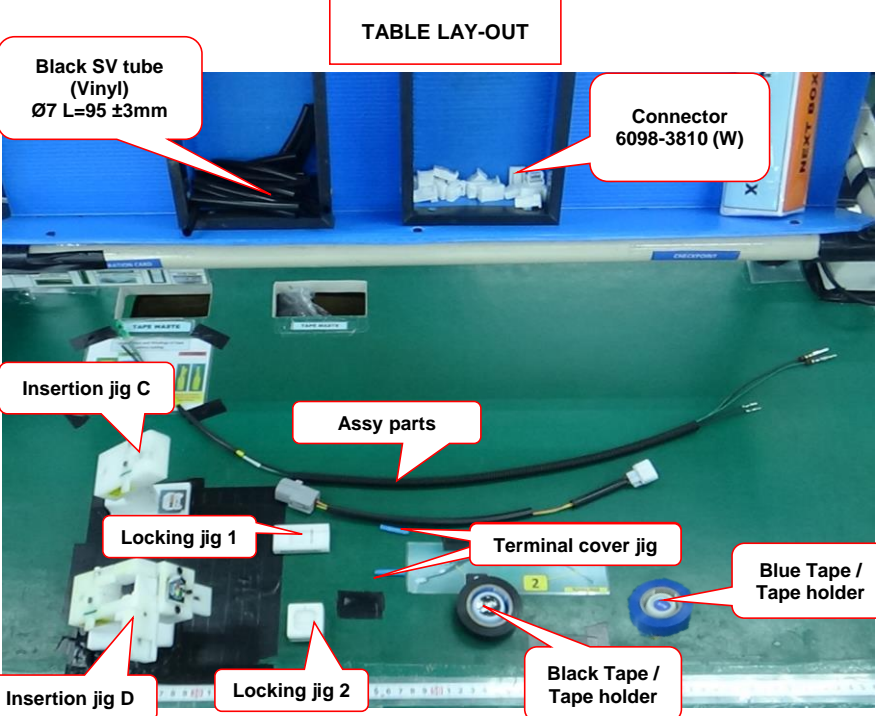
	WORK INSTRUCTION			Effectivity Date:	October 1, 2024		
	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Process Name/Title:			Document No.:	WI-ENG-PDE-1073B		
	Model code/Part number:	500B / 7L0084-7023A	Customer:	TRQSS	Car Model:	TOYOTA-SIENNA	
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	1 of 10

PARTS:		1. All parts: Connector 6098-3810 (W); B wires L=710±3mm; Black SV tube (vinyl) Ø7 L=95±3mm; Black tape; Blue tape				JIG:		1. Insertion jig 2. Locking jig 3. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	P2	<div> <div>TABLE LAY-OUT</div>  </div>				<div> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>		Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance	
Revision History						Prepared by	Reviewed by	Approved by	Noted by
10/1/24	1	Change purpose from pre-launch to Masspro.				M. Ariola	C. Villanueva	A. Arañes	n/a
9/20/24	0	Initial Issue. Transfer process 2 and 7-10 from P1 to P2, process 11 from P3 to P2 and change process sequence process 4-6 due to Process improvement. Inclusion of car model "TOYOTA-SIENNA" Improved Table lay-out and Visual inspection/Quality checkpoints.				M. Ariola	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted
						Est. Date:	September 21, 2024		

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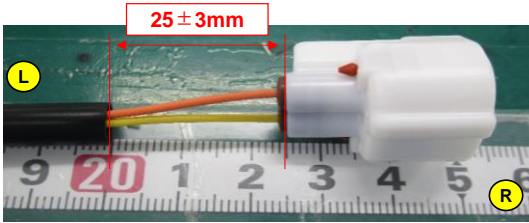
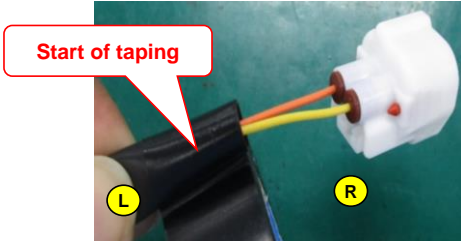
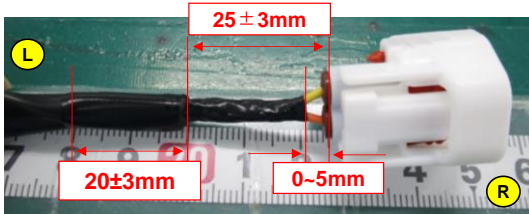


