



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:

March 7, 2025

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

559D / 7N0237-7020B

Customer:

TRJ

Car Model: TOYOTA HI-ACE

Document No.:

WI-ENG-PDE-1064A

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

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PARTS:

1. Assy parts; Connector 6098-3802 (W); AVSSf 0.3 B-B wires L=977±3mm; Clip type clamp 82711-1E360 (W); Brown tape

JIG:

1. Insertion jig
2. Locking jig

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

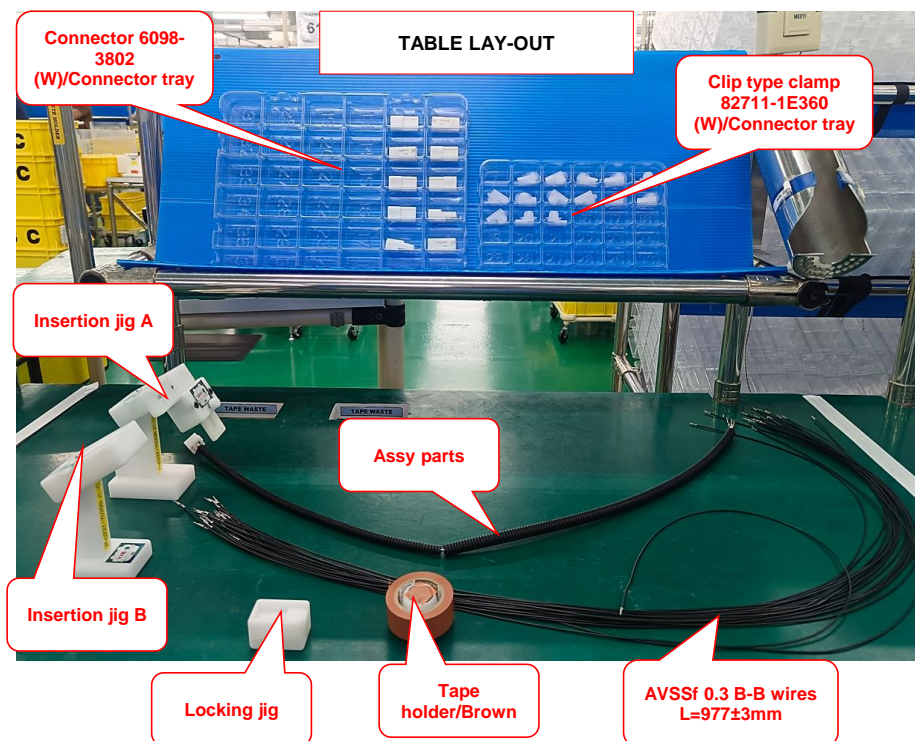
TOOLS/PPE

QUALITY POINTERS

1

P1

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 wrong use of connector
2. No damaged connector
3. No wrong insert
4. One by one insertion
5. No deformed terminal
6. No wrong terminal Orientation

Important reminders/Note/s:

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

Document references:

1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.
2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved	Prepared by	Checked by	Reviewed by	Approved by
03/07/25	1	Change from Pre-launch to Masspro. Additional table lay-out; Update the Work/Procedure Illustration.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
01/13/25	0	Initial issue. Change wire length from P,W,G wires L=830±3mm to P,W,G wires L=810±3mm; Change COT length from Ø5, L=349±3mm to Ø5, L=329±3mm; Additional spot taping (Black tape and Brown tape 20mm)	M. Ariola	C. Villanueva	A. Arañes	n/a				

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PARTS: 1. Connector 6098-3802 (W)

JIG:

1. Insertion jig

NO.

