

	<b>WORK INSTRUCTION</b>						Effectivity Date:		April 08, 2025				
	<b>TAPING ASSEMBLY PROCESS</b>						Validity Date:		n/a				
	Process Name/Title:			Model code/Part number: <b>521B / 7M0656-7020</b>			Customer: <b>TRJ</b>		Car Model: <b>TOYOTA CAMRY</b>		Document No.:	<b>WI-ENG-PDE-1171B</b>	
	Purpose:			<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:		0	Page No.:

<b>PARTS:</b>	1. Assy Parts; Connector 6098-3802 (W); Black Tape						JIG:	1. Insertion Jig 2. Locking jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>						<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
1	P2	<div style="border: 1px solid black; padding: 5px; display: inline-block; color: red; font-weight: bold;">Table Lay-out</div>						<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <b>Housekeeping</b>            1. Maintain and always practice 5's.            2. Personal things on the workplace is prohibited. Keep it in your locker.         </div> <div style="border: 1px dashed red; padding: 5px;"> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>	1. No missing parts/tools 2. No excess parts/tools

Revision History								Prepared by	Checked by	Reviewed by	Approved by
								 A. Hernandez	 J. Loterte	 C. Villanueva	 A. Arañes
03/08/25	0	Initial issue. Split type process transfer from P1.	A. Hernandez	J. Loterte	C. Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved					

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March 08, 2025

Process Name/Title:

Model code/Part number:

521B / 7M0656-7020

Customer: TRJ

Car Model: TOYOTA CAMRY

Validity Date:

n/a

Document No.:

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Purpose:



PROTOTYPE



PRE-LAUNCH



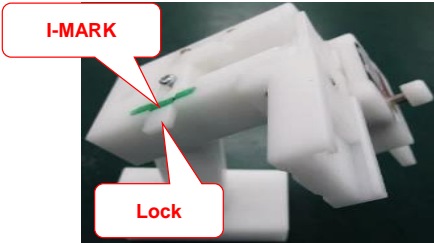

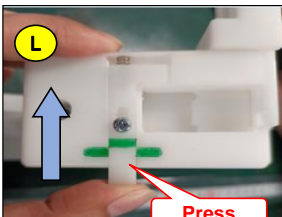
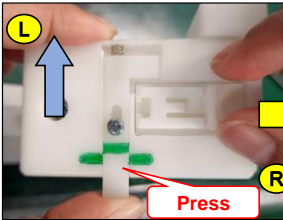
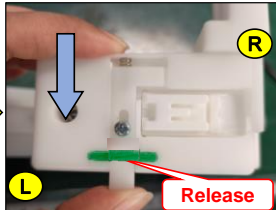
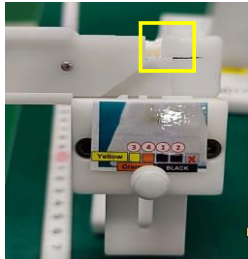
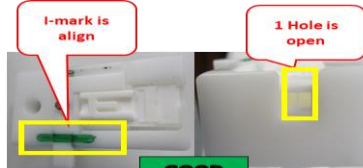

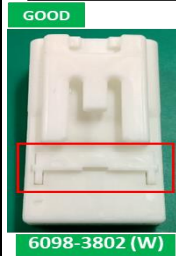
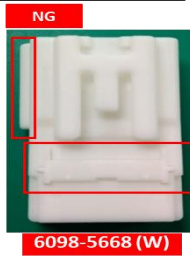
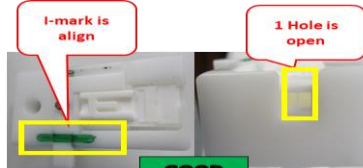

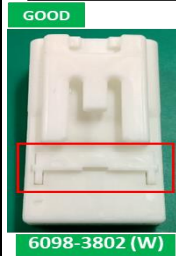
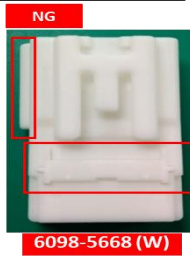
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PARTS:	1. Connector 6098-3802 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2  Connector setting to insertion jig 6098-3802 (W)	<div><div></div><div></div></div> <div><div></div><div></div><div></div></div> <div><div><p>1. Press the lock of insertion jig using left hand.</p></div><div><p>2. Get the connector using then Insert the connector <b>6098-3802 (W)</b> using right hand into jig using and release the lock. <b>Note: Follow the connector orientation.</b></p></div><div></div><div><p>3. Do not push the lower wire guide upward. Slot for <b>2 Black wires</b> must be open.</p></div></div> <div>n/a</div> <td><div><p>1. Use the provided jig per model 2. No wrong orientation of the connector. 3. No wrong use of connector 4. No damaged connector.</p></div><div><div>Connector Orientation Illustration</div><div><div></div><div></div></div><div><div>CONNECTOR ILLUSTRATION</div><div><div></div><div></div></div></div></div></td>	<div><p>1. Use the provided jig per model 2. No wrong orientation of the connector. 3. No wrong use of connector 4. No damaged connector.</p></div> <div><div>Connector Orientation Illustration</div><div><div></div><div></div></div><div><div>CONNECTOR ILLUSTRATION</div><div><div></div><div></div></div></div></div>	

