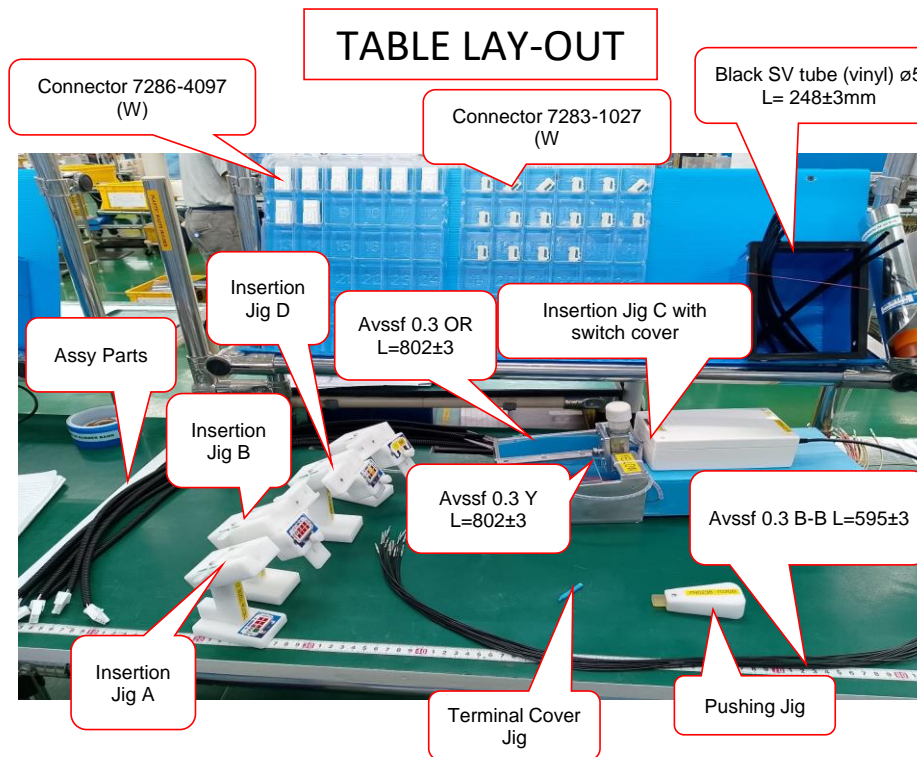
TOOLS/PPE

QUALITY POINTERS

1

P1

Table Lay-out

**Safety Instruction**

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

**Housekeeping**

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

**Alert level**

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

1. No missing parts/tools  
2. No excess parts/tools

## Revision History

Prepared by

Checked by

Reviewed by

Approved by

04/23/25 0 Initial issue.

A.Hernandez J.Loterte C.Villanueva A.Arañes

A.Hernandez

J.Loterte

C.Villanueva

A.Arañes

Eff. Date Rev. No

Details of Change

Revised Checked Reviewed Approved

Est. Date:

April 23, 2025

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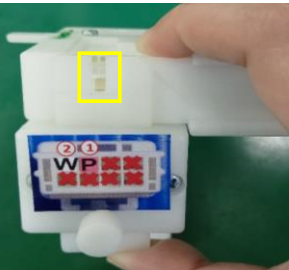

