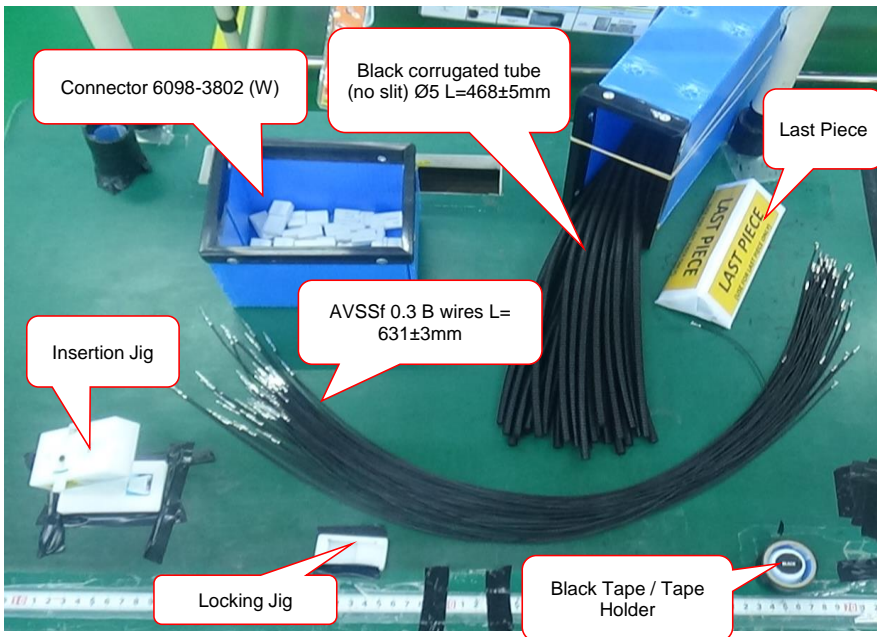

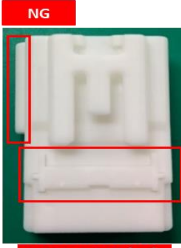
	<b>WORK INSTRUCTION</b>				Effectivity Date:		July 18, 2024	
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: <b>011B / 7M0368-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-CAMRY</b>	Document No.: <b>WI-ENG-PDE-237A</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		6	Page No.: 1 of 7

<b>PARTS:</b>	1. Connector 6098-3802 (W); AVSSf 0.3 B wires L= 631±3mm; Black corrugated tube (no slit) Ø5 L=468±5mm; Black tape			JIG:	1. Insertion jig 2. Locking jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
1	P1	<p><b>TABLE LAY-OUT</b></p> 	<p><b>Safety Instruction</b> Be sure to wear prescribed personal equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>1. No missing parts/ tools. 2. No Excess parts/tools.</p> <p><b>CONNECTOR ILLUSTRATION</b></p> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <p><b>GOOD</b></p>  <p><b>6098-3802 (W)</b></p> </div> <div style="text-align: center;"> <p><b>NG</b></p>  <p><b>6098-5668 (W)</b></p> </div> </div>	

Revision History				Prepared by	Reviewed by	Approved by	Noted by
07/18/24	6	Change process sequence due to removal of cover jig. Transfer VM tube insertion and COT to VM tube taping process due to Process improvement. Inclusion of Car model "TOYOTA-CAMRY". Improved Visual inspection/Quality checkpoints.	D.Castillo	C. Villanueva	A. Arañes	n/a	
12/9/22	5	Improve Quality pointers; Reminders/notes and references on pages no.1 to 7; Improve Work procedure/illustration on process no.4-Connector lock process. Inclusion of Quality Pointers.	M.Ariola	J. Loterte	C. Villanueva	A. Arañes	
05/26/22	4	Additional table Lay-out.	M.Ariola	J. Loterte	C. Villanueva	A. Arañes	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: February 10, 2018

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# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

July 18, 2024

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

011B / 7M0368-7020A

Customer: TRJ

Car Model: TOYOTA-CAMRY

Document No.:

WI-ENG-PDE-237A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

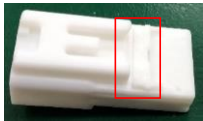
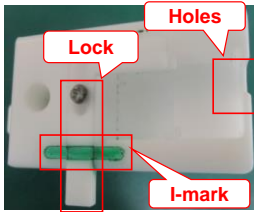
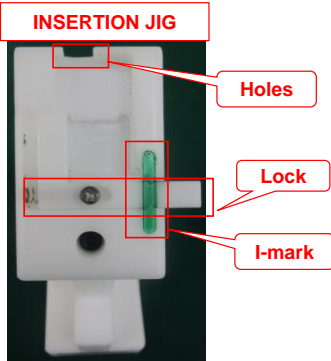