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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Taping 2 SV tube (Vinyl) to wire near Connector	<div></div> <div></div> <div></div> <div></div>		<div>MEASURING TAPE</div> 	<p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <p>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <ul style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension

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PARTS:		1. Connector 6098-3810 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	<div><div>INSERTION JIG</div><div><div>Holes</div><div>Lock</div></div><div>INSERTION JIG ORIENTATION</div><div><div>I-MARK</div><div>CONNECTOR ORIENTATION</div></div><div><div>L</div><div>R</div><div>Press</div><div>Press</div><div>Release</div></div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6098-3810 (W) into jig using right hand and release the lock. Note: Follow the connector orientation.</div><div>3. Check the holes/terminal slot for B-B wires.</div></div>		n/a	<div><div>Connector Orientation Illustration</div><div><div>I-mark was align</div><div>2 holes were only open</div><div>GOOD</div></div><div><div>I-mark is NOT align</div><div>All holes were open</div><div>NG</div></div><div>CONNECTOR ILLUSTRATION</div><div><div>GOOD</div><div>NG</div></div><div><div>6098-3810 (W)</div><div>6098-5677 (W)</div></div><div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div></div>

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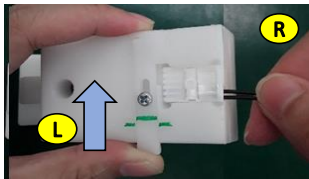
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PARTS:		1. Assy parts 2. Black SV tube (vinyl) Ø7 L=95±3mm		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Wire insertion to Black SV tube (vinyl) Ø7 L=95±3mm	<div></div> <div>1. Get the Black SV tube (vinyl) Ø7 L=95 ± 3mm using right hand and insert the wires.</div>	n/a	1. No wrong usage of parts 2. No deformed terminal
5		Wire insertion to connector 6098-3810 (W)	<div></div> <div></div> <div>1. Get the 1st Black wire then insert to connector slot 1 using right hand.</div> <div></div> <div>2. Get the 2nd Black wire then insert to connector slot 2 using right hand.</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>	n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force. 3. Insertion of wires must be from left to right 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

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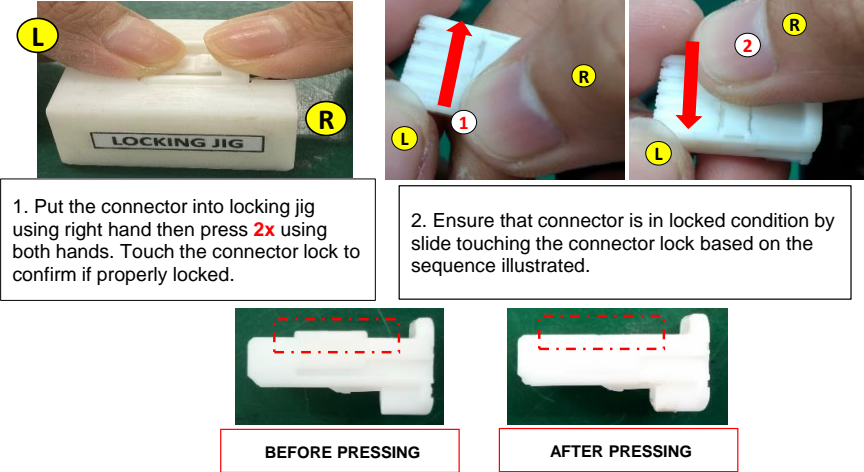

