

	<b>WORK INSTRUCTION</b>					Effectivity Date:		November 11, 2023	
	<b>TAPING ASSEMBLY PROCESS</b>					Validity Date:		n/a	
	Process Name/Title:			Model code/Part number: <b>310D/ 7N0191-7020</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-RAV 4</b>	Document No.: <b>WI-ENG-PDE-750</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO					Revision No.:		0	Page No.: 1 of 7

<b>PARTS:</b>	1. Connector 6098-3871 (L) 2. IRRAX A ROPE-LAY 0.3 B-B wires L=223±2mm [2pcs.]					JIG:	n/a	
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1  Wire Insertion to connector 6098-3871 (L)	<div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;"> <p><b>CONNECTOR ORIENTATION</b></p> <p><b>VISUAL REFERENCE</b></p> </div> <div style="text-align: center;"> <p><b>WIRE FACING</b></p> </div> </div> <div style="display: flex; justify-content: space-around; align-items: center; margin-top: 20px;"> </div> <div style="display: flex; justify-content: space-between; margin-top: 10px;"> <div style="width: 45%;"> <p>1. Hold the connector <b>6098-3871 (L)</b> then get the 1st Black wire and insert to terminal <b>slot 1</b> using right hand. Conduct <b>2x</b> push-pull after wire insertion.  <b>Note: Insertion of wire must be from left to right.</b></p> </div> <div style="width: 45%;"> <p>2. Get the <b>2nd Black wire</b> and insert to terminal <b>slot 2</b> using right hand. Conduct <b>2x</b> push-pull after wire insertion.</p> </div> </div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <p><b>Safety Instruction</b></p> <p>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <p><b>Housekeeping</b></p> <p>1. Maintain and always practice 5's.            2. Personal things on the workplace is prohibited. Keep it in your locker.</p> </div> <div style="border: 1px dashed red; padding: 5px;"> <p><b>Alert level</b></p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>	<p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length Tolerance</p> <p><b>Important reminders/note/s:</b></p> <p>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.            Do not exert extra force.</p> <p>1. No loose insertion            2. No wrong insertion            3. One by one insertion            4. No deform terminal            5. No wrong wire facing</p>

Revision History								Prepared by	Reviewed by	Approved by	Noted by
11/11/23	0	Initial issue.	D.Castillo	J.Loterte	C.Villanueva	A. Arañes	 D. Castillo	 J. Loterte	 C. Villanueva	 A. Arañes	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	November 11, 2023			

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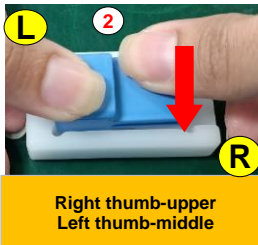

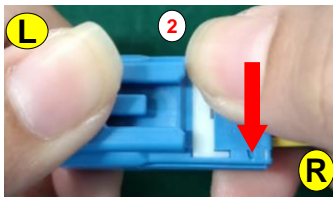
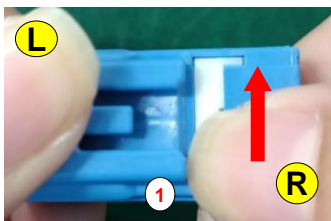