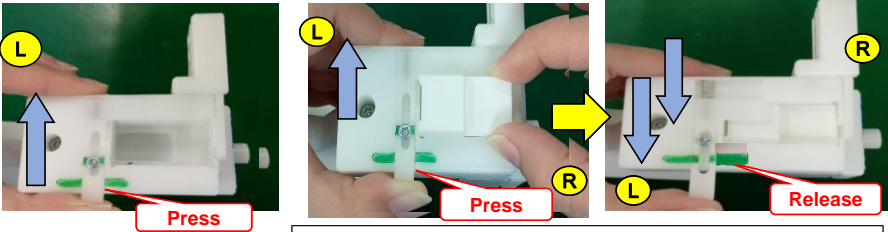

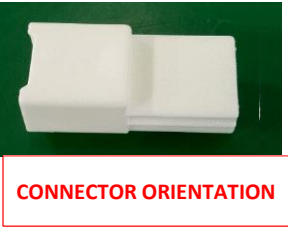
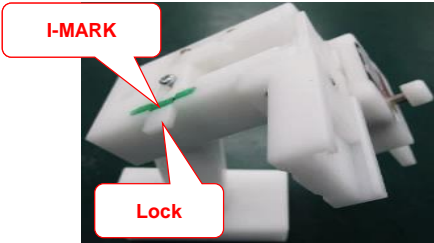
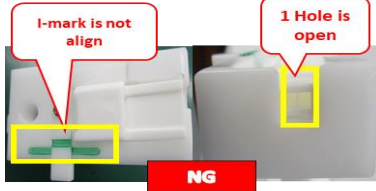
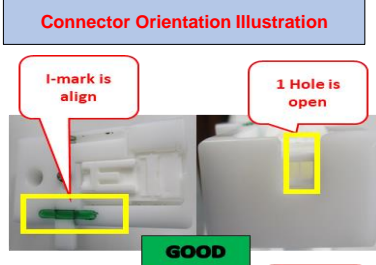
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PARTS:	1. Connector 7286-4097 (W)			JIG:	1. Insertion Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1 Connector setting to insertion jig 7286-4097 (W)	<div></div> <div>1. Press the lock of insertion jig using left hand.</div> <div>2. Get the connector using then Insert the connector <b>7286-4097 (W)</b> using right hand into jig using and release the lock. <i>Note: Follow the connector orientation.</i></div> <div>3. Push the guide using left hand. The slot for <b>P wire</b> will be opened.</div>		n/a	<div>1. Use the provided jig per model</div> <div>2. No wrong orientation of the connector.</div> <div>3. No wrong use of connector</div> <div>4. No damaged connector.</div> <div></div>

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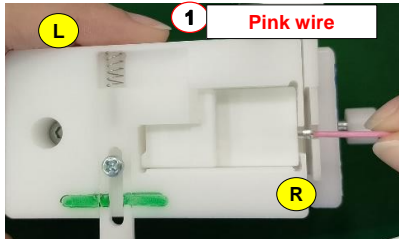
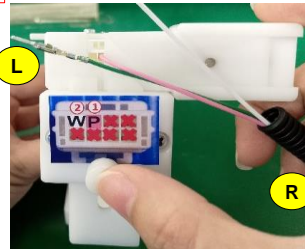
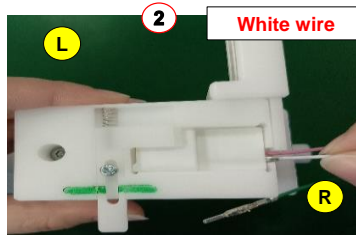
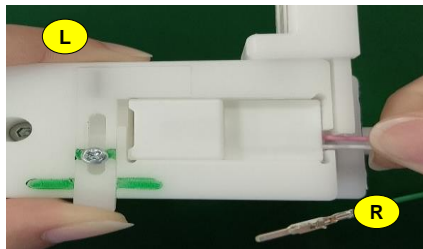
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1  Wire insertion to connector 7286-4097 (W)	<div><div><p>Visual reference</p></div><div><p>Terminal facing</p></div><div><p>1. Hold the insertion jig using left hand. Get the <b>Pink wire</b> and insert to connector using right hand. Conduct <b>2x push-pull</b> after wire insertion.</p></div><div><p>2. Press the button using right thumb. Slot for <b>White wire</b> will be open.</p></div><div><p>3. Get the <b>White wire</b> and insert to connector using right hand. Conduct <b>2x push-pull</b> after wire insertion.</p></div><div><p>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.</p></div></div> <td>n/a</td> <td><p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</p><p><b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal.</b> <b>2. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b></p><p><b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b> <b>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b></p></td>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</p> <p><b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal.</b> <b>2. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b></p> <p><b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b> <b>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b></p>

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PARTS:		1. Assy Parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 Connector setting to insertion jig 7286-4097 (W)	<div><div></div><div></div><div></div><div></div><div></div></div> <div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the connector 7286-4097 (W) into jig using right hand and release the lock.</p><p>3. Check the holes/terminal slot for G wire.</p></div>		n/a	<div><div></div><div></div><p>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p></div>

