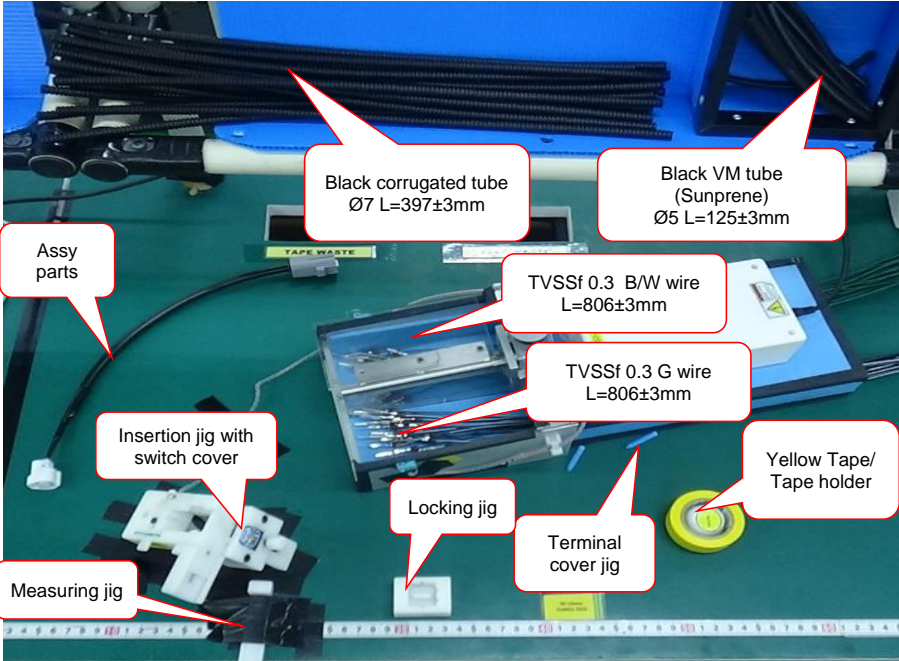

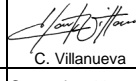
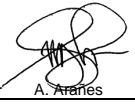
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	Process Name/Title: TAPING ASSEMBLY PROCESS						Validity Date:		n/a	
	Model code/Part number: 320B / 7L0053-7025A			Customer: TRQSS		Car Model: TOYOTA-RAV4		Document No.: WI-ENG-PDE-1035B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						Revision No.:		1	Page No.: 1 of 6


PARTS:		1. Assy parts; Black corrugated tube Ø7 L=397±3mm; Black VM tube (Sunprene) Ø5 L=125±3mm; TVSSf 0.3 G wire L=806±3mm; TVSSf 0.3 B/W wire L=806±3mm; Yellow tape				JIG:		1. Insertion jig with switch cover 2. Locking jig 3. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	P2	<div>TABLE LAY-OUT</div> 				<div><b>Safety Instruction</b> Be sure to wear prescribed 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>		<div><b>Document references:</b> 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>	

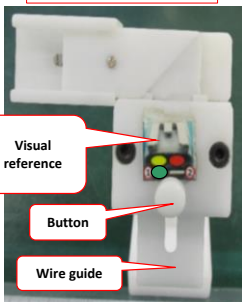
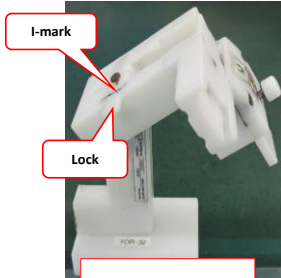


