



## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

September 12, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

010B / 7L0030-7024A

Customer:

TRQSS

Car Model:

TOYOTA CAMRY

Document No.:

WI-ENG-PDE-1031

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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## PARTS:

1. All parts: Connector 6188-0407 (W); TVSSf 0.3 wires G L= 558±3mm; TVSSf 0.3 wires B/W L= 558±3mm; Black VM tube (Sunprene) Ø5 L=125±3mm; Black Corrugated tube Ø5 L=363±4mm (No slit); Clip type clamp 82711-1E360(W); Black tape

JIG:

1. Insertion jig with switch cover  
2. Measuring jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

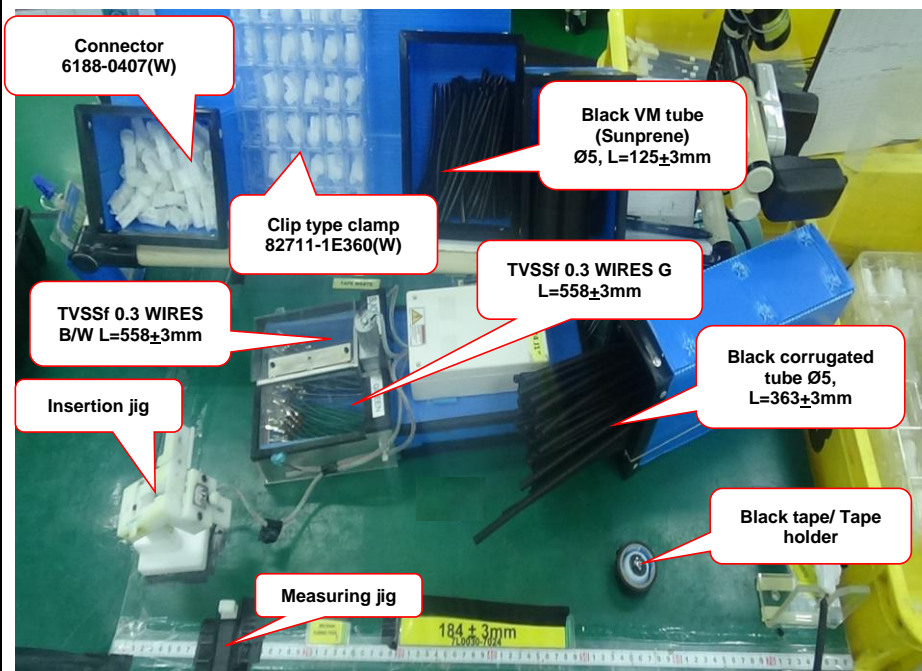
QUALITY POINTERS

1

P1

Table Lay-out

## TABLE LAY-OUT



## Safety Instruction

Be sure to wear prescribed 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

							Prepared by	Reviewed by	Approved by	Noted by
09/12/24	1	Change pre-launch to mass pro.	A.Hernandez	C.Villanueva	A. Arañes	n/a	A.Hernandez	C. Villanueva	A. Arañes	n/a
09/09/24	0	Initial issue	A.Hernandez	C.Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 09, 2024		

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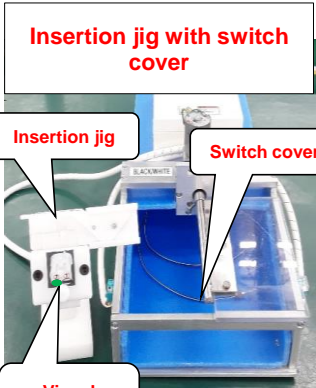
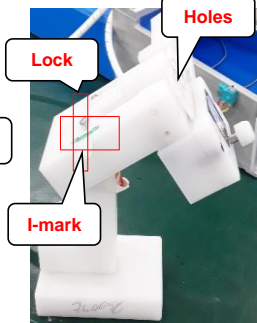
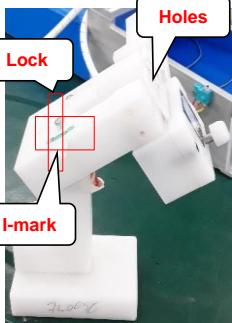

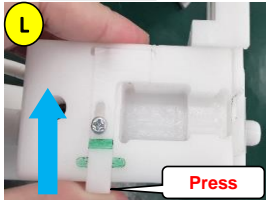
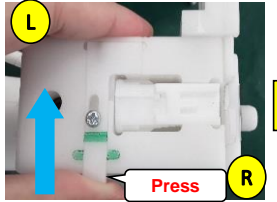
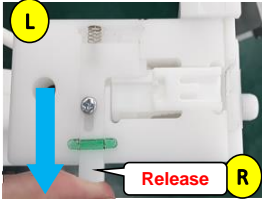

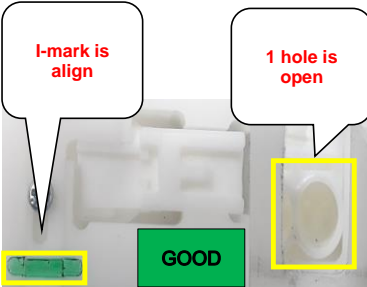
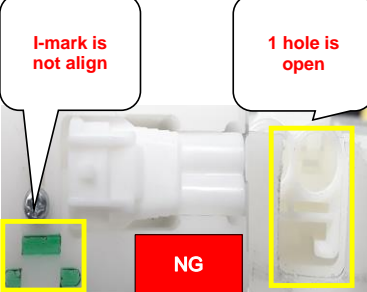

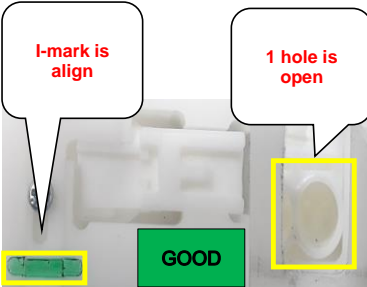
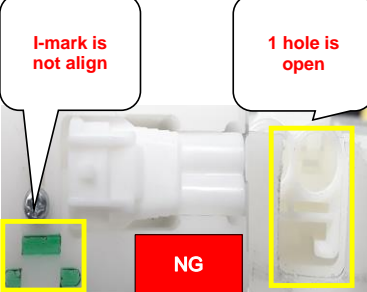
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PARTS:	1.Connector 6188-0407 (W)		JIG:	1. Insertion Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1  Connector setting to Insertion jig 6188-0407 (W)	<div><div><p>Insertion jig with switch cover</p><p>Insertion jig</p><p>Switch cover</p><p>Visual reference</p></div><div><p>Lock</p><p>I-mark</p></div><div><p>Holes</p></div><div><p>Connector orientation</p></div><div><p>L</p><p>Press</p><p>1. Press the lock of insertion jig using left thumb.</p></div><div><p>L</p><p>Press</p><p>R</p><p>2. Insert the connector <b>6188-0407 (W)</b> into jig using right hand and release the lock. <i>Note: Refer to above illustration for correct setting.</i></p></div><div><p>L</p><p>Release</p><p>R</p><p>3.Push the guide using right thumb. The slot for <b>B/W</b> wire will be opened.</p></div></div> <div>n/a</div> <td><div><div><p>Connector Orientation Illustration</p></div><div><p>I-mark is align</p><p>1 hole is open</p><p>GOOD</p></div><div><p>I-mark is not align</p><p>1 hole is open</p><p>NG</p></div></div><div>1. Use provided jig for model. 2.No wrong orientation of connector</div></td>	<div><div><p>Connector Orientation Illustration</p></div><div><p>I-mark is align</p><p>1 hole is open</p><p>GOOD</p></div><div><p>I-mark is not align</p><p>1 hole is open</p><p>NG</p></div></div> <div>1. Use provided jig for model. 2.No wrong orientation of connector</div>	

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010B / 7L0030-7024A

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TRQSS

Car Model:

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WI-ENG-PDE-1031

Purpose:

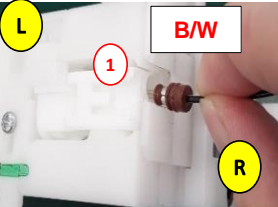
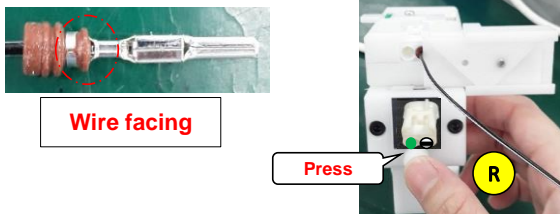
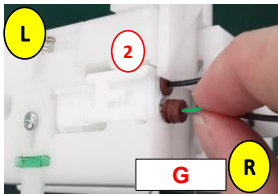
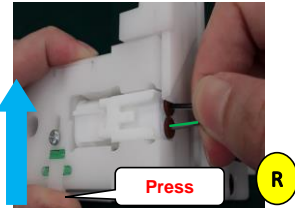
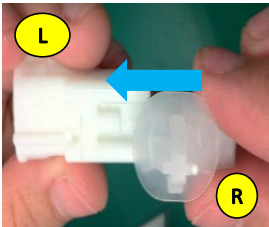
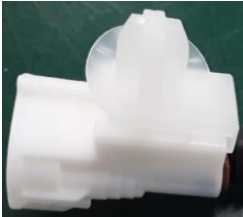
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PARTS:		1.TVSSf 0.3 wires G L=558±3mm 2.TVSSf 0.3 wires B/W L=558±3mm 3. Clamp 82711-1E360(W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1  Wire Insertion to connector 6188-0407 (W)	<div><div></div><div></div><div></div><div></div><div><p>1. Get <b>Black/White wire</b> then insert to terminal slot <b>1</b> using right hand.</p><p>2. Push the button after insertion. Hole for <b>Green wire</b> will be open.</p><p>3. Get <b>Green wire</b> then insert to terminal slot <b>2</b> using right hand.</p><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></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>Document references:</b> <b>1.Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b> <b>2.Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b></div> <div><b>Important reminders/Note/s:</b> <b>1. Make sure wires are properly inserted.</b> <b>Conduct <u>Pull-Push-Pull-Push</u> after insertion.</b> <b>Do not exert extra force.</b> <b>2.Insertion should be left to right.</b></div>
4	Clamp attachment (clip type clamp)	<div><div></div><div></div><div><p>1. Hold the connector using left hand, get the clip type clamp <b>82711-1E360 (W)</b> then insert the clamp using right hand. <b>Note: Sound will be heard if properly inserted.</b></p></div></div>		n/a	1. Must be fully inserted

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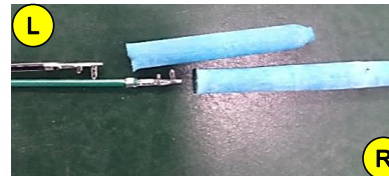

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PARTS:		1. Black VM tube (Sunprene) Ø5 L=125±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1	<div><div></div><div>1. Get the terminal cover jig using right hand then insert <b>G</b> and B/W wires using left hand.</div></div> <div></div> <div>2. Get the Corrugated Ø5 L=363±4mm (no slit) using right hand and insert the GR and B/W wires using left hand</div> <div><div></div><div>3. After insertion, remove the terminal cover jig using right hand.</div></div>		n/a	1. No wrong use of parts 2. No deformed terminal
6		<div></div> <div>1. Get the VM tube (Sunprene)Ø5 L=125±3mm using right hand then insert the <b>Green</b> and Black/White wire using left hand.</div>		n/a	1. No wrong use of parts 2. No deformed terminal

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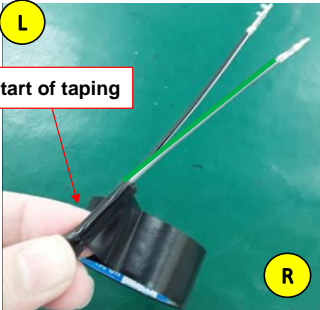
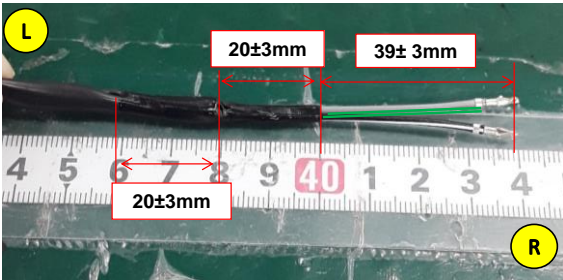

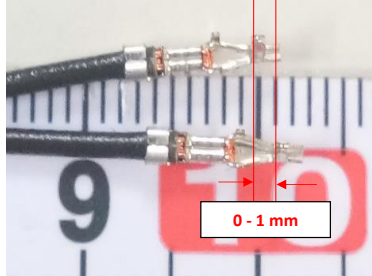
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PARTS:		1. Black tape 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1 Taping 1 VM tube (Sunprene) to wire near terminal	<div></div> <div>1. Measure the end of the sunprene tube up to the end of the terminal pointed tip <b>59mm</b> using both hands.</div> <div></div> <div>2. Get the <b>Black tape</b> using right hand. Hold the sunprene tube using left hand then start taping using both hands.</div> <div></div> <div>3. After taping, check the measurement, alignment and tape condition.</div>		<div></div> <div>Measuring tape</div>	<div></div> <div>Wire alignment tolerance</div> <div>0 - 1 mm</div> <div>1. No loose tape 2. No peel-off tape 3. No flip-out tape 4. No wrong use of tape 5. No wrong dimension</div> <div>Important reminders/note/s:  1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document reference/s:  1. Refer to <b>WI-PRO-ASY-001</b> for taping procedure.</div>

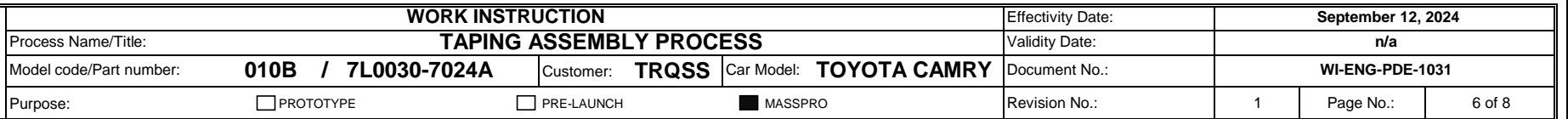
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<b>PARTS:</b>	1. Assy parts			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
9	P1	Measurement	<p><b>NOTE:</b> A Taping (B)</p>	<div>Measuring tape</div>	<p><b>Important reminders and note/s:</b></p> <ol style="list-style-type: none"><li>Please use calibrated/verified measuring tape when getting the measurement.</li><li>For Hatsumono, Nakamono and Owarimono.</li></ol> <p><b>Document reference/s:</b></p> <ol style="list-style-type: none"><li>Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection.</li></ol> <p>1. No wrong dimension</p>

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PARTS:

1. Assy parts

JIG:

n/a

### QUALITY CHECKPOINTS

## TAPING - P1

## 7L0030-7024A



2



① No Deformed Terminal

③ No Terminal Backing Out

⑤ No Missing Tape

② No Wrong Insert

④ No Missing Clip

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