PROCESS NAME

1

WORK PROCEDURE/ ILLUSTRATION

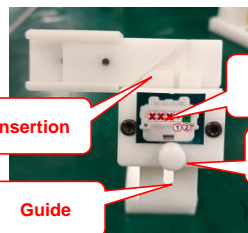
TOOLS/PPE

QUALITY POINTERS

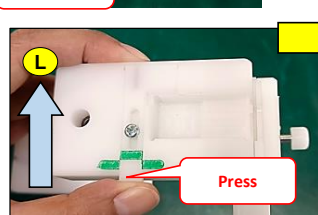
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P1

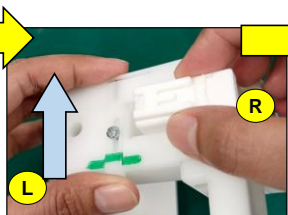
Connector setting to
insertion jig 6098-3802
(W)



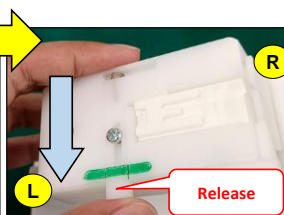
CONNECTOR
ORIENTATION



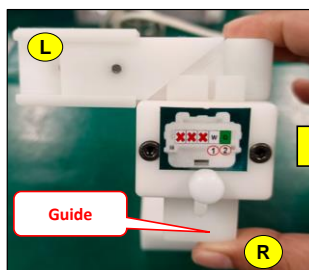
1. Press the lock of insertion jig
using left thumb.



2. Insert the connector 6098-3802 (W) into jig
using right hand and release the lock.

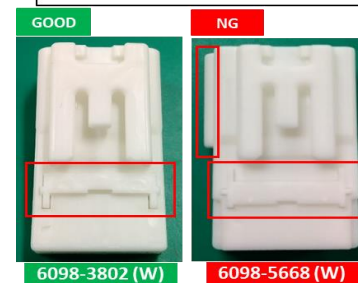


3. Push the guide using
right hand. the slot for
White wire will be
opened.



1. Use provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No damaged connector.

CONNECTOR ILLUSTRATION



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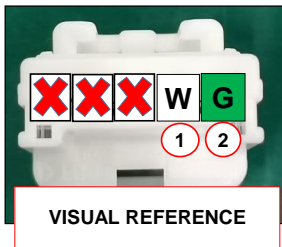



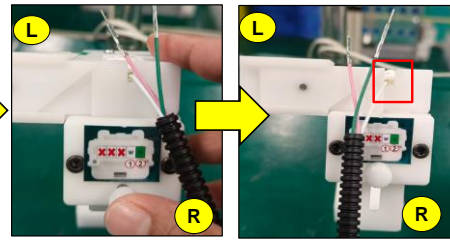
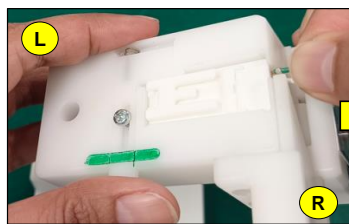
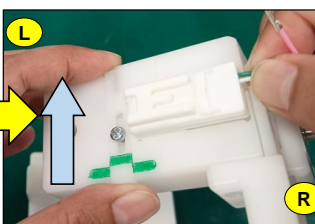
☒ MASSPRO

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PARTS:		1. Connector 6098-3802 (W) 2. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to connector 6098-3802 (W)	<div><div><p>VISUAL REFERENCE</p></div><div><p>CONNECTOR ORIENTATION</p></div><div><p>TERMINAL ORIENTATION</p></div><div><div><p>1. Get the White wire then insert to terminal slot ① using right hand.</p></div><div><p>2. After insertion of White wire press the button using right hand. Slot for Green wire will be opened.</p></div><div><div><p>3. Get the Black wire then insert to terminal slot ② using right hand.</p></div><div><p>4. After insertion, press the lock using left hand thumb then hold the wires and gently pull-out the connector from jig using right hand.</p></div></div></div><div>n/a</div><div><p>1. No wrong use of connector 2. No damaged connector 3. No wrong insert 4. One by one insertion 5. No deformed terminal 6. No wrong terminal Orientation</p><p>Important reminders/Note/s:</p><p>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p><p>2. Please hold the wire near terminal during insertion.</p><p>Document references:</p><p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p></div></div>			

