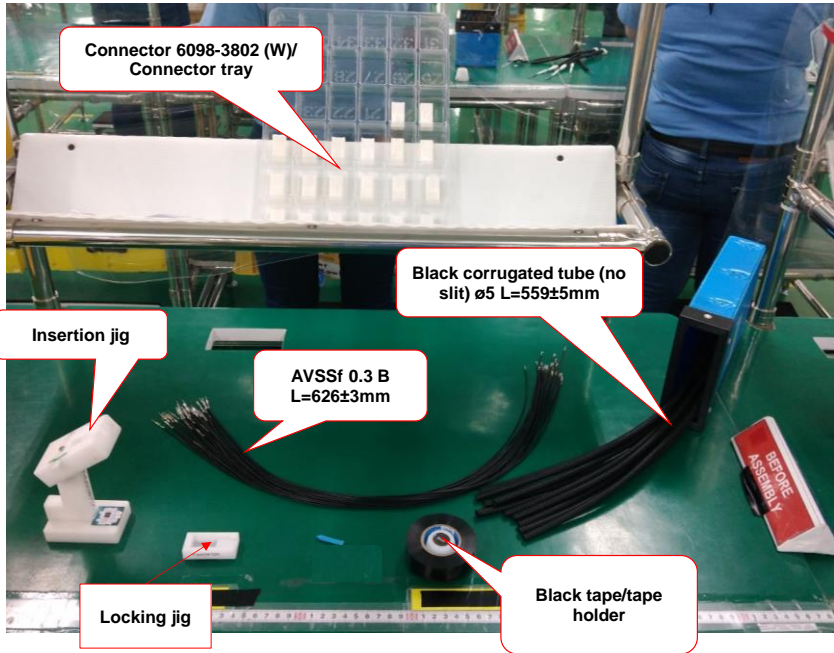



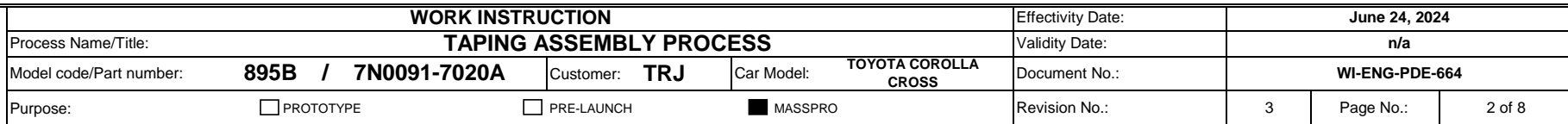
	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>June 24, 2024</b>		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>895B / 7N0091-7020A</b>	Customer: <b>TRJ</b>	Car Model: <b>TOYOTA COROLLA CROSS</b>	Document No.:	<b>WI-ENG-PDE-664</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	3	Page No.:	1 of 8

PARTS:		1. Connector 6098-3802 (W); AVSSf 0.3 B L=626±3mm; Black corrugated tube (no slit) ø5 L=559±5mm; Black tape		JIG:	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1	<div>TABLE LAY-OUT</div> 		<div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<div>Documents reference/s:</div> <p>1. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length tolerance.</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>


Revision History							Prepared by	Reviewed by	Approved by	Noted by
06/24/24	3	Update process sequence due to removal of cover jig and process improvement. Inclusion of Car model "TOYOTA-COROLLA CROSS" and Measurement.	D.Castillo	C. Villanueva	A. Arañes	n/a	 M. Ariola	 C. Villanueva	 A. Arañes	n/a
05/03/23	2	Change Document no. from <b>WI-ENG-PDE-664A</b> to <b>WI-ENG-PDE-664</b> due to separation of P1 and P2 process.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
04/26/23	1	Change Purpose from Pre-launch to Masspro.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change			Revised	Reviewed	Approved	Noted	Est. Date:	April 18, 2023


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	Model code/Part number: <b>895B / 7N0091-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA COROLLA CROSS</b>	Document No.:	<b>WI-ENG-PDE-664</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	3	Page No.:	3 of 8

