

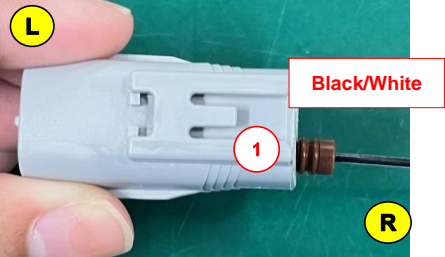




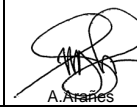
	WORK INSTRUCTION				Effectivity Date:		March 29, 2025	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 400D / 7L0167-7020D		Customer: TRQSS		Car Model: TOYOTA bZ4x (BEV)	
	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO		Document No.: WI-ENG-PDE-1243		Revision No.: 0		Page No.: 1 of 19	

PARTS:		1. Connector 6188-0066 (GR) 2. TVSSf 0.3 G and B/W wires L=571±3mm		JIG:		n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1	P1 Wire insertion to connector 6188-0066 (GR)	<div><p>1 2 Bw G</p><p>VISUAL REFERENCE</p></div> <div><p>TERMINAL FACING</p></div> <div><p>Black/White</p><p>1</p><p>L R</p><p>1. Get the connector using left hand and get the Black/White wire and insert to connector using right hand.</p></div> <div><p>Green</p><p>2</p><p>L R</p><p>2. Hold the connector using left hand. Get the Green wire and insert to connector using right hand.</p></div>		<div><p>Safety Instruction</p><p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p></div> <div><p>Housekeeping</p><p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p></div> <div><p>Alert level</p><p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p></div>	<p>Important reminders/Note/s:</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>Document references:</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> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p>		

Revision History				Prepared by		Checked by		Reviewed by		Approved by	
03/29/25	0	Initial issue.		A.Hernandez	J.Loterte	C.Villanueva	A.Arañes				
Eff. Date	Rev. No	Details of Change		Revised	Checked	Reviewed	Approved	Est. Date:	March 29, 2025		

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Process Name/Title:

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400D / 7L0167-7020D

Customer:

TRQSS

Car Model:

TOYOTA bZ4x (BEV)

Purpose:



PROTOTYPE



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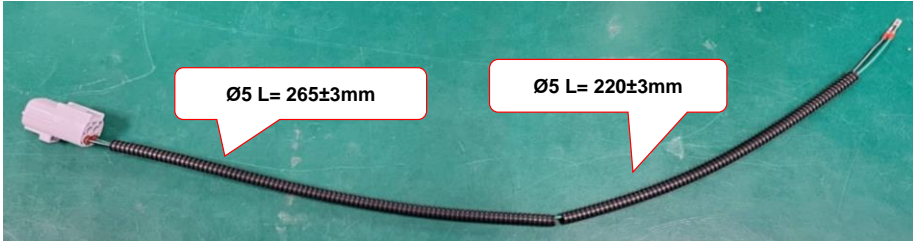
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PARTS:		1. Black corrugated tube $\phi 5$ L=265 \pm 3mm (No slit) 2. Black corrugated tube $\phi 5$ L=220 \pm 3mm (No slit)		3. Assy parts	JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	Wire insertion to Black corrugated tube $\phi 5$ L=265 \pm 3mm (No slit)	<div></div> <div>1.Get the Black corrugated tube $\phi 5$ L=265\pm3mm (No slit) using right hand and insert B/W wire and G wire by using left hand.</div>		n/a	1. No wrong use of parts 2. No deformed terminal
3		Wire insertion to Black corrugated tube $\phi 5$ L=220 \pm 3mm (No slit)	<div></div> <div>1.Get the Black Corrugated Tube $\phi 5$ L=220\pm3mm (No Slit) using left hand and insert B/W wire and G wire by using left hand.</div> <div></div> <div><div>$\phi 5$ L= 265\pm3mm</div><div>$\phi 5$ L= 220\pm3mm</div></div>		n/a	1. No wrong use of parts 2. No deformed terminal

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PARTS:

1. Assy parts
2. Connector 6189-1161 (B)

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

P1

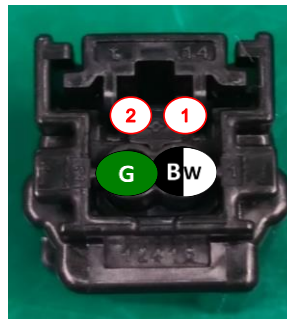
Wire insertion to connector 6189-1161 (B)



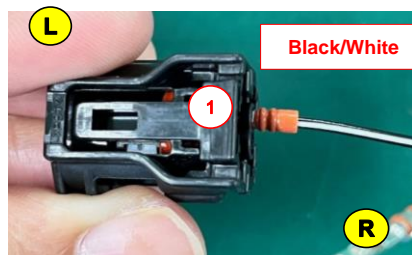
CONNECTOR ORIENTATION



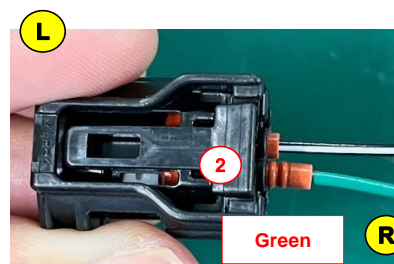
TERMINAL FACING



VISUAL REFERENCE



1. Get the connector using left hand and get the **Black/White wire** and insert to connector using right hand.



2. Hold the connector using left hand. Get the **Green wire** and insert to connector using right hand.

n/a

Important reminders/Note/s:

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.

