



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

November 22, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

559D / 7N0238-7020A

Customer:

TRJ

Car Model: TOYOTA HIGH-ACE

Document No.:

WI-ENG-PDE-1160

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

0

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PARTS: 1. Connector 7286-4097 (W); wire avssf 0.3 B-B L=975mm; wire avssf 0.3 P-W-G L=830mm; wire avssf 0.3 Y-OR L=582mm

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

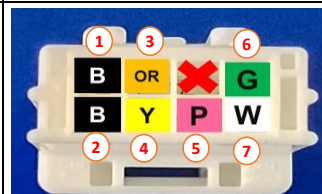
TOOLS/PPE

QUALITY POINTERS

1

P1

Wire insertion to
Connector 7286-4097 (W)



VISUAL REFERENCE

WIRE INSERTION ILLUSTRATION

1	3	5	7
B	OR	X	G
975	582	830	830
2	4	6	8
B	Y	P	W
975	582	830	830

Wire Terminal
Facing



1. Hold the connector **7286-4097 (W)** then get the **B wire** and insert to terminal **slot 1** of connector using right hand. Conduct **2x** push pull after wire insertion. Repeat the process to **B-OR-Y-P-G-W wires**.

Note: Follow the insertion sequence based on the illustration.

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.

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

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.

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**

Revision History

Prepared by

Reviewed by

Approved by

Noted by

11/22/24 0 Initial issue

A.Hernandez C.Villanueva A. Arañes n/a

A.Hernandez

C.Villanueva

A. Arañes

n/a

Eff. Date Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

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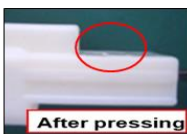
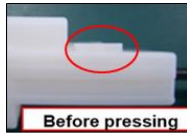


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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<div><div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div><div><p>2. Press the lower part of 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 thumb-middle Left</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>LOCKING JIG</div></div>	<div>1. Use the provided jig per model 2. No unlocked/half-locked connector</div> <div>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR LOCK 2. Use provided jig tool per model to avoid damaged lock.</div> <div>Document references: 1. Refer to GL-PRO-ASY-017 for the verification of connector lock.</div> <div></div> <div><div>GOOD</div><div>Full Lock</div><div>NG</div><div>Half Lock</div></div>

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PARTS:		1. Assy parts 2. Black Corrugated tube $\varnothing 7$ L= 290 \pm 3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1	<div><div></div><div></div><div></div></div> <div>1. Get the terminal cover jig using right hand and insert wires using left hand.</div> <div>2. Get the Black Corrugated tube $\varnothing 5$ L=290\pm3mm (no slit) using right hand and insert to wires.</div> <div>3. After insertion, remove the terminal cover jig using right hand.</div>		<div>TERMINAL COVER JIG</div> 	1. No wrong usage of parts 2. No deformed terminal

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PARTS:		1. Assy parts 2. Black Corrugated tube $\phi 7$ L= 290 \pm 3mm 3. Black SV tube (vinyl) $\phi 5$ L= 248 \pm 3mm		4. Connector 7283-1027 (W)		JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	P1	Wire Insertion to Black Corrugated tube $\phi 7$ L=290 \pm 3mm (no slit) (Continuation)	<div></div> <div>1. Get the P-W-G wire using right hand then insert the Black Corrugated tube $\phi 7$ L=290\pm3mm using right hand.</div> <div></div> <div>2. Get the Y-OR wire using right hand then insert the Black Corrugated tube $\phi 7$ L=290\pm3mm using right hand.</div>			n/a	1. No wrong use of parts 2. No deformed terminal
5		Wire Insertion to Black SV tube (vinyl) $\phi 5$ L= 248 \pm 3mm	<div></div> <div>1. Get the Y-OR wire using right hand then insert the Black SV tube (vinyl) $\phi 5$ L=248\pm3mm using right hand.</div>			n/a	1. No wrong use of parts 2. No deformed terminal

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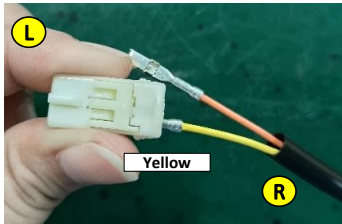
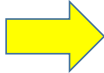
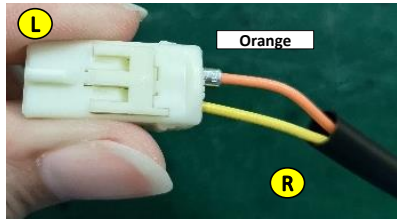
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PARTS:		1. Assy parts 2. Connector 7283-1027 (W)		JIG:	n/a						
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS						
6	P1 Wire insertion to Connector 7283-1027 (W)	<div><div> VISUAL REFERENCE</div><div><table><tr><th>1</th><th>2</th></tr><tr><td>Y</td><td>OR</td></tr><tr><td>582</td><td>582</td></tr></table></div><div><div>Wire Terminal Facing</div></div><div> Yellow</div><div></div><div> Orange</div><div><div>1. Get the connector 7283-1027 (BW) then hold the Yellow wire and insert to terminal slot 1 of connector using right hand. Conduct 2x push pull after wire insertion.</div><div>2. Get the connector 7283-1027 (BW) then hold the Orange wire and insert to terminal slot 2 of connector using right hand. Conduct 2x push pull after wire insertion.</div></div></div> <td>n/a</td> <td><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. 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.</div></td>		1	2	Y	OR	582	582	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. 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.</div>
1	2										
Y	OR										
582	582										