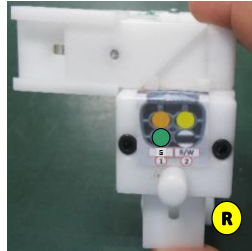
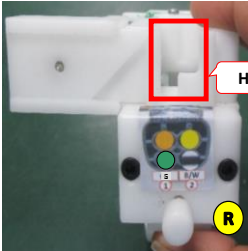
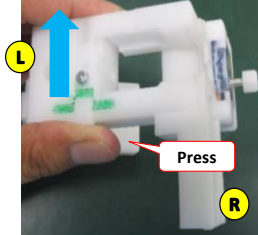
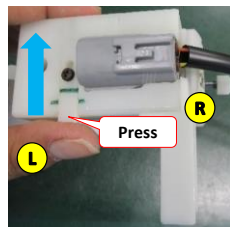
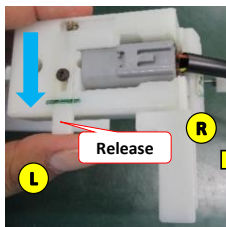
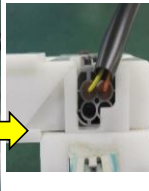
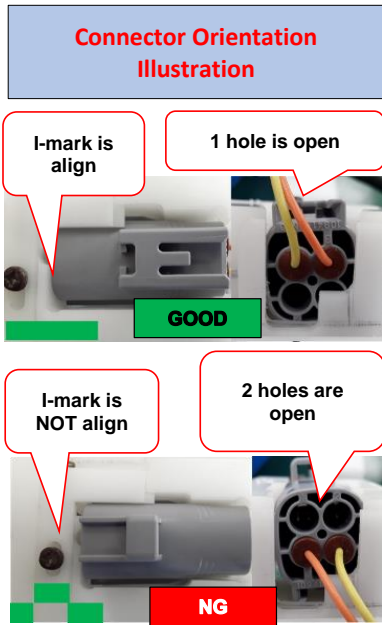
Revision History						Prepared by	Reviewed by	Approved by	Noted by				
						 D. Castillo	 C. Villanueva	 A. Arañes	n/a				
09/12/24	1	Change from Pre-launch to Masspro.								D. Castillo	C. Villanueva	A. Arañes	n/a
09/11/24	0	Initial issue.								D. Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change								Revised	Reviewed	Approved	Noted

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		<b>WORK INSTRUCTION</b>				Effectivity Date:		September 12, 2024	
Process Name/Title:		<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
Model code/Part number:		<b>320B / 7L0053-7025A</b>		Customer: <b>TRQSS</b>		Car Model: <b>TOYOTA-RAV4</b>		Document No.: <b>WI-ENG-PDE-1035B</b>	
Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.: 1      Page No.:      2 of 6	

<b>PARTS:</b>		1. Connector 6188-0066 (GR)				<b>JIG:</b>		1. Insertion jig with switch cover	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>				<b>TOOLS/PPE</b>		<b>QUALITY POINTERS</b>	
2	P2 Connector setting to insertion jig 6188-0066 (GR)	<div><div><div></div><div></div><div></div></div><div></div><div></div><div></div><div></div></div> <div><div></div><div></div><div></div></div> <div><p>1. Push the lower wire guide upward using right thumb. Slot for <b>Green wire</b> will be opened.</p><p>2. Press the lock using left thumb.</p><p>3. Flip the assy parts upward to make way for insertion using left hand. Push the wire guide upward using right hand. Slot for <b>Green wire</b> will be opened.</p></div>				n/a		<div><div><div></div></div><div><p>1. Use provided jig per model</p><p>2. No wrong usage of parts</p><p>3. No wrong orientation of connector</p><p>4. No damaged connector</p></div></div>	

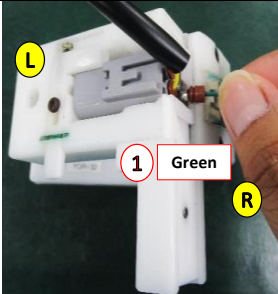
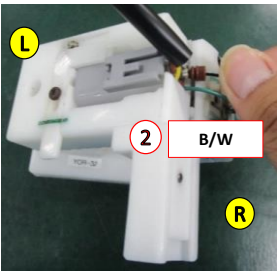