Document references:

1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

1. No loose insertion
2. No wrong insertion
3. One by one insertion
4. No deformed terminal
5. No wrong wire facing

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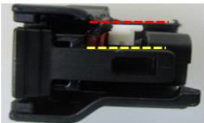





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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1	Connector lock	<div><p>LOCKING JIG 7M0594 A7045D 7M0610 A7047E 7M0521 A7057B A7043E A7059B</p></div> <div><p>1. Put the connector into locking jig using both hands and then press 2x. Check the connector if properly locked.</p></div> <div><p>Connector lock appearance</p><div><p>NG</p><p>Unlock Condition</p></div><div><p>NG</p><p>Half Lock Condition</p></div><div><p>GOOD</p><p>Full Lock Condition</p></div></div> <div><p>BEFORE PRESSING</p></div> <div><p>AFTER PRESSING</p></div>	<div><p>LOCKING JIG</p></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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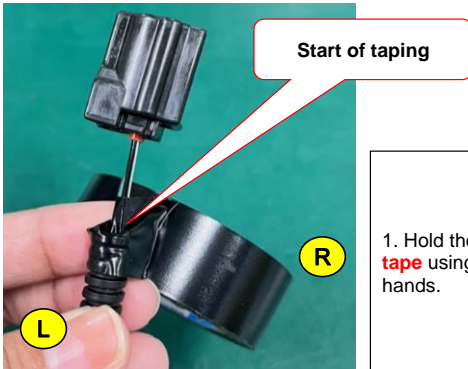
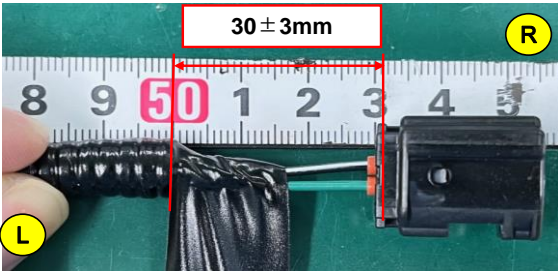
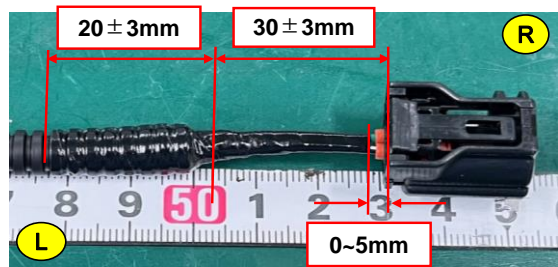

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PARTS:		1. Assy Parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1 Taping 1 Black corrugated tube to wire near connector	 <p>Start of taping</p> <p>1. Hold the corrugated tube using left hand, get the Black tape using right hand then start pre-taping using both hands.</p>  <p>30 ± 3mm</p> <p>2. Measure from end of the corrugated tube up to connector 30±3mm then continue the taping process using both hands.</p>  <p>20 ± 3mm 30 ± 3mm 0~5mm</p> <p>3. After taping, check the measurement and taping condition.</p>		MEASURING TAPE 	Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. Document references: 1. Refer to WI-PRO-ASY-001A for Taping process 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 7. No insufficient tape

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

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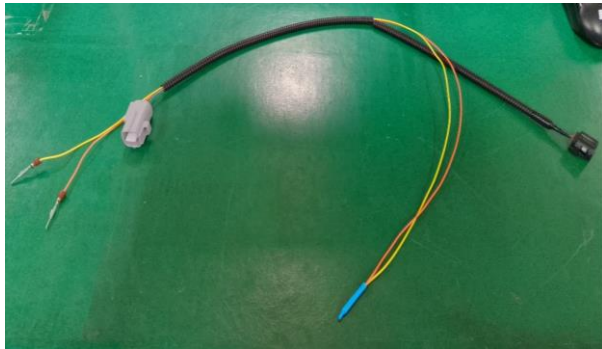

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PARTS:		1. AVSSf 0.3 Y-OR wire L=802±3mm 2. Assy part		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1 Wire insertion to assy parts (Black corrugated tube ø5 L=265±3mm (No slit))	 <p>1. Get the Y-OR wire using left hand and insert terminal cover jig using right hand.</p>  <p>2. Get the assy part using right hand then insert the wires in Black corrugated tube ø5 L=265±3mm (No slit) using right hand.</p>  <p>3. After insertion, remove the terminal cover jig using right hand.</p>		TERMINAL COVER JIG 	Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 1. No wrong usage of parts 2. No damaged rubber seal