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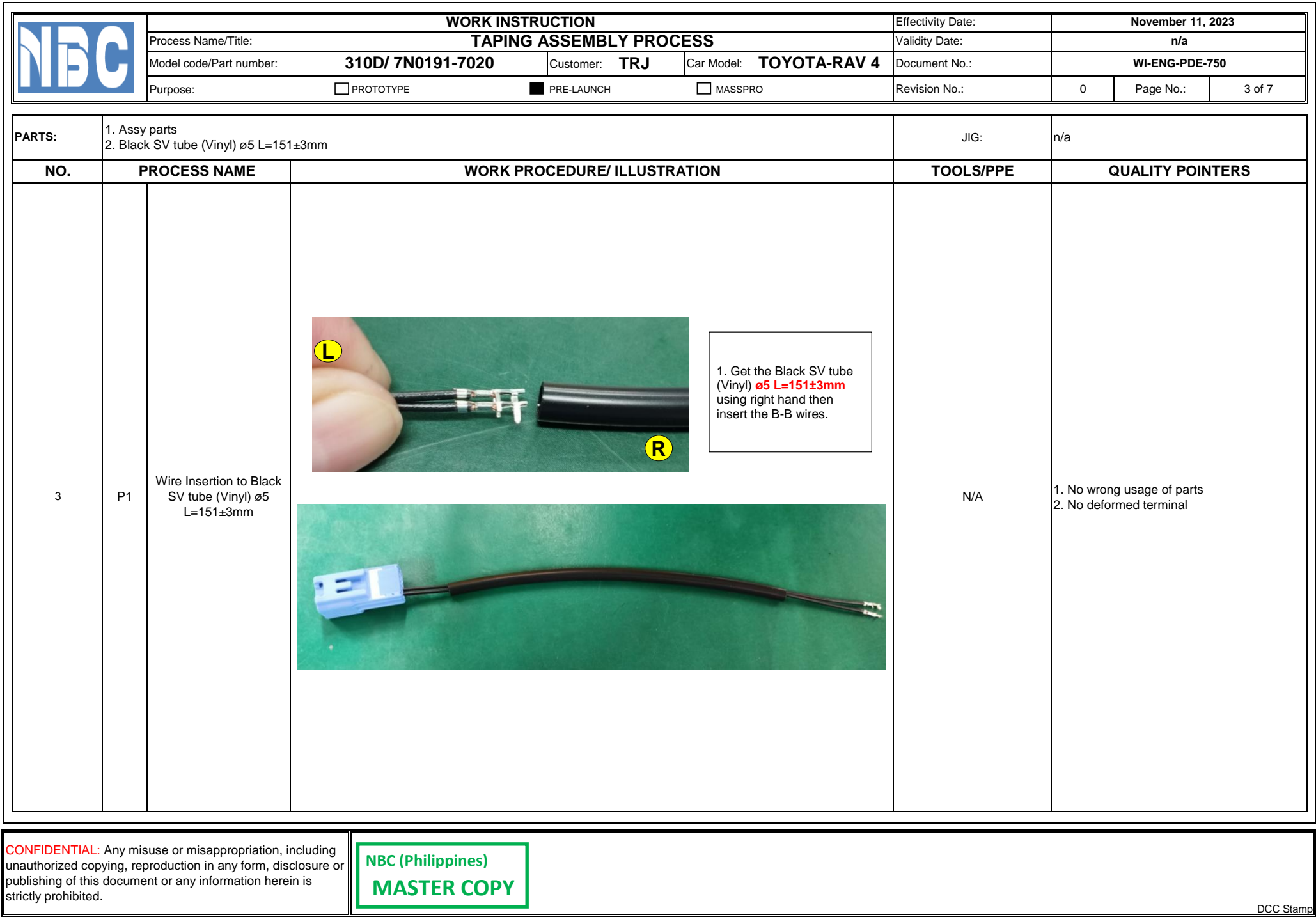
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<b>PARTS:</b>	1. Assy parts			JIG:	1. Locking jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	P1	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div> <div><p>Right thumb-Lower Left thumb-middle</p><p>Right thumb-upper Left thumb-middle</p><p>Right thumb-middle Left thumb-middle</p><p>3. Press the lower parts of connector using right hand while left hand holding the middle.</p><p>4. Press the upper part of connector using right hand while left hand holding the middle.</p><p>5. Lift then press the connector in the middle using left and right hand.</p></div> <div><p>6. Ensure that connector is in locked condition by touching the connector lock based on the sequence illustrated.</p></div>		<div><b>LOCKING JIG</b></div> 	<p>1. No Unlock and half-locked 2. Use provided jig tools per model to avoid damaged lock.</p> <p><b>Important reminders/Note/s:</b> <b>1. Manual locking may cause damaged connector</b></p>