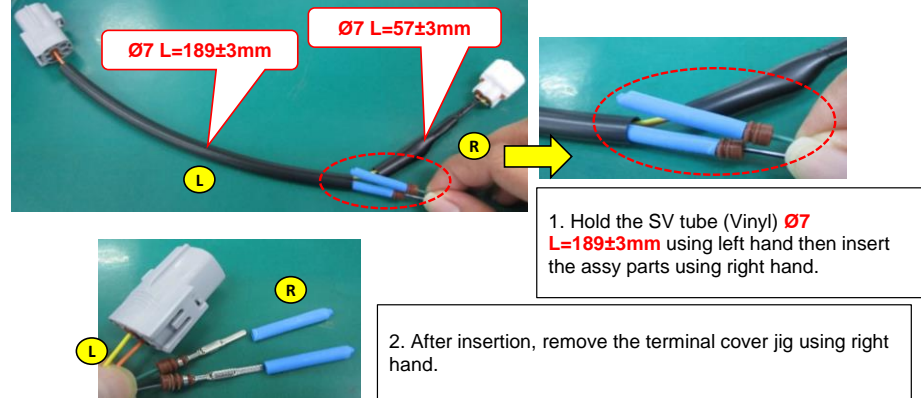

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PARTS:		1. Assy parts		JIG:	1. Locking jig 2. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	Connector Lock	 <p>1. Put the connector into locking jig using right hand then press 2x using both hands. Touch the connector lock to confirm if properly locked.</p> <p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p> <p>BEFORE PRESSING AFTER PRESSING</p>			<p>Important reminders/Note/s:</p> <p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <p>CONNECTOR LOCK CONDITION</p> <p>GOOD NG</p> <p>Fully Locked UnLocked</p> <p>1. Use the provided locking jig per model 2. No unlock/half-locked connector</p>
7	Wire (G / BW) insertion to Assy parts (Black SV tube (Vinyl) Ø7 L-189±3mm)	 <p>1. Hold the SV tube (Vinyl) Ø7 L=189±3mm using left hand then insert the assy parts using right hand.</p> <p>2. After insertion, remove the terminal cover jig using right hand.</p>			<p>1. No wrong usage of parts 2. No damaged rubber seal</p>

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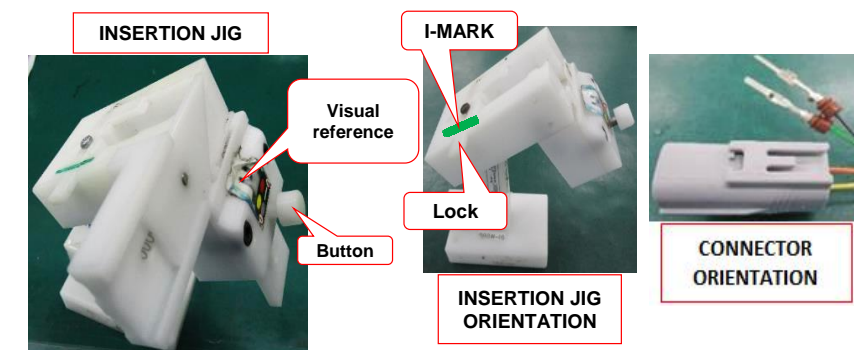
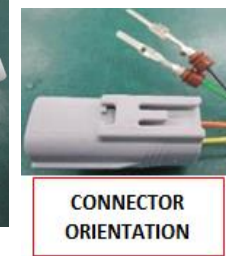