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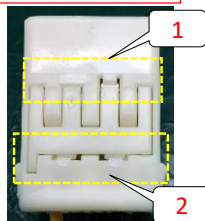
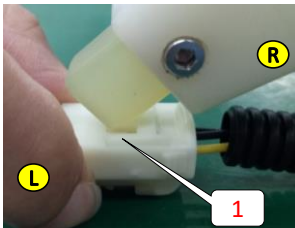
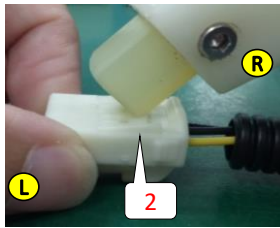
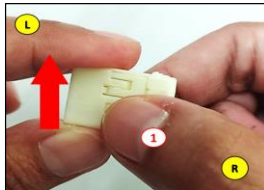
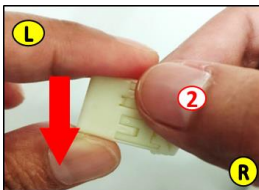

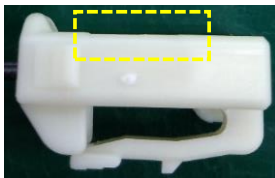

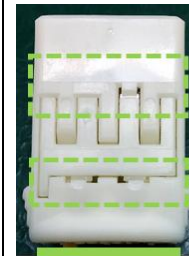
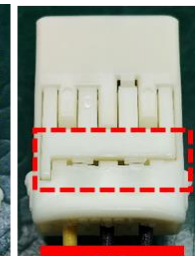
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PARTS:	1. Assy Parts		JIG:	1. Pushing jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1 Connector lock	<div><div><div>LOCKING SEQUENCE</div><div></div></div><div><div></div><div></div><div><p>1. Hold the connector using left hand and place on the table. Get the pushing jig using right hand and start the sequential locking based on above illustration. Push the lower part of the connector lock first and then push the upper part.</p></div></div><div><div></div><div></div><div><p>2. Ensure that connector is in locked condition by touching the connector lock based on the sequence illustrated.</p></div></div><div><div></div><div></div><div><p>BEFORE PRESSING</p></div><div><p>AFTER PRESSING</p></div></div></div> <div><div>PUSHING JIG</div><div></div></div> <div><div><p>1. No unlocked/half-locked connector 2. No damage connector 3. Use provided jig tool per model to avoid damaged lock.</p><p>Important reminders/Note/s:</p><p>1. Manual locking may cause damaged connector lock.</p><p>2. Position of pushing jig during locking must be slant.</p></div><div><div>LOCKED CONDITION</div><div><div></div><div></div><div><p>GOOD</p></div><div><p>NG</p></div></div></div></div>		

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PARTS:		1. Assy Parts 2. Black Corrugated tube $\varnothing 7$ L=110±3mm (no slit)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1 Wire Insertion to Black Corrugated tube $\varnothing 7$ L=110±3mm (no slit)	<div><p>1. Get the terminal cover jig using right hand and insert wires using left hand.</p></div> <div><p>2. Get the Black Corrugated tube Black Corrugated tube $\varnothing 7$ L=110±3mm (no slit) using right hand and insert to wires.</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div>		n/a	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
9		Wire Insertion to Black Corrugated tube $\varnothing 7$ L=110±3mm (no slit)	<div><p>1. Get the P-W-G wire using right hand then insert the Black Corrugated tube $\varnothing 7$ L=110±3mm using right hand.</p></div>		n/a

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PARTS:

1. Assy Parts
2. Black Corrugated tube $\varnothing 5$ L=349 \pm 3mm (no slit)
3. Connector 6098-5677 (W)

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

Wire Insertion to Black
Corrugated tube
 $\varnothing 5$ L=349 \pm 3mm (no slit)



1. Get the **P-W-G wire** using right hand then insert the **Black Corrugated tube $\varnothing 5$ L=349 \pm 3mm** using right hand.

n/a

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

10

P1

Wire insertion to
Connector 6098-5677
(W)