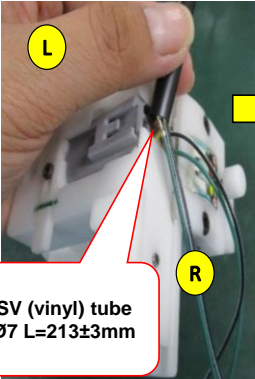
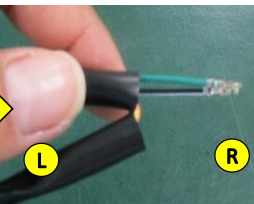
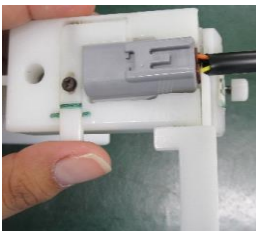
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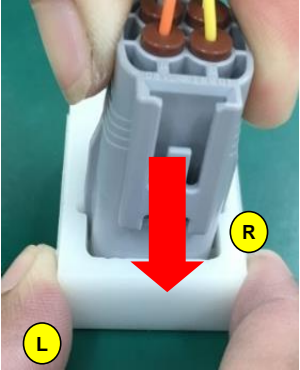
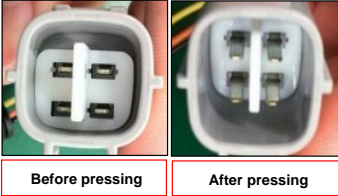



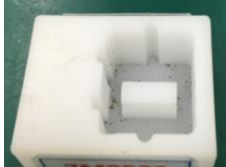
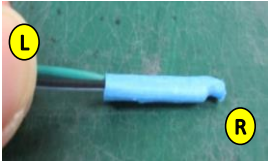

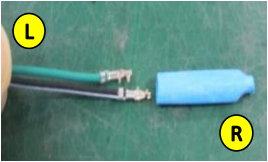

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	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date: <b>n/a</b>	
	Model code/Part number: <b>320B / 7L0053-7025A</b>		Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA-RAV4</b>	Document No.: <b>WI-ENG-PDE-1035B</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: <b>1</b>		Page No.: <b>3 of 6</b>	

<b>PARTS:</b>		1. Assy parts 2. TVSSf 0.3 B/W wire L=806±3mm 3. TVSSf 0.3 G wire L=806±3mm		JIG:	1. Insertion jig with switch cover
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
3	Wire insertion to connector 6188-0066 (GR)	<div>   </div> <div>  <div> <b>TERMINAL FACING</b> </div> </div> <div> <p>1 Hold the <b>Green wire</b> then insert to terminal slot <b>1</b> using right hand.</p> <p>3. Hold the <b>B/W wire</b> then insert to terminal slot <b>2</b> using right hand.</p> <p>2. Press the button using right thumb. The slot for <b>B/W wire</b> will be opened.</p> </div> <td>         n/a       </td> <td>         1. No loose insertion          2. No wrong insertion          3. One by one insertion          4. No deformed terminal          5. No wrong wire facing   <b>Document references:</b>          1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance          2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.   <b>Important reminders/Note/s:</b>          1. Make sure wires are properly inserted.          Conduct Pull-Push-Pull-Push after insertion.          Do not exert extra force.       </td>		n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing  <b>Document references:</b> 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.  <b>Important reminders/Note/s:</b> 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
4	Wire insertion to SV tube (Vinyl) (Ø7 L=213±3mm) with assy parts	<div>   </div> <div>  </div> <div> <p>SV (vinyl) tube Ø7 L=213±3mm</p> <p>1. Hold the assy parts upward using left hand. Insert the <b>Green and Black/White wires</b> to SV (vinyl) tube using right hand.</p> <p>2. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</p> </div> <td>         n/a       </td> <td>         1. No wrong insertion          2. No deformed terminal       </td>		n/a	1. No wrong insertion 2. No deformed terminal

