



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

559D / 7N0238-7020B

Customer: TRJ

Car Model: TOYOTA HI-ACE

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Effectivity Date:

March 12, 2025

Validity Date:

n/a

Document No.:

WI-ENG-PDE-974A

Revision No.:

1

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PARTS:

1. Assy parts; Connector 7286-4097 (W); Connector 7283-1027 (W; Black SV tube (vinyl) ø5 L= 248±3mm; Avssf 0.3 OR L=802±3; Avssf 0.3 Y L=802±3; Avssf 0.3 B-B L=595±3.

JIG:

1. Insertion jig with switch cover
2. Insertion jig
3. Pushing Jig 4. Terminal cover jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

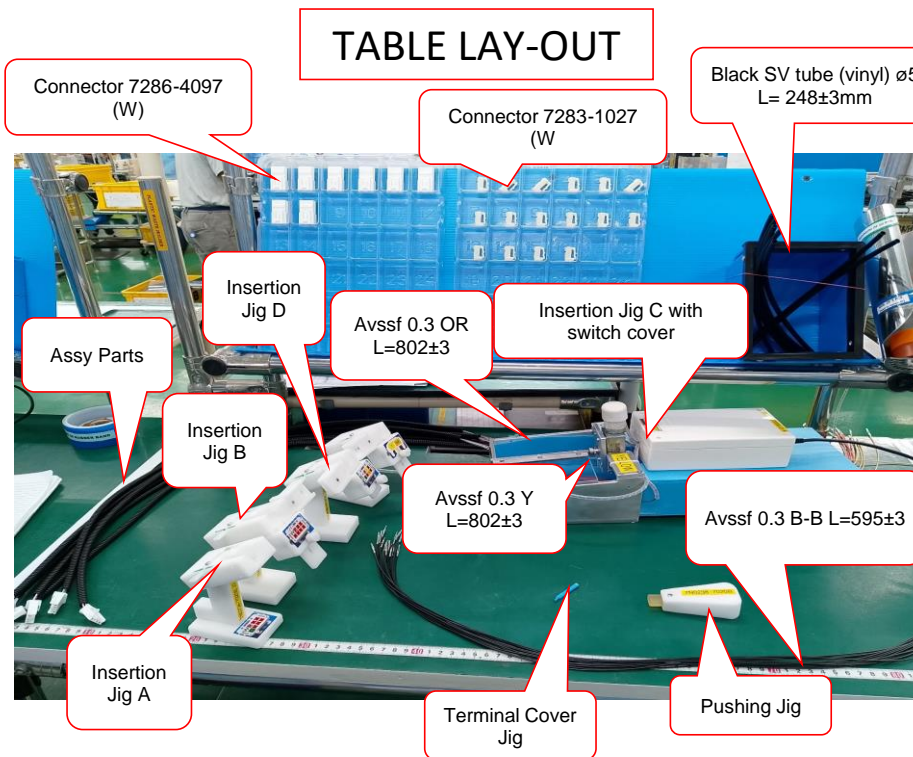
TOOLS/PPE

QUALITY POINTERS

1

P1

Table Lay-out

**Safety Instruction**

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. No missing parts/tools
2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved	Est. Date:	Prepared by	Checked by	Reviewed by	Approved by
03/12/25	1	Change document purpose from pre-launch to mass pro, split type process.	A.Hernandez	J.Loterte	C.Villanueva	A.Arañes		A.Hernandez	J.Loterte	C.Villanueva	A.Arañes
01/28/25	0	Initial issue.	A.Hernandez	C.Villanueva	A.Arañes	n/a		A.Hernandez	J.Loterte	C.Villanueva	A.Arañes

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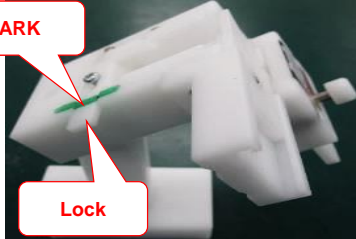

