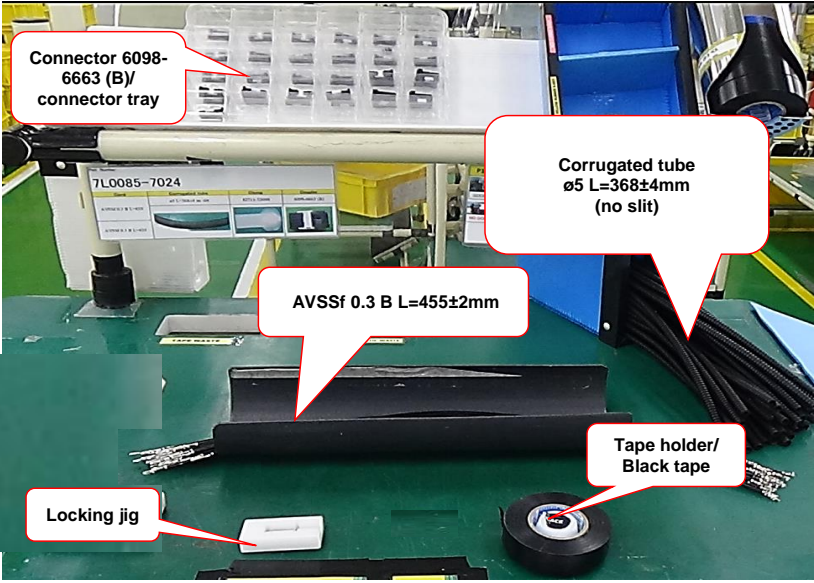



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	Model code/Part number: 500B / 7L0085-7024		Customer: TRQSS	Car Model: TOYOTA-SIENNA	Document No.: WI-ENG-PDE-050		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	8	Page No.:	1 of 6


PARTS:		1. Connector 6098-6663 (B); AVSSf 0.3 B L=455mm; Black Corrugated tube ø5 L=368±4mm (no slit); Black tape		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1	<div> <div>Table Lay-out</div>  </div>		<div> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	Document references/s: 1. Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.



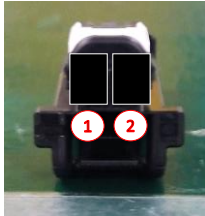

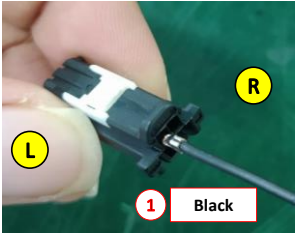
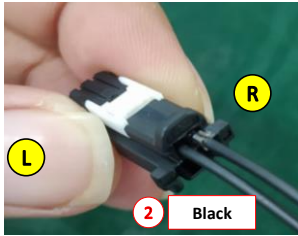
Revision History								Prepared by	Reviewed by	Approved by	Noted by
07/10/24	8	Separate Clamp setting and clamp assembly to Clamp assembly process. Inclusion of car model "TOYOTA-SEINNA". Change process due to removal of cover jig and inertion jig. Update Table lay-out, Measurement and Visual inspection/Quality pointers.	D.Castillo	C.Villanueva	A. Arañes	N/A					
01/20/23	7	Inclusion of batching quantity [10pcs] on page 1 as countermeasure for audit finding; Transfer Table lay-out 2 to pg.7 process 7; Inclusion of Quality checkpoints on page no.13.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes					
09/09/22	6	Merge from P1 to P2 due to process improvements. Change of tolerance from 35+/-3mm to 35(+3/-1mm) as countermeasure for encountered NG dimension from end of tape to terminal pointed tip on process no.5. Improve quality pointers on page 1, 3, 4, 5, 6, 7, 8, 10 and 11. Improve work procedure/ Illustration on process.no 4, 9, 10, and 11. additional Table lay-out.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	 D. Castillo	 C. Villanueva	 A. Arañes	n/a	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	November 19,2019			

