


NBC		WORK INSTRUCTION				Effectivity Date:		October 22, 2024		
Process Name/Title:		TAPING ASSEMBLY PROCESS				Validity Date:		n/a		
Model code/Part number:		890B / 7L0098-7020		Customer: TRQSS		Car Model: TOYOTA- C-SUV		Document No.: WI-ENG-PDE-126		
Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.: 5		
								Page No.: 1 of 9		
PARTS:		1. Connector 6098-3802 (W); AVSSf 0.3 B L=627±3mm; Black corrugated tube (no slit) ø5 L=535±5mm; Black tape				JIG:		1. Insertion jig 2. Locking jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS		
1	P1	<p style="text-align: center;">Table Lay-out</p>				<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>		<p>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>		
Revision History										
						Prepared by	Reviewed by	Approved by	Noted by	
10/22/24	5	Removal of cover jig and change process sequence due to Process improvement. Inclusion of car model "TOYOTA-C-SUV" and Measurement.				D.Castillo	C.Villanueva	A. Arañes	n/a	
04/28/23	4	Inclusion of quality checkpoints				J. Loterte	C.Villanueva	A. Arañes	n/a	
10/20/22	3	Additional table layout. Improve quality pointers: Reminders/notes and references in process no.1,2,3,4,6 and 7 due to document improvement. Change of tolerance from end of tape up to terminal pointed tip 35+3mm/-3mm to 35+3mm/-1mm as countermeasure due to encountered minimum dimension. Work procedure/illustration in process no.4 - connector lock.				M. Catapang	J. Loterte	C.Villanueva	A. Arañes	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	
						Est. Date:	August 24, 2020			

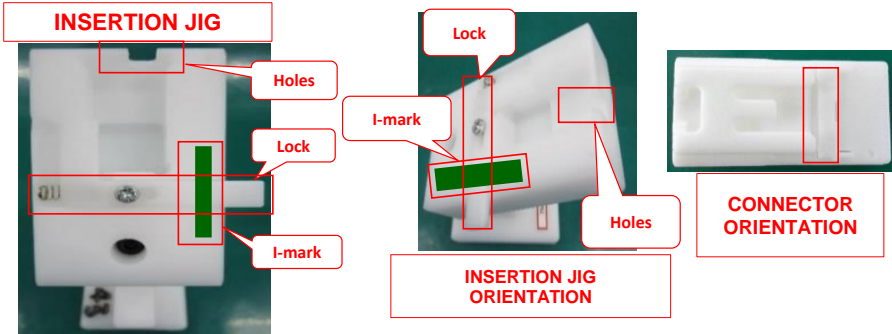
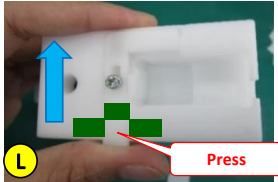
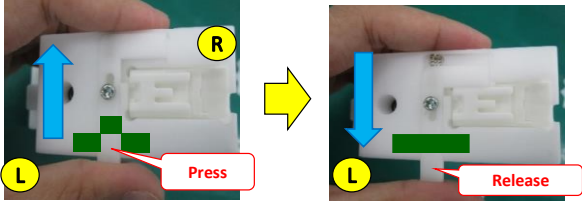


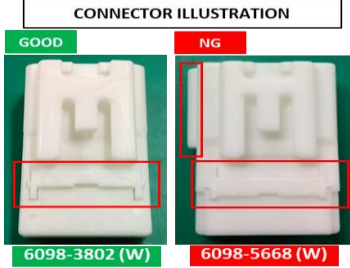
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PARTS:		1. Connector 6098-3802 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
2	P1 Connector setting to insertion jig 6098-3802 (W)	   	n/a	  1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector	

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PARTS:

1. Black Corrugated tube $\phi 5$ L=535 \pm 5mm (no slit)
2. AVSSf 0.3 B L=627 \pm 3mm [2pcs]

JIG:

n/a

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

3

P1

Wire Insertion to
Black Corrugated tube
 $\phi 5$ L=535 \pm 5mm
(no slit)



