

	WORK INSTRUCTION				Effectivity Date:		January 27, 2025	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 700B / 7N0099-7020		Customer: TRJ	Car Model: Toyota-Land Cruiser	Document No.: WI-ENG-PDE-716B	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO		Revision No.:	2 Page No.: 1 of 8

PARTS:		1. Assy part; Black tape		JIG:		1. Insertion Jig 2. Locking jig	
NO.	PROCESS NAME	2	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
1	P2	Table Lay-out		<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px; color: red;">TABLE LAY-OUT</div>		<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> 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 solid red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	1. No missing parts/tools 2. No excess parts/tools

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
01/27/25	2	Transfer process 2-5 from P1 and separate other process to P3 due to process improvement. Improved Table lay-out Y-taping work procedure and Visual inspection/Quality checkpoint.				D.Castillo	C.Villanueva	A. Arañes	n/a				n/a		
09/12/23	1	Change purpose from pre launch to mass pro. Additional of table lay-out				A.Hernandez	J.Loterte	C.Villanueva	A. Arañes						
08/02/23	0	Initial issue.				D.Castillo	J.Loterte	C.Villanueva	A. Arañes						
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	August 02, 2023				

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700B / 7N0099-7020Customer: **TRJ**Car Model: **Toyota-Land Cruiser**

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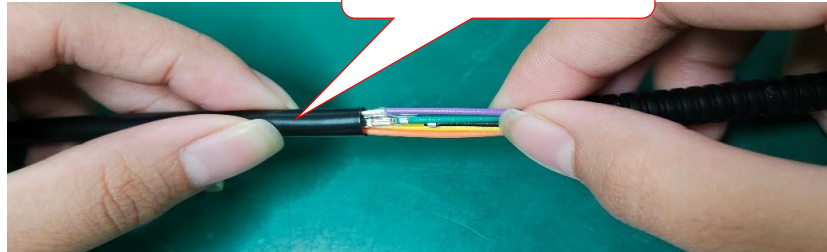
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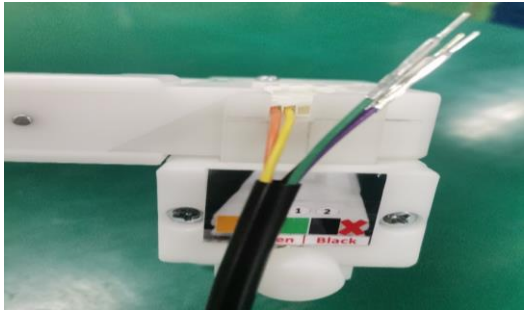
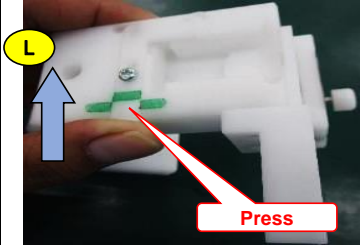

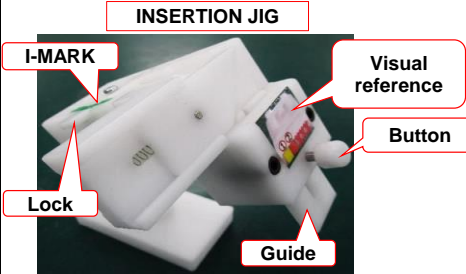
PARTS:		1. Assy Parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 <div>2</div> Wire Insertion to assy part	<div><div>Ø5 L=165±3mm</div></div> <div>1. Hold the corrugated tube (no slit) Ø5 L=165±3mm using left hand then insert the assy part using right hand.</div> <div><div>Ø5 L=188±3mm</div></div> <div>2. Hold the SV tube (Vinyl) Ø5 L=188±3mm using left hand then insert the assy part using right hands.</div>		N/A	1. No wrong use of parts 2. No deformed terminal 3. No wrong use of insertion

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.:	3 of 8

PARTS:	1. Assy Parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2 Connector setting to insertion jig 6098-3802 (W)	<div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the connector 6098-3802 (W) into jig using right hand and release the lock. <i>Note: Follow the connector orientation.</i></p><p>3. Push the guide using left hand. The slot for G wire will be opened.</p></div>	N/A	1. No wrong use of parts 2. No deformed terminal 3. No wrong use of insertion