VISUAL REFERENCE

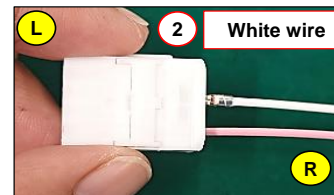
WIRE INSERTION
ILLUSTRATION

1	2	3	4
P	X	W	G
830	830	830	830

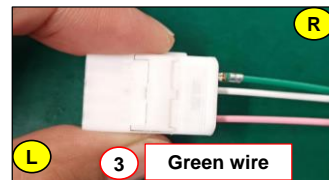
Wire Terminal
Facing



1. Hold the connector using left hand. Get the **Pink wire** then insert to terminal **slot 1** using right hand.



2. Hold the connector using left hand. Get the **White wire** then insert to terminal **slot 2** using right hand.



3. Hold the connector using left hand. Get the **Green wire** then insert to terminal **slot 3**

n/a

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

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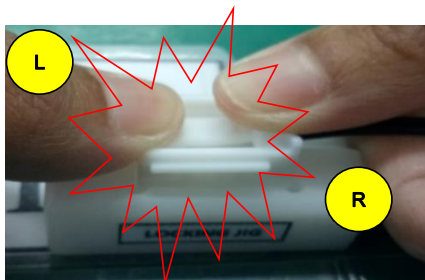
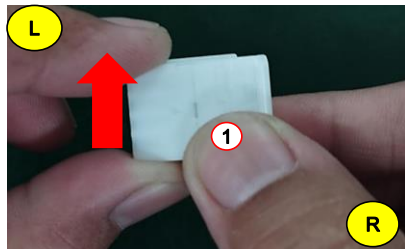
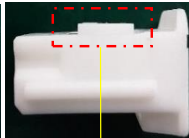
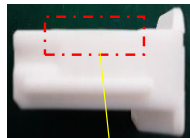

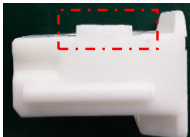

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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1	Connector Lock	<div><p>1. Put the connector into locking jig using right hand then press 2x to lock. Touch the connector lock to confirm if properly pressed.</p></div> <div><p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div>	<div><p>Fully Locked UnLocked</p></div> <div></div>	<p>Important reminders/Note/s:</p> <p>1. Manual Locking may caused damaged connector lock.</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-017 for verification of connector lock.</p> <p>1. Use the provided jog per model 2. No unlocked/half-locked connector</p>

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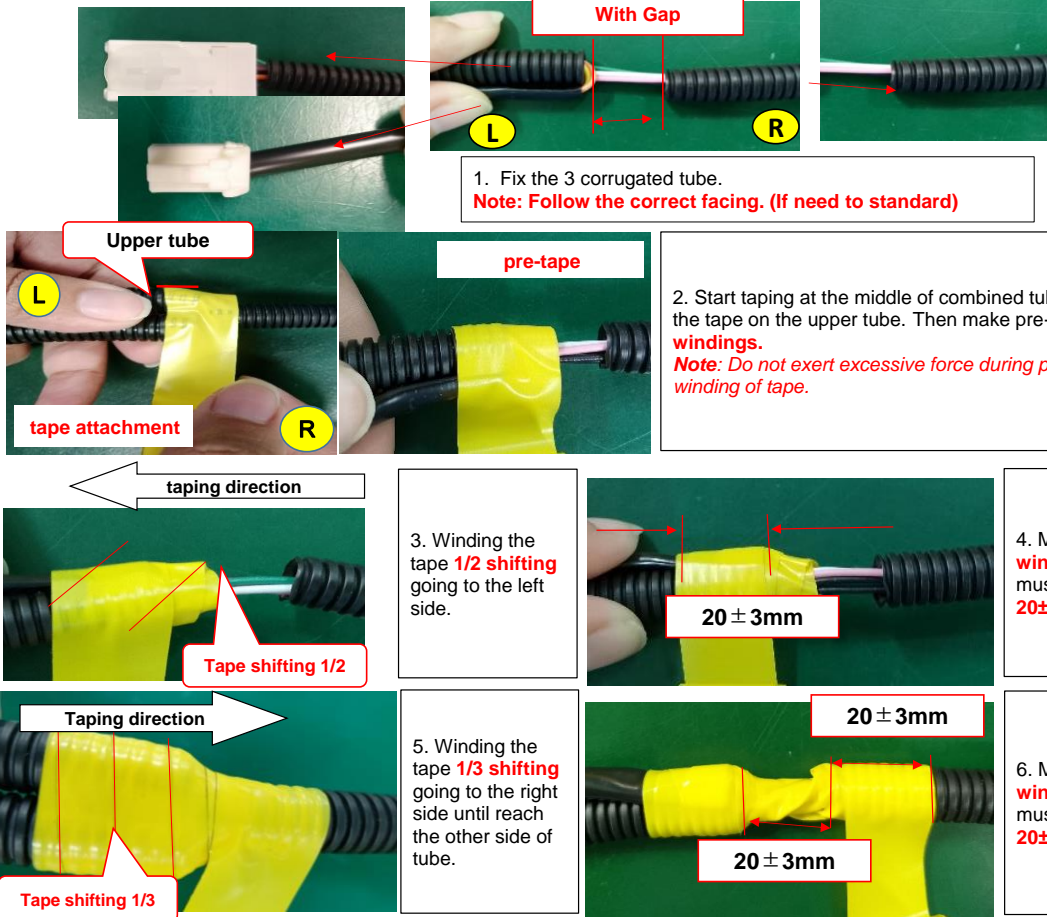
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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
12	P1 Taping 1 Y-Taping	 <p>1. Fix the 3 corrugated tube. Note: Follow the correct facing. (If need to standard)</p> <p>2. Start taping at the middle of combined tubes, attach the tape on the upper tube. Then make pre-tape 2 windings. Note: Do not exert excessive force during pulling & winding of tape.</p> <p>3. Winding the tape 1/2 shifting going to the left side.</p> <p>4. Make 2 windings, width must be - 20±2mm.</p> <p>5. Winding the tape 1/3 shifting going to the right side until reach the other side of tube.</p> <p>6. Make 2 windings, width must be 20±3mm.</p>			<p>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>Important reminders/Note/s: 1. Use <u>yellow tape</u> for easy visualization of tape shifting, but actual should be BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension-out tape 6. No exposed wire 7. No gap between tubes</p>