1. Get black corrugated tube $\phi 5$ L=535 \pm 5mm (no slit) using left hand and insert Black wires L=627 \pm 3mm using right hand.

n/a

1. No wrong use of parts
2. No deformed terminal

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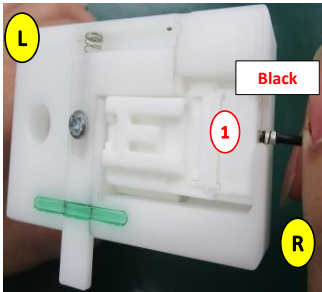
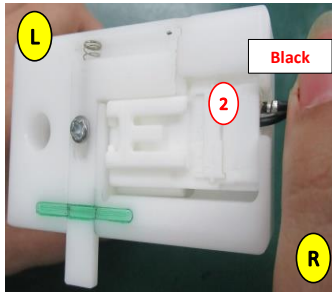
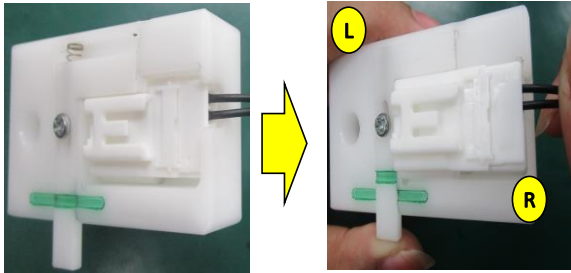
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PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 Wire insertion to connector 6098-3802 (W)	<div><div>Wire facing</div></div> <div><div>1. Get the 1st Black wire then insert to terminal slot 1 of connector using right hand.</div></div> <div><div>2. Get the 2nd Black wire then insert to terminal slot 2 of connector using right hand.</div></div> <div><div>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.</div></div>		n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>Important reminders/Note/s: 1. Insertion of wires must be from left to right. 2. Please hold the wire near terminal. 3. 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 GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div>

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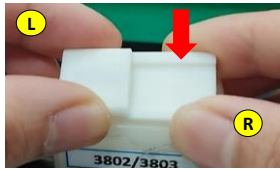
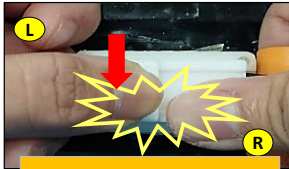


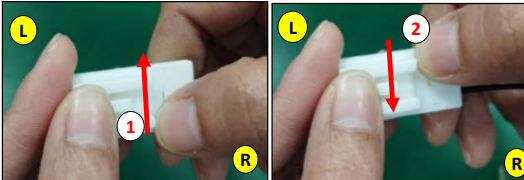





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PARTS:	1. Assy parts			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div> <div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div> <div><p>Right thumb-Lower Left thumb-middle</p><p>3. Press the lower parts of connector using right hand while left hand holding the middle.</p></div> <div><p>Right thumb-upper Left thumb-middle</p><p>4. Press the upper part of connector using right hand while left hand holding the middle.</p></div> <div><p>Right thumb-middle Left thumb-middle</p><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><p>LOCKING JIG</p></div>	<div><p>Before pressing</p></div> <div><p>After pressing</p></div> <div><div><p>GOOD</p><p>Full Lock</p></div><div><p>NG</p><p>Half Lock</p></div></div> <p>Important reminders/Note/s:</p> <p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <p>1. Use the provided jig tool to lock the connector. 2. No unlock/half-locked connector</p>

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	<div>5</div> <div>P1</div> <div>Taping 1 COT to wire near connector</div>	<div><div><div>Start of taping</div><div><div>L</div><div>R</div></div></div><div>1. Hold the corrugated tube using left hand, get Black tape and start pre-taping using right hand.</div></div> <div><div><div>25 ± 3mm</div><div><div>L</div><div>R</div></div></div><div>2. Measure from end of corrugated tube up to the edge of connector 25±3mm then continue the taping process using both hands.</div></div> <div><div><div>25 ± 3mm</div><div>20±3mm</div><div>0~5mm</div><div><div>L</div><div>R</div></div></div><div>3. After taping, check the measurement and taping condition.</div></div>		<div>Measuring tape</div> <div></div>	<div>1. No peel-off tape 2. No flip-out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension 6. No missing tape</div> <div>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</div>

