



WORK INSTRUCTION

Effectivity Date:

February 07, 2025

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

400D / 7L0160-7020A

Customer:

TRQSS

Car Model:

TOYOTA-bZ4X (BEV)

Document No.:

WI-ENG-PDE-1191

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Revision No.:

0

Page No.:

1 of 8

PARTS:

1. Black Corrugated tube $\phi 5$ L=218 \pm 3mm (No slit)
2. IRRAX A ROPE-LAY 0.3 B-B wires L=369 \pm 2mm [2pcs.]

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

P1

Wire Insertion to Black
Corrugated tube
 $\phi 5$ L=218 \pm 3mm
(no slit)



1. Get 2pcs **IRRAX A ROPE-LAY 0.3 B wire** L=369 \pm 2mm using right hand and get the Black Corrugated tube $\phi 5$ L=218 \pm 3mm (**no slit**) using left hand and insert to wires.

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 wrong use of parts
2. No deformed terminal


Revision History


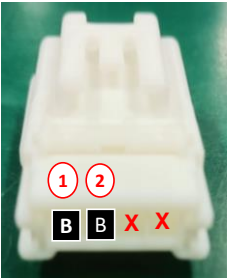

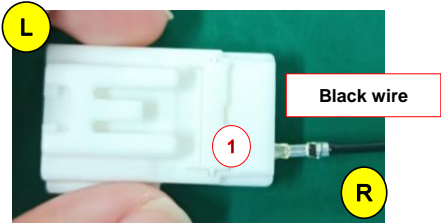
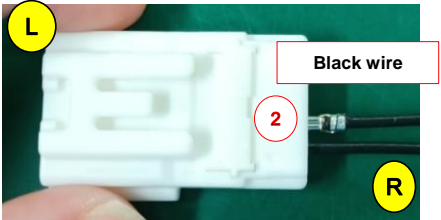
| Eff. Date | Rev. No | Details of Change | Revised | Reviewed | Approved | Noted | Prepared by | Reviewed by | Approved by | Noted by |
|-----------|---------|-------------------|------------|---------------|-----------|-------|-------------|-------------|-------------|----------|
| 02/07/25 | 0 | Initial issue. | D.Castillo | C. Villanueva | A. Arañes | n/a | | | | n/a |

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| | Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO | | | | Revision No.: | 0 | Page No.: | 2 of 8 |

| | | | | | |
|---------------|---|--|--|------------------|--|
| PARTS: | 1. Connector 6098-5668 (W) 2. Assy parts | | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 2 | P1 Wire Insertion to connector 6098-5668 (W) | <div><div>CONNECTOR ORIENTATION</div></div> <div><div>VISUAL REFERENCE</div></div> <div><div>TERMINAL FACING</div></div> <div><div>Black wire</div></div> <div><div>Black wire</div></div> <div>1. Hold the connector 6098-5668 (W) then get the 1st Black wire and insert to terminal slot 1 using right hand. Conduct 2x push-pull after wire insertion.</div> <div>2. Get the 2nd Black wire and insert to terminal slot 2 using right hand. Conduct 2x push-pull after wire insertion.</div> | | n/a | Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing |

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PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

0

Page No.:

3 of 8

PARTS:

1. Assy parst

JIG:

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

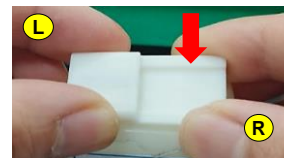
3

P1

Connector lock



1. Load the connector into the jig holding both side of the connector, tip first.



2. Press the lower part of connector to fully insert into the locking jig.



Right thumb-Lower
Left thumb-middle

3. Press the lower parts of connector using right hand while left hand holding the middle.



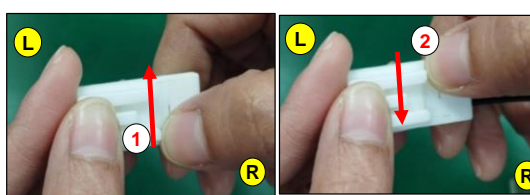
Right thumb-upper
Left thumb-middle

4. Press the upper part of connector using right hand while left hand holding the middle.



Right thumb-middle
Left thumb-middle

5. Lift then press the connector in the middle using left and right hand.



6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.

