



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 15, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

102D / 7L0121-7024A

Customer:

TRQSS

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-1096A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

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PARTS:

1. All parts: Connector 6188-0407 (W); TVSSf 0.3 G-B/W wires L=588±3mm; Black VM tube (Sunprene) ø5 L=101±3mm; Black Corrugated tube ø5 L=393±3mm (no slit); Black tape

JIG:

1. Insertion jig with switch cover
2. Terminal Cover jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

P1

Table Lay-out

Table Lay-out

Connector
6188-0407 (W)

Black VM tube (Sunprene)
ø5 L=101±3mm

TVSSf 0.3 G L=588±3mm

TVSSf 0.3 B/W L=588±3mm

Insertion jig
with switch
cover

Terminal
cover jig

Black tape/
Tape holder

Black Corrugated tube
ø5 L=393±3mm
(no slit)

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.

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire
and Strip Length Tolerance.

1. No missing parts/tools
2. No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	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	A. Hernandez	C. Villanueva	A. Arañes	n/a
10/14/24	0	Initial issue	A. Hernandez	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 14, 2024		

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☐ PRE-LAUNCH

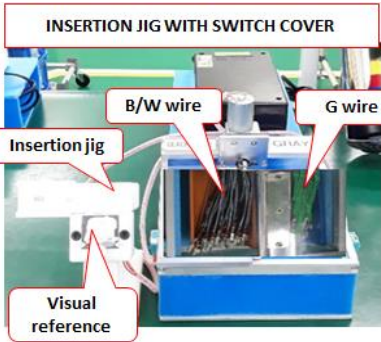
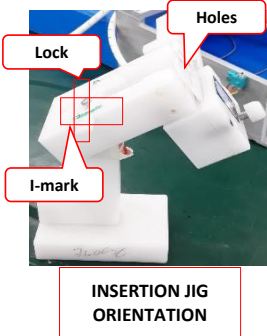

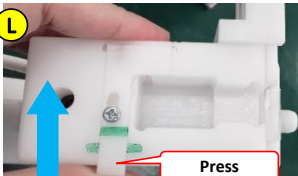
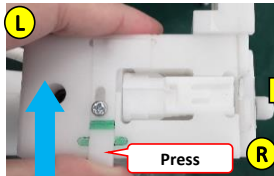


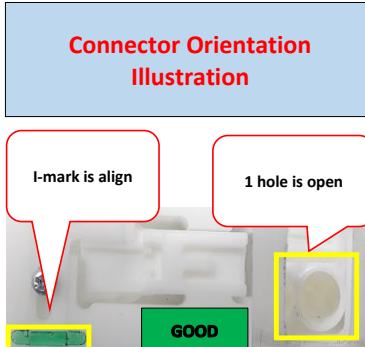

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PARTS:	1. Connector 6188-0407 (W)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Connector setting to insertion jig 6188-0407 (W)	<div><div></div><div></div><div></div></div> <div><div></div><div><p>1. Press the lock of insertion jig using left thumb.</p></div><div></div><div><p>2. Insert the connector 6188-0407 (W) into jig using right hand and release the lock.</p></div><div><p><i>Note: Refer to above illustration for correct setting.</i></p></div><div></div><div><p>3. Push the guide upward using right hand. Hole/terminal slot for B/W wire will be opened.</p></div><div></div></div>	n/a	<div><div></div><div></div><div><p>1. Use the provided jig per model</p><p>2. No wrong orientation of connector</p><p>3. No wrong use of connector</p><p>4. No damaged connector</p></div></div>

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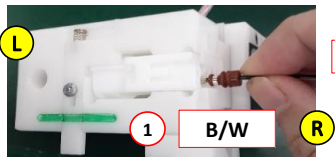

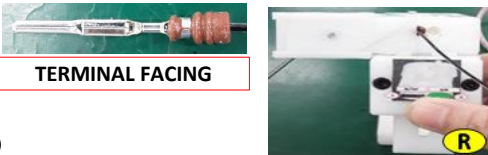





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PARTS:	1. Black corrugated tube (no slit) Ø5 L=393±3mm (no slit) 2. TVSSf 0.3 G-B/W wires L=588±3mm		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to connector 6188-0407 (W) P1	<div><p>1. Get the B/W wire then insert to terminal slot 1 using right hand.</p></div> <div><p>3. Get the G wire then insert to terminal slot 2 using right hand.</p></div> <div><p>TERMINAL FACING</p><p>2. Push the button after insertion. Hole for G wire will be opened.</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>	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: 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. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</div>
4	Wire Insertion to Black Corrugated tube Ø5 L=393±3mm (no slit)	<div><p>1. Get the terminal cover jig using right hand then insert the G-B/W wires using left hand.</p></div> <div><p>2. Get the corrugated tube (no slit) Ø5 L=393±3mm using right hand and then insert the</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div>	<div>TERMINAL COVER JIG</div> 	<div>1. No wrong use of parts 2. No deformed terminal</div>

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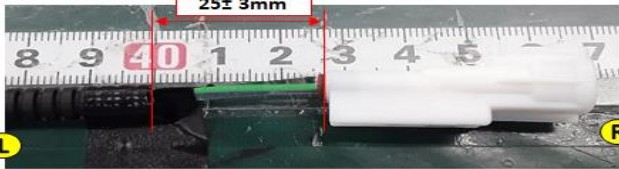
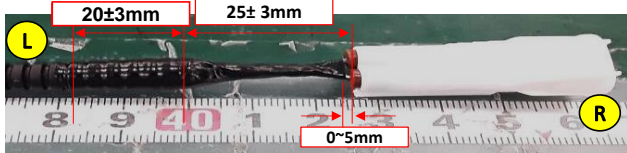


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PARTS:		1. Assy parts 2. Black tape 3. Black VM tube (Sunprene) Ø5 L=101±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1 Taping 1 Black corrugated tube to wire near connector	<div><div><p>Start of taping</p></div><div><p>1. Hold the corrugated tube using left hand, get the Black tape then start pre-taping at the middle of COT and wires using both hands.</p></div><div><p>25± 3mm</p></div><div><p>2. Measure from end of corrugated tube up to end of connector 25mm then continue the taping process using both hands.</p></div><div><p>20±3mm 25± 3mm</p><p>0~5mm</p></div><div><p>3. After taping, check the measurement and taping condition.</p></div></div>		<div><p>MEASURING TAPE</p></div>	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <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>
7	Wire insertion to Black VM tube (Sunprene) Ø5 L=101±3mm	<div><div><p>L R</p></div><div><p>1. Get the VM tube (Sunprene) Ø5 L=101±3mm using right hand then insert the G-B/W wires using left hand.</p></div></div>		n/a	<p>1. No wrong use of parts 2. No deformed terminal</p>

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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**TAPING - P1****7L0121-7024A****1 No Wrong Insert****2 No Missing tape (BLACK)****3 No Missing COT and VM tube (SUNPRENE)****4 No Terminal Backing Out****5 No Deformed terminal**

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