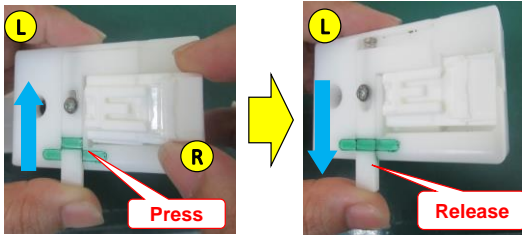
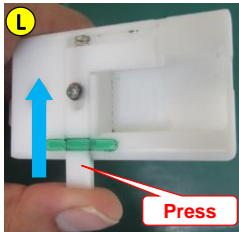


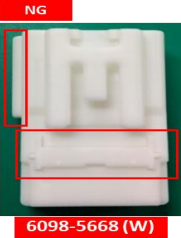

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PARTS:		1. Connector 6098-3802 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1 Connector setting to insertion jig 6098-3802 (W)	<div><p>CONNECTOR ORIENTATION</p></div> <div></div> <div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the connector <b>6098-3802 (W)</b> into jig using right hand and release the lock using left hand.</p><p>3. Check the holes/terminal slot for <b>B-B wires</b>.</p></div>		n/a	<p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p> <div><p>CONNECTOR ILLUSTRATION</p></div>

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

July 18, 2024

Validity Date:

n/a

Model code/Part number:

**011B / 7M0368-7020A**

Customer:

**TRJ**

Car Model:

**TOYOTA-CAMRY**

Document No.:

**WI-ENG-PDE-237A**

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**PARTS:**

1. Corrugated tube Ø5 L=468±5mm
2. AVSSf 0.3 B wires L= 631±3mm [2pcs]

JIG:

n/a

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

3

P1

Wire insertion to  
corrugated tube (no slit)  
Ø5 L=468±5mm



1. Get black corrugated tube **Ø5 L=468±5mm** using left hand and  
insert Black wires **L= 631±3mm** using right hand.


n/a


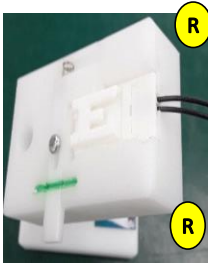
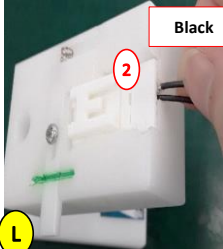
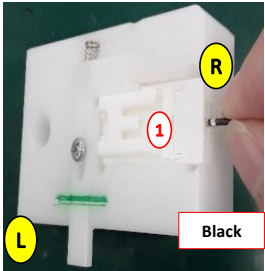
1. No wrong usage of parts
2. No deformed terminal

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	6	Page No.:	4 of 7


<b>PARTS:</b>	1. Assy parts			JIG:	1.Insertion jig			
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
4	P1 Wire insertion to connector 6098-3802 (W)	<div><div>Wire facing</div><div>Black</div><div>Black</div><div>Black</div><div>1</div><div>2</div><div>1. Get the first <b>Black wire</b> and insert to <b>Slot 1</b> of connector using right hand.</div><div>2. Get the second <b>Black wire</b> and insert to <b>Slot 2</b> of connector using right hand.</div><div>3. After insertion, push the lock using left thumb, hold the wires and gently pull out the connector from jig using right hand.</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><b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal during insertion.</b> <b>2.insertion must ber from left to right.</b> <b>3. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Pull after insertion.</b> <b>Do not exert extra force.</b></div> <div><b>Document reference/s:</b> <b>1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</b> <b>2. Refer to GL-PRO-ASY for pull-push procedure.</b></div>		



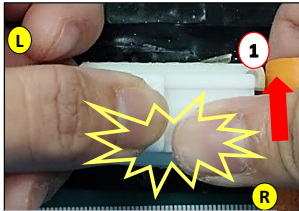

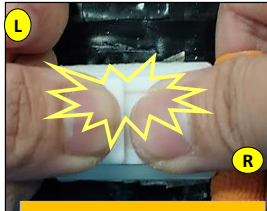
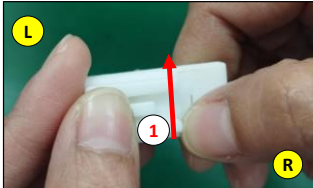
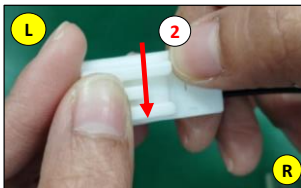

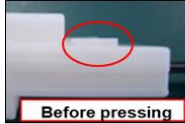



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<b>PARTS:</b>	1. Assy parts			JIG:	1. Locking jig			
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
5	P1	Connector Lock	<div><div><p>1. Load the connector into the jig holding both side 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></div></div> <div><div><b>LOCKING JIG</b></div></div> <div><div><p>Before pressing</p></div><div><p>After pressing</p></div><div><div><p>GOOD Full Lock</p></div><div><p>NG Half Lock</p></div></div><p>1. Use the provided jog per model 2. No unlocked/half-locked connector</p><p><b>Important reminders/Note/s:</b></p><p>1. Manual locking may cause damaged connector lock.</p><p><b>Document reference/s:</b></p><p>1. Refer to WI-PRO-KIT-001 for Proper locking and checking of connector lock.</p></div>					