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

Effectivity Date:

March 08, 2025

Process Name/Title:

Model code/Part number:

521B / 7M0656-7020

Customer:

TRJ

Car Model:

TOYOTA CAMRY

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1171B

Purpose:



PROTOTYPE



PRE-LAUNCH



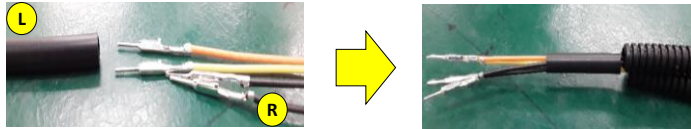



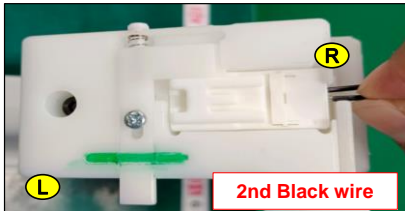
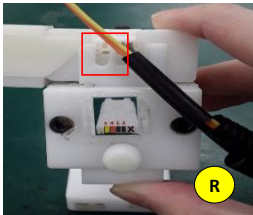
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PARTS:		1.Black SV tube (Viny) Ø5 L= 30±3mm 2. Assy parts		JIG:	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to Black SV tube (Viny) Ø5 L= 30±3mm	<div></div> <div>1. Combine the assy parts (Y-OR wires with COT Ø5 L= 254±3mm and 2 Black wires with COT Ø5 L= 390±3mm) then get the <b>SV tube (Viny) Ø5 L= 30±3mm</b> using left hand and insert the wires using right hand.</div>		n/a	1. No wrong use of parts
4	P2  Wire insertion to Connector 6098-3802 (W)	<div><div><div>VISUAL REFERENCE</div></div><div><div>TERMINAL FACING</div></div></div> <div><div><div>1st Black wire</div></div><div><div>2nd Black wire</div></div></div> <div><div></div><div>3. Press the lower guide using right hand. Slot for <b>Yellow wire</b> will be open.</div></div> <div>1. Hold the insertion jig using left hand. Insert the <b>1st Black wire</b> to connector using right hand. Conduct <b>2x push-pull</b> after insertion.</div> <div>2. Get the <b>2nd Black wire</b> then insert to connector using right hand. Conduct <b>2x push-pull</b> after insertion.</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>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal.</b> <b>2. Insertion must be from left to right.</b> <b>3. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b></div> <div><b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b></div>

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Model code/Part number:

521B / 7M0656-7020

Customer: TRJ

Car Model: TOYOTA CAMRY

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Purpose:



PROTOTYPE



PRE-LAUNCH





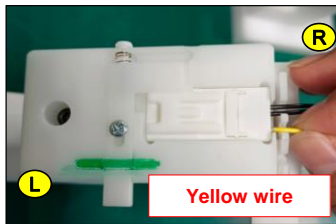
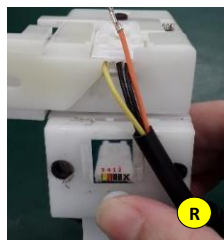
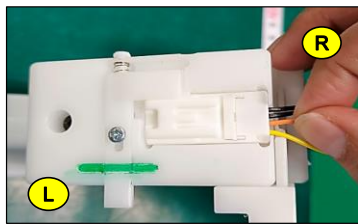

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PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2	<div><div><div><div><div></div><div>VISUAL REFERENCE</div></div><div></div></div><div><div><div></div><div>TERMINAL FACING</div></div><div></div></div></div><div><div><div><div><div></div><div>Yellow wire</div></div><div></div></div><div><div><div></div><div>4. Hold the insertion jig using left hand. Get the <b>Yellow wire</b> to connector using right hand. Conduct <b>2x push-pull</b> after insertion.</div></div></div></div><div><div><div><div><div></div><div>Yellow wire</div></div><div></div></div><div><div><div></div><div>5. Press the button of insertion jig using right hand and slot for <b>Orange wire</b> will be open.</div></div></div></div><div><div><div><div><div></div><div>Orange wire</div></div><div></div></div><div><div><div></div><div>6. Hold the insertion jig using left hand. Get the <b>Orange wire</b> to connector using right hand. Conduct <b>2x push-pull</b> after insertion.</div></div></div></div><div><div><div><div><div></div><div>Orange wire</div></div><div></div></div><div><div><div></div><div>7. 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></div></div><div>n/a</div><div><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><p><b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal.</b> <b>2. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b> <b>3. Insertion of wires must be from left to right</b></p><p><b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b></p></div></div></div></div></div>		