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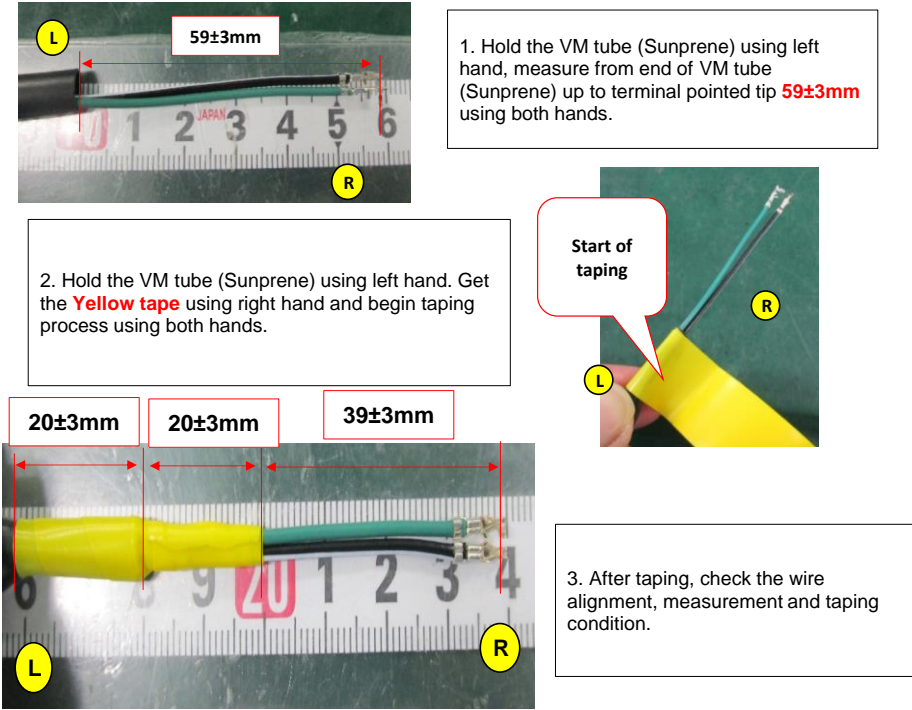

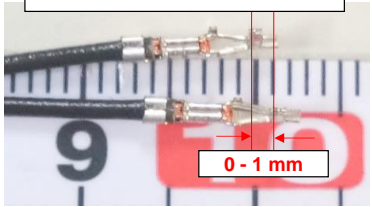
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	Model code/Part number: <b>320B / 7L0053-7025A</b>		Customer: <b>TRQSS</b>		Car Model: <b>TOYOTA-RAV4</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.: <b>WI-ENG-PDE-1035B</b>		Revision No.: <b>1</b>		
<b>PARTS:</b>		1. Assy parts 2. Black Corrugated tube Ø5 L=397±3mm (no slit)				JIG: 1. Clamp assembly jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>				<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
5	Connector Lock	<div>   <div> <b>Connector Cross Sectional View</b> <div> <div> <b>NG</b>  Unlock Condition </div> <div> <b>NG</b>  Half Lock Condition </div> <div> <b>GOOD</b>  Full Lock Condition </div> </div> </div> </div>				<b>LOCKING JIG</b> 	<b>Important reminders/Note/s:</b> <b>1. Manual locking may cause damaged lock.</b>  1. Use the provided locking jig per model 2. No unlock/half-locked connector 3. No damaged lock
6	Wire Insertion to Black Corrugated tube Ø5 L=397±3mm (no slit)	<div>    </div> <div>         1. Hold the wires using left hand, get the terminal cover jig using right hand then insert the <b>G-B/W wires</b> using left hand.           2. Get the corrugated tube (<b>no slit</b>) Ø5 L=397±3mm using right hand then insert the <b>G-B/W wires</b> using left hand.           3. After insertion, remove the terminal cover jig using right hand.       </div>				<b>TERMINAL COVER JIG</b> 	1. No wrong use of parts. 2. No deformed terminal

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	Model code/Part number: <b>320B / 7L0053-7025A</b>		Customer: <b>TRQSS</b>		Car Model: <b>TOYOTA-RAV4</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.: <b>WI-ENG-PDE-1035B</b>		Revision No.: <b>1</b>		
<b>PARTS:</b>		1. Assy parts 2. Black VM tube (Sunprene) Ø5 L=125±3mm 3. Yellow tape				JIG: 1. Clamp assembly jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>				<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
7	Wire insertion to Black VM tube (Sunprene) Ø5 L=125±3mm	 <div> <p>1. Get the <b>Black VM tube (Sunprene) Ø5 L=125±3mm</b> using right hand then insert the <b>G-B/W wires</b> using left hand.</p> </div>				n/a	1. No wrong use of parts 2. No damaged terminal
8	P2 Taping 2 Black VM tube (Sunprene) to wire near terminal	 <div> <p>1. Hold the VM tube (Sunprene) using left hand, measure from end of VM tube (Sunprene) up to terminal pointed tip <b>59±3mm</b> using both hands.</p> <p>2. Hold the VM tube (Sunprene) using left hand. Get the <b>Yellow tape</b> using right hand and begin taping process using both hands.</p> <p>3. After taping, check the wire alignment, measurement and taping condition.</p> </div>					 <p>Wire alignment tolerance</p> <p>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 dimension          6. No wrong use of tape</p> <p><b>Important reminder/Note/s:</b>          1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p><b>Document references:</b>          1. Please refer to WI-PRO-ASY-001 for taping procedure.</p>

