



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 15, 2024

Model code/Part number:

380D / 7L0140-7020A

Customer:

TRQSS

Car Model:

TOYOTA-CAMRY

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-1094B

Revision No.:

1

Page No.:

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PARTS:

1. Connector 6189-1142 (W) 2. Black Corrugated tube $\varnothing 7$ L=497 \pm 3mm 3. Assy part 4. Black Tape

JIG:

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

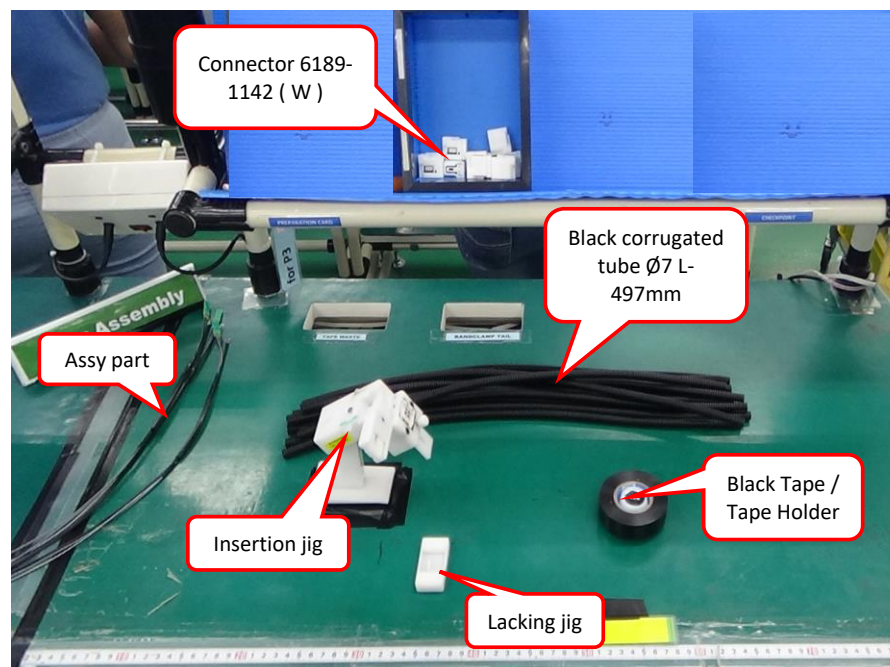
QUALITY POINTERS

1

P2

Table Lay-out

TABLE LAY-OUT



Safety Instruction

Be sure to wear required 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.

Document reference/s:

1. Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.

Revision History

							Prepared by	Reviewed by	Approved by	Noted by
10/15/24	1	Change from Pre-launch to Masspro.	A. Hernandez	C. Villanueva	A. Arañes	n/a				
10/14/24	0	Initial Issue.	A. Hernandez	C. Villanueva	A. Arañes	n/a				n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 14, 2024		

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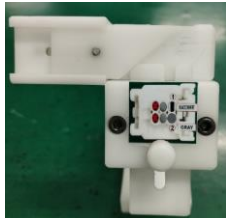
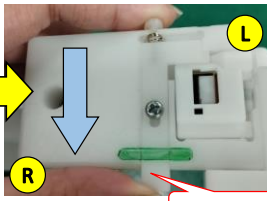
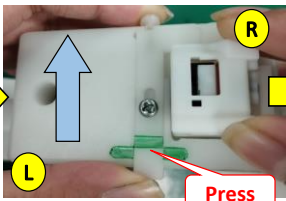
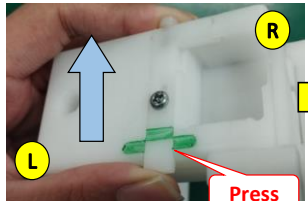
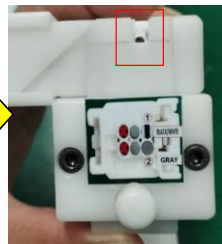

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PARTS:		1. Connector 6189-1142(W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Connector setting to insertion jig 6189-1142 (W)	<div><div><div>CONNECTOR ORIENTATION</div></div><div><div>INSERTION JIG ORIENTATION</div><div><div>Press</div><div>Press</div><div>Release</div></div><div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6189-1142 (W) into jig using right hand and release the lock.</div></div><div><div><div>3. Press the guide using left thumb. The slot for B/W wire will be opened.</div></div></div></div><div>n/a</div><td><div>1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. 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.</div></td></div>		<div>1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. 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.</div>	

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PARTS:		1. Assy part 2. Black Corrugated tube $\varnothing 7$ L=497 \pm 3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	<div></div> <div>1. Get the (B-B wires L-684mm , GR and BW L-692mm)(Assy part) using right hand then insert to Black Corrugated tube (No slit) $\varnothing 7$ L=497\pm3mm using both hands.</div>		n/a	1. No wrong use of parts 2. No deformed terminal

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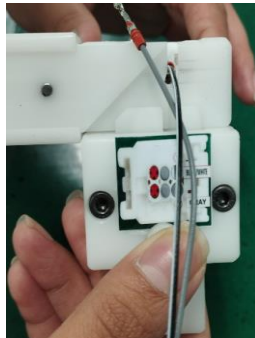