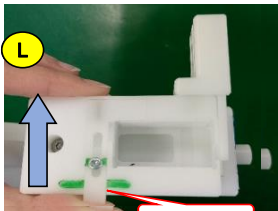
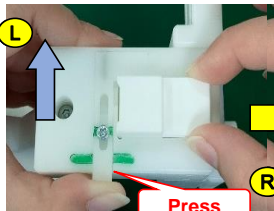
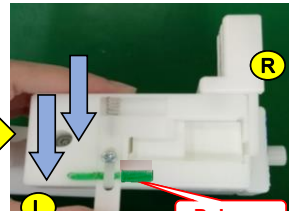



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PARTS:	1. Connector 7286-4097 (W)		JIG:	1. Insertion Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Connector setting to insertion jig 7286-4097 (W)	<div><div><p data-bbox="739 649 1034 697">INSERTION JIG ORIENTATION</p></div><div><p data-bbox="1117 549 1402 612">CONNECTOR ORIENTATION</p></div><div><div><p data-bbox="710 924 822 948">Press</p></div><div><p data-bbox="1012 924 1124 948">Press</p></div><div><p data-bbox="1348 908 1438 932">Release</p></div><div><p data-bbox="553 963 846 1032">1. Press the lock of insertion jig using left hand.</p><p data-bbox="869 963 1433 1032">2. Get the connector using then Insert the connector 7286-4097 (W) using right hand into jig using and release the lock. <i>Note: Follow the connector orientation.</i></p><div><p data-bbox="949 1096 1359 1272">3. Push the guide using left hand. The slot for P wire will be opened.</p></div></div></div><div>n/a</div><div><p>1. Use the provided jig per model 2. No wrong orientation of the connector. 3. No wrong use of connector 4. No damaged connector.</p><div><p data-bbox="1774 612 2076 636">Connector Orientation Illustration</p><div><p data-bbox="1897 844 1984 868">GOOD</p></div><div><p data-bbox="1919 1035 1962 1059">NG</p></div></div></div></div>		

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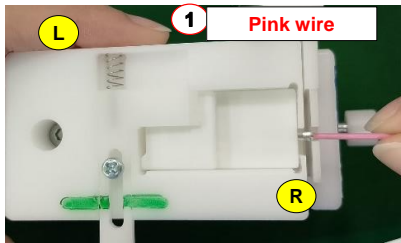
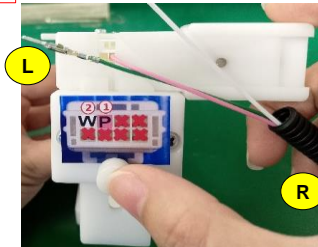
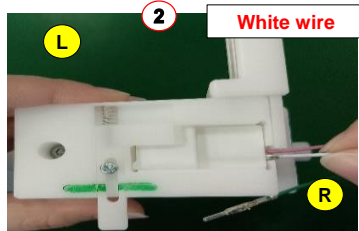
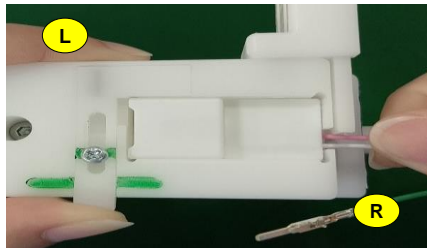
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to connector 7286-4097 (W)	<div><div><p>Visual reference</p></div><div><p>Terminal facing</p></div><div><p>1. Hold the insertion jig using left hand. Get the Pink wire and insert to connector using right hand. Conduct 2x push-pull after wire insertion.</p></div><div><p>2. Press the button using right thumb. Slot for White wire will be open.</p></div><div><p>3. Get the White wire and insert to connector using right hand. Conduct 2x push-pull after wire insertion.</p></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> <td>n/a</td> <td><p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform 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></td>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform 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>

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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	<div><div><p>Insertion Jig</p></div><div><p>Insertion Jig Orientation</p></div><div><p>Connector Orientation</p></div><div><p>1. Press the lock of insertion jig using left thumb.</p></div><div><p>2. Insert the connector 7286-4097 (W) into jig using right hand and release the lock.</p></div><div><p>3. Check the holes/terminal slot for G wire.</p></div></div>		n/a	<div><p>Connector Orientation Illustration</p><div><p>I-mark is align</p></div><div><p>2 Holes are widely open</p></div><div><p>I-mark is align</p></div><div><p>2 holes are partially open.</p></div></div> <p>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p>