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

September 12, 2024

Validity Date:

n/a

Model code/Part number:

320B / 7L0053-7025A

Customer:

TRQSS

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-1035B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

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### PARTS:

1. Assy parts

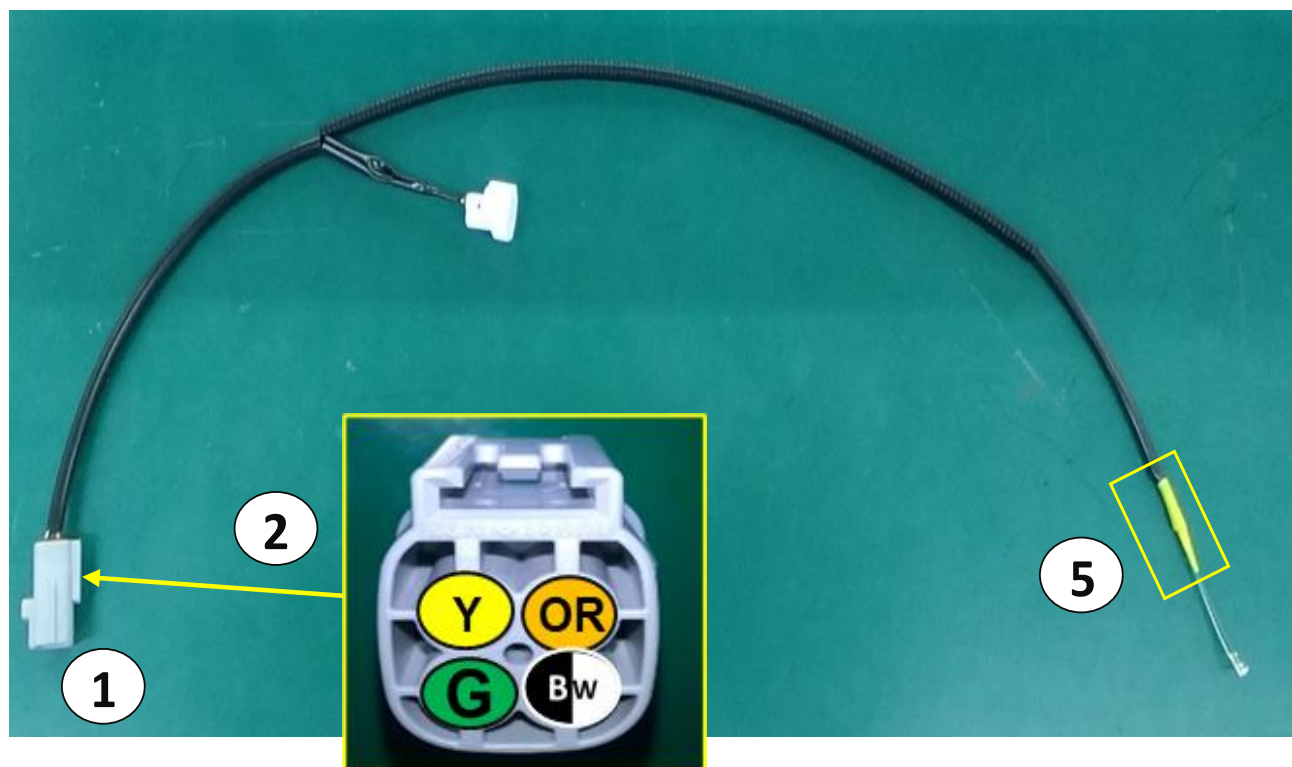
JIG:

n/a

### VISUAL INSPECTION/ QUALITY CHECKPOINTS

## TAPING - P2

## 7L0053-7025A



- 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  
(YELLOW tape)

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