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PARTS:		1. Assy parts 2. Connector 6189-1142(W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2 Wire Insertion to Connector 6189-1142 (W)	<div><div><p>1. Hold the insertion jig using left hand. Get the B/W wire and insert to connector using right hand. Note : Conduct Pull-Push-Pull-Push after insertion.</p></div><div><p>2. Press the button using right thumb. The slot for Gray wire will be opened.</p></div><div><p>3. Get the Gray wire and insert to connector using right hand. Note : Conduct Pull-Push-Pull-Push after 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 wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. 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: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p></td>		n/a	<p>1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. 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: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>

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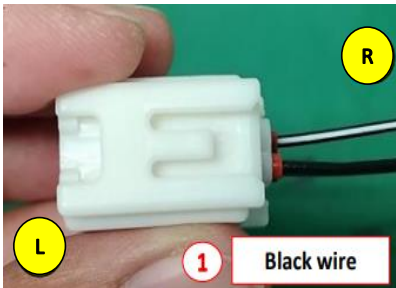
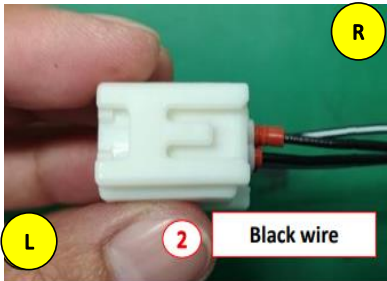
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PARTS:		1. Assy parts 2. Connector 6189-1142(W)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2	<div><div>CONNECTOR ORIENTATION</div><div>1. Hold the connector 6189-1142 (W) then get the B-wire and insert to terminal slot 1 using right hand. Conduct 2x push-pull after wire insertion.</div><div>2. Get the Gray wire and insert to terminal slot 2 using right hand. Conduct 2x push-pull after wire insertion.</div></div>		n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>Important reminders/Note/s:</div> <div>1. Please hold the wire near terminal during insertion. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 3. Insertion must be from left to right.</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance. 2. Please refer to GL-PRO-ASY-029 for Pull-Push procedure</div>

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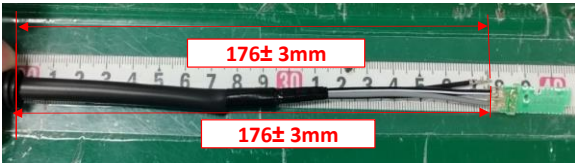
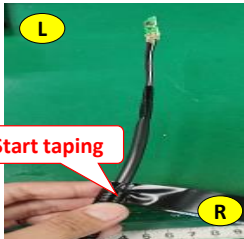


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PARTS:		1. Assy parts 2. Black tape		JIG:	1. Lacking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	Connector Lock	<div></div> <div>BEFORE PRESSING </div> <div>AFTER PRESSING </div> <div>1. Put the connector into locking jig using right hand and then press 2x using both hands. Check the connector lock if properly locked.</div>		<div>LOCKING JIG</div> 	<ol style="list-style-type: none">1. Use the provided jig tool per model2. No unlock/half-locked connector3. No damaged lock <p>Important reminders/Note/s:</p> <p>1. Manual locking may cause damaged connector lock.</p>
7	Taping 2 Black Corrugated tube to Black VM tube (Sunprene)	<div></div> <div></div> <div>Start taping</div> <div>2. Hold the corrugated tube using left hand. Get the Black tape using right hand and start taping process using both hands.</div> <div></div> <div>3. After taping, check the measurement and taping condition. Note : Taping must be tape width 25±3mm.</div>		<div>MEASURING TAPE</div> 	<ol style="list-style-type: none">1. No peel-off tape2. No flip out tape3. No loose tape4. No wrong use of tape5. No wrong dimension6. No missing tape <p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p>

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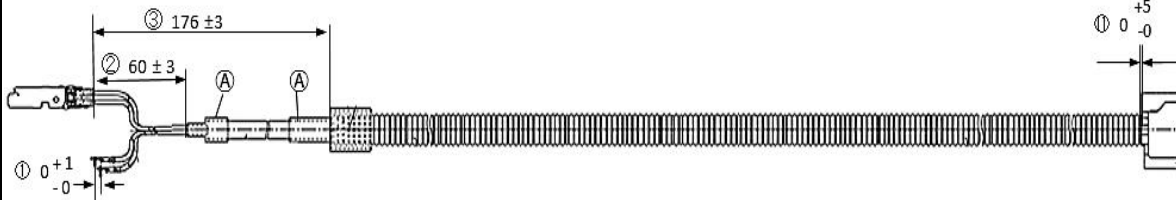

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PARTS:		1. Assy parts 2. Black tape		JIG:	1. Lacking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P2	Measurement		<div>MEASURING TAPE</div> 	<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>

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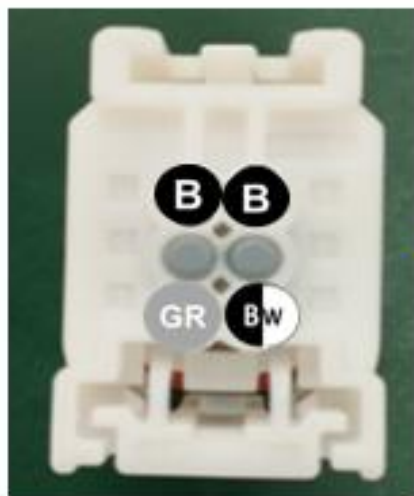
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PARTS:

1. Assy part

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**TAPING - P2****7L0140-7020B****① No Unlocked/Halflocked Connector****② No Wrong Insert****③ No Missing Tape (Black Tape)**

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