<b>PARTS:</b>	1.Corrugated tube ø5 L=559±5mm (No slit) 2. AVSSf 0.3 B L=626±3mm [2pcs]			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
3	P1 <div>3</div> Wire insertion to Corrugated tube ø5 L=559±5mm (no slit)	<div><div>1.Get black corrugated tube <b>Ø5 L=559+5mm</b> using left hand and insert Black wires <b>L=626±3mm</b> using right hand.</div></div>	n/a	1. No wrong use of parts 2. No deformed terminal	

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Customer:

**TRJ**

Car Model:

**TOYOTA COROLLA  
CROSS**

Document No.:

**WI-ENG-PDE-664**

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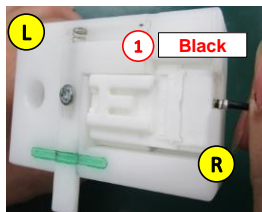

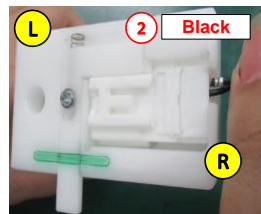

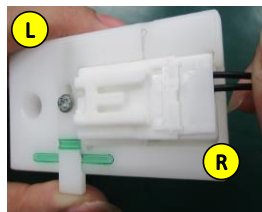
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PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1  Wire insertion to connector 6098-3802 (W)	<div><div></div><div></div><div></div><div><div>1. Get the <b>1st Black wire</b> then insert to terminal slot <b>1</b> of connector using right hand.</div><div>2. Get the <b>2nd Black wire</b> then insert to terminal slot <b>2</b> of connector using right hand.</div></div><div><div></div><div></div><div>3. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</div></div></div>		n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</div> <div><b>Important reminders/note/s:</b>  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><b>Document reference/s:</b>  1. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length Tolerance.  2. Please refer to <b>GL-PRO-ASY-029</b> for Pull-Push procedure</div>

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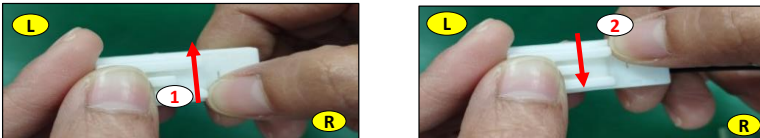

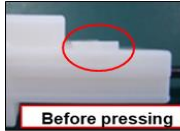



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<b>PARTS:</b>	1. Assy parts			JIG:	1. Locking jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
5	P1	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</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>1 2</p><p>6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div>		<div><b>LOCKING JIG</b></div> 	<p>1. Use the provided locking jig per modle 2. No unlocked/half-locked connector 3. No damaged lock</p> <p><b>Important reminders/note/s:</b></p> <p>1. Manual locking may cause damaged connector lock.</p> <div><p>Before pressing</p><p>After pressing</p></div> <div><p><b>GOOD</b></p><p>Full Lock</p><p><b>NG</b></p><p>Half Lock</p></div>

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

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Model code/Part number:

895B / 7N0091-7020A

Customer: TRJ

Car Model: TOYOTA COROLLA CROSS

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### PARTS:

1. Assy parts
2. Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

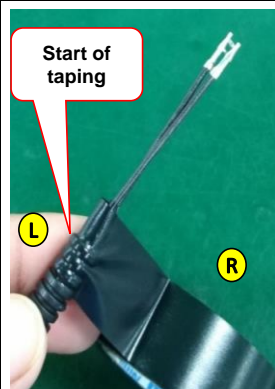
TOOLS/PPE

QUALITY POINTERS

6

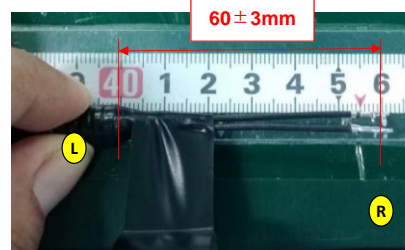
P1

Taping 1  
Black corrugated tube to  
wire near terminal



Start of  
taping

1. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.