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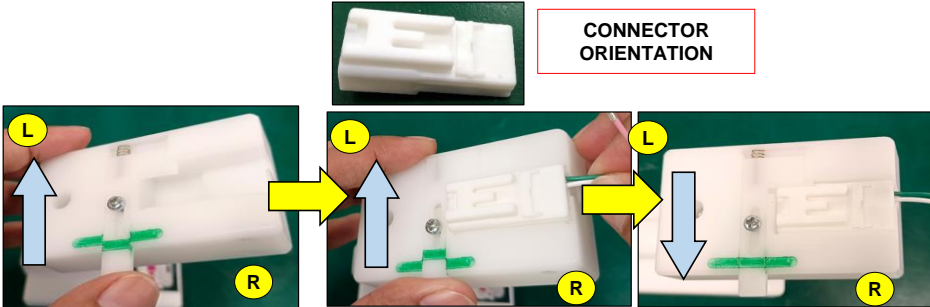
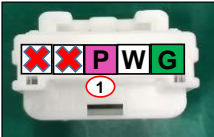
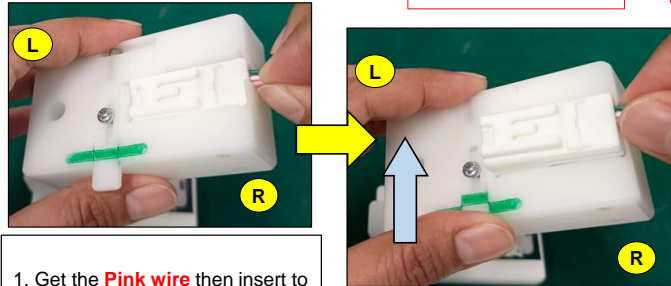
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PARTS:		1. Assy parts 2. Connector 6098-3802 (W) with Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Connector setting to insertion jig 6098-3802 (W)	<div><div>CONNECTOR ORIENTATION</div></div> <div>1. Press the lock of insertion jig using left thumb.</div> <div>2. Get the connector 6098-3802 (W) with assy parts and insert into jig using right hand and release the lock using left hand.</div>		n/a	1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector.
5	P1 Wire insertion to Connector 6098-3802 (W)	<div><div>VISUAL REFERENCE</div><div>CONNECTOR ORIENTATION</div><div>TERMINAL ORIENTATION</div><div>1. Get the Pink wire then insert to terminal slot ① using right hand.</div><div>2. After insertion, press the lock using left hand thumb then hold the wires and gently pull-out the connector from jig using right hand.</div></div> <div>Important reminders/Note/s: 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 2. Please hold the wire near terminal during insertion. Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>			

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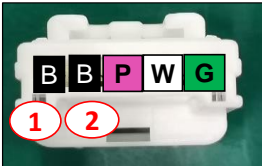


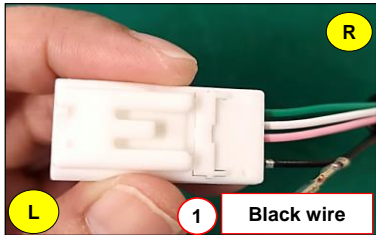
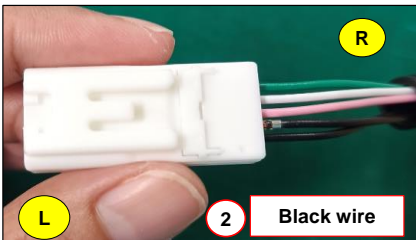
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PARTS:		1. Assy parts 2. AVSSf 0.3 B-B wires L=977±3mm		JIG:	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	Wire insertion to Black Corrugated tube (Assy parts)	 <p>1. Get the assy parts using left hand and insert AVSSf 0.3 B-B wires L=977±3mm using right hand.</p>		n/a	1. No wrong usage of parts 2. No deformed terminal Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.
7	P1 Wire insertion to Connector 6098-3802 (W)	 <p>VISUAL REFERENCE</p>  <p>CONNECTOR ORIENTATION</p>  <p>TERMINAL ORIENTATION</p>  <p>1. Hold the connector using left hand. Get the 1st Black wire then insert to terminal slot 1 using right hand.</p>  <p>2. Get the 2nd Black wire then insert to terminal slot 2 using right hand.</p>		n/a	1. No wrong use of connector 2. No damaged connector 3. No wrong insert 4. One by one insertion 5. No deformed terminal 6. No wrong terminal Orientation Important reminders/Note/s: 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 2. Please hold the wire near terminal during insertion. Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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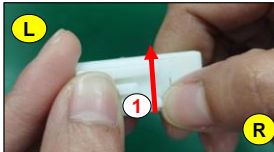