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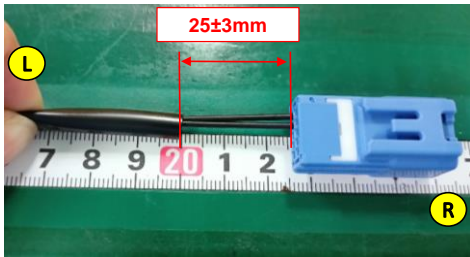
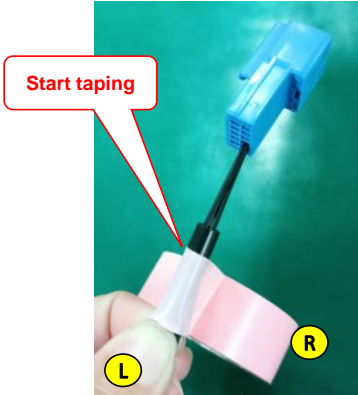
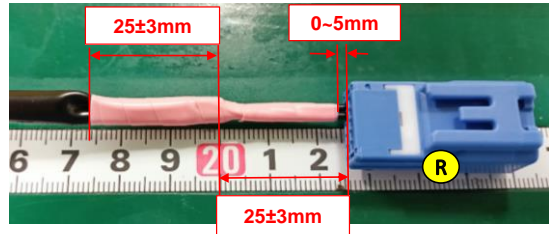
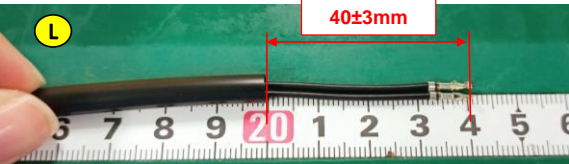

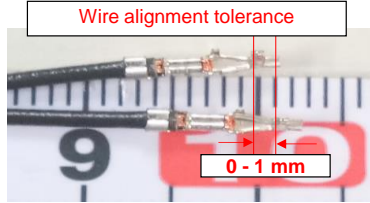
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PARTS:		1. Assy parts 2. Pink tape [1pc]	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1 Taping 1 SV tube (Vinyl) to wire near Connector	 <p>1. Hold the Black vinyl tube using left hand and measure from end of vinyl tube up to connector <b>25±3mm</b>.</p>  <p>2. Get the <b>Pink tape</b> using right hand then start taping process using both hands.</p>  <p>3. After taping, check the measurement, taping condition and wire alignment.</p> 	<p><b>MEASURING TAPE</b></p> 	<p>1. No flip-out tape 2.No peel-off tape 3. No loose tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape</p> <p><b>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></p> 

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**PARTS:**

1. Assy parts
2. Engineering sample

JIG:

n/a

**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

5

P1

Visual inspection

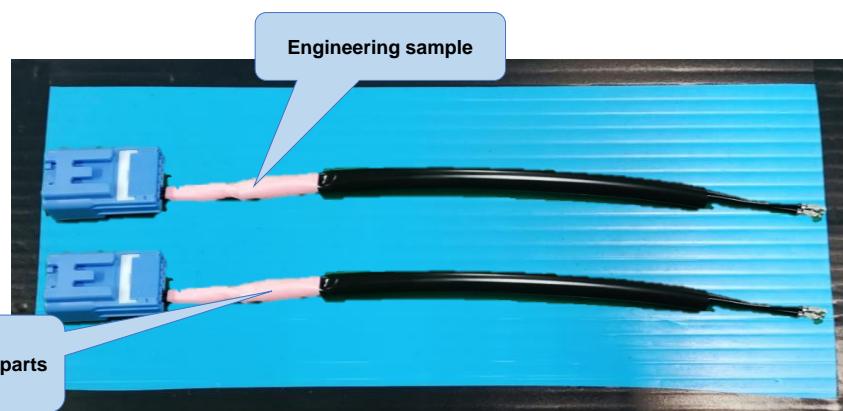
1. Check the connector lock.