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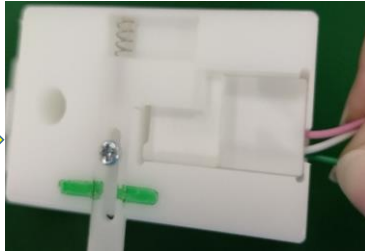
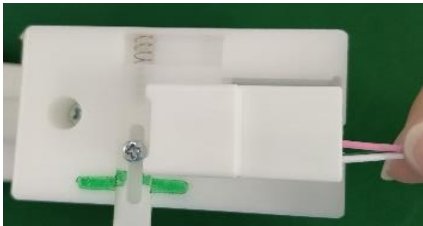
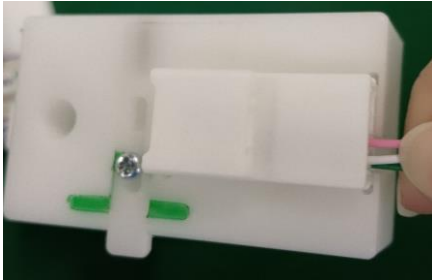
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PARTS:	1. Assy Parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1 Wire insertion to connector 7286-4097 (W)	<div><p>Visual reference</p><p>Terminal facing</p><p>1. Hold the insertion jig using left hand. Get the Pink wire and insert to connector using right hand. Conduct 2x push-pull after wire insertion.</p><p>3. 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	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform 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>

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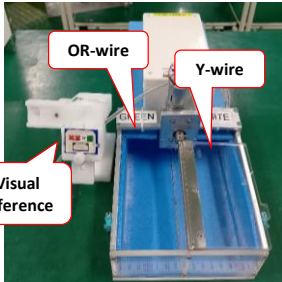
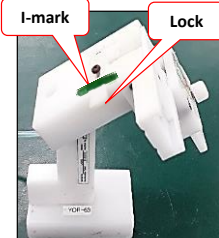
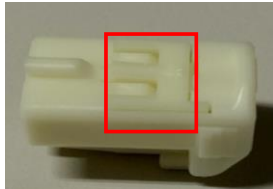
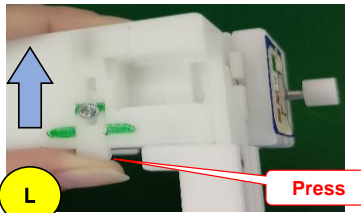
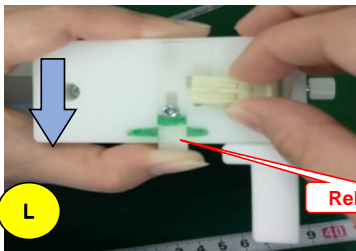
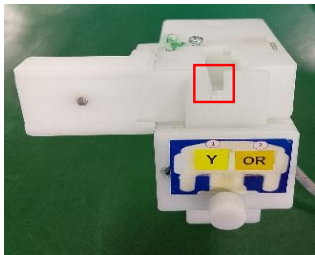
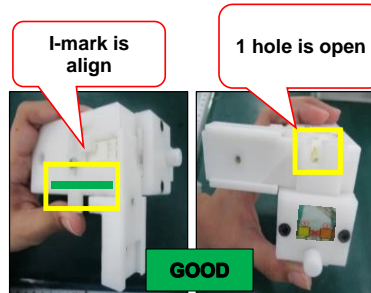
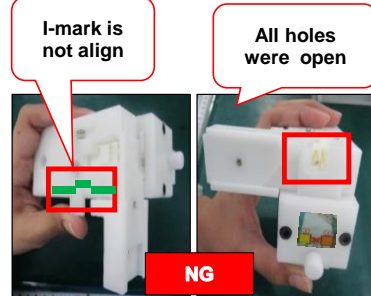
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PARTS:		1. Connector 7283-1027 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1 Connector setting to insertion jig Connector 7283-1027 (W)	<div><div>INSERTION JIG ILLUSTRATION</div><div><div>Visual reference</div></div><div><div>INSERTION JIG ORIENTATION</div></div><div><div>CONNECTOR ORIENTATION</div></div><div><div>1. Press the lock of insertion jig using left thumb.</div></div><div><div>2. Insert the connector 7283-1027 (W) into jig using right hand and release the lock. Note: Follow the connector orientation.</div></div><div><div>3. Push the guide using left hand. The slot for Y wire will be opened.</div></div></div>		n/a	<div><div>Connector Orientation Illustration</div><div><div>GOOD</div></div><div><div>NG</div></div><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></div>

