



## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

May 20, 2024

Process Name/Title:

Model code/Part number:

881A / A7469D

Customer:

TRQSS

Car Model:

TOYOTA-CAMRY

Validity Date:

n/a

Document No.:

WI-ENG-PDE-889

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS:		1. Connector 6188-0407 (W) 2. AVSSf 0.3 G and B/W L=728±3mm 3. Black Corrugated tube (No Slit) Ø7 L=333±3mm 4. Black SV tube (Vinyl) Ø5 L=337±3mm 5. Black tape (19mm)				JIG:		1. Insertion Jig with cover 2. Locking Jig 3. Terminal Cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	P1	<div><div>Connector 6188-0407 (W)</div><div>TABLE LAY-OUT</div><div>Black Corrugated tube (No Slit) Ø7 L=333±3mm</div><div>Switch Cover</div><div>Black SV tube (Vinyl) Ø5 L=337±3mm</div><div>Insertion Jig</div><div>Black Wire</div><div>Terminal Cover Jig</div><div>Green Wire</div><div>Locking Jig</div><div>Tape holder / Black tape</div></div>				<div><b>Safety Instruction</b> Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> 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
5/20/2024	1	Change from Pre-launch to Mass pro. Inclusion of table lay-out. Improved Measurement and Visual Inspection.				A.Hernandez	C.Villanueva	A. Arañes	n/a
5/15/2024	0	Initial issue.				A.Hernandez	C.Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted
						Est. Date:	May 15, 2024		

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### PARTS:

- Connector 6188-0407 (W)
- AVSSf 0.3 G and B/W L=728±3mm

JIG:

1. Insertion Jig with cover

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

P1

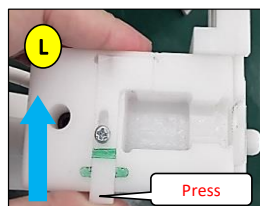
Wire Insertion to  
Connector  
6188-0407 (W)



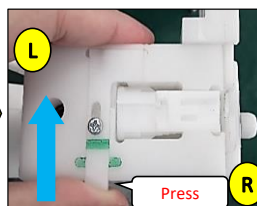
Connector Setting



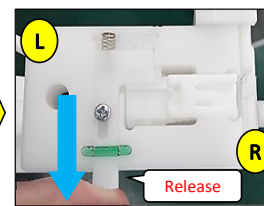
Wire facing



Press



Press

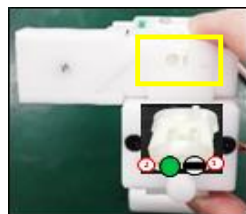


Release

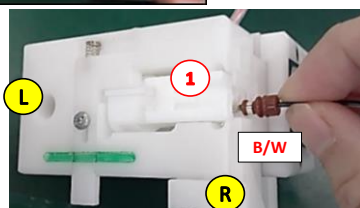
1. Press the lock of insertion jig using left thumb.

2. Insert the connector 6188-0407 (W) into jig using right hand and release the lock.

*Note: Refer to above illustration for correct setting.*

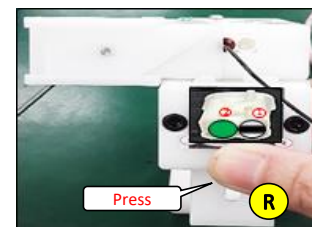


3. Check the holes/terminal slot for B/W wire.



B/W

4. Hold the insertion jig using left hand. Get the B/W wire L=728±3mm and insert to terminal slot ① using right hand.



Press

5. Press the button using right hand. Slot for Green wire will be open.

n/a

### Important reminders/Note/s:

- Please hold the wire near terminal during insertion.
- Make sure wires are properly inserted. Conduct Pull-Push-Pull after insertion. Do not exert extra force.