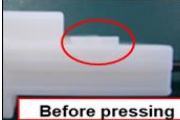
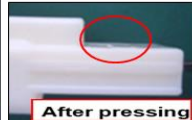


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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1 Connector Lock	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div> <div><p>2. 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>3. Press the lower parts of connector using right hand while left hand holding the middle.</p></div> <div><p>Right thumb-upper Left thumb-middle</p><p>4. Press the upper part of connector using right hand while left hand holding the middle.</p></div> <div><p>Right thumb-middle Left thumb-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 slide touching the connector lock based on the sequence illustrated.</p></div>		<div>LOCKING JIG</div> 	<p>1. Use provided jig per model 2. No unlock/half-locked connector</p> <p>Important reminders/Note/s:</p> <p>1. Manual locking jig may caused damaged connector lock.</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-017 for the verification of connector lock.</p> <div><p>Before pressing</p><p>After pressing</p></div> <div><p>GOOD Full Lock</p><p>NG Half Lock</p></div>

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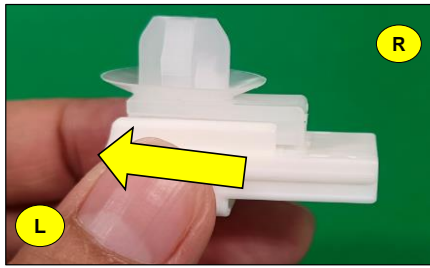
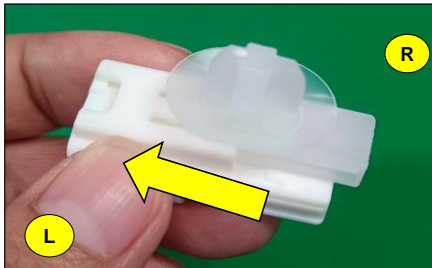
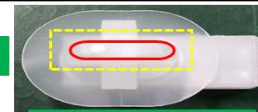

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PARTS:		1. Assy parts 2. Clip type clamp 82711-1E360 (W)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1 Clip attachment (Clip type clamp)	<div> CLAMP ORIENTATION</div> <div></div> <div>1. Hold the Connector using left hand, get the clip type clamp 82711-1E360 (W) then insert the clamp using right hand. Note: Sound will be heard if properly inserted.</div>		n/a	<div>CLIP CLAMP ILLUSTRATION</div> <div> GOOD 82711-1E360 (W)</div> <div> NG 82711-12B10 (W)</div> <div>1. No wrong used of clamp 2. No damaged clamp 3. No missing clamp</div>

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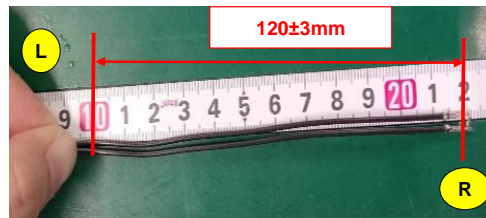
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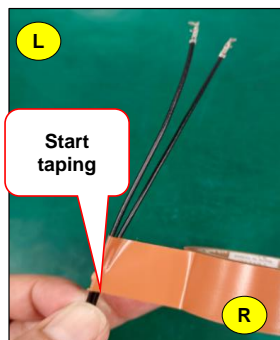
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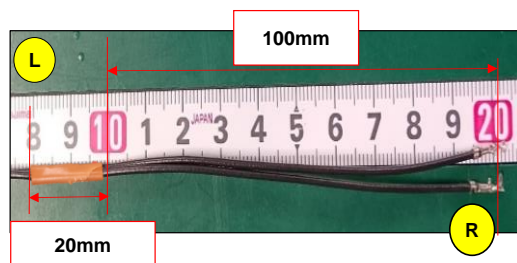
PARTS:		1. Assy parts 2. Brown tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	P1	Spot taping 2	<div>MEASURING TAPE</div> 	<div>1. No Flip-out tape 2. No Peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension. 6. No wrong use of tape.</div> <div>Important reminders/ Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div>



1. Hold the wires using left hand and measure from wire up to terminal pointed tip **120±3mm**



2. Get the **Brown tape** and start taping on the black wires. Conduct **2 windings** of tape before cut the tape using both hands.



3. After taping, check the measurement and taping condition.

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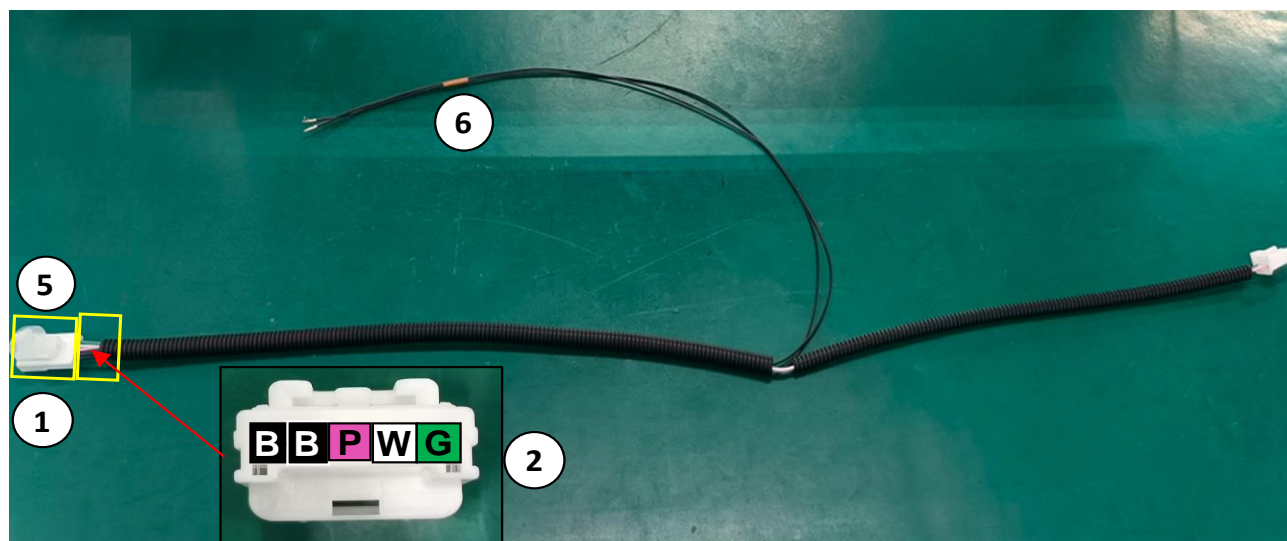
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PARTS:

JIG:

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING -P1****7N0237-7020B**

- ① **No Unlocked/Half-locked connector**
- ② **No Wrong Insert**
- ③ **No Terminal Backing Out**
- ④ **No Deformed Terminal**
- ⑤ **No Missing clip**
- ⑥ **No Missing spot tape (BROWN TAPE)**

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