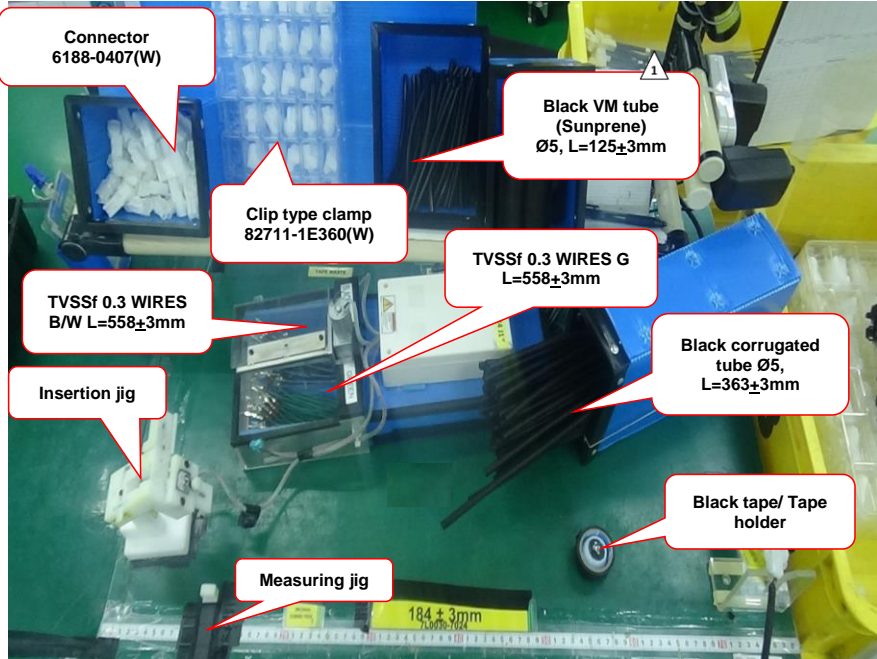
	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date: May 20, 2024	
	Process Name/Title:				Validity Date: n/a	
	Model code/Part number: 010B / 7L0030-7024		Customer: TRQSS		Car Model: TOYOTA CAMRY	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.: WI-ENG-PDE-390		Revision No.: 1	
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PARTS: 1. All parts: Connector 6188-0407 (W); TVSSf 0.3 wires G L= 558±3mm; TVSSf 0.3 wires B/W L= 558±3mm; Black VM tube (Sunprene) Ø5 L=125±3mm; Black Corrugated tube Ø5 L=363±4mm (No slit); Clip type clamp 82711-1E360(W); Black tape		JIG: 1. Insertion jig with switch cover 2. Measuring jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
1	P1 Table Lay-out	<div style="text-align: center;"> TABLE LAY-OUT </div> 	<div style="border: 1px dashed red; padding: 5px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>
QUALITY POINTERS		Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length tolerance.	
		1. No missing parts/tools 2. No excess parts/tools	


Revision History								Prepared by	Reviewed by	Approved by	Noted by
05/20/24	1	Transfer to new format. Inclusion of Car model "TOYOTA CAMRY" and Visual inspection. Update table lay-out and . Change term from sunprene to VM tube (Sunprene). Transfer Clamp attachment (clip clamp type) from WI-ENG-PDE-390B due to Porcess improvement.						D.Castillo	C.Villanueva	A. Arañes	n/a
01/29/22	0	Initial Issue. Change PCB from 2 chips (61C619-0002) to 1 chip (7N0994-7060). Change Wire color from Gray (GR) to Green (G).						M.Ariola	J.Loterte	C.Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change						Revised	Reviewed	Approved	Noted



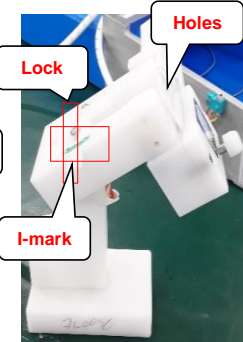
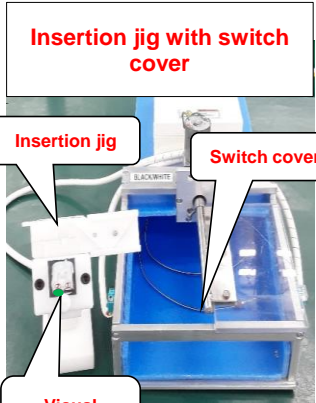

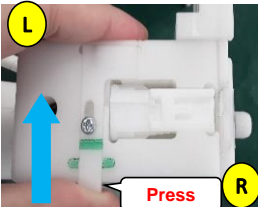
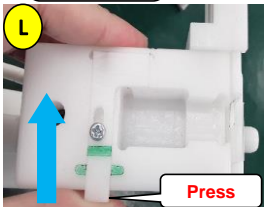







