

	WORK INSTRUCTION					Effectivity Date:		June 18, 2024		
	TAPING ASSEMBLY PROCESS					Validity Date:		n/a		
	Process Name/Title:		Model code/Part number: 310D / 7M0528-7020D		Customer: TRJ	Car Model: TOYOTA RAV4	Document No.:		WI-ENG-PDE-033A	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		7	Page No.:	1 of 6	

PARTS:		1. Assy parts; Connector 6098-6663 (B); Black Corrugated tube (no slit) $\phi 5$ L=399 \pm 3mm; AVSSf 0.3 wires B L=569 \pm 3mm; Black tape				JIG:		1. Insertion jig 2. Locking jig	
NO.	PROCESS NAME	<div style="border: 1px solid black; padding: 5px; display: inline-block;">7</div> WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	P1 Table Lay-out	<div style="text-align: center;"> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;">Table Lay-out</div> </div>				<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Housekeeping 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 solid red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>		Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. 2. Refer to WI-ENG-PDE-109 for Offline assembly process.	

Revision History										
06/18/24	7	Transfer COT to wire insertion from Offline assembly process and transfer Spot taping to P2 due to process improvement. Inclusion of car model "TOYOTA-RAV 4", Table lay-out and Visual inspection/Quality checkpoints. Standardize term of SV tube (Vinyl). Update Connector lock Work procedure/Illustration process.	D. Castillo	C. Villanueva	A. Arañes	n/a	Prepared by	Reviewed by	Approved by	Noted by
05/12/21	6	Removal of validity date. Apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
11/11/20	5	Changed effectivity and validity date. Remove cycle time.	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	July 02, 2018		

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☐ PROTOTYPE

☐ PRE-LAUNCH


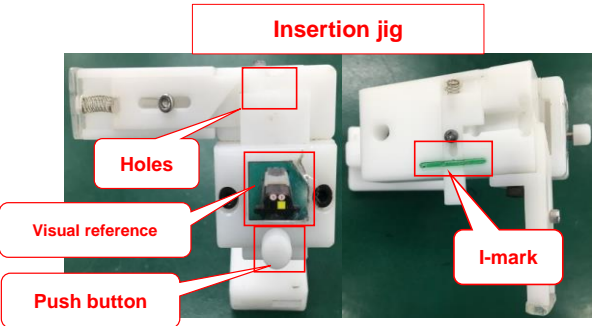
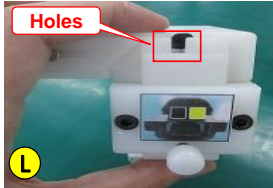
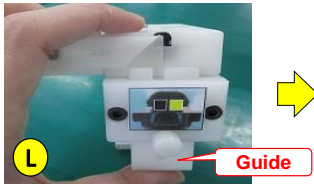
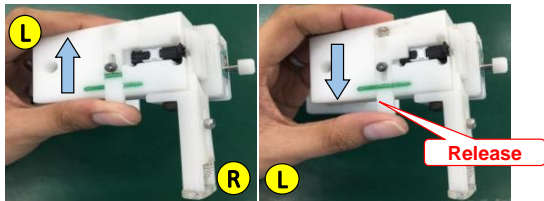
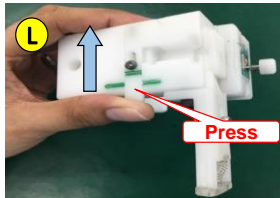
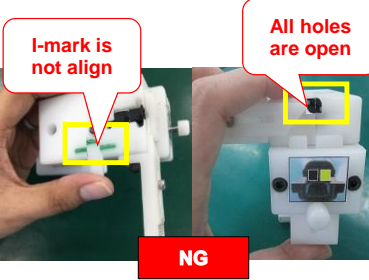
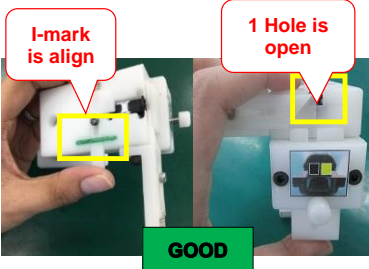
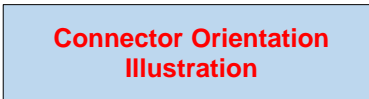
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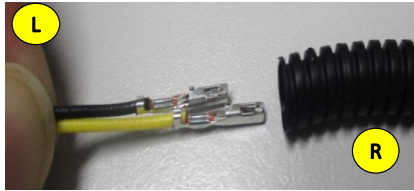

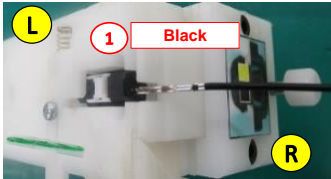


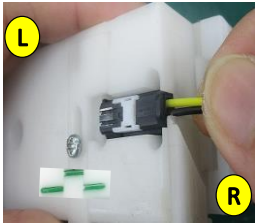
PARTS:	1. Connector 6098-6663 (B)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Connector setting to insertion jig 6098-6663 (B)	<div><div></div><div></div><div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the connector 6098-6663 (B) into jig using right hand and release the lock.</p><p>3. Push the guide using left thumb. The slot for B wire will be opened.</p></div></div>	n/a	<div><div></div><div><p>1. Use the provided jig per model</p><p>2. No wrong orientation of connector</p><p>3. No wrong use of connector</p><p>4. No damaged connector</p></div></div>

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	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 310D / 7M0528-7020D		Customer: TRJ	Car Model: TOYOTA RAV4	Document No.:	WI-ENG-PDE-033A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	7	Page No.:	3 of 6