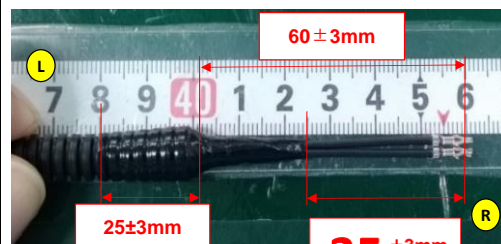
60 ± 3mm

2. Measure from end of COT up to terminal pointed tip 60 ± 3mm then continue the taping process using both hands.



35 +3mm  
-1mm

3. Confirm measurement of 35 ± 3mm from end of tape up to terminal pointed tip then continue the taping process using both hands.



60 ± 3mm

25 ± 3mm

35 +3mm  
-1mm

4. After taping, check the measurement, taping condition and terminal appearance.

MEASURING TAPE



1. No peel-off tape
2. No flip out tape
3. No loose tape
4. No wrong use of tape
5. No wrong dimension

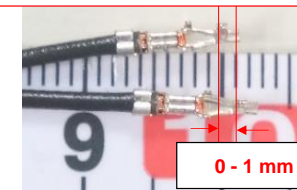
### Important reminders and Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.

### Document reference/s:

1. Refer to WI-PRO-ASY-001 for taping procedure.

Wire alignment tolerance





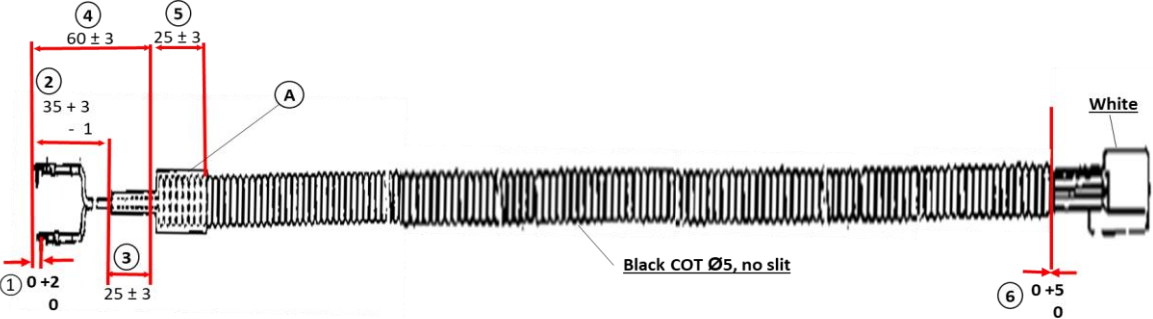
0 - 1 mm

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	Purpose: <input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	3	Page No.:	7 of 8

<b>PARTS:</b>	1. Assy parts			JIG:	n/a		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
7	P1	Measurement	<div><div>MEASURING TAPE</div></div> 			<div><b>Important reminders and note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b> <b>2. For Hatsumono, Nakamono and Owarimono.</b>  <b>Document reference/s:</b> <b>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</b></div> <div>1. No wrong dimension</div>	

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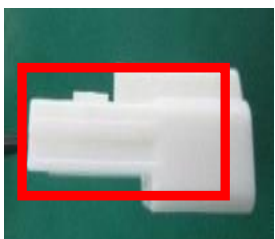
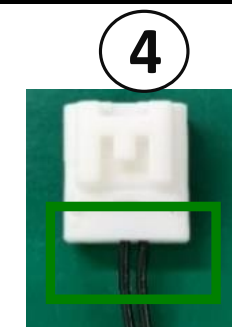
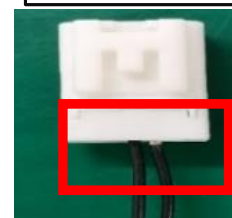
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P1****7N0091-7020A****GOOD****NO GOOD****GOOD****NO GOOD****① No Unlock/Halflocked Connector****② No Wrong Insert****③ No Missing tape****④ No Terminal Backing Out**

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