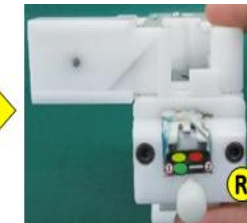
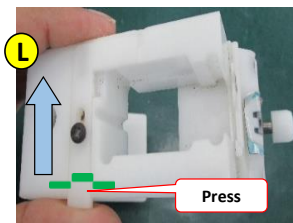
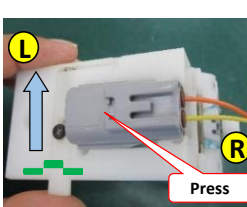
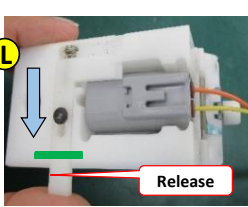
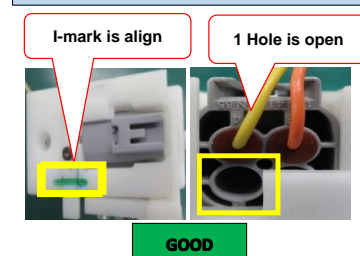

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PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P2	<p>Connector setting to insertion jig 6188-0066 (GR) (Assy parts)</p>      <p>1. Press the guide using right thumb. The slot for G wire will be opened.</p>   <p>2. Press the lock of insertion jig using left thumb.</p> <p>3. Insert the connector 6188-0066 (GR) with inserted Y/OR wire using right hand. Note: Follow the connector orientation.</p>		n/a	<p>Connector Orientation Illustration</p>   <p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p>

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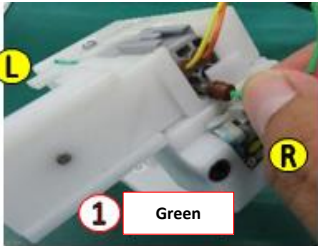

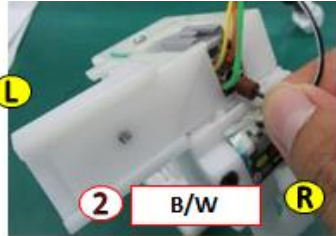

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PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P2 Wire insertion to connector 6188-0066 (GR) (Assy parts)	<div><div>WIRE FACING</div></div> <div><div></div><div>1. Hold the insertion jig using left hand, get G wire then insert to connector slot 1 using right hand.</div></div> <div><div></div><div>2. Press the button using right hand, slot for B/W wire will be opened.</div></div> <div><div></div><div>3. Hold the insertion jig using left hand, get B/W wire then insert to connector slot 2 using right hand.</div></div> <div><div></div><div>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.</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>Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</div> <div>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>

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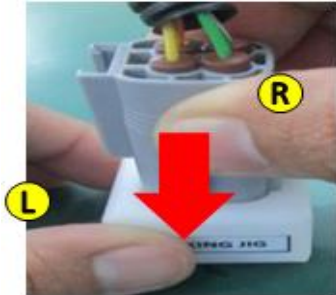


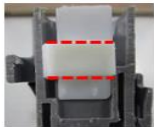
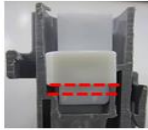


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PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	P2	<div><div><div></div><div><p>1. Put the connector into locking jig using both hands and then press 2x using both hands. Check the connector if properly locked.</p></div></div><div><div><div><p>BEFORE PRESSING</p></div><div><p>AFTER PRESSING</p></div></div><div><div><p>Coupler Cross Sectional View</p><div><div><p>NG</p><p>Unlock</p></div><div><p>NG</p><p>Half Lock Condition</p></div><div><p>GOOD</p><p>Full Lock Condition</p></div></div></div></div></div><div><div><p>LOCKING JIG</p></div></div></div>	<div><p>1. Use the provided locking jig per model</p><p>2. No unlock/half-locked connector</p><p>3. No damage connector</p></div>	

