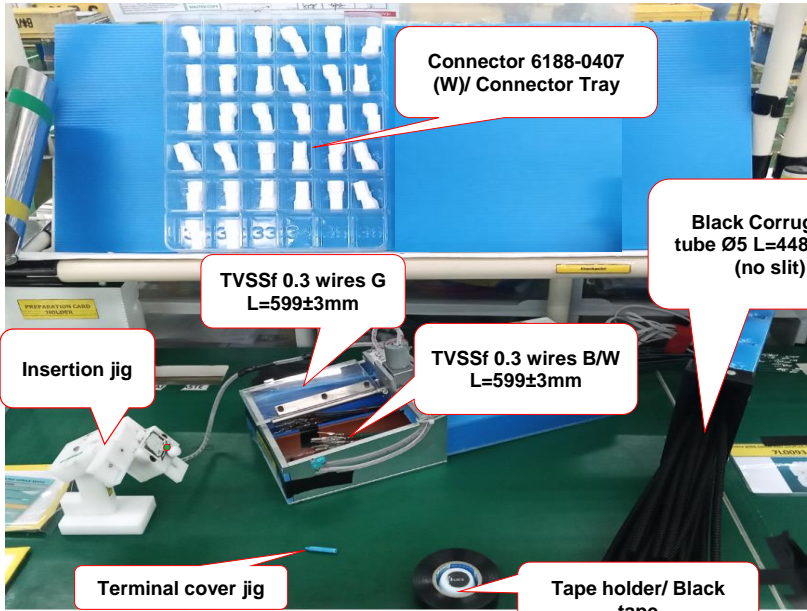



	WORK INSTRUCTION TAPING ASSEMBLY PROCESS			Effectivity Date:	November 04, 2024		
	Process Name/Title:			Validity Date:	n/a		
	Model code/Part number:	101D / 7N0098-7021C	Customer: TRJ	Car Model: TOYOTA-RAV4	Document No.:	WI-ENG-PDE-1118A	
	Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	1	Page No.:	1 of 5

PARTS:	1. All parts: Connector 6188-0407 (W); TVSSf 0.3 wires G-B/W L=599±3mm; Black Corrugated tube Ø5 L=448±4mm (no slit); Black tape			JIG:	1. Insertion jig with switch cover 2. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1	Table Lay-out	<div> <div>TABLE LAY-OUT</div>  </div>	<div> <div> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div> </div>	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
11/04/24	1	Change document purpose from pre-launch to masspro.	M. Ariola	C. Villanueva	A. Arañes	n/a				n/a
10/16/24	0	Initial issue	M. Ariola	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 16, 2024		

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WORK INSTRUCTION

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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PARTS:		1. Connector 6188-0407 (W)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<div><div>Connector setting to Insertion jig 6188-0407 (W)</div><div><div><div>INSERTION JIG WITH FLIP COVER</div><div><div>Visual reference</div><div>Insertion jig</div><div>Switch cover</div></div><div><div>Lock</div><div>I-mark</div><div>Holes</div></div><div>CONNECTOR ORIENTATION</div></div><div><div><div><div>L</div><div>Press</div></div><div>1. Press the lock of insertion jig using left thumb.</div></div><div><div><div>L</div><div>Press</div><div>R</div></div><div>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></div></div><div><div><div>L</div><div>R</div><div>Release</div></div><div>3. Check the holes/terminal slot for B/W wire.</div></div></div><div><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>1 hole is open</div><div>NG</div></div></div></div></div>		n/a	<div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div>

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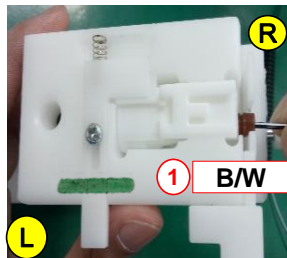

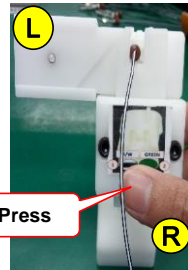

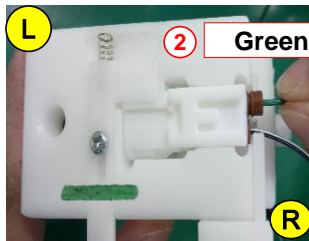
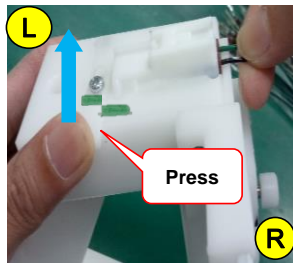

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PARTS:		1. TVSSf 0.3 wires G-B/W L=599±3mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1	<div><div></div><div></div><div></div><div><p>1. Hold the Insertion jig using left hand. Get Black /White wire then insert to terminal slot 1 using right hand.</p></div><div></div><div><p>2. Push the button using right hand. The slot for Green wire will be opened.</p></div><div></div><div></div><div><p>3. Get the Green wire then insert to terminal slot 2 using right hand.</p></div><div></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> <div>n/a</div> <div><p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p><p>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.</p><p>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</p></div>			