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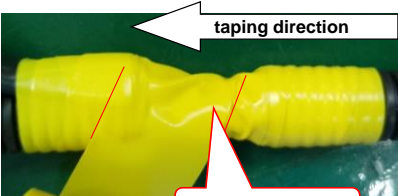
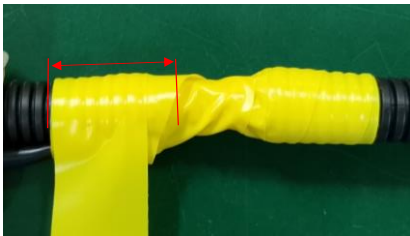
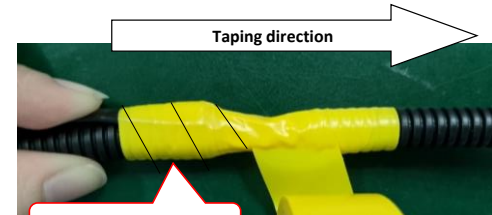
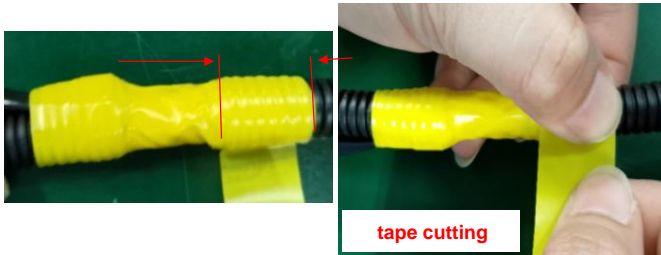
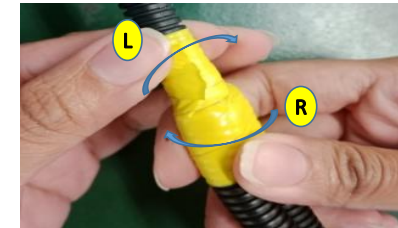
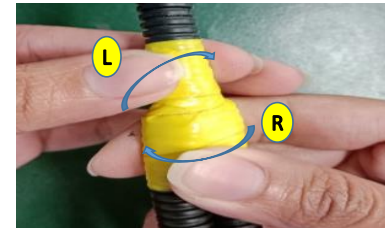
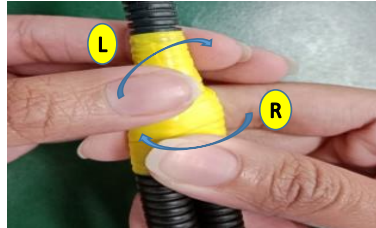
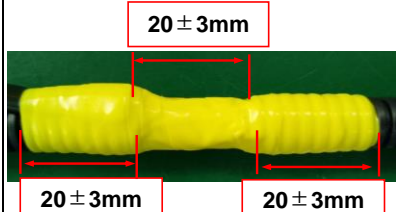
MASSPRO

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
12	P1 Taping 1 Y-Taping (continuation)	<div><div><p>7. Winding the tape 1/2 shifting going to the left side.</p></div><div><p>8. Make 2 windings, width must be - 20±3mm.</p></div><div><div><p>9. Winding the tape 1/2 shifting going to the right side until it reach the other side of tube</p></div><div><p>10. Make 3 winds, width must be 20±3mm. Then cut the tape.</p></div><div><p>11. conduct proper pressing of end tape using left hand (top part). <i>Note: Reference only.</i></p></div><div><p>12. conduct proper pressing of end tape using left hand (Middle part). <i>Note: Reference only.</i></p></div><div><p>13. conduct proper pressing of end tape using left hand (bottom part).</p></div></div></div>			<p>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>Important reminders/Note/s: 1. Use yellow tape for easy visualization of tape shifting, but actual should be BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement.</p> <ul style="list-style-type: none">1. No loose tape2. No flip-out tape3. No peel-off tape4. No wrong use of tape5. No wrong dimension-out tape6. No exposed wire7. No gap between tubes <div><p>14. Check the Measurement and condition of tape.</p></div>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