Est. Date:	January 29, 2022
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	Model code/Part number: 010B / 7L0030-7024		Customer: TRQSS	Car Model: TOYOTA CAMRY	Document No.:	WI-ENG-PDE-390	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	2 of 8


PARTS:	1.Connector 6188-0407 (W)			JIG:	1. Insertion Jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
2	P1 Connector setting to Insertion jig 6188-0407 (W)	<div></div> <div></div> <div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the connector 6188-0407 (W) into jig using right hand and release the lock. <i>Note: Refer to above illustration for correct setting.</i></p><p>3.Push the guide using right thumb. The slot for B/W wire will be opened.</p></div>		n/a	<div></div> <div></div> <p>1. Use provided jig for model. 2.No wrong orientation of connector</p>		

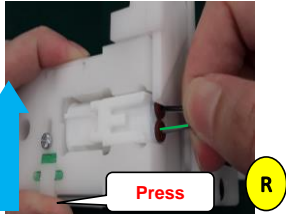
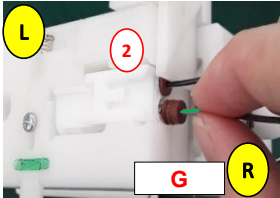
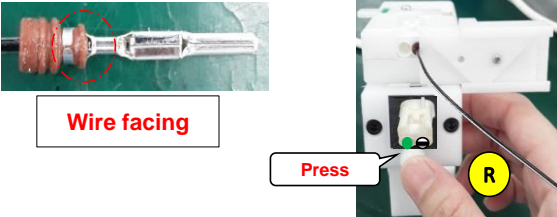
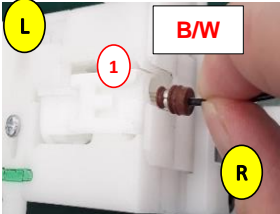
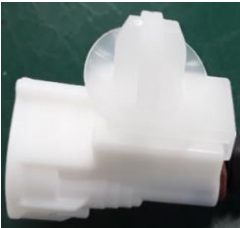
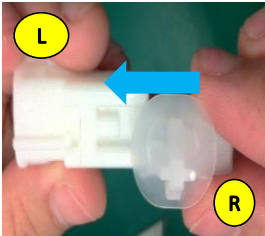
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	Model code/Part number: 010B / 7L0030-7024		Customer: TRQSS	Car Model: TOYOTA CAMRY	Document No.:	WI-ENG-PDE-390		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	3 of 8

PARTS:	1.TVSSf 0.3 wires G L=558±3mm 2.TVSSf 0.3 wires B/W L=558±3mm 3. Clamp 82711-1E360(W)			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Wire Insertion to connector 6188-0407 (W)	<div><p>1. Get Black/White wire then insert to terminal slot 1 using right hand.</p><p>2. Push the button after insertion. Hole for Green wire will be open.</p><p>3. Get Green wire then insert to terminal slot 2 using right hand.</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>		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>Document references: <i>1.Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i> <i>2.Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></div> <div>Important reminders/Note/s: <i>1. Make sure wires are properly inserted.</i> <i>Conduct Pull-Push-Pull-Push after insertion.</i> <i>Do not exert extra force.</i> <i>2.Insertion should be left to right.</i></div>
4	Clamp attachment (clip type clamp)	<div><p>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></p></div>		n/a	1. Must be fully inserted

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TOYOTA CAMRY

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

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PARTS: 

1. Black VM tube (Sunprene) Ø5 L=125±3mm

JIG:


n/a


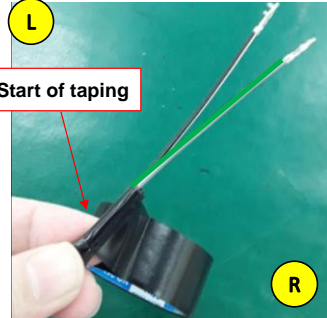
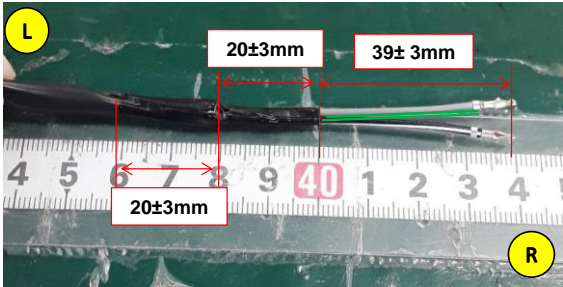