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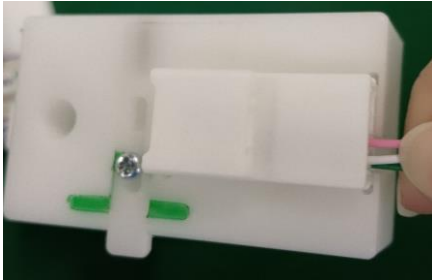
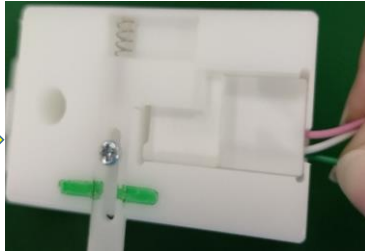
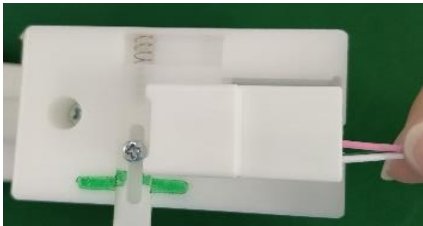
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<b>PARTS:</b>	1. Assy Parts			JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
5	P1  Wire insertion to connector 7286-4097 (W)	<div><p>Visual reference</p><p>Terminal facing</p><p>1. Hold the insertion jig using left hand. Get the <b>Pink wire</b> and insert to connector using right hand. Conduct <b>2x push-pull</b> after wire insertion.</p><p>3. After insertion, push the lock using left thumb and then hold the wires and gently pull-out the connector from jig using right hand.</p></div>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</p> <p><b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal.</b> <b>2. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b></p> <p><b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b> <b>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b></p>

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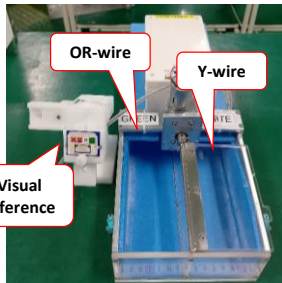
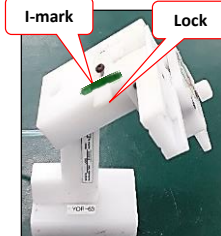
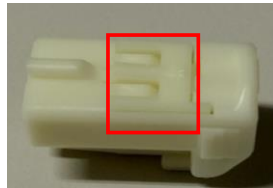
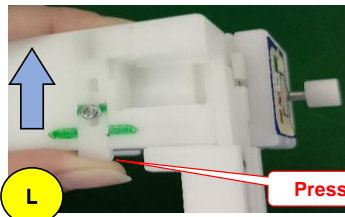
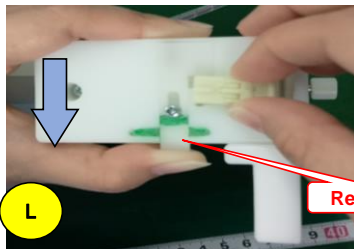
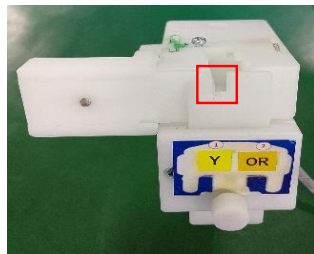
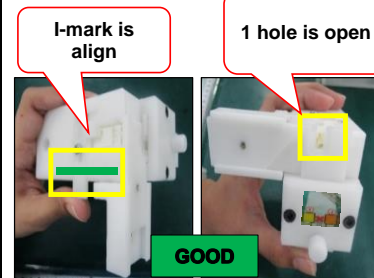
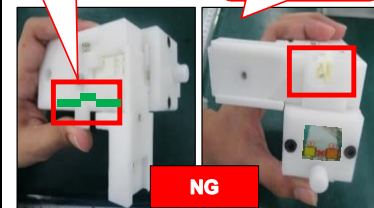
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PARTS:		1. Connector 7283-1027 (W)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1  Connector setting to insertion jig Connector 7283-1027 (W)	<div><div>INSERTION JIG ILLUSTRATION</div><div><div>Visual reference</div><div>OR-wire</div><div>Y-wire</div></div><div><div>I-mark</div><div>Lock</div><div>INSERTION JIG ORIENTATION</div></div><div><div>CONNECTOR ORIENTATION</div></div><div><div>Press</div><div>L</div></div><div><div>Release</div><div>L</div></div><div></div><div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector <b>7283-1027 (W)</b> into jig using right hand and release the lock. <i>Note: Follow the connector orientation.</i></div><div>3. Push the guide using left hand. The slot for <b>Y wire</b> will be opened.</div></div></div>		n/a	<div>Connector Orientation Illustration</div> <div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div></div> <div><div>I-mark is not align</div><div>All holes were open</div><div>NG</div></div> <div><div>1. Use the provided jig per model</div><div>2. No wrong orientation of connector</div><div>3. No wrong use of connector</div><div>4. No damaged connector</div></div>