November 22, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

559D / 7N0238-7020A

Customer: TRJ

Car Model: TOYOTA HIGH-ACE

Document No.:

WI-ENG-PDE-1160

Purpose:



PROTOTYPE



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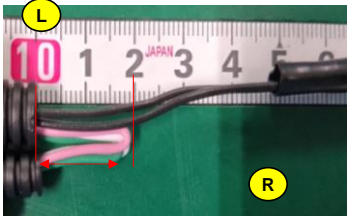
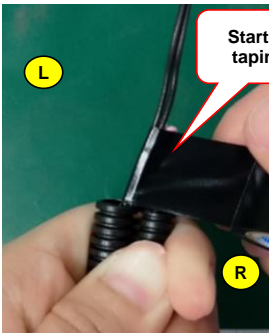
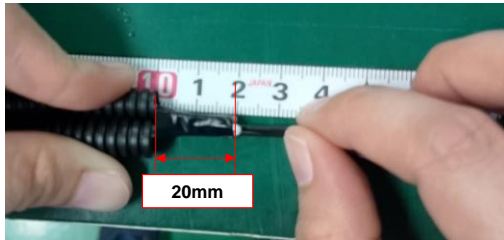

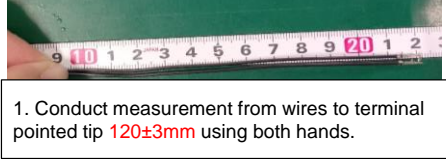
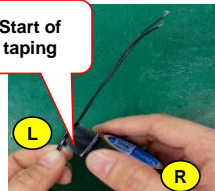
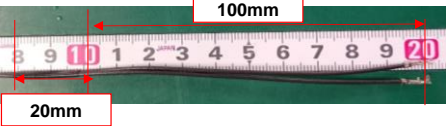

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
13	Spot Tape 1	<div><p>1. Combine the assy parts then and then conduct measurement 20mm</p></div> <div><p>Start of taping</p><p>2. Get the Black tape using right hand then conduct 2 windings of spot taping using both hands.</p></div> <div><p>20mm</p><p>3. After taping, check the measurement and taping condition.</p></div>		<div>MEASURING TAPE</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>
14	Spot Tape 2	<div><p>1. Conduct measurement from wires to terminal pointed tip 120±3mm using both hands.</p></div> <div><p>Start of taping</p><p>2. Get the Black tape using right hand then conduct 2 windings of spot taping using both hands.</p></div> <div><p>100mm 20mm</p><p>3. After taping, check the measurement and taping condition.</p></div>		<div>MEASURING TAPE</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>

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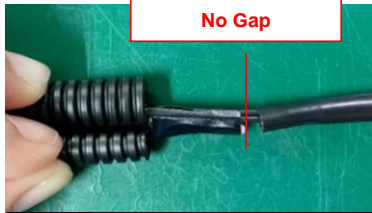
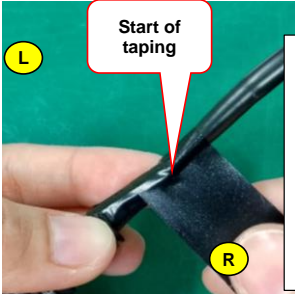
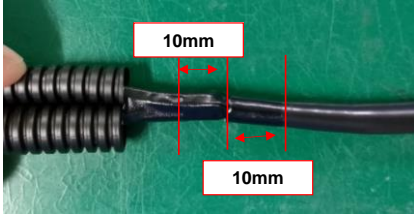
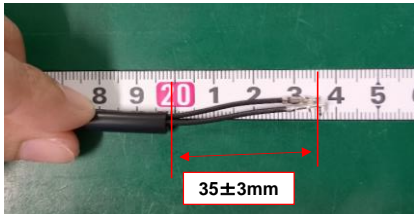
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PARTS:		1. Assy parts 2. Black SV tube (vinyl) ø5 L= 490±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
15	P1	Wire Insertion to Black SV tube (vinyl) ø5 L= 490±3mm	<div></div> <div>1. Get the B-B wire using right hand then insert the Black SV tube (vinyl) ø5 L=490±3mm using right hand.</div>	n/a	1. No wrong use of parts 2. No deformed terminal
16		Sport Tape 3	<div><div></div><div>1. Combine the assy parts then and Black SV tube (vinyl) ø5 L= 490±3mm.</div></div> <div><div></div><div>2. Get the Black tape using right hand then conduct 2 windings of spot taping using both hands.</div></div> <div><div></div><div></div><div>3. After taping, check the measurement and taping condition.</div></div>	n/a	Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 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

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559D / 7N0238-7020A

Customer: TRJ

Car Model: TOYOTA HIGH-ACE

Validity Date:

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Purpose:



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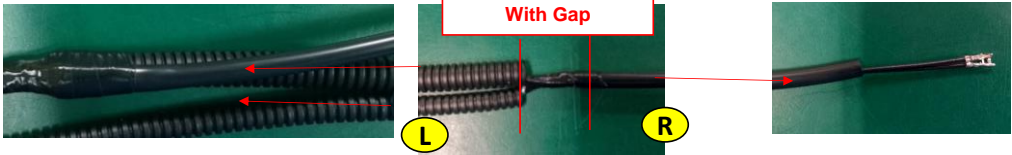
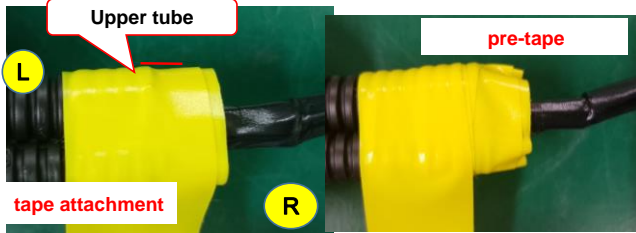
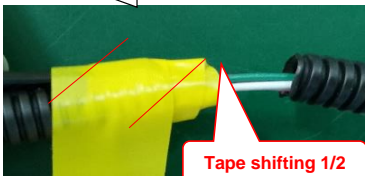
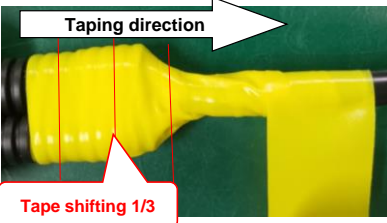
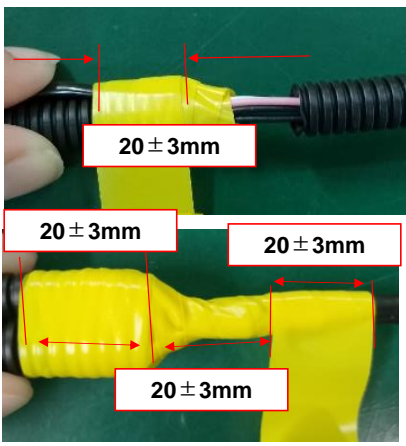
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PARTS:		1. Assy parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
17	P1 Taping 2 Y-Taping	 <p>1. Fix the 3 corrugated tube. Note: Follow the correct facing. (If need to standard)</p>  <p>2. Start taping at the middle of combined tubes, attach the tape on the upper tube. Then make pre-tape 2 windings. Note: Do not exert excessive force during pulling & winding of tape.</p>  <p>3. Winding the tape 1/2 shifting going to the left side.</p>  <p>4. Make 2 windings, width must be - 20±3mm.</p>  <p>5. Winding the tape 1/3 shifting going to the right side until reach the other side of tube.</p> <p>6. Make 2 windings, width must be 20±3mm.</p>			<p>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>Important reminders/Note/s: 1. Use yellow tape for easy visualization of tape shifting, but actual should be BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none">1. No loose tape2. No flip-out tape3. No peel-off tape4. No wrong use of tape5. No wrong dimension-out tape6. No exposed wire7. No gap between tubes

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

November 22, 2024

Process Name/Title:

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n/a

Model code/Part number:

559D / 7N0238-7020A

Customer: TRJ

Car Model: TOYOTA HIGH-ACE

Document No.:

WI-ENG-PDE-1160

Purpose:



PROTOTYPE



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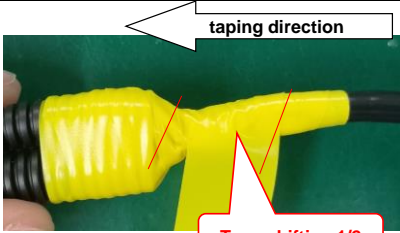
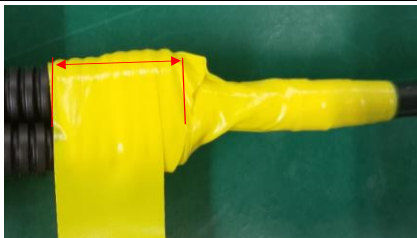
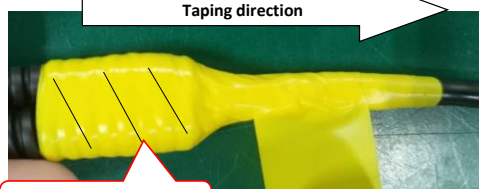
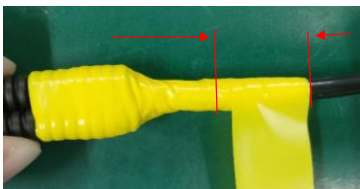
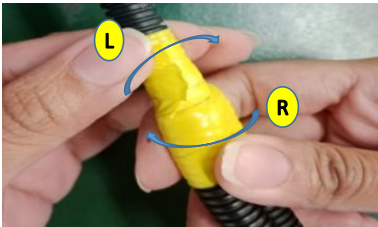