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Car Model:

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PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2 <div>2</div> <			

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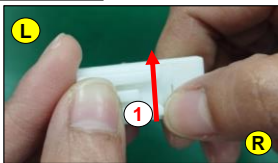



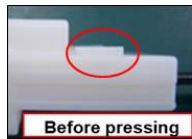


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PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2 <div>2</div> Connector lock	<div> 1. Load the connector into the jig holding both side of the connector, tip first. 2. Press the lower part of connector to fully insert into the locking jig.</div> <div> Right thumb-Lower Left thumb-middle Right thumb-upper Left thumb-middle 3. Press the lower parts of connector using right hand while left hand holding the middle. 4. Press the upper part of connector using right hand while left hand holding the middle.</div> <div> Right thumb-middle Left thumb-middle 5. Lift then press the connector in the middle using left and right hand. 6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</div>	<div>LOCKING JIG</div> 	<div>1. Use the provided jog 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> Before pressing After pressing</div> <div><div>GOOD</div><div>Full Lock</div><div>NG</div><div>Half Lock</div></div>

LOCKING JIG

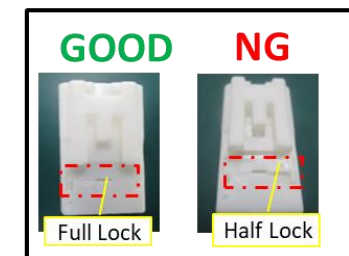
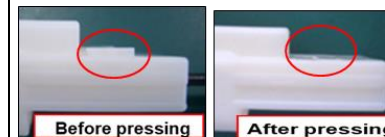
1. Use the provided jog per model
2. No unlocked/half-locked connector

Important reminders/Note/s:

1. **MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR LOCK**
2. Use provided jig tool per model to avoid damaged lock.

Document references:

1. Refer to GL-PRO-ASY-017 for the verification of connector lock.



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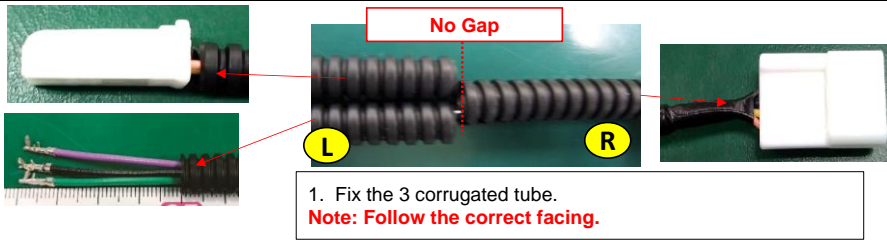
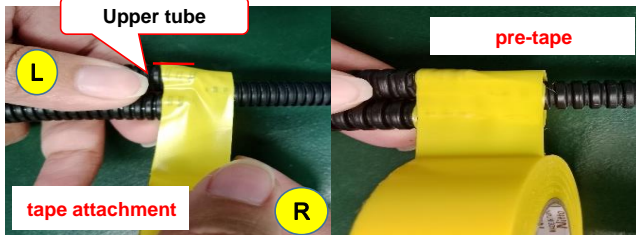
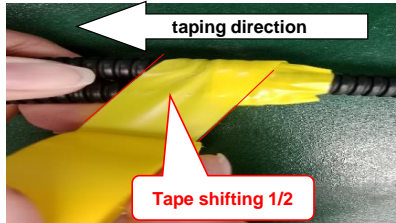
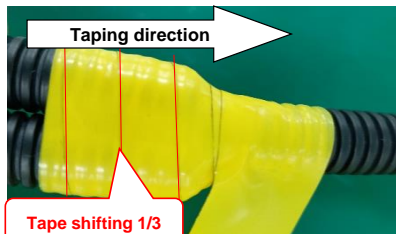
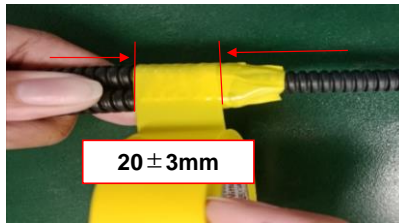
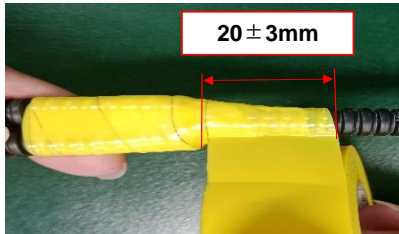