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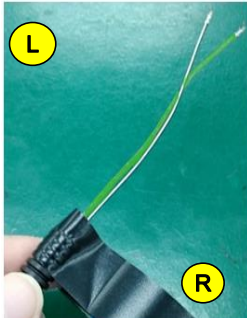
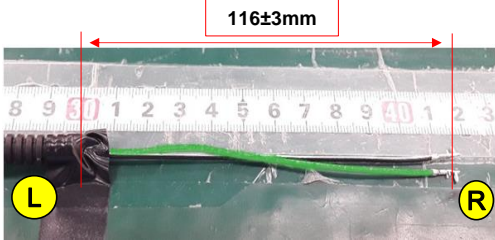
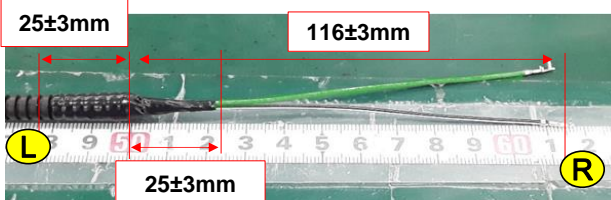

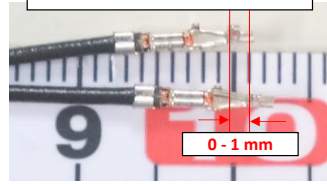
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PARTS:		1. Assy parts 2. Black Corrugated tube Ø5 L=448±4mm (no slit)		JIG:	1. Locking jig 2. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Wire insertion to Corrugated tube Ø5 L=448±4mm (no slit)	 <p>1. Get the terminal cover jig using right hand then insert the G-B/W wires using left hand.</p> <p>2. Get the Corrugated Ø5 L=448±4mm (no slit) using right hand and insert the G-B/W wires using left hand</p> <p>3. After insertion, remove the terminal cover jig using right hand.</p>		TERMINAL COVER JIG 	1. No wrong use of parts 2. No deformed terminal
5	P1 Taping 1 COT to wire near terminal	 <p>1. Hold the COT using left hand get Black tape using right hand and conduct pre taping using both hands.</p>  <p>2. Measure the end of COT to terminal tip 116±3mm and continue the process using both hands</p>  <p>3. After taping, check the measurement, terminal appearance and taping condition.</p>		MEASURING TAPE 	 <p>Wire alignment tolerance 0 - 1 mm</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p> <p>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p>

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PARTS:

n/a

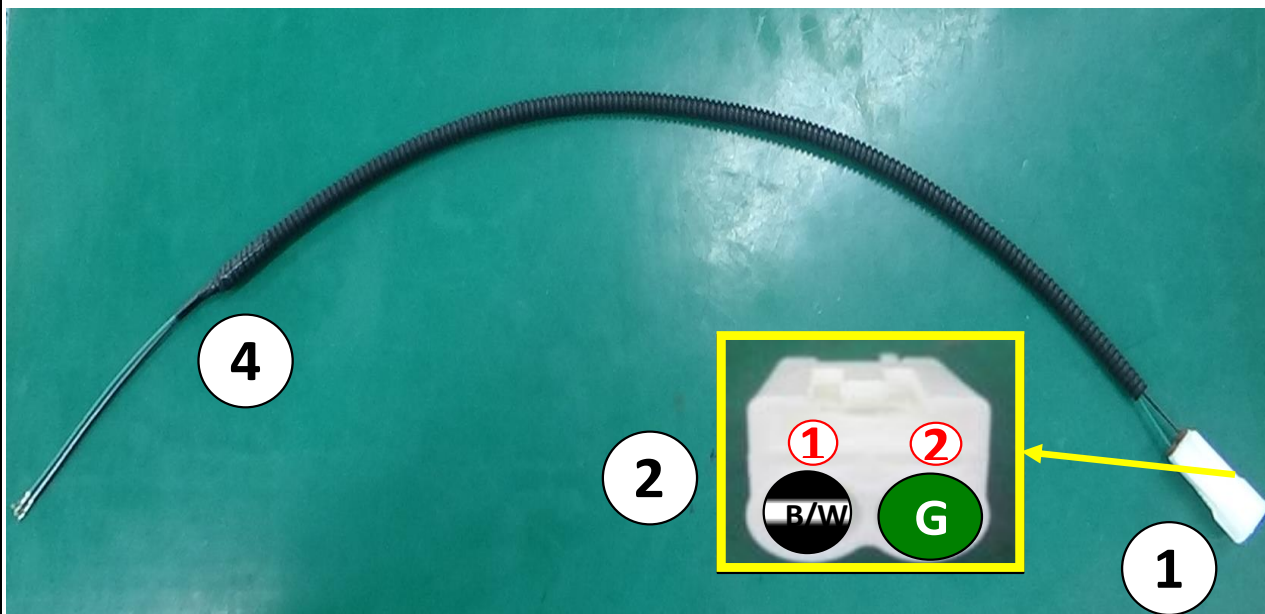
JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING- P1

7N0098-7021C



- 1 No unlock/half-locked connector
- 2 No Wrong insert
- 3 No Terminal Backing out
- 4 No Missing tape(Black)

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