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Purpose:



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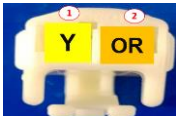

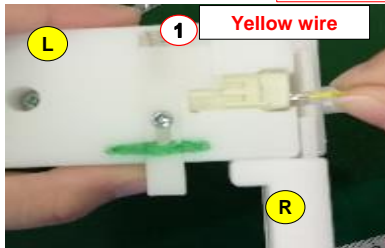
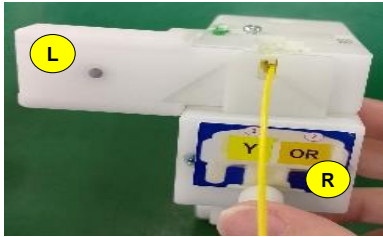
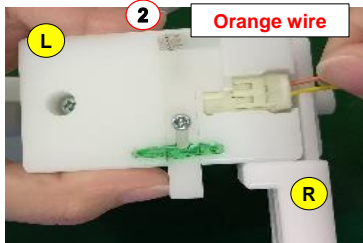
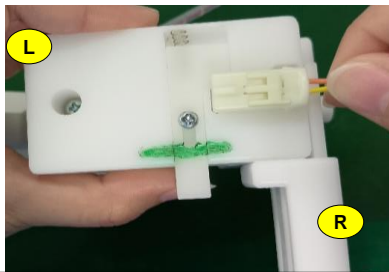
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PARTS:		1. Connector 7283-1027 (W) 2. Wire avssf 0.3 Y-OR L=582mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1  Wire insertion to Connector 7283-1027 (W)	<div><div><p>Visual reference</p></div><div><p>Terminal facing</p></div></div> <div><div><p>1. Hold the insertion jig using left hand. Get the <b>Pink wire</b> and insert to connector using right hand. Conduct <b>2x push-pull</b> after wire insertion.</p></div><div><p>2. Press the button using right thumb. Slot for <b>White wire</b> will be open.</p></div></div> <div><div><p>3. Get the <b>Orange wire</b> and insert to connector using right hand. Conduct <b>2x push-pull</b> after wire insertion.</p></div><div><p>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.</p></div></div>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</p> <p><b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal.</b> <b>2. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b></p> <p><b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b> <b>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b></p>

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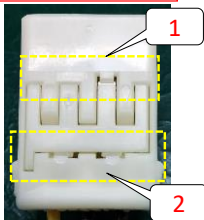
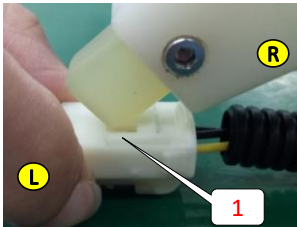
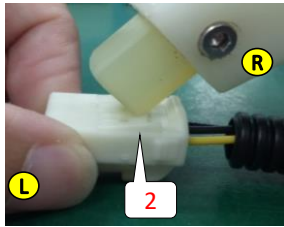
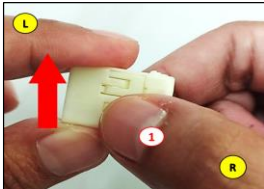
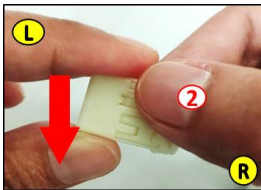
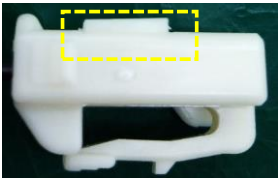
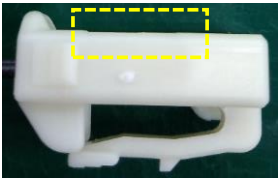
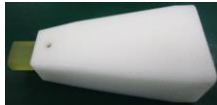