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	2 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
6	P2	Y-taping	<div><p>1. Fix the 3 corrugated tube. Note: Follow the correct facing.</p></div> <div><p>2. Start taping at the middle of combined tubes, attach the tape on the upper tube. Then make pre-tape 2 windings. Note: Do not exert excessive force during pulling & winding of tape.</p></div> <div><p>3. Winding the tape 1/2 shifting going to the left side.</p></div> <div><p>5. Winding the tape 1/3 shifting going to the right side until reach the other side of tube.</p></div> <div><p>4. Make 2 windings, width must be 20±3mm.</p></div> <div><p>6. Make 2 windings, width must be 20±3mm.</p></div> <div><p>CORRECT FACING</p></div>	<p>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>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.</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 tubes	

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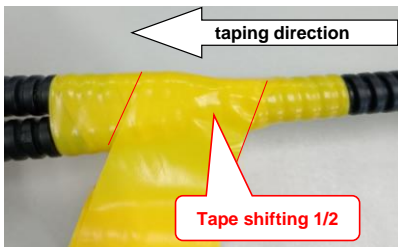
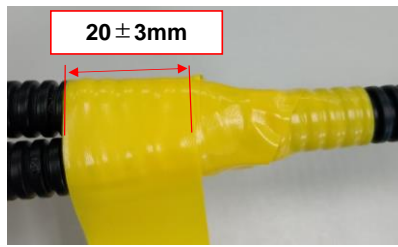
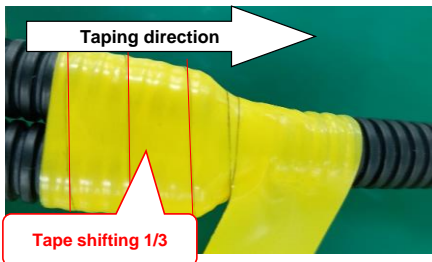
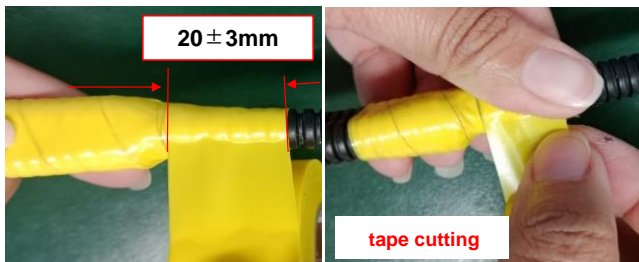
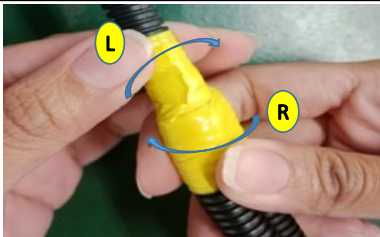

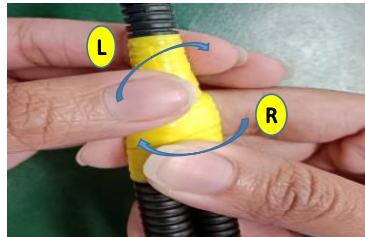
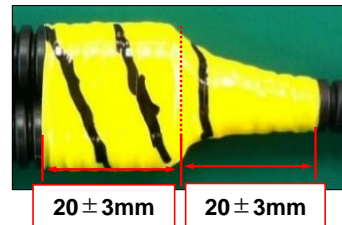
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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	2 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P2 Y-taping (Continuation)	<div><div></div><div><p>7. Winding the tape 1/2 shifting going to the left side.</p></div><div></div><div><p>8. Make 2 windings, width must be 20±3mm.</p></div><div></div><div><p>9. Winding the tape 1/3 shifting going to the right side until reach the other side of tube.</p></div><div></div><div><p>10. Make 3 winds, width must be 20±3mm. Then cut the tape.</p></div><div></div><div><p>11. conduct proper pressing of end tape using left hand (top part). Note: Reference only.</p></div><div></div><div><p>12. conduct proper pressing of end tape using left hand (Middle part). Note: Reference only.</p></div><div></div><div><p>13. conduct proper pressing of end tape using left hand (bottom part). Note: Reference only.</p></div><div></div><div><p>14. Check the Measurement and condition of tape.</p></div></div>		<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 tubes	