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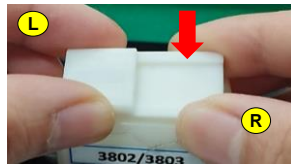



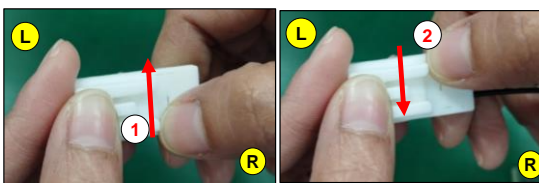





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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P2	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div> <div><p>2. Press the lower 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>6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div>		<div><p>LOCKING JIG</p></div>	<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> <div><p>Before pressing</p><p>After pressing</p></div> <div><div><p>GOOD Full Lock</p></div><div><p>NG Half Lock</p></div></div> <p><b>Important reminders/Note/s:</b> <b>1. Manual locking may cause damaged connector lock.</b></p>

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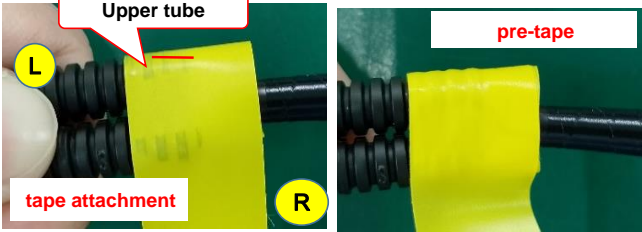
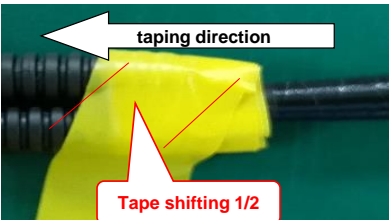

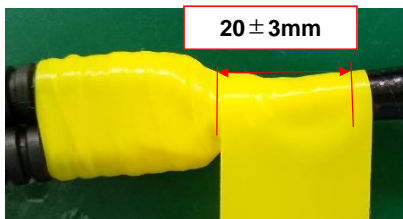
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PARTS:		1. Assy Parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P2	Y-taping			
<div><div></div><div><div><p>1. Fix the 3 corrugated tube. <b>Note: Follow the correct facing. (If need to standard)</b></p></div><div></div><div><div></div><div><p>3. Winding the tape <b>1/2 shifting</b> going to the left side.</p></div><div></div><div><p>5. Winding the tape <b>1/3 shifting</b> going to the right side until reach the other side of tube.</p></div><div></div><div><p>6. Make <b>2 windings</b>, width must be <b>20±3mm</b>.</p></div></div><div><p>2. Start taping at the middle of combined tubes, attach the tape on the upper tube. Then make pre-tape <b>2 windings</b>. <b>Note: Do not exert excessive force during pulling &amp; winding of tape.</b></p></div><div><p>4. Make <b>2 windings</b>, width must be - <b>20±2mm</b>.</p></div></div><div><p><b>Document reference/s:</b> <b>1. Refer to WI-PRO-ASY-001C for taping procedure (special).</b></p><p><b>Important reminders/Note/s:</b> <b>1. Use yellow tape for easy visualization of tape shifting, but actual should be BLACK TAPE.</b> <b>2. Please use calibrated/verified measuring tape when getting the measurement.</b></p><ol style="list-style-type: none"><li>1. No loose tape</li><li>2. No flip-out tape</li><li>3. No peel-off tape</li><li>4. No wrong use of tape</li><li>5. No wrong dimension-out tape</li><li>6. No exposed wire</li><li>7. No gap between tubes</li></ol></div></div>					