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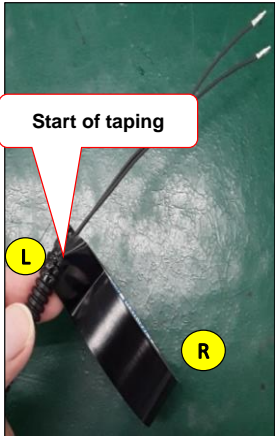

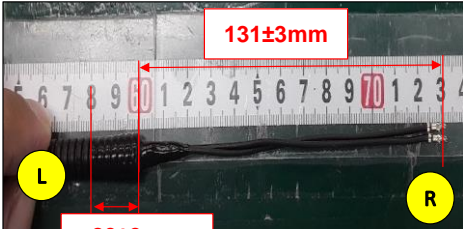

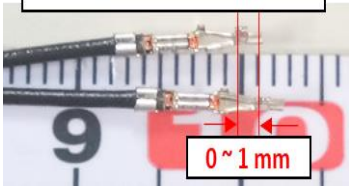
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<b>PARTS:</b>		1. Assy parts 2. Black tape		JIG:	n/a	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
6	P1  Taping 1 Corrugated tube to wire near terminal	<div><p>Start of taping</p></div> <div><p>131±3mm</p></div> <div><p>20±3mm</p></div> <div>1. Hold the COT (Assy Part) using left hand, get the <b>Black tape</b> then start taping using both hands.</div> <div>2. Measure from end of COT up to the terminal tip <b>131±3m</b> then continue the taping process.</div> <div>3. After taping, check the taping condition, wire alignment and measurement.</div>		<div><p>MEASURING TAPE</p></div>	<div><p>Wire alignment tolerance</p><p>0 ~ 1 mm</p></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><b>Important reminders and Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></div> <div><b>Document reference/s:</b> <b>1. Refer to WI-PRO-ASY-001 for taping procedure.</b></div>	

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**WI-ENG-PDE-237A**

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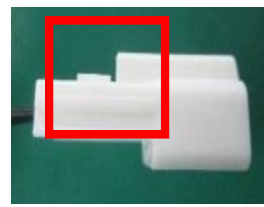
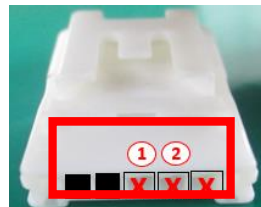
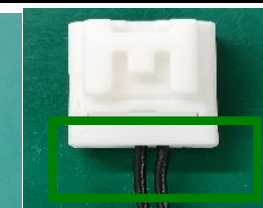
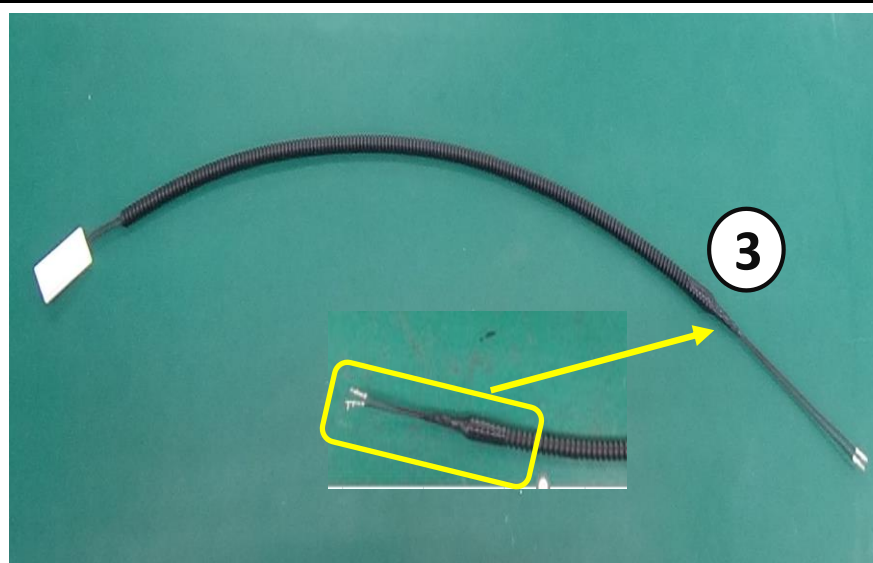
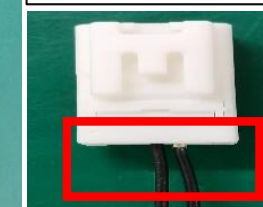
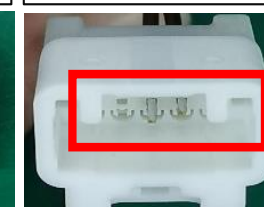
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P1****7M0368-7020A****GOOD****GOOD****NO GOOD****NO GOOD****GOOD****GOOD****NO GOOD****NO GOOD****① No Unlock/Halflock Connector****② No Wrong Insert****③ No Missing Tape (taping on COT-wire)****④ No Terminal Backing Out**

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