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WORK INSTRUCTION

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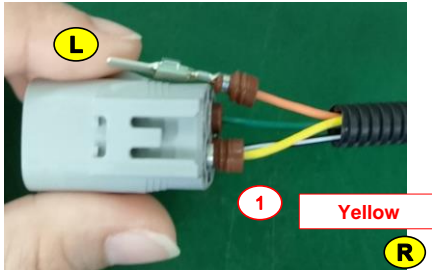
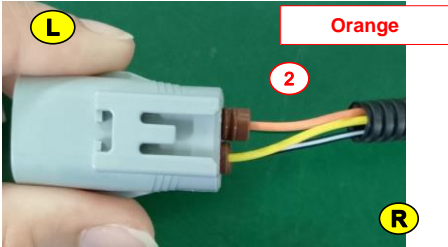
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P1 Wire insertion to connector 6188-0066 (GR)	<div><p>CONNECTOR ORIENTATION</p></div> <div><p>VISUAL REFERENCE</p></div> <div><p>TERMINAL FACING</p></div> <div><p>1. Hold the connector part using left hand and hold the first Yellow wire then insert to connector using right hand.</p></div> <div><p>2. Hold the connector using left hand and hold the second Orange wire then insert to connector using right hand.</p></div>	n/a	<p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal.</p> <p>2. Make sure wires are properly inserted.</p> <p>Conduct Pull-Push-Pull-Push after insertion.</p> <p>Do not exert extra force.</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>1. No loose insertion</p> <p>2. No wrong insertion</p> <p>3. One by one insertion</p> <p>4. No deformed terminal</p> <p>5. No wrong wire facing</p>

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

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400D / 7L0167-7020D

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Car Model:

TOYOTA bZ4x (BEV)

Purpose:



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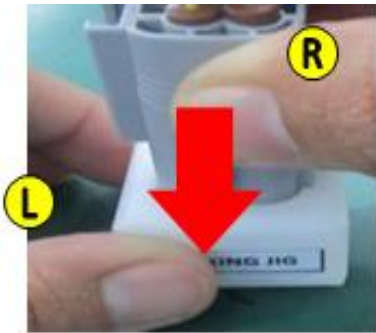


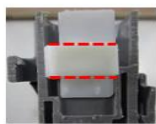
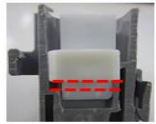
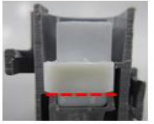

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PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P1 Connector lock	<div><div>1. Put the connector into locking jig using both hands and then conduct 2x pressing. Check the connector if properly locked.</div><div><div>Before pressing</div><div>After pressing</div></div><div><div>Connector Cross Sectional View</div><div><div><div>Unlock</div></div><div><div>Half Lock Condition</div></div><div><div>Full Lock Condition</div></div></div></div></div>	<div>LOCKING JIG</div> 	<div>Important reminders/Note/s:</div> <div>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</div> <div>1. No unlock/half-locked connector</div> <div>2. No damage connector</div>

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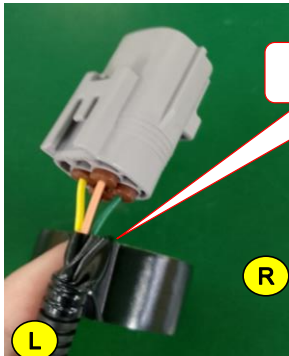
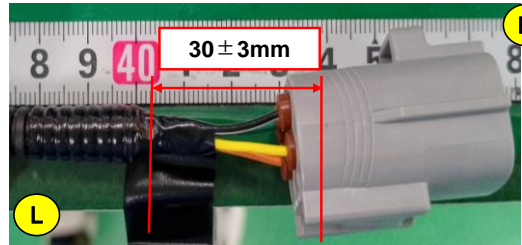
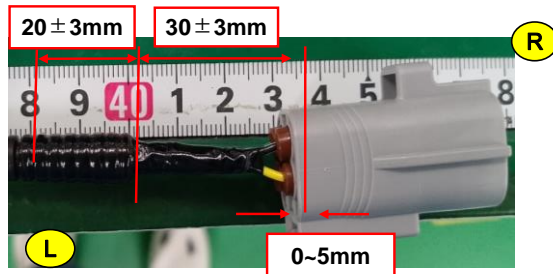

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	P1	<div><div><p>Start of taping</p></div><div><p>1. Hold the corrugated tube using left hand, get the Black tape using right hand then start pre-taping using both hands.</p></div></div> <div><div><p>30 ± 3mm</p></div><div><p>2. Measure from end of the corrugated tube up to connector 30±3mm then continue the taping process using both hands.</p></div></div> <div><div><p>20 ± 3mm 30 ± 3mm</p><p>0~5mm</p></div><div><p>3. 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. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document references:</p> <p>1. Refer to WI-PRO-ASY-001A for Taping process</p> <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 7. No insufficient tape</p>

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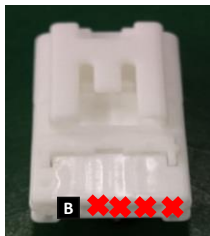