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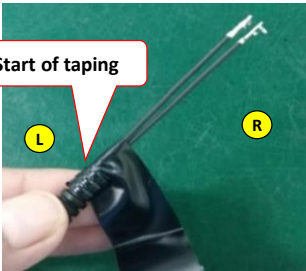
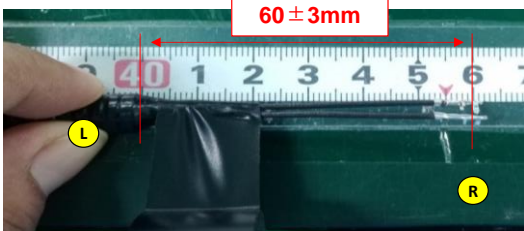
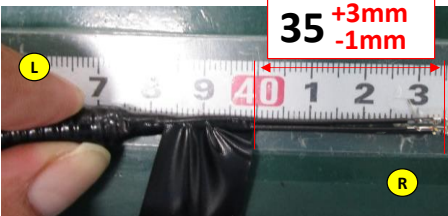
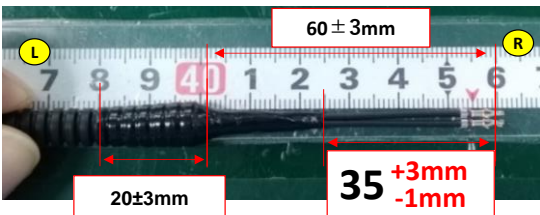

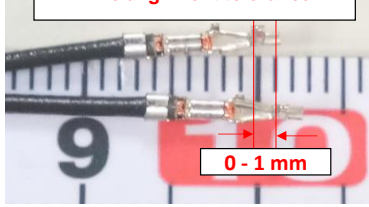
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PARTS:	1. Assy Part 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1 Taping 2 Corrugated tube to wire near terminal	<div><p>Start of taping</p></div> <div><p>60 ± 3mm</p></div> <div><p>1. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.</p></div> <div><p>2. Measure from end of COT up to terminal pointed tip 60±3mm then continue the taping process using both hands.</p></div> <div><p>35 +3mm -1mm</p></div> <div><p>3. Confirm measurement of 35+3mm/-1mm from end of tape up to terminal pointed tip then continue the taping process using both hands.</p></div> <div><p>60 ± 3mm 20±3mm 35 +3mm -1mm</p></div> <div><p>4. After taping, check the measurement, taping condition and terminal appearance.</p></div>	<div><p>Measuring tape</p></div> 	<p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</p> <p>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 1. Refer to WI-ENG-PDE-588 for TAPE AND TUBE END STANDARD TOLERANCE 2. Refer to WI-PRO-ASY-001 for taping procedure.</p> <div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div>

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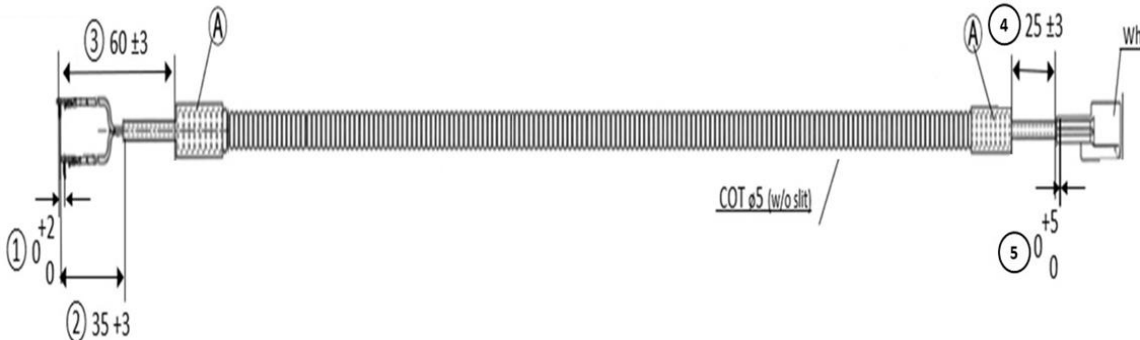
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PARTS:	1. Assy Part		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P1	Measurement	<div>MEASURING TAPE</div>   <p>NOTE: Ⓐ - Taping (B)</p>	<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>