LOCKING JIG



1. No Unlock and half-locked
2. Use provided jig tools per model to avoid damaged lock.

Important reminders/note/s:
1. MANUAL LOCKING MAY CAUSED DAMAGED LOCK
2. Use provided jig tool per model to avoid damaged lock.



GOOD

NG



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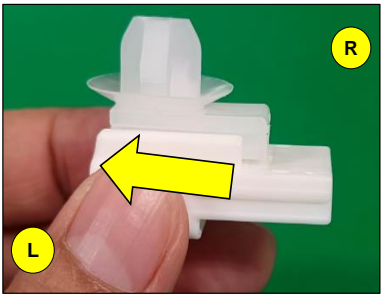
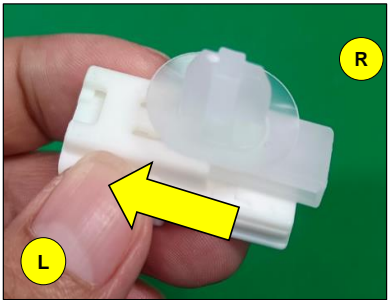
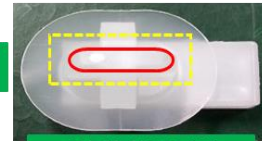
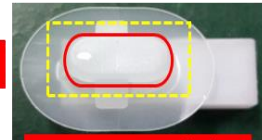
MASSPRO

Revision No.:

0

Page No.:


4 of 8


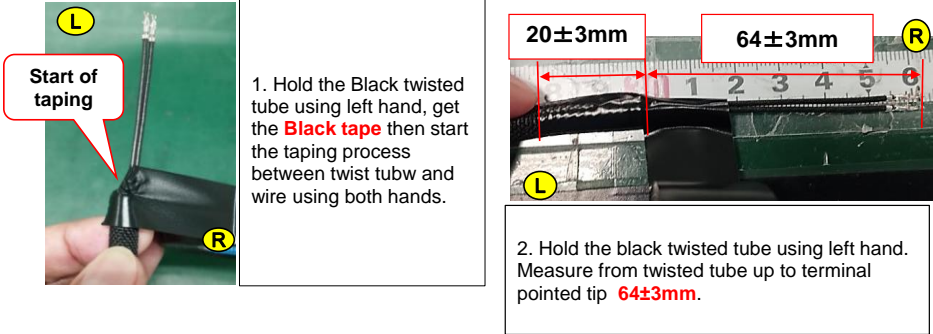
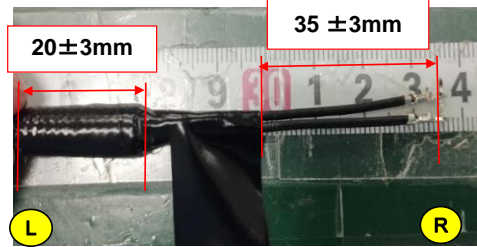

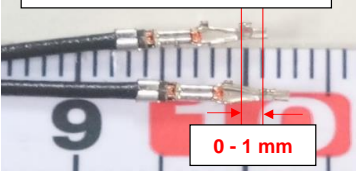
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|---------------|---|---|--|------------------|---|
| PARTS: | | 1. Clamp 82711-1E360 (W) 2. Assy parts | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 4 | P1 Clamp attachment (Clip type clamp) | <div></div> <div></div> <div>1. Hold the Connector using left hand, get the clip type clamp 82711-1E360 (W) then insert the clamp using right hand. Note: Follow the illustration. Sound will be heard if properly inserted.</div> | | | <div>1. No wrong used of clamp 2. No damaged clamp 3. No missing clamp</div> <div>CLIP CLAMP ILLUSTRATION</div> <div><div>GOOD</div><div>82711-1E360 (W)</div><div>NG</div><div>82711-12B10 (W)</div></div> |