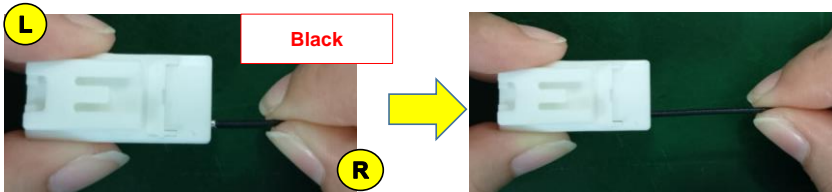
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PARTS:		1. Connector 6098-3802 (W) 2. Avssf 0.3 wire B L=595±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1 Wire insertion to connector 6098-3802 (W)	<div> CONNECTOR ORIENTATION</div> <div> B XXXXX</div> <div> TERMINAL FACING</div> <div></div> <div>1. Get the connector using left hand and get the Black wire and insert to connector using right hand.</div>		n/a	<p>Important reminders/Note/s:</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>Document references:</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> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p>

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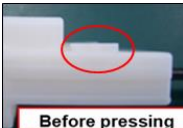


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PARTS:	1. Assy Parts		JIG:	1. Locking Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
12	P1 Connector lock	<div><div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div><div><p>2. 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 2. Use provided jig tool per model to avoid damaged lock.</div> <div>Document references: 1. Refer to GL-PRO-ASY-017 for the verification of connector lock.</div> <div><div></div><div><div></div></div></div>

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400D / 7L0167-7020D

Customer:

TRQSS

Car Model:

TOYOTA bZ4x (BEV)

Document No.:

WI-ENG-PDE-1243

Purpose:



PROTOTYPE



PRE-LAUNCH




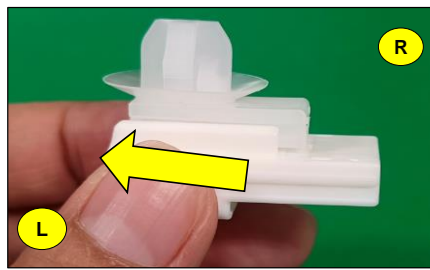
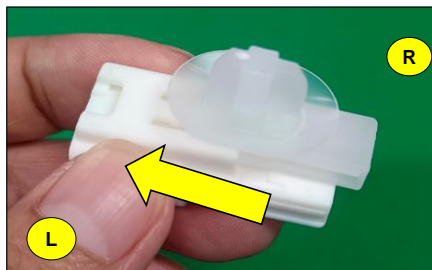
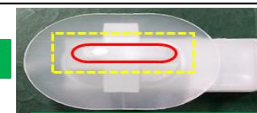
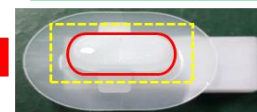
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PARTS:		1. Assy Parts 2. Clip Clamp 82711-1E360(W)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
13	P1 Clip attachment (Clip type clamp)	<div><div>CLAMP ORIENTATION</div><div></div><div>1. Hold the Connector using left hand, get the clip type clamp 82711-1E360 (W) then insert the clamp using right hand. <i>Note: Sound will be heard if properly inserted.</i></div></div>		n/a	<div>CLIP CLAMP ILLUSTRATION</div> <div><div>GOOD</div><div>82711-1E360 (W)</div><div>NG</div><div>82711-12B10 (W)</div></div> <div>1. No wrong used of clamp 2. No damaged clamp 3. No missing clamp</div>

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

Process Name/Title:

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PARTS:		1. Assy Parts 2. Black corrugated tube $\phi 5$ L=364 \pm 3mm (No slit)	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
14	P1 Wire insertion to assy parts (Black corrugated tube $\phi 5$ L=364 \pm 3mm (No slit))	<div></div> <div>1. Combined the Y-OR-B wire and then get and insert to terminal cover jig using right hand.</div> <div></div> <div></div> <div>2. Get Black corrugated tube $\phi 5$ L=364\pm3mm (No slit) and insert using left hand then insert.</div> <div></div> <div>3. After insertion, remove the terminal cover jig using right hand.</div> <div></div>	<div>TERMINAL COVER JIG</div> 	1. No wrong usage of parts 2. No damaged rubber seal

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n/a

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PARTS:

1. Assy Parts
2. Black Tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

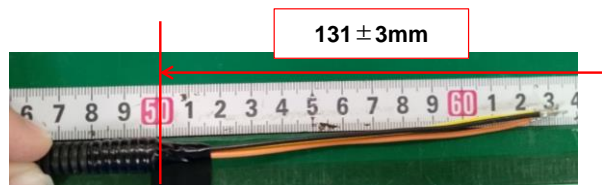
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P1

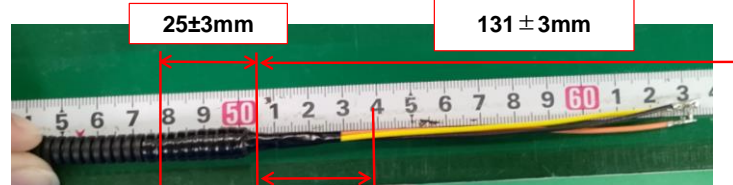
Taping 3
Black Corrugated tube
to wire near terminal



1. Hold the assy parts using left hand. Get the **Black tape** using right hand then start taping between COT to wire using both hands.