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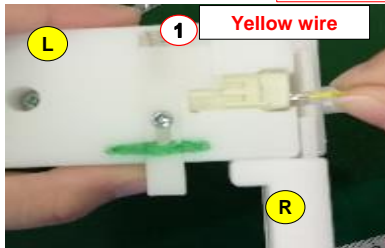
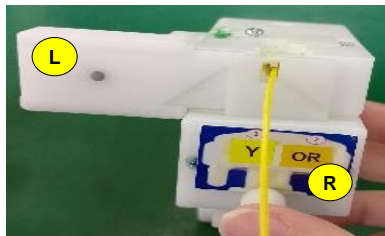
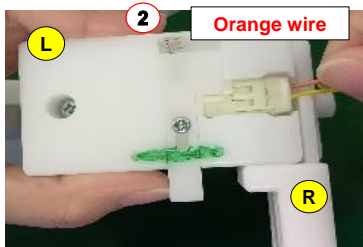
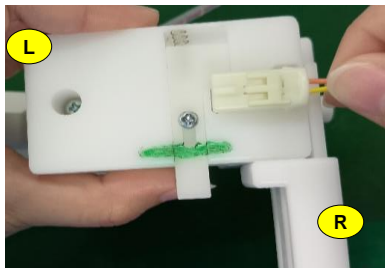
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PARTS:		1. Connector 7283-1027 (W) 2. Wire avssf 0.3 Y-OR L=582mm		JIG:	1. Insertion Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1 Wire insertion to Connector 7283-1027 (W)	<div><div><div>Visual reference</div></div><div><div>Terminal facing</div></div><div><div>1. Hold the insertion jig using left hand. Get the Pink wire and insert to connector using right hand. Conduct 2x push-pull after wire insertion.</div></div><div><div>2. Press the button using right thumb. Slot for White wire will be open.</div></div><div><div>3. Get the Orange wire and insert to connector using right hand. Conduct 2x push-pull after wire insertion.</div></div><div><div>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.</div></div></div> <td>n/a</td> <td><div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</div><div>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.</div><div>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</div></td>		n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</div> <div>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.</div> <div>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</div>

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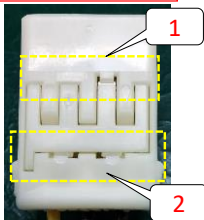
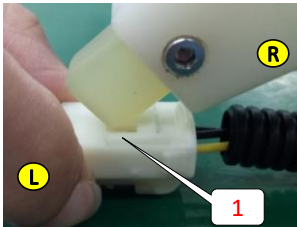
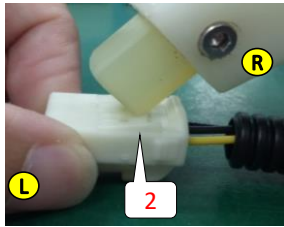
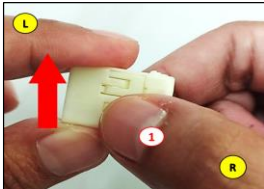
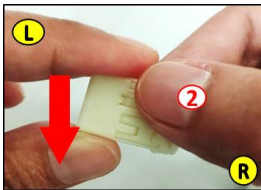
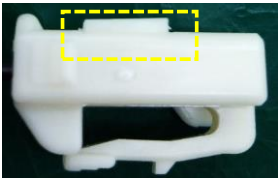
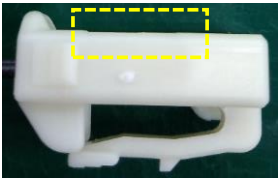
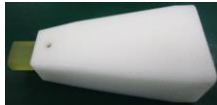