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May 20, 2024

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n/a

Car Model: **TOYOTA-CAMRY**

WI-ENG-PDE-889

 MASSPRO

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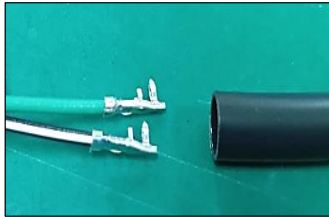

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PARTS:		1. Assy Part 2. Black Corrugated tube $\phi 7$ L=333 $\pm$ 3mm 3. Black SV tube (Vinyl) $\phi 5$ , L=337 $\pm$ 3mm 4. Black tape (19mm)		JIG:	1. Terminal Cover Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1	Wire insertion Black Corrugated tube ( $\phi 7$ L=333 $\pm$ 3mm)	 1. Get the terminal cover jig using right hand then insert the terminal tip of <b>G</b> and <b>B/W</b> wires.  2. Get the <b>Black Corrugated <math>\phi 7</math> L=333<math>\pm</math>3mm (no slit)</b> using right hand and insert the <b>G</b> and <b>B/W</b> wires with terminal cover jig.. 3. After insertion, remove the terminal cover jig using right hand.		1. No wrong use of parts 2. No deformed terminal
6		Wire insertion Black SV tube (Vinyl) ( $\phi 5$ , L=337 $\pm$ 3mm)	 1. Get the <b>Black SV tube (Vinyl) <math>\phi 5</math> L=337<math>\pm</math>3mm</b> using right hand then insert the <b>G</b> and <b>B/W</b> wires. 	n/a	

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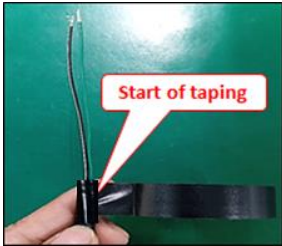
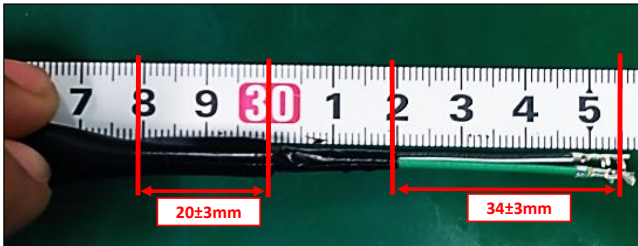


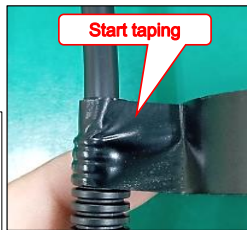
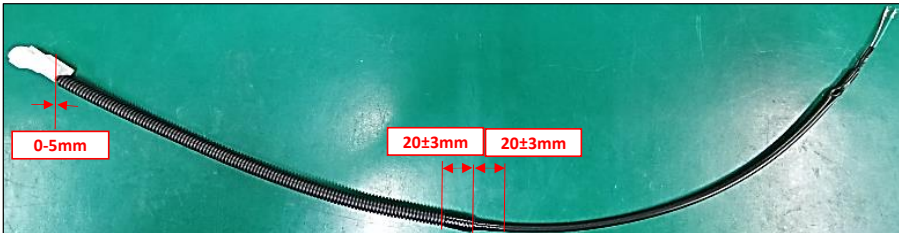
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PARTS:		1. Assy Part 2. Black tape (19mm)		JIG:	1. Measuring tape
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1	<div><div></div><div></div></div> <div><div>1. Hold the end of <b>Black SV tube (Vinyl)</b> using left hand. Get the <b>Black tape</b> using right hand and start taping...</div><div>2. After taping, check the condition of tape, measurement and wire alignment. <i>Refer to WI-PRO-ASY-001 for taping procedure</i></div></div>		<div>Measuring Tape</div> <div></div>	<div>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</div>
8		<div><div></div><div></div></div> <div><div>1. Fix the <b>Black Corrugated tube</b> and <b>Black SV tube (Vinyl)</b> using both hands.</div><div>2. Hold the <b>Black Corrugated tube</b> and <b>Black SV tube (Vinyl)</b> using left hand then start taping using right hand. <i>Refer to WI-PRO-ASY-001 for taping procedure</i></div></div> <div><div></div><div>3. After taping, check the condition of tape, measurement and wire alignment. <i>Refer to WI-PRO-ASY-001 for taping procedure</i></div></div>			

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### PARTS:

1. Assy part

JIG:

1.Measuring tape

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

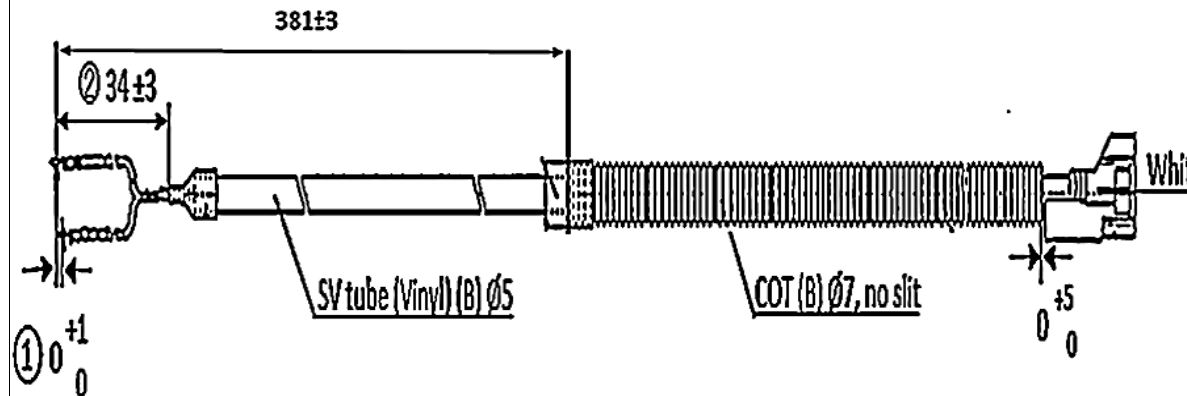
TOOLS/PPE

QUALITY POINTERS

9

P1

Measurement

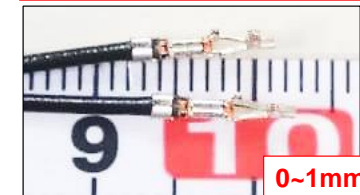


1. No wrong dimension

Measuring Tape



Wire alignment tolerance



### Important reminders/note/s:

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

### Document references;

1. Please refer to **WI-PRO-ASY-001** for taping procedure.

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PARTS:

n/a

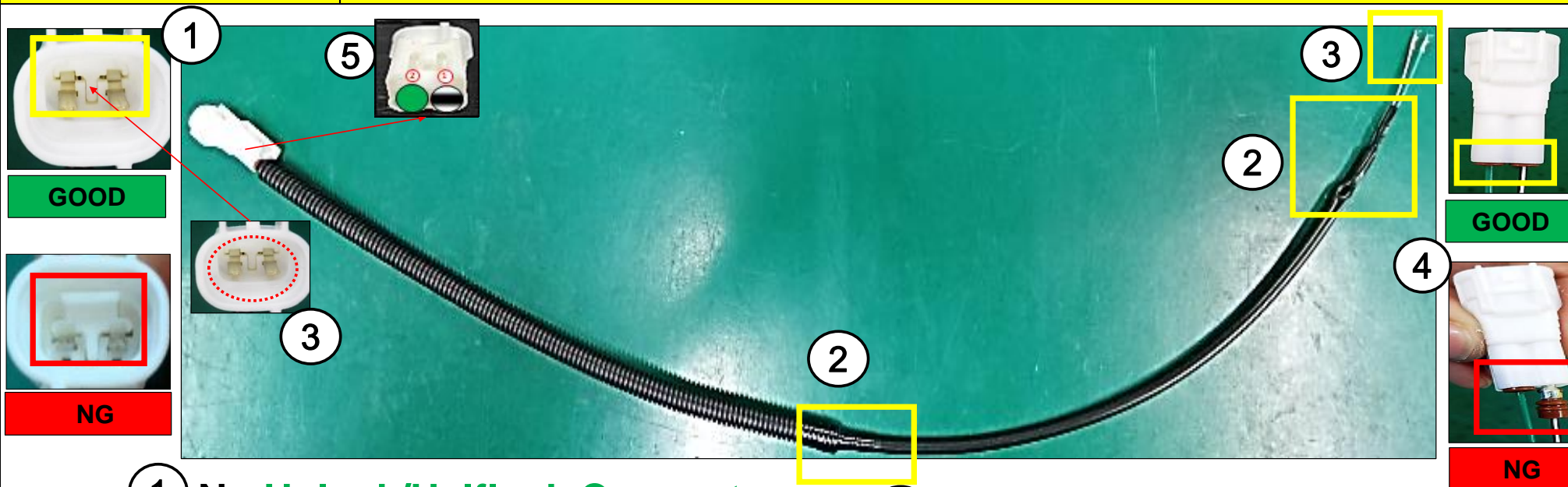
JIG:

n/a

### VISUAL INSPECTION/QUALITY CHECKPOINTS

# TAPING

# A7469D



- 1 No Unlock/Halflock Connector
- 2 No Missing Tape
- 3 No Deformed Terminal

- 4 No Terminal Backing Out
- 5 No Wrong Insertion

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