2. Measure from end of COT up to terminal pointed tip **131±3mm** then continue the taping process using both hands



3. After taping, check the measurement, terminal alignment and taping condition.

MEASURING
TAPE



Important reminders/Note/s:

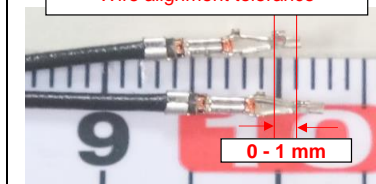
1. Please use calibrated/verified measuring tape when getting the measurement.

Document references:

1. Refer to WI-PRO-ASY-001A for Taping process

1. No flip-out tape
2. No peel-off tape
3. No loose tape
4. No wrong dimension
5. No wrong use of tape
6. No missing tape
7. No insufficient tape

Wire alignment tolerance



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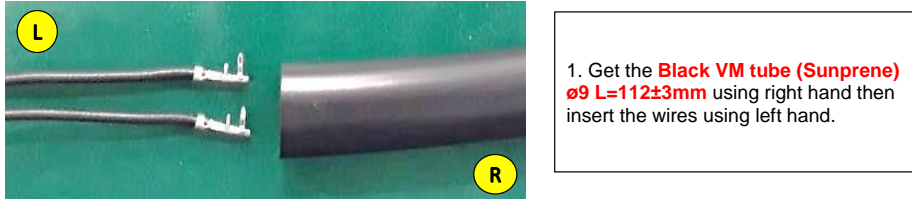
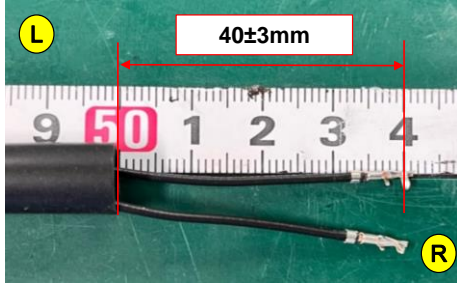
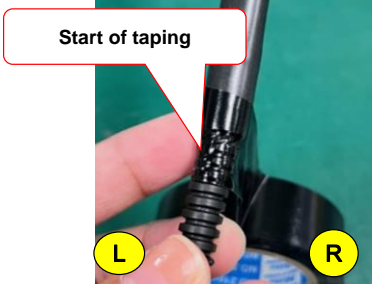
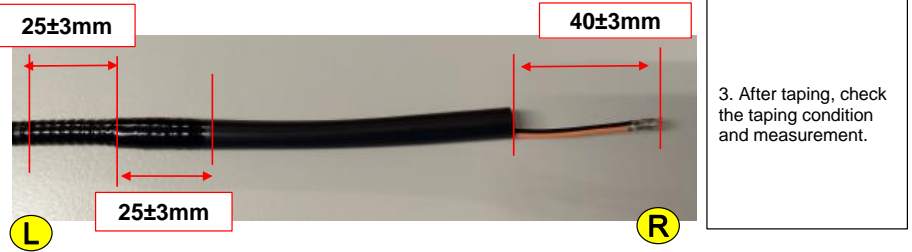

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PARTS:		1. Assy Parts 2. Black Tape 3. Black VM tube (Sunprene) $\varnothing 9$ L=112 \pm 3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
16		Wire insertion to Black VM tube (Sunprene) $\varnothing 9$ L=112 \pm 3mm		n/a	1. No wrong use of parts 2. No deformed terminal
17	P1	Taping 4 Black VM tube (Sunprene) to Black corrugated tube (no slit)	   <p>40\pm3mm</p> <p>25\pm3mm</p> <p>25\pm3mm</p> <p>40\pm3mm</p>	<p>MEASURING TAPE</p> 	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001B for taping procedure.</p> <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 7. No insufficient tape</p>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

400D / 7L0167-7020D

Customer:

TRQSS

Car Model: TOYOTA bZ4x (BEV)

Purpose:



PROTOTYPE



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PARTS:

1. Assy parts
2. Black Tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

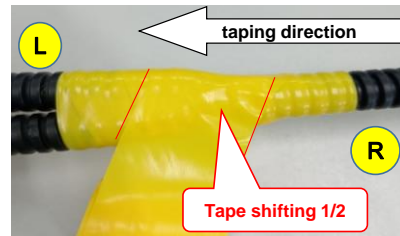
TOOLS/PPE

QUALITY POINTERS

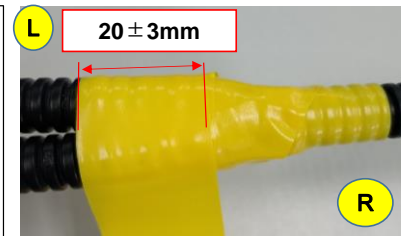
18

P1

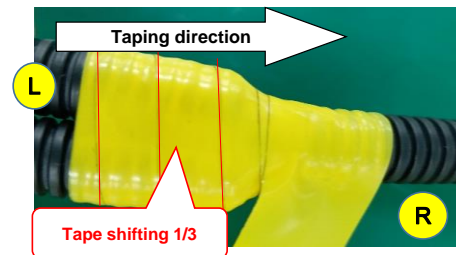
Y-taping
(Continuation)