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PARTS:		1. Assy Parts		JIG:	1. Pushing Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1	Connector lock	<div><div>LOCKING SEQUENCE</div><div></div><div></div><div></div><div><p>1. Hold the connector using left hand and place on the table. Get the pushing jig using right hand and start the sequential locking based on above illustration. Push the lower part of the connector lock first and then push the upper part.</p></div><div></div><div></div><div><p>2. Ensure that connector is in locked condition by touching the connector lock based on the sequence illustrated.</p></div><div></div><div></div><div><p>BEFORE PRESSING</p></div><div><p>AFTER PRESSING</p></div></div>	<div>PUSHING JIG</div> <div></div>	<p>1. No unlocked/half-locked connector 2. No damage connector 3. Use provided jig tool per model to avoid damaged lock.</p> <p>Important reminders/Note/s:</p> <p>1. Manual locking may cause damaged connector lock.</p> <p>2. Position of pushing jig during locking must be slant.</p> <div>LOCKED CONDITION</div> <div></div> <div></div> <div>GOOD</div> <div>NG</div>

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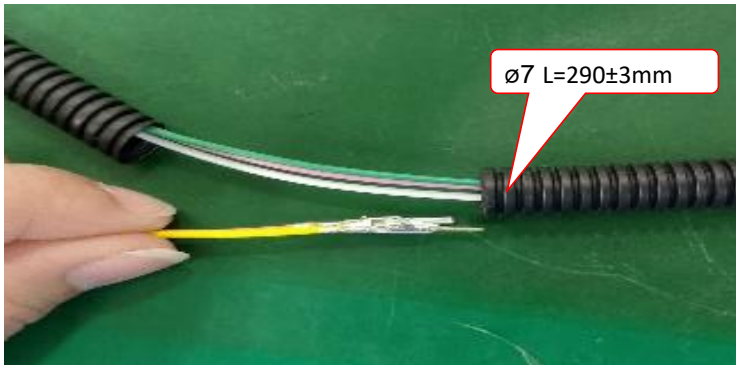
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PARTS:		1. Assy Parts 2. Black SV tube (vinyl) $\phi 5$ L= 248 \pm 3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	Wire Insertion to Black SV tube (vinyl) $\phi 5$ L= 248 \pm 3mm	 <div>1. Get the Y-OR wire using right hand then insert the Black SV tube (vinyl) $\phi 5$ L=248\pm3mm using right hand.</div>		n/a	1. No wrong use of parts 2. No deformed terminal
10	P1 Wire Insertion to Assy parts	 <div>$\phi 7$ L=290\pm3mm</div> <div>1. Hold the Black Corrugated tube $\phi 7$ L=290\pm3mm (no slit) using left hand then insert the Y-OR wire using right hand.</div>		n/a	1. No wrong use of parts 2. No deformed terminal 3. No wrong use of insertion

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

559D / 7N0238-7020B

Customer: TRJ

Car Model: TOYOTA HI-ACE

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

March 12, 2025

Validity Date:

n/a

Document No.:

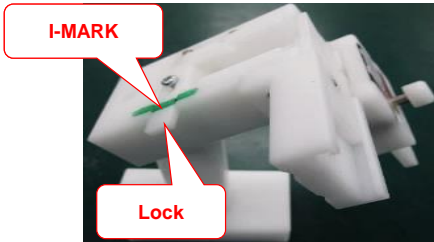
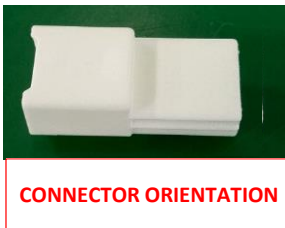

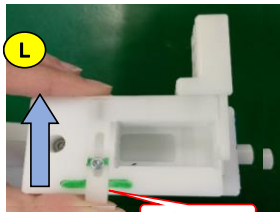
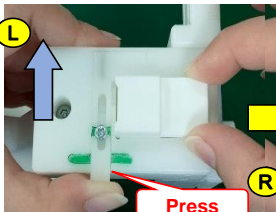
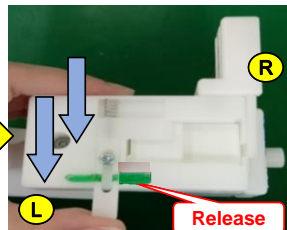
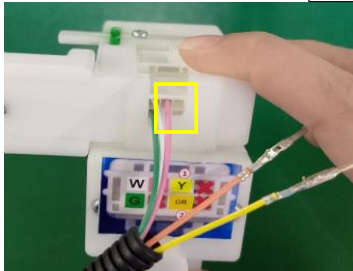