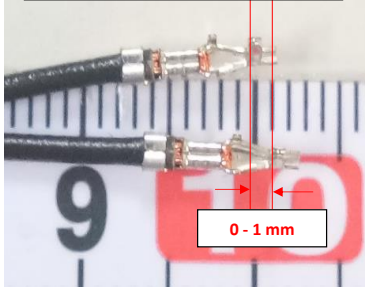
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1 Wire Insertion to Black Corrugated tube Ø5 L=363±4mm (no slit)	   <p>1. Get the terminal cover jig using right hand then insert G and B/W wires using left hand.</p> <p>2. Get the Corrugated Ø5 L=363±4mm (no slit) using right hand and insert the GR and B/W wires using left hand</p> <p>3. After insertion, remove the terminal cover jig using right hand.</p>	n/a	1. No wrong use of parts 2. No deformed terminal
6	 Wire insertion to Black VM tube (Sunprene) Ø5 L=125±3mm	 <p>1. Get the VM tube (Sunprene) Ø5 L=125±3mm using right hand then insert the Green and Black/White wire using left hand.</p>	n/a	1. No wrong use of parts 2. No deformed terminal

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PARTS:		1. Black tape 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
7	P1 Taping 1 VM tube (Sunprene) to wire near terminal	<div><p>1. Measure the end of the sunprene tube up to the end of the terminal pointed tip 59mm using both hands.</p></div> <div><p>2. Get the Black tape using right hand. Hold the sunprene tube using left hand then start taping using both hands.</p></div> <div><p>3. After taping, check the measurement, alignment and tape condition.</p></div>	<div><p>Measuring tape</p></div>	<div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div> <div><p>1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong use of tape 5. No wrong dimension</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-001 for taping procedure.</p></div>	

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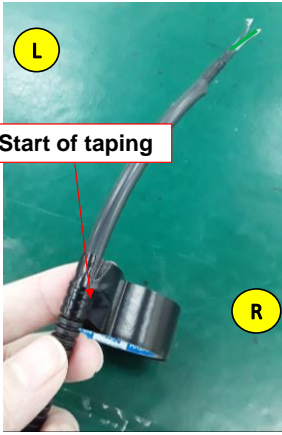
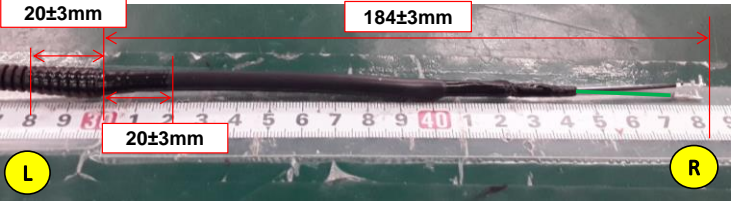

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PARTS:	1. Black tape 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P1 Taping 2 Corrugated tube to VM tube (Sunprene)	<div><p>1. Measure the end of the corrugated tube up to the end of the terminal pointed tip 184mm.</p></div> <div><p>2. Get the Black tape using right hand. Hold corrugated tube using left hand then start taping using both hand.</p></div> <div><p>3. After taping, check the measurement, alignment and tape condition.</p></div>	<div><p>Measuring tape</p></div>	<div><p>1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong use of tape 5. No wrong dimension</p></div> <div><p>Important reminders/note/s:</p><p>1. Please use calibrated/verified measuring tape when getting the measurement.</p></div> <div><p>Document reference/s:</p><p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p></div>

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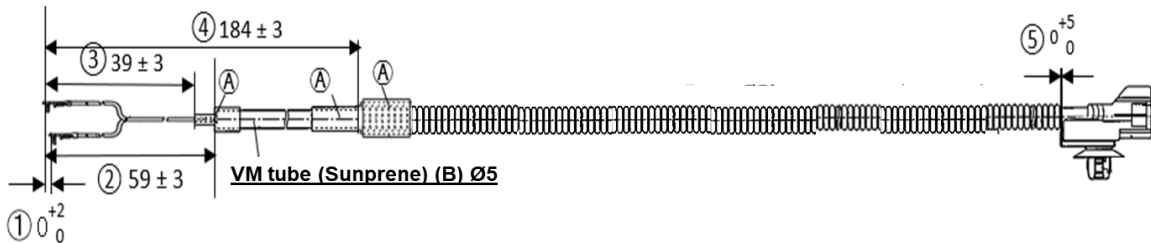

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PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1	Measurement	 NOTE: (A) Taping (B)	<div>Measuring tape</div> 	<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified 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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PARTS:

1. Assy parts

JIG:

n/a



QUALITY CHECKPOINTS

P1

7L0030-7024

1



GOOD



NO GOOD

4

2



5

3



GOOD



NO GOOD

1

No Unlocked/Half-locked connector

3

No Terminal Backing Out

5

No Missing of tape

2

No Wrong insert

4

No Deformed terminal

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