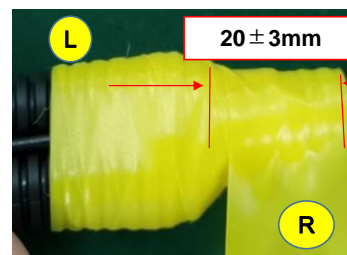
7. Winding the tape **1/2 shifting** going to the left side.



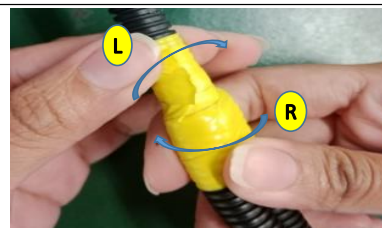
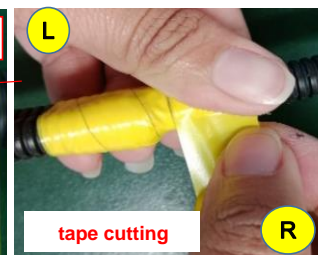
8. Make **2 windings**, width must be - **20±3mm**.



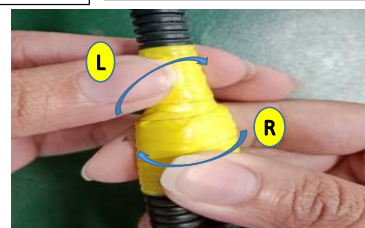
9. Winding the tape **1/3 shifting** going to the right side until reach the other side of tube.



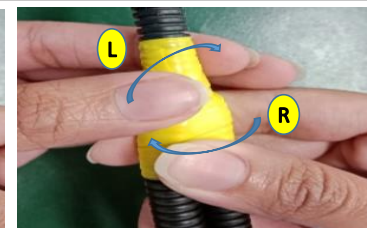
10. Make **3 winds**, width must be **20±3mm**. Then cut the tape.



11. conduct proper pressing of end tape using left hand (**top part**).
Note: Reference only.



12. conduct proper pressing of end tape using left hand (**Middle part**).
Note: Reference only.



13. conduct proper pressing of end tape using left hand (**bottom part**).
Note: Reference only.

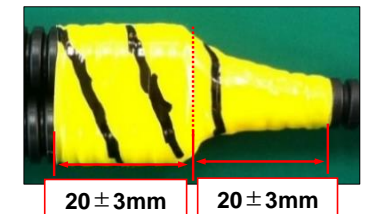
Document reference/s:

1. Refer to WI-PRO-ASY-001C for taping procedure (special).

Important reminders/Note/s:

1. Use **yellow tape** for easy visualization of tape shifting, but actual should be **BLACK TAPE**.
2. 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-out tape
6. No exposed wire
7. No gap between tubes
8. No insufficient tape



14. Check the Measurement and condition of tape.

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

March 29, 2025

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

400D / 7L0167-7020D

Customer:

TRQSS

Car Model: TOYOTA bZ4x (BEV)

Document No.:

WI-ENG-PDE-1243

Purpose:



PROTOTYPE



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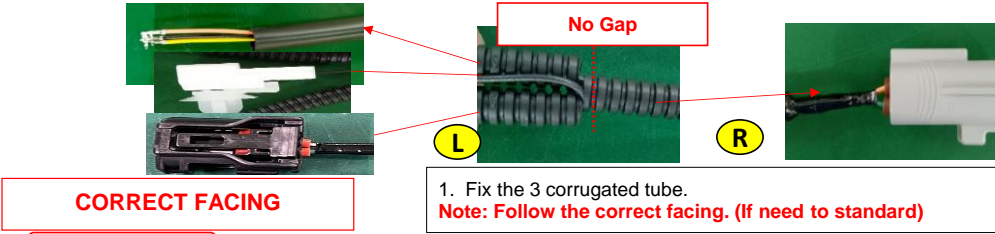
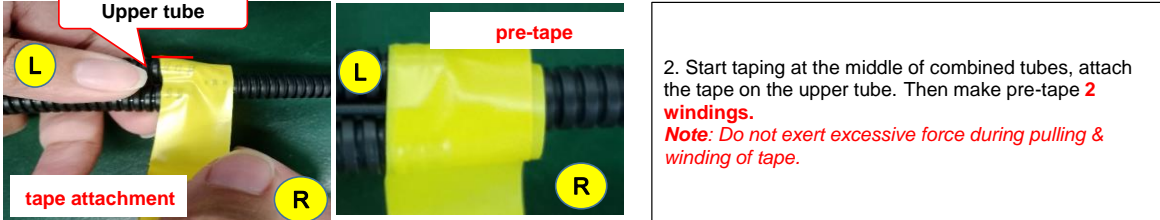
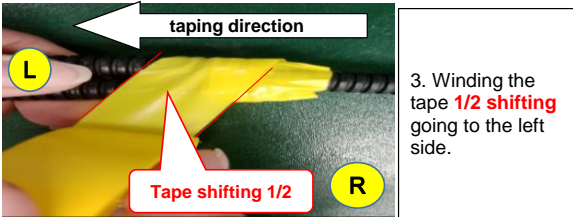
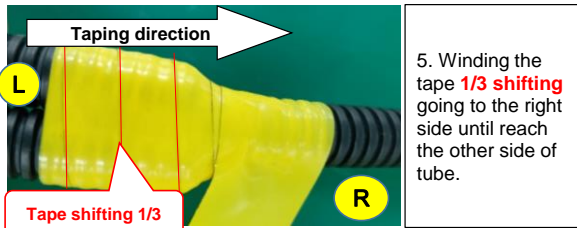
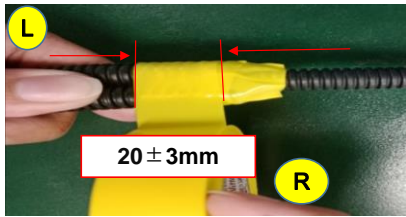
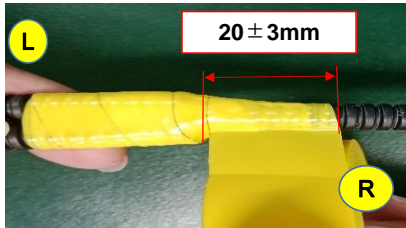
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PARTS:		1. Assy parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
18	P1 Y-taping	<div><div></div><div></div><div></div><div></div><div></div><div></div></div> <td></td> <td><p>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p><p>Important reminders/Note/s: 1. Use <u>yellow tape</u> 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><ol style="list-style-type: none">1. No loose tape2. No flip-out tape3. No peel-off tape4. No wrong use of tape5. No wrong dimension-out tape6. No exposed wire7. No gap between tubes8. No insufficient tape</td>			<p>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>Important reminders/Note/s: 1. Use <u>yellow tape</u> 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> <ol style="list-style-type: none">1. No loose tape2. No flip-out tape3. No peel-off tape4. No wrong use of tape5. No wrong dimension-out tape6. No exposed wire7. No gap between tubes8. No insufficient tape

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

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TOYOTA bZ4x (BEV)

Purpose:



PROTOTYPE



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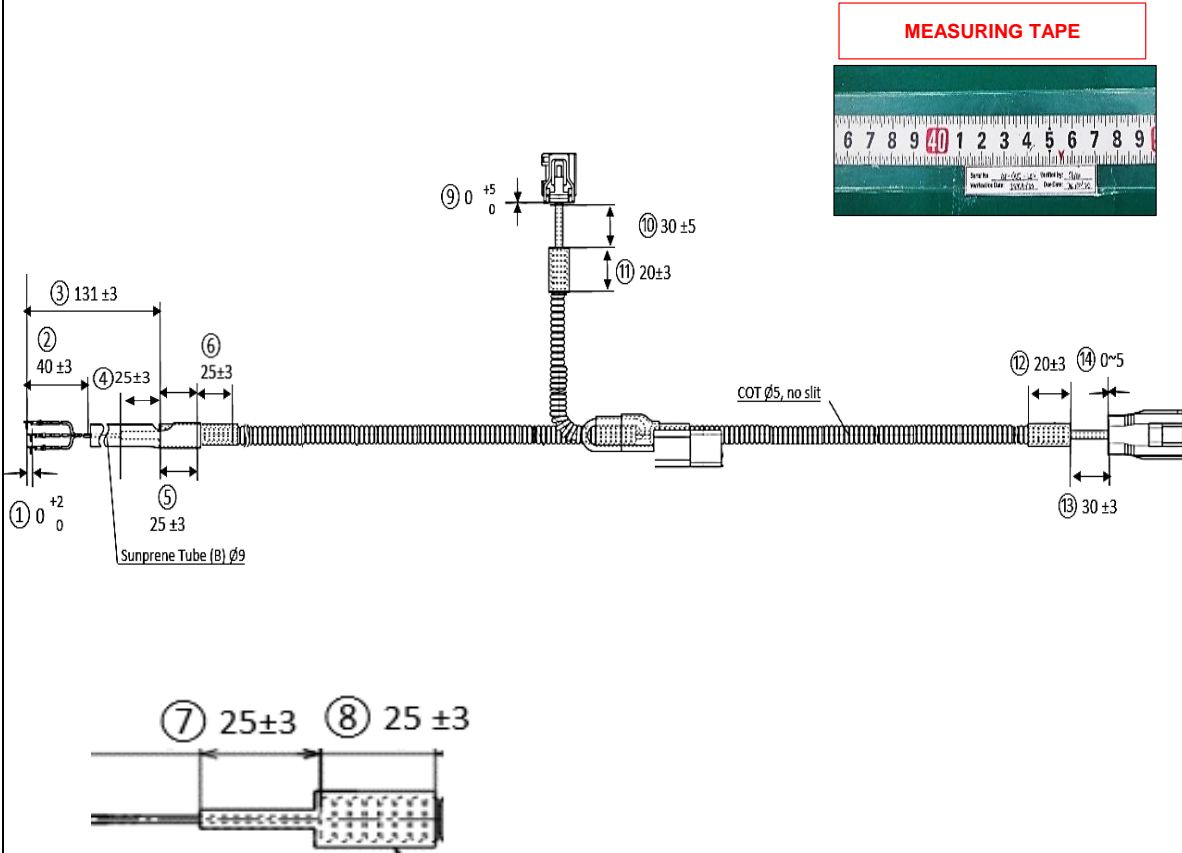