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	Model code/Part number: 500B / 7L0085-7024		Customer: TRQSS	Car Model: TOYOTA-SIENNA	Document No.:		WI-ENG-PDE-050	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		8	Page No.: 2 of 6

PARTS:	1. Black Corrugated tube ø5 L=368±4mm (no slit) 2.AVSSf 0.3 B L=455±2mm [2pcs]			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	<div>8</div> Wire Insertion to Corrugated tube ø5 L=368±4mm (no slit)	<div><div>1. Get the Black corrugated tube ø5 L=368±4mm (no slit) using left had and get B-B wires using right hand then insert.</div></div>		n/a	1. No deformed terminal 2. No wrong usage of parts
3	<div>8</div> P1 Wire insertion to connector 6098-6663 (B)	<div><div><div>CONNECTOR ORIENTATION</div></div><div><div>VISUAL REFERENCE</div></div><div><div>WIRE FACING</div></div><div><div>1. Hold the connector 6098-6663 (B) then get the first Black wire and insert to terminal slot 1 using right hand. Conduct 2x push pull after wire insertion.</div></div><div><div>2. Hold the connector 6098-6663 (B) then get the second Black wire and insert to terminal slot 2 using right hand. Conduct 2x push pull after wire insertion.</div></div></div>		n/a	<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. Insertion of wire must be from left to right. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.</div> <div>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.</div>

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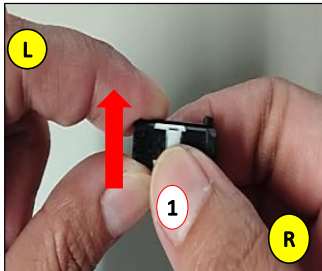
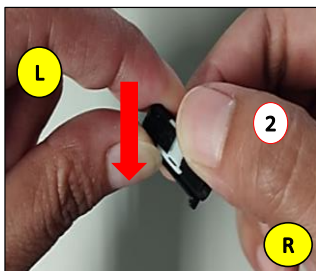

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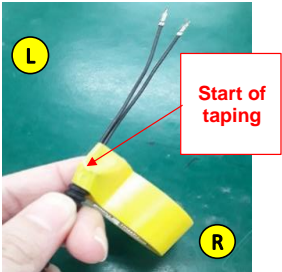
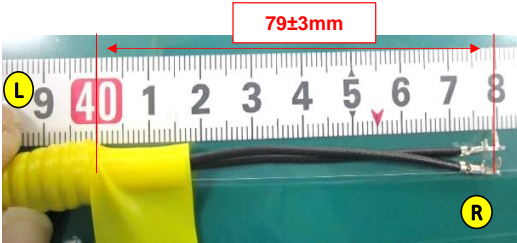
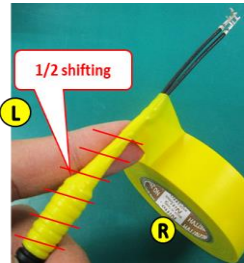
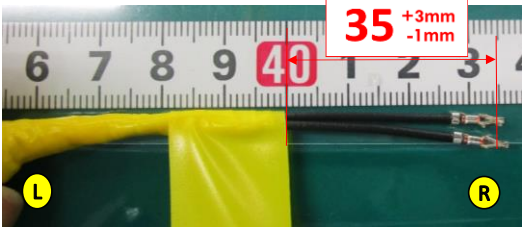
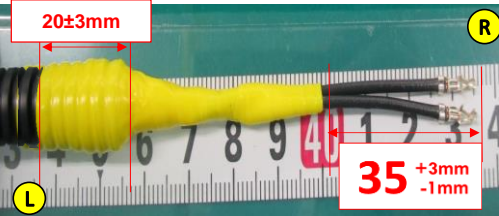