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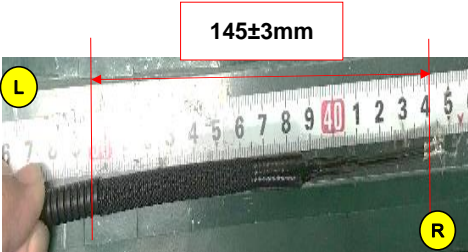

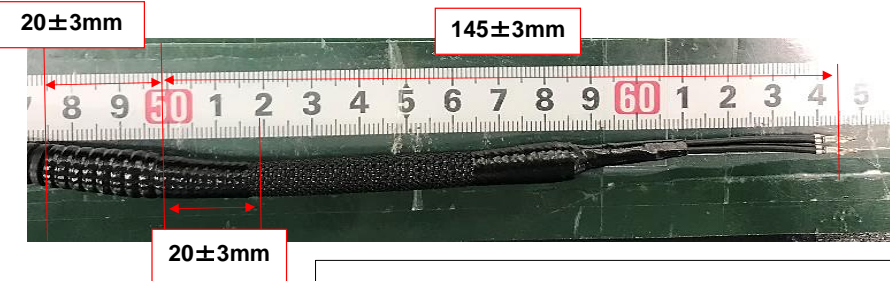

| | | | | | |
|---------------|---|--|--|--|---|
| PARTS: | 1. Assy parts 2. Black Twisted tube 2420F ø5, t=0.5; L=81±3mm 3. Black tape | | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 5 | Wire insertion to Black Twisted tube 2420F ø5, t=0.5; L=81±3mm |  <p>1. Get the Wire insertion Black Twisted tube 2420F ø5, t=0.5; L=81±3mm using right hand and insert to black wires using left hand.</p> | | n/a | 1. No wrong usage of parts 2. No deformed terminal |
| 6 | P1 Taping 1 Twisted tube to wire near terminal |  <p>1. Hold the Black twisted tube using left hand, get the Black tape then start the taping process between twist tubw and wire using both hands.</p> <p>2. Hold the black twisted tube using left hand. Measure from twisted tube up to terminal pointed tip 64±3mm.</p>  <p>3. Hold the black twisted tube using left hand. Measure from twisted tube up to terminal pointed tip 35±3mm.</p> <p>4. After taping check the measurement, wire alignment and taping condition.</p> | | <div>MEASURING TAPE</div>  | <p>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 7. No insufficient tape</p> <p>Important reminders/Note/s:</p> <p>1. Please use calibrated/ verified measuring tape when gerring the measurement.</p> <p>Document references:</p> <p>1. Refer to WI-PRO-ASY-001B for Taping assembly procedure</p> <div>Wire alignment tolerance</div>  |

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| | | | | | | |
|--------|---|--|--|---|---|--|
| PARTS: | | 1. Assy parts 2. Black tape | | JIG: | n/a | |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS | |
| 7 | P1 Wire insertion to Black Corrugated tube to Black Twisted tube | <div></div> <div></div> <div></div> <div>1. Measure from end of COT up to terminal pointed tip 145±3mm.</div> <div>2. Hold the assy part using left hand. Get Black tape using right hand and start the taping process between COT and Twist tube using both hands.</div> <div>3. After taping, check the measurement and taping condition.</div> | | <div>MEASURING TAPE</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>Important reminders/Note/s:</div> <div>1. Please use calibrated/ verified measuring tape when gerring the measurement.</div> <div>Document references:</div> <div>1. Refer to WI-PRO-ASY-001B for Taping assembly procedure</div> | |