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PARTS:		1. Assy Parts		JIG:	1. Pushing Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1	Connector lock	<div><div>LOCKING SEQUENCE</div><div></div><div></div><div></div><div><p>1. Hold the connector using left hand and place on the table. Get the pushing jig using right hand and start the sequential locking based on above illustration. Push the lower part of the connector lock first and then push the upper part.</p></div><div></div><div></div><div><p>2. Ensure that connector is in locked condition by touching the connector lock based on the sequence illustrated.</p></div><div></div><div></div><div><p>BEFORE PRESSING</p></div><div><p>AFTER PRESSING</p></div></div>	<div>PUSHING JIG</div> <div></div>	<div>1. No unlocked/half-locked connector</div> <div>2. No damage connector</div> <div>3. Use provided jig tool per model to avoid damaged lock.</div> <div><b>Important reminders/Note/s:</b></div> <div>1. Manual locking may cause damaged connector lock.</div> <div>2. Position of pushing jig during locking must be slant.</div> <div>LOCKED CONDITION</div> <div></div> <div></div> <div>GOOD</div> <div>NG</div>

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PROTOTYPE



PRE-LAUNCH




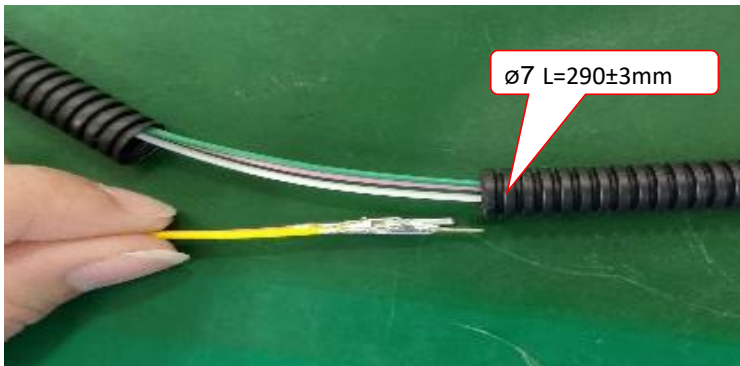
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<b>PARTS:</b>		1. Assy Parts 2. Black SV tube (vinyl) ø5 L= 248±3mm		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
9	Wire Insertion to Black SV tube (vinyl) ø5 L= 248±3mm	 <div>1. Get the <b>Y-OR wire</b> using right hand then insert the <b>Black SV tube (vinyl) ø5 L=248±3mm</b> using right hand.</div>		n/a	1. No wrong use of parts 2. No deformed terminal
10	P1 Wire Insertion to Assy parts	 <div>ø7 L=290±3mm</div> <div>1. Hold the <b>Black Corrugated tube ø7 L=290±3mm</b> (no slit) using left hand then insert the <b>Y-OR wire</b> using right hand.</div>		n/a	1. No wrong use of parts 2. No deformed terminal 3. No wrong use of insertion

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# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

April 23, 2025

Process Name/Title:

Model code/Part number:

559D / 7N0238-7020C

Customer: TRJ

Car Model: TOYOTA HI-ACE

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1253A

Purpose:

☐ PROTOTYPE

☒ PRE-LAUNCH

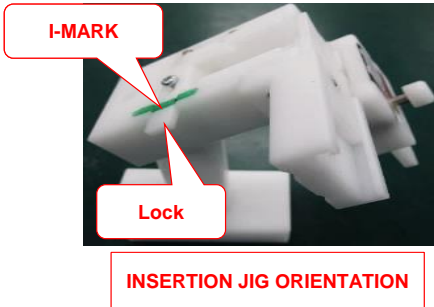
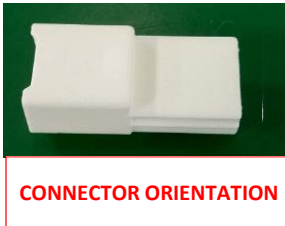
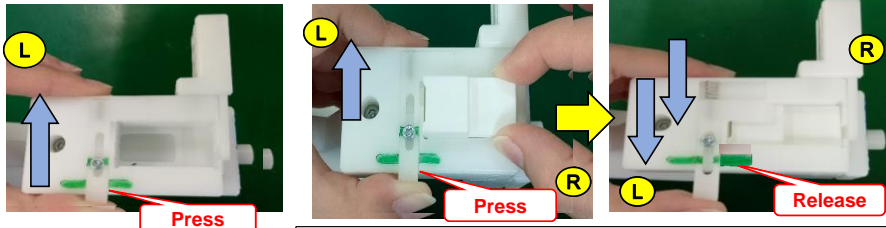
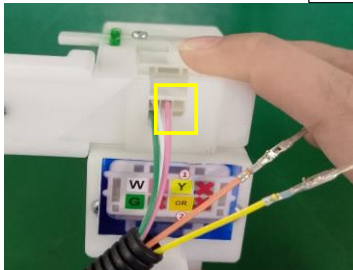
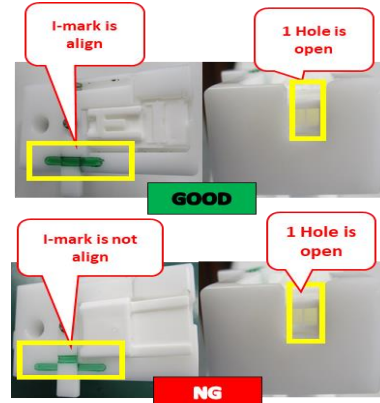
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PARTS:		1. Connector 7286-4097 (W)		JIG:	1. Insertion Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1	<div><div><div></div><div></div><div></div><div><p>1. Press the lock of insertion jig using left hand.</p></div><div><p>2. Get the connector using then Insert the connector <b>7286-4097 (W)</b> using right hand into jig using and release the lock. <i>Note: Follow the connector orientation.</i></p></div><div></div><div><p>3. Push the guide using left hand. The slot for <b>Y wire</b> will be opened.</p></div></div></div>		n/a	<div><p>1. Use the provided jig per model</p><p>2. No wrong orientation of the connector.</p><p>3. No wrong use of connector</p><p>4. No damaged connector.</p></div> <div><div>Connector Orientation Illustration</div><div><div></div></div></div>

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

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559D / 7N0238-7020C

Customer: TRJ

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PROTOTYPE



PRE-LAUNCH




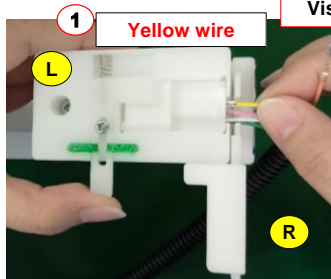
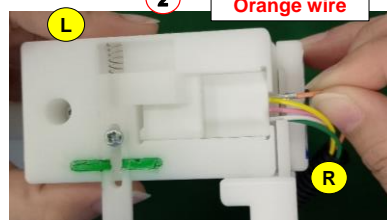

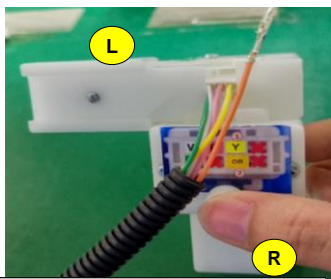
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PARTS:		1. Assy parts		JIG:	1. Insertion Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
12	P1	<div><div><p>Visual reference</p></div><div><p>1 Yellow wire</p></div><div><p>2 Orange wire</p></div></div> <div><p>1. Hold the insertion jig using left hand. Get the <b>Yellow wire</b> and insert to connector using right hand. Conduct <b>2x push-pull</b> after wire insertion.</p><p>2. Press the button using right thumb. Slot for <b>OR wire</b> will be open.</p><p>3. Get the <b>Orange wire</b> and insert to connector using right hand. Conduct <b>2x push-pull</b> after wire insertion.</p><p>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.</p></div> <div><p>Terminal facing</p><p>L R</p></div> <div>n/a</div> <td><p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</p><p><b>Important reminders/Note/s:</b></p><p>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.</p><p><b>Document references:</b></p><p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p></td>		<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</p> <p><b>Important reminders/Note/s:</b></p> <p>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.</p> <p><b>Document references:</b></p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p>	

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Process Name/Title:

Model code/Part number:

**559D / 7N0238-7020C**Customer: **TRJ**Car Model: **TOYOTA HI-ACE**

Purpose:



PROTOTYPE



PRE-LAUNCH



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Effectivity Date:

**April 23, 2025**

Validity Date:

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PARTS:		1. Wire Avssf 0.3 B-B L=595±3 2. Assy Parts		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
13	P1	Wire Insertion to Assy parts	<div><div></div><div><div>1. Get the terminal cover jig using right hand then insert the 2 Black wires.</div></div></div>	<div><div>TERMINAL COVER JIG</div><div></div></div>	1. No wrong use of parts 2. No deformed terminal 3. No wrong use of insertion
			<div><div><div><div></div><div></div></div><div>2. Hold the <b>Black Corrugated tube</b> <math>\phi 7</math> L=290±3mm using left hand then insert the <b>B-B wires</b> using right hand and continuation to <b>Black Corrugated tube</b> <math>\phi 7</math> L=110±3mm (no slit).</div></div><div><div><div></div><div><div>3. After insertion, remove the terminal cover jig using right hand.</div></div></div></div></div>		

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# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

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559D / 7N0238-7020C

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### PARTS:

1. Assy parts

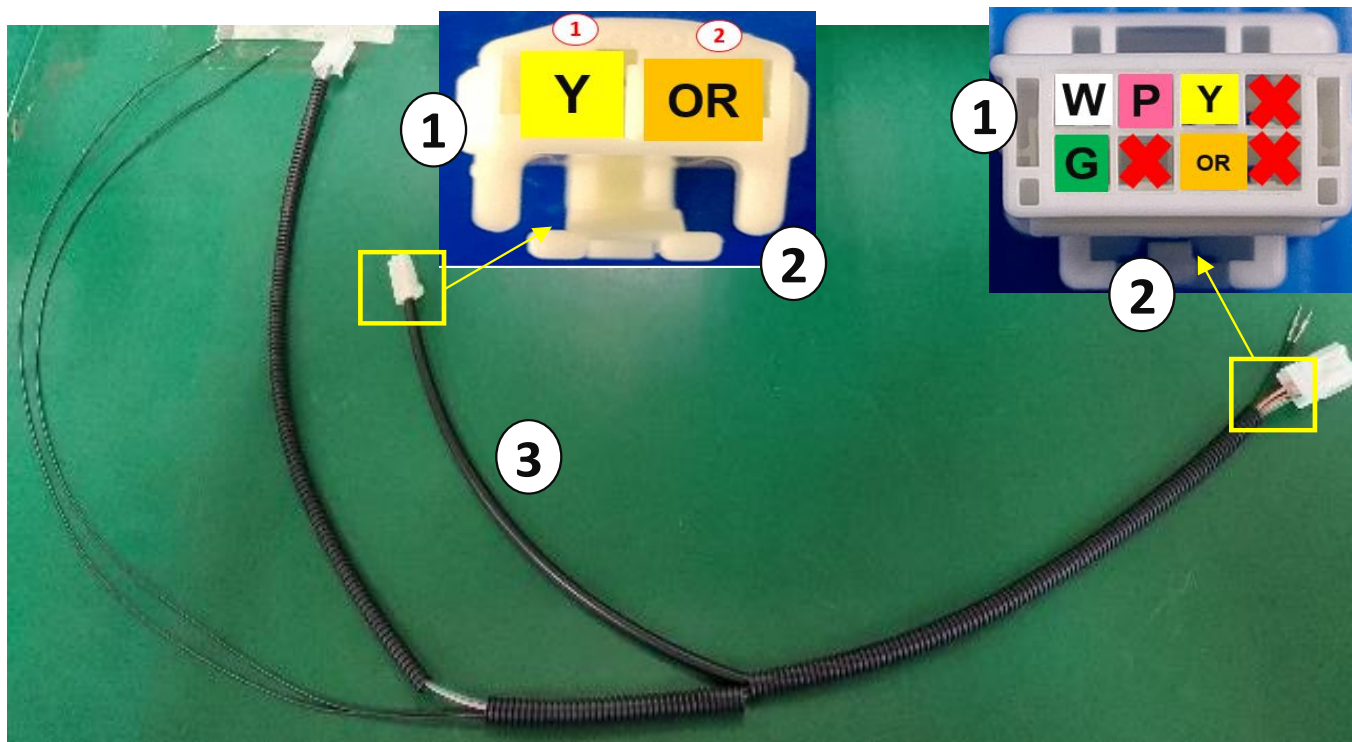
JIG:

n/a

### VISUAL INSPECTION/ QUALITY CHECKPOINTS

## TAPING - P1

## 7N0238-7020C



- 1 No Unlocked/  
Half-locked connector
- 2 No Wrong Insert
- 3 No Missing SV tube  
(vinyl)
- 4 No Deformed terminal
- 5 No Terminal backing  
out

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