2. Check the color of tape and taping condition.

3. Check the terminal appearance. Make sure no deformed terminal.

**Actual Product**

4. Compare to Engineering Sample by Tapping.

**ENGINEERING SAMPLE**

1. No skip checking during inspection

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<b>PARTS:</b>		1. Assy parts		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
6	P1	Measurement	 		<b>Important reminders and note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b>  <b>2. For Hatsumono, Nakamono and Owarimono.</b>  <b>Document reference/s:</b> <b>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</b>  1. No wrong dimension

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PARTS:

1. Assy parts

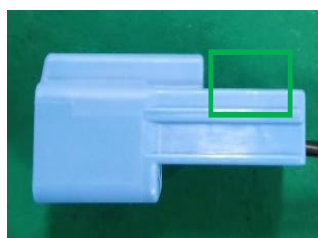
JIG:

N/A

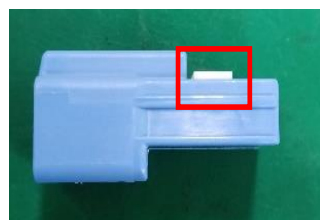
### QUALITY CHECKPOINTS

P1

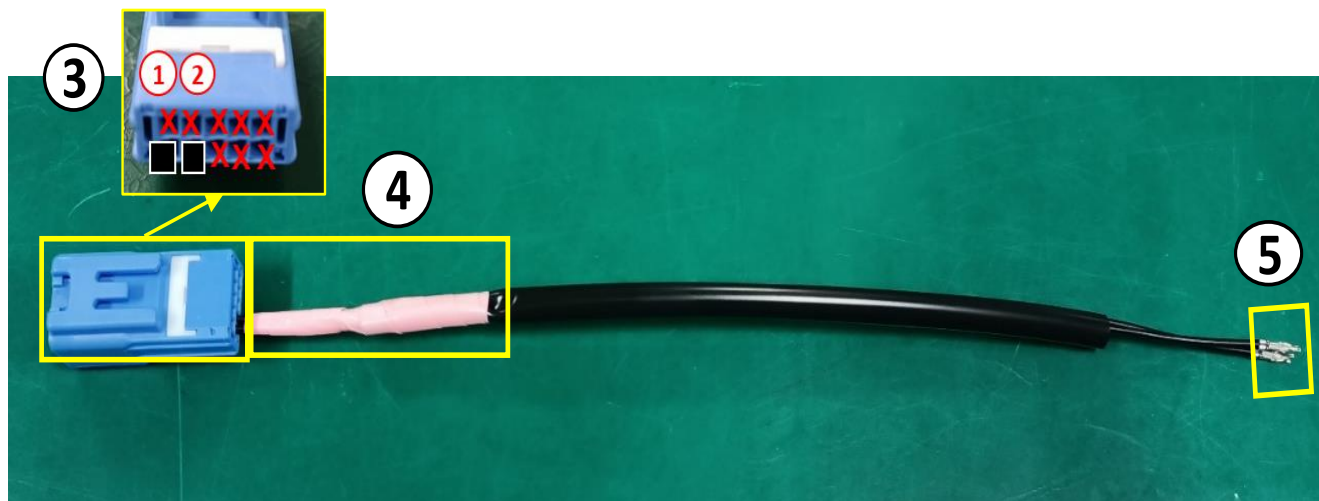
7N0191-7020



GOOD



NO GOOD



① No Unlocked/ Half Locked Connector

② No Terminal Backing Out

③ No wrong insert

④ No Missing Tape/ No wrong color of tape

⑤ No Deformed Terminal



GOOD



NO GOOD

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