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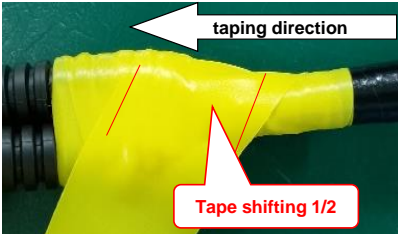
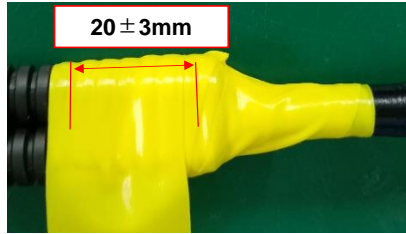
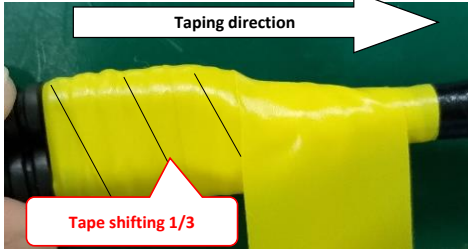
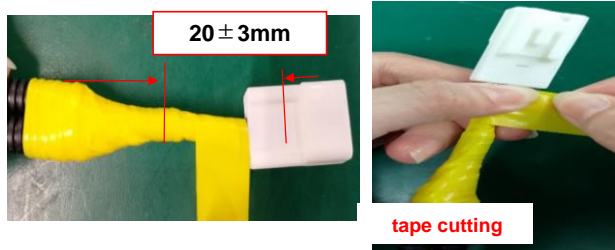
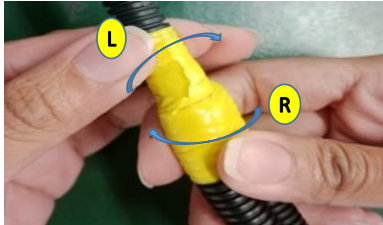
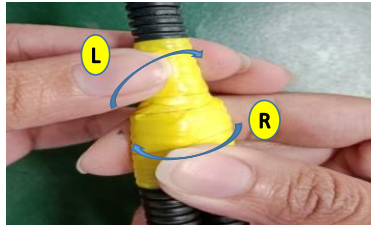

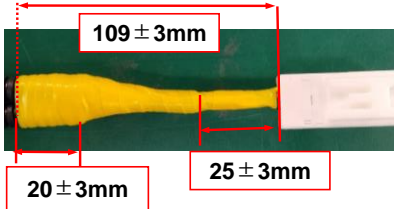
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PARTS:		1. Assy Parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P2  Y-taping (Continuation)	<div><div></div><div><p>7. Winding the tape <b>1/2 shifting</b> going to the left side.</p></div><div></div><div><p>8. Make <b>2 windings</b>, width must be <b>20±3mm</b>.</p></div><div></div><div><p>9. Winding the tape <b>1/3 shifting</b> going to the right side until it reach the other side of tube</p></div><div></div><div><p>10. Make <b>3 winds</b>, width must be <b>20±3mm</b>. Then cut the tape.</p></div><div></div><div><p>11. conduct proper pressing of end tape using left hand (<b>top part</b>). <b>Note: Reference only.</b></p></div><div></div><div><p>12. conduct proper pressing of end tape using left hand (<b>Middle part</b>). <b>Note: Reference only.</b></p></div><div></div><div><p>13. conduct proper pressing of end tape using left hand (<b>bottom part</b>). <b>Note: Reference only.</b></p></div><div></div><div><p>14. Check the Measurement and condition of tape.</p></div></div>			<p><b>Document reference/s:</b> <b>1. Refer to WI-PRO-ASY-001C for taping procedure (special).</b></p> <p><b>Important reminders/Note/s:</b> <b>1. Use yellow tape for easy visualization of tape shifting, but actual should be BLACK TAPE.</b> <b>2. Please use calibrated/verified measuring tape when getting the measurement.</b></p> <ol style="list-style-type: none"><li>1. No loose tape</li><li>2. No flip-out tape</li><li>3. No peel-off tape</li><li>4. No wrong use of tape</li><li>5. No wrong dimension-out tape</li><li>6. No exposed wire</li><li>7. No gap between tubes</li></ol>

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Process Name/Title:

Model code/Part number:

**521B / 7M0656-7020**Customer: **TRJ**Car Model: **TOYOTA CAMRY**

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P2 Measurement	<div><div><div>③ 131 ±3</div><div>② 31 ±3</div><div>⑤ 20 ±3</div><div>④ 20 ±3</div><div>① 0 +2 0</div><div>Sunprene tube(B) ø9</div></div><div><div>⑧ 25 ±3</div><div>⑩ 0 +5 0</div><div>⑨ 109 ±5</div><div>Vinyl tube(B) ø5</div></div><div><div>⑪ 20 ±3</div><div>⑫ 161 ±10</div><div>⑬ 117 ±10</div><div>⑭ 0 +5 0</div><div>COT(B) ø5</div></div><div><div>⑥ 20 ±3</div><div>⑦ 20 ±3</div><div>COT &amp; Wire Taping</div></div></div>	<div>MEASURING TAPE</div> 	<div>1. No wrong dimension</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 <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div>

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

March 08, 2025

Validity Date:

n/a

Model code/Part number:

**521B / 7M0656-7020**Customer: **TRJ**Car Model: **TOYOTA CAMRY**

Document No.:

**WI-ENG-PDE-1171B**

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

0

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PARTS:

n/a

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P2****7M0656-7020****1 No Unlocked/  
Half-locked connector****2 No Missing SV Tube (vinyl)****6 No Missing Tape****2 No Wrong Insert****4 No Deformed terminal****7 No Wrong Facing  
of Y-Taping****5 No Terminal backing out**

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