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700B / 7N0099-7020Customer: **TRJ**Car Model: **Toyota-Land Cruiser**

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PARTS:

1. Assy parts

JIG:

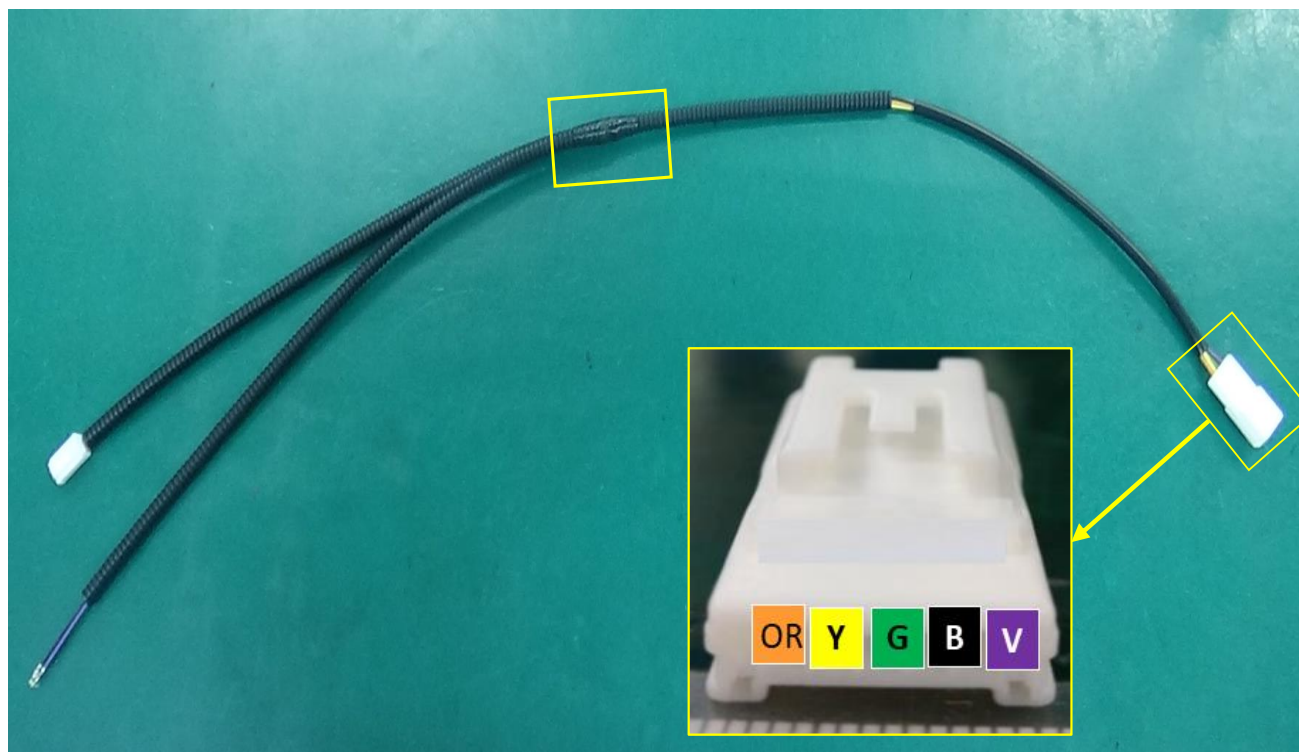
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2

VISUAL INSPECTION/QUALITY CHECKPOINTS

TAPING - P2

7N0099-7020



- ① No **Unlocked/ Half-locked connector**
- ② No **Wrong Insert**
- ③ No **Deformed terminal**
- ④ No **Terminal backing out**
- ⑤ No **Missing Tape**
No **wrong use tape (Black tape)**

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