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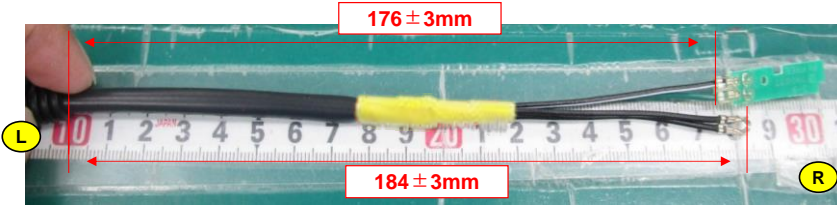
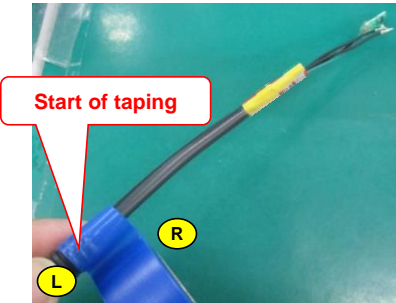


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PARTS:		1. Assy parts 2. Blue tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P2	<p>Taping 3 Black VM tube (sunprene) to wire near hotmelted wires and terminal pointed tip</p>  <p>1. Measure from end of VM tube (Sunprene) up to edge of hotmelted wire $176\pm 3\text{mm}$ and up to terminal pointed tip $184\pm 3\text{mm}$ using both hands.</p>  <p>2. Get the Blue tape using right hand then start taping process using both hands.</p>  <p>3. After taping, check the measurement and taping condition.</p>			<p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <p>Important reminders/Note/s:</p> <p>1. Use BLUE TAPE only</p> <p>2. 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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PARTS:

1. Assy parts

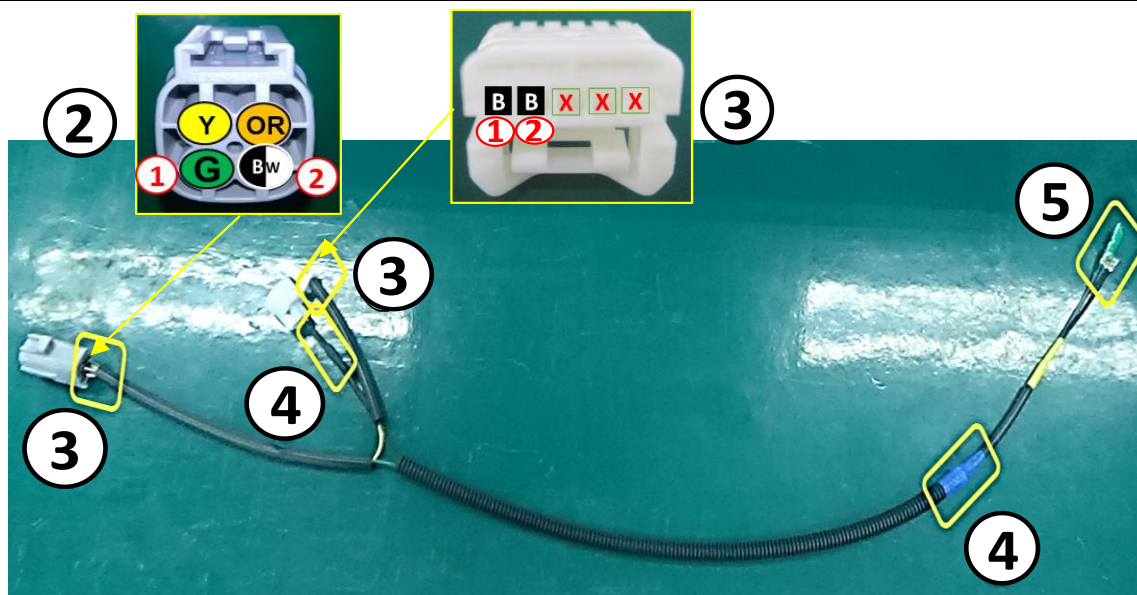
JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING - P2

7L0084-7023A



- 1 No Unlocked /Half-locked Connector
- 2 3 No Wrong insert
- 4 No Wrong wrong color of tape (COT to VM tube (Sunprene) (Blue) SV tube (Vinyl) Black tape
- 5 No Deformed terminal

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