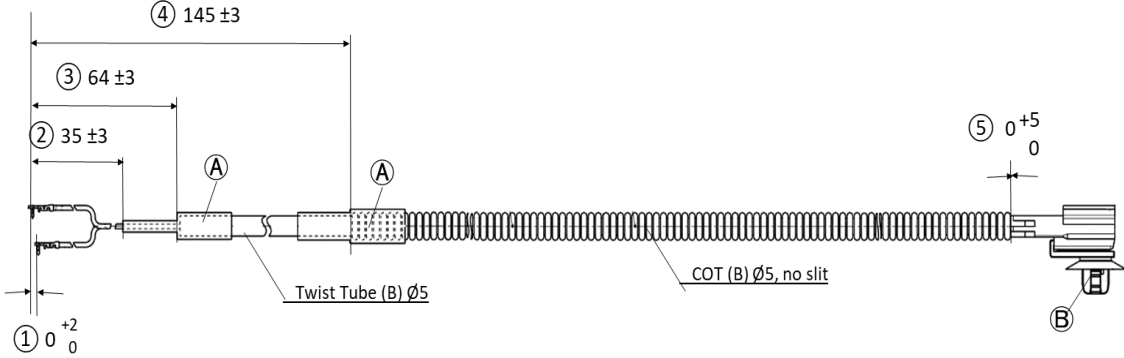
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| | | | | | | |
|--------|--------------|------------------------------|--|--|---|--|
| PARTS: | | 1. Assy parts | | JIG: | n/a | |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS | |
| 8 | P1 | Measurement | | <div>MEASURING TAPE</div>   <div>NOTE: A - Taping (B) B - Clamp (W) *Unit of dimension is in millimeter (mm)</div> | <div>Important reminders and note/s:</div> <div>1.Please use calibrated /verified measuring tape when getting the measurement.</div> <div>2. For Hatsumono,Nakamono and Owarimono.</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection.</div> <div>1.No wrong dimension</div> | |

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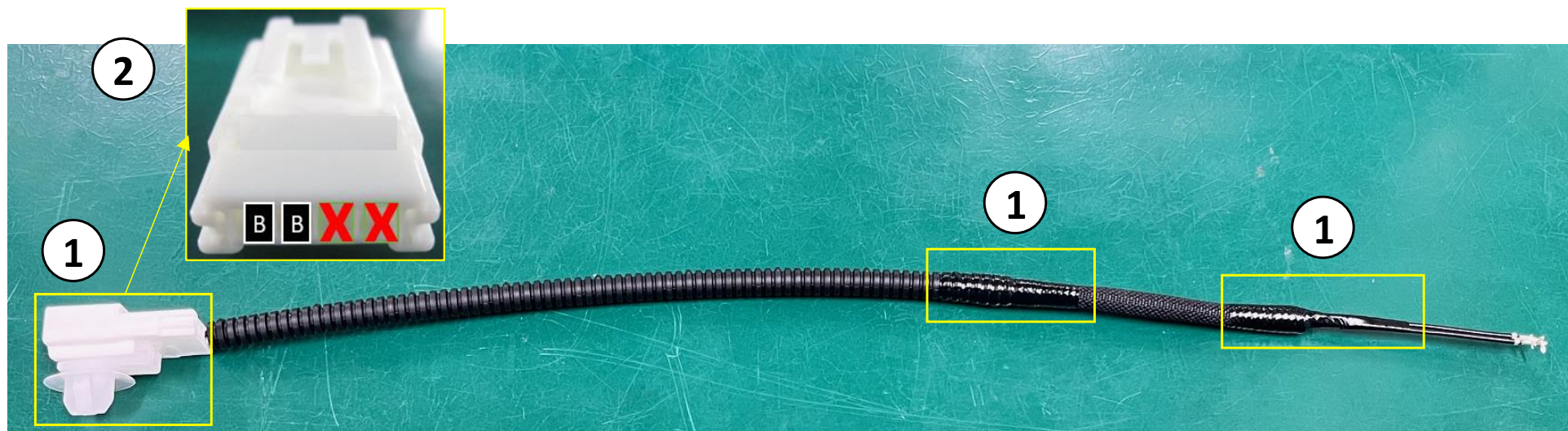
8 of 8

PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P1****7L0160-7020A****① No Unlocked/Half-locked connector****② No Wrong Insert****③ No Terminal Backing Out****④ No Deformed Terminal****⑤ No Missing Tape/
No Wrong color of tape****⑥ No Missing Clamp (Clip)**

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