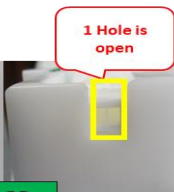


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PARTS:		1. Connector 7286-4097 (W)		JIG:	1. Insertion Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1	<div><div><div><p>I-MARK</p><p>Lock</p></div><div><p>CONNECTOR ORIENTATION</p></div><div><p>INSERTION JIG ORIENTATION</p></div><div><div><p>L</p><p>Press</p></div><div><p>L</p><p>Press</p><p>R</p></div><div><p>L</p><p>Release</p><p>R</p></div></div><div><p>1. Press the lock of insertion jig using left hand.</p><p>2. Get the connector using then Insert the connector 7286-4097 (W) using right hand into jig using and release the lock. <i>Note: Follow the connector orientation.</i></p><div><p>3. Push the guide using left hand. The slot for Y wire will be opened.</p></div></div></div></div>		n/a	<div><p>1. Use the provided jig per model</p><p>2. No wrong orientation of the connector.</p><p>3. No wrong use of connector</p><p>4. No damaged connector.</p></div> <div><p>Connector Orientation Illustration</p><div><div><p>I-mark is align</p></div><div><p>1 Hole is open</p></div><p>GOOD</p></div><div><div><p>I-mark is not align</p></div><div><p>1 Hole is open</p></div><p>NG</p></div></div>

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TAPING ASSEMBLY PROCESS

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559D / 7N0238-7020B

Customer: TRJ

Car Model: TOYOTA HI-ACE

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Purpose:



PROTOTYPE



PRE-LAUNCH




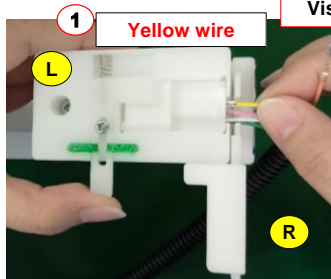
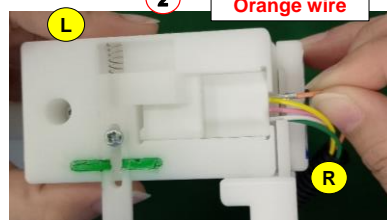

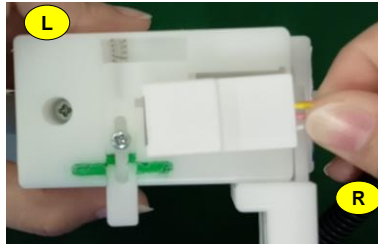
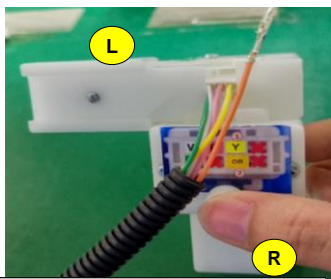
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PARTS:		1. Assy parts		JIG:	1. Insertion Jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
12	P1	Wire insertion to connector 7286-4097 (W)	<div><div><p>Visual reference</p></div><div><p>1 Yellow wire</p></div><div><p>2 Orange wire</p></div></div> <div><p>1. Hold the insertion jig using left hand. Get the Yellow wire and insert to connector using right hand. Conduct 2x push-pull after wire insertion.</p><p>2. Press the button using right thumb. Slot for OR wire will be open.</p><p>3. Get the Orange wire and insert to connector using right hand. Conduct 2x push-pull after wire insertion.</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> <div><p>Terminal facing</p></div>	n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</p> <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>

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

Process Name/Title:

Model code/Part number:

559D / 7N0238-7020BCustomer: **TRJ**Car Model: **TOYOTA HI-ACE**

Purpose:



PROTOTYPE



PRE-LAUNCH



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Effectivity Date:

March 12, 2025

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PARTS:		1. Wire Avssf 0.3 B-B L=595±3 2. Assy Parts		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
13	P1	<div><div></div><div><div></div><div><div></div><div>1. Get the terminal cover jig using right hand then insert the 2 Black wires.</div><div>2. Hold the Black Corrugated tube $\phi 7$ L=290±3mm using left hand then insert the B-B wires using right hand and continuation to Black Corrugated tube $\phi 7$ L=110±3mm (no slit).</div><div>3. After insertion, remove the terminal cover jig using right hand.</div></div><div><div>TERMINAL COVER JIG</div></div></div></div>			1. No wrong use of parts 2. No deformed terminal 3. No wrong use of insertion

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TAPING ASSEMBLY PROCESS

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PROTOTYPE



PRE-LAUNCH



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PARTS:

n/a

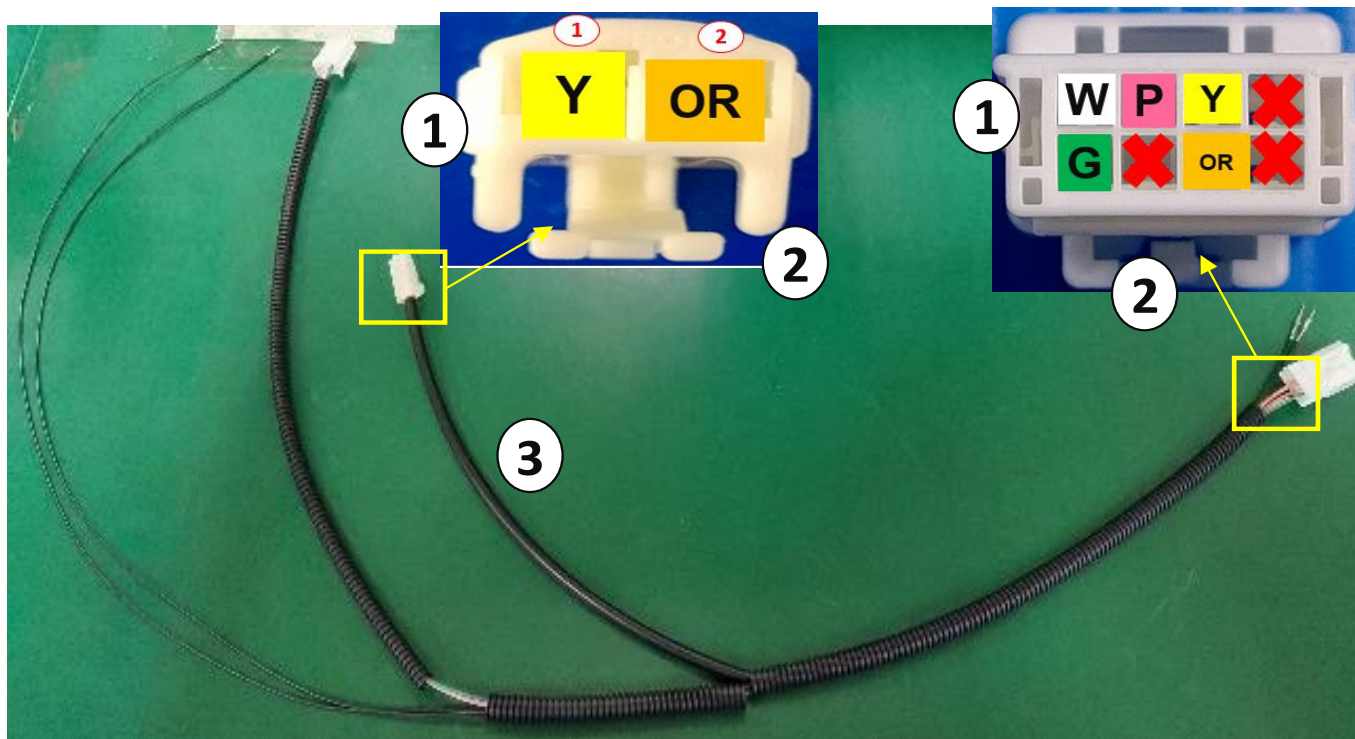
JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING - P1

7N0238-7020B



- 1 No Unlocked/
Half-locked connector
- 2 No Wrong Insert
- 3 No Missing SV tube
(vinyl)
- 4 No Deformed terminal
- 5 No Terminal backing
out

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