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PARTS:	1. Assy Parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
19	P1 Measurement	<div></div>	<div>MEASURING TAPE</div> 	<p>1. No wrong dimension</p> <p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified 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>

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WORK INSTRUCTION

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PARTS:

n/a

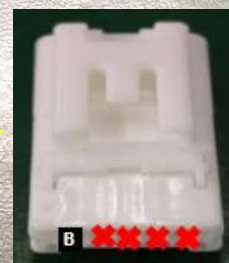
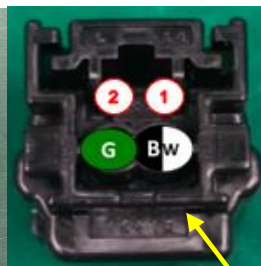
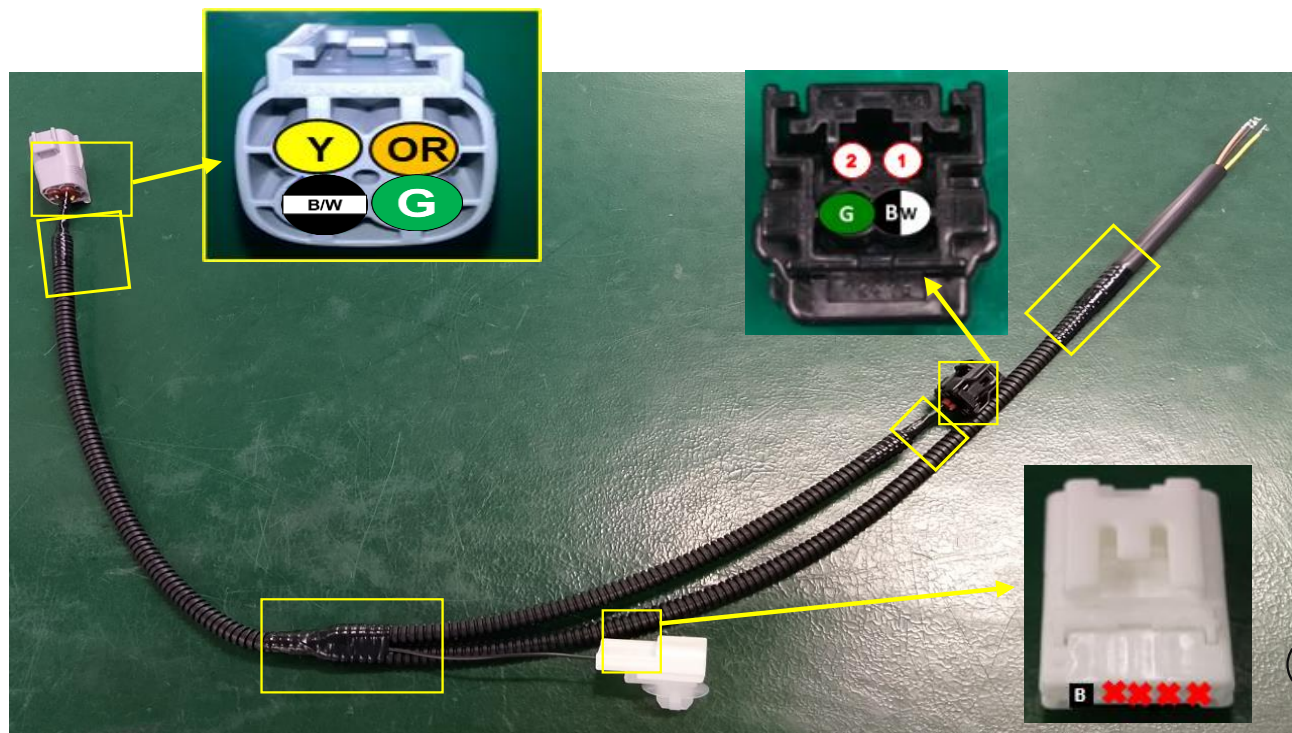
JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING - P1

7L0167-7020D



- ① No Unlock/Halflock Connector
- ② No Wrong Insert
- ③ No Missing tape COT to Wire near terminal and VM tube to COT)
- ④ No Wrong Facing of Y-Taping
- ⑤ No Terminal Backing Out
- ⑥ No Deformed Terminal

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