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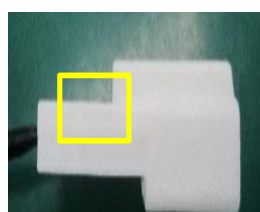
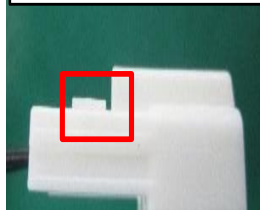
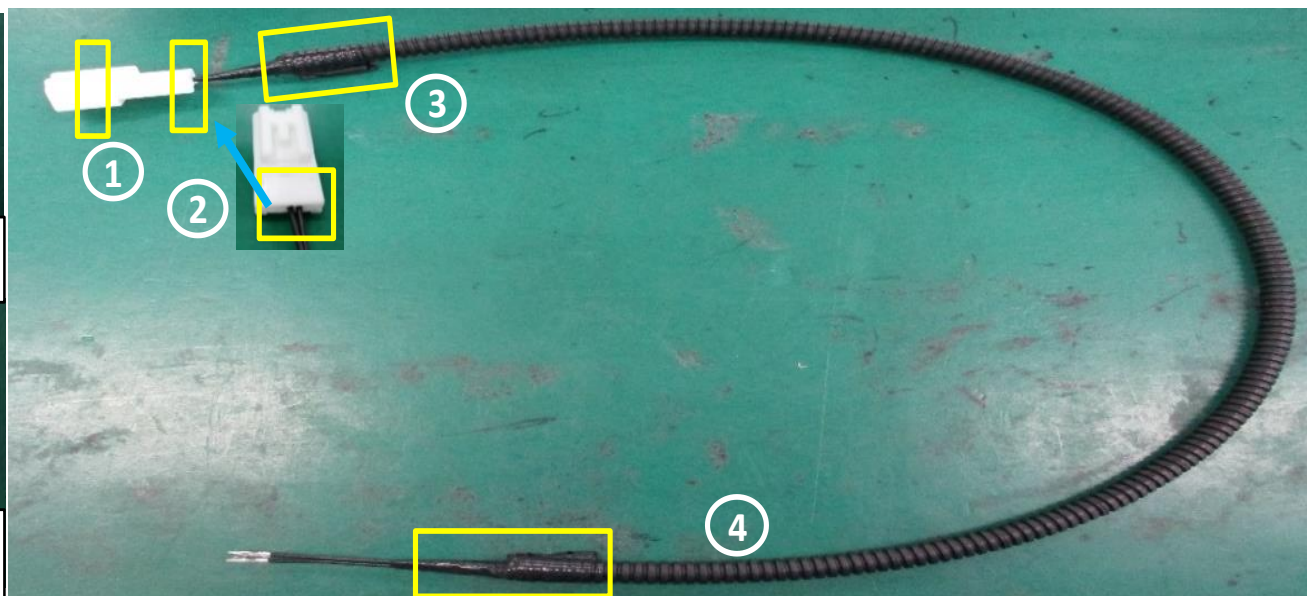
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSEPTION/ QUALITY CHECKPOINTS**P1****7L0098-7020****GOOD****NO GOOD****① No Unlocked/Half locked connector****② No Wrong Insert****③ ④ No Missing Tape****⑤ No Terminal Backing out****⑤****GOOD****NO GOOD**

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