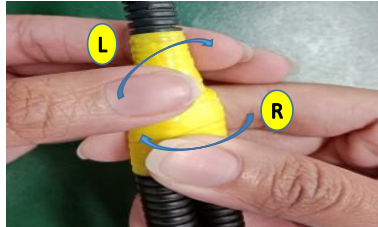
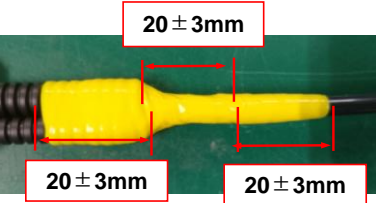
MASSPRO

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PARTS:		1. Assy parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
17	P1 Taping 2 Y-Taping (continuation)	<div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div></div> <div><div>8. Make 2 windings, width must be 20±3mm.</div><div>tape cutting</div><div>10. Make 3 winds, width must be 20±3mm. Then cut the tape.</div></div> <div><p>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p><p>Important reminders/Note/s: 1. Use yellow tape for easy visualization of tape shifting, but actual should be BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement.</p><ol style="list-style-type: none">1. No loose tape2. No flip-out tape3. No peel-off tape4. No wrong use of tape5. No wrong dimension-out tape6. No exposed wire7. No gap between tubes<div>14. Check the Measurement and condition of tape.</div></div>			

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Effectivity Date:

November 22, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

559D / 7N0238-7020ACustomer: **TRJ**Car Model: **TOYOTA HIGH-ACE**

Document No.:

WI-ENG-PDE-1160

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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PARTS:		1. Assy parts 2.Clamp 82711-16830 (B) 3.Clamp 82711-52090 (W)		4.Clamp 82711-16820 (BR) 5. Black tape		JIG:	1. Temporary Assembly jig 2. Bando Gun
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
18	P1	Clamp Setting	<div></div> <div>1. Get 1pc. of clamp 82711-16830 (B) using right hand and set to clamp location 1 using both hands.</div> <div>2. Get 1pc. of clamp 82711-52090 (W) using right hand and set to clamp location 2 and 3 using both hands.</div> <div>3. Get 1pc. of clamp 82711-16820 (BR) using right hand and set to clamp location 4 using both hands.</div> <div>4. Initially attach Black tape to clamp location 2 using both hands.</div>				<div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div> <div>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

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559D / 7N0238-7020A

Customer: TRJ

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PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Assy parts

2. Clamp 82711-16830 (B)

3. Clamp 82711-52090 (W)

4. Clamp 82711-16820 (BR)

5. Black tape

JIG:

1. Temporary Assembly jig

2. Bando Gun

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

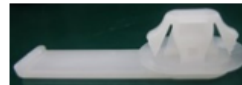
QUALITY POINTERS

19

P1



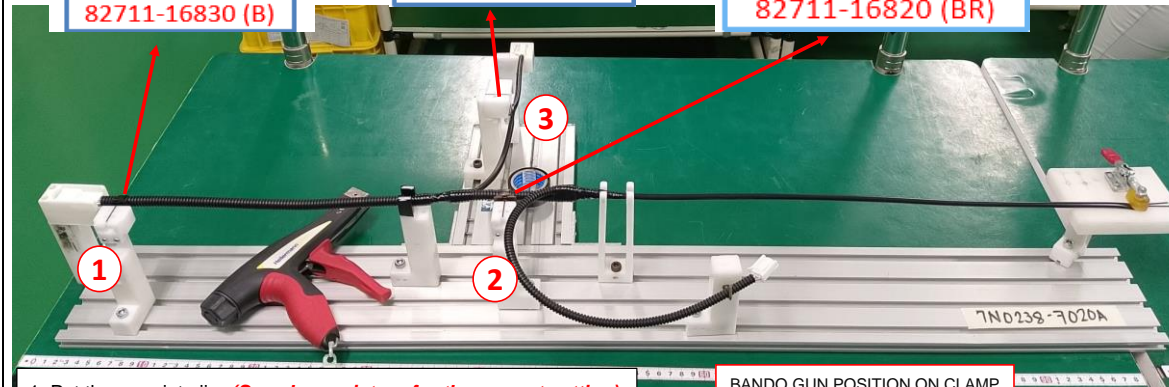
82711-16830 (B)



82711-52090 (W)



82711-16820 (BR)



1. Put the assy into jig. **(See above picture for the correct setting).** First, set the connector **7286-4097 (W)** to **Receiver base 1**. Second, connector **7283-1027 (W)** to **Receiver base 2**. **Third**, set the **B-B wires** together within stopper then press by toggle clamp. **Fourth**, Put the connector **6098-5677 (W)** to **hook**.