PARTS:		1.Assy part		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	<div></div> <div>1. Put the connector into locking jig using right hand then press to lock 2x using both hands.</div> <div></div> <div></div> <div></div> <div>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</div>		<div>LOCKING JIG</div> 	<p>Important reminders/Note/s:</p> <p>1. Manual locking may cause damaged connector lock.</p> <p>1. No unlocked/half-locked connector 2. Use provided jig tool per model.</p>

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	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:		8	Page No.:	4 of 6		

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
5	P1 Taping 1 Black COT to wire near terminal	<div><p>1. Hold the corrugated tube using left hand then start pre-taping using both hands.</p></div> <div><p>2. Hold the COT using left hand and measure from end of COT up to terminal tip 79±3mm using both hands then continue the taping process.</p></div> <div><p>3. Make 1/2 shifting on wires going to terminal using both hands.</p></div> <div><p>4. Confirm 35+3/-1mm measurement from end of tape up to terminal tip using both hands.</p></div> <div><p>5. After taping, check the measurement, taping condition and terminal appearance.</p></div>		<div><p>MEASURING TAPE</p></div>	<p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p> <p>Important reminders/Note/s:</p> <p>1. Used YELLOW TAPE for easy visualization of shiftingh lines. But actual should be BLACK. 2. Please use calibrated/verified measuring tape when getting the measurement.</p>	

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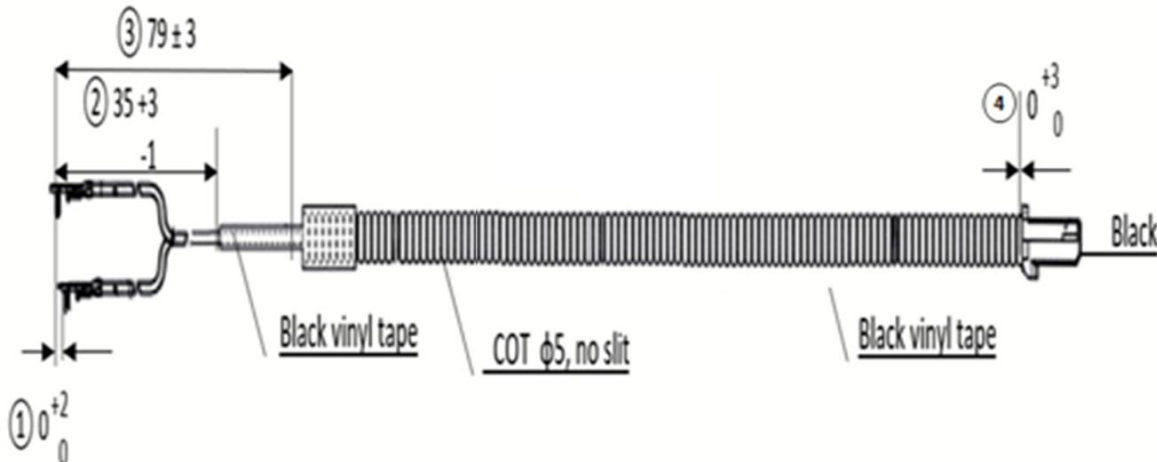
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PARTS:	1. Assy part			JIG:	1. Locking jig
NO.	PROCESS NAME	<div>8</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
6	P1	Measurement	<div>MEASURING TAPE</div> 	<p>Important reminders and note/s:</p> <p>1.Please use calibrated /verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</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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PARTS:

1. Assy parts

JIG:

n/a



VISUAL INSPECTION/ QUALITY INSPECTION

TAPING-P1**7L0085-7024**

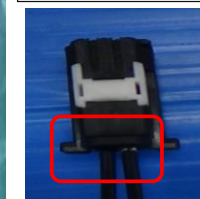
1

**GOOD****NO GOOD**

2



3

**GOOD****NO GOOD**

4

1

No Unlocked/Half-locked connector

2

No Terminal Backing Out

3

No Missing Tape

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