2. Initially tighten the band clamp on location **1** using both hands. Continue to clamp location **2**.

3. Initially tighten the band clamp on location **2** using both hands. Continue to clamp location **3**.

4. Hold the tape on clamp location **3**, make **3 windings** of tape then cut the tape using both hands.

BANDO GUN POSITION ON CLAMP
LOCATION 1 and 2PROPER CUTTING POSITION OF
BANDO GUN

BANDO GUN ALIGNMENT

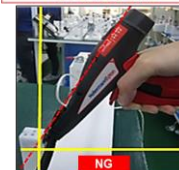


NG

OK

HORIZONTAL

NG

IMPROPER CUTTING POSITION
OF BANDO GUN

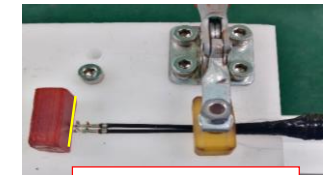
Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube.
For: ø5 - 1-2,
ø7 - 3-4

5. Conduct **POINT CHECKING** before removing the harness from jig.

1. No wrong use of parts
2. No wrong use of tape
3. No damaged clamp
4. No wrong clamp position

Important reminders/Note/s:

1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.



No gap between stopper and terminals

BANDO GUN



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PROTOTYPE



PRE-LAUNCH



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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
20	P1	Measurement			

Important reminders and note/s:
1. Please use calibrated/verified measuring tape when getting the measurement.

2. For Hatsumono, Nakamono and Owarimono.

Document reference/s:

1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection

1. No wrong dimension

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☐ PROTOTYPE

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PARTS:

n/a

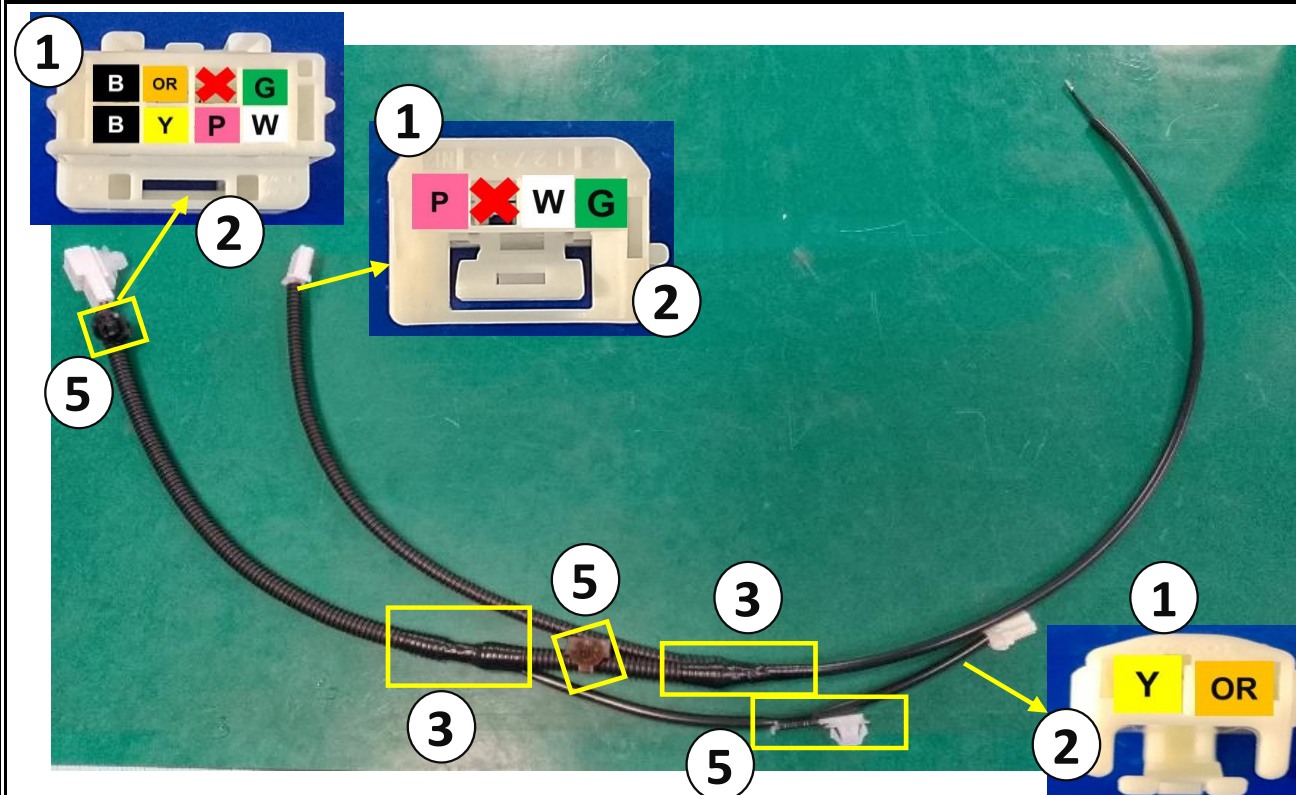
JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING - P1

7N0238-7020A



- 1 No Unlocked/
Half-locked connector
- 2 No Wrong Insert
- 3 No Missing Tape
- 4 No Wrong facing Y-Yaping
- 5 No Missing Clamp
- 6 Check the Clamp Alignment
- 7 No Deformed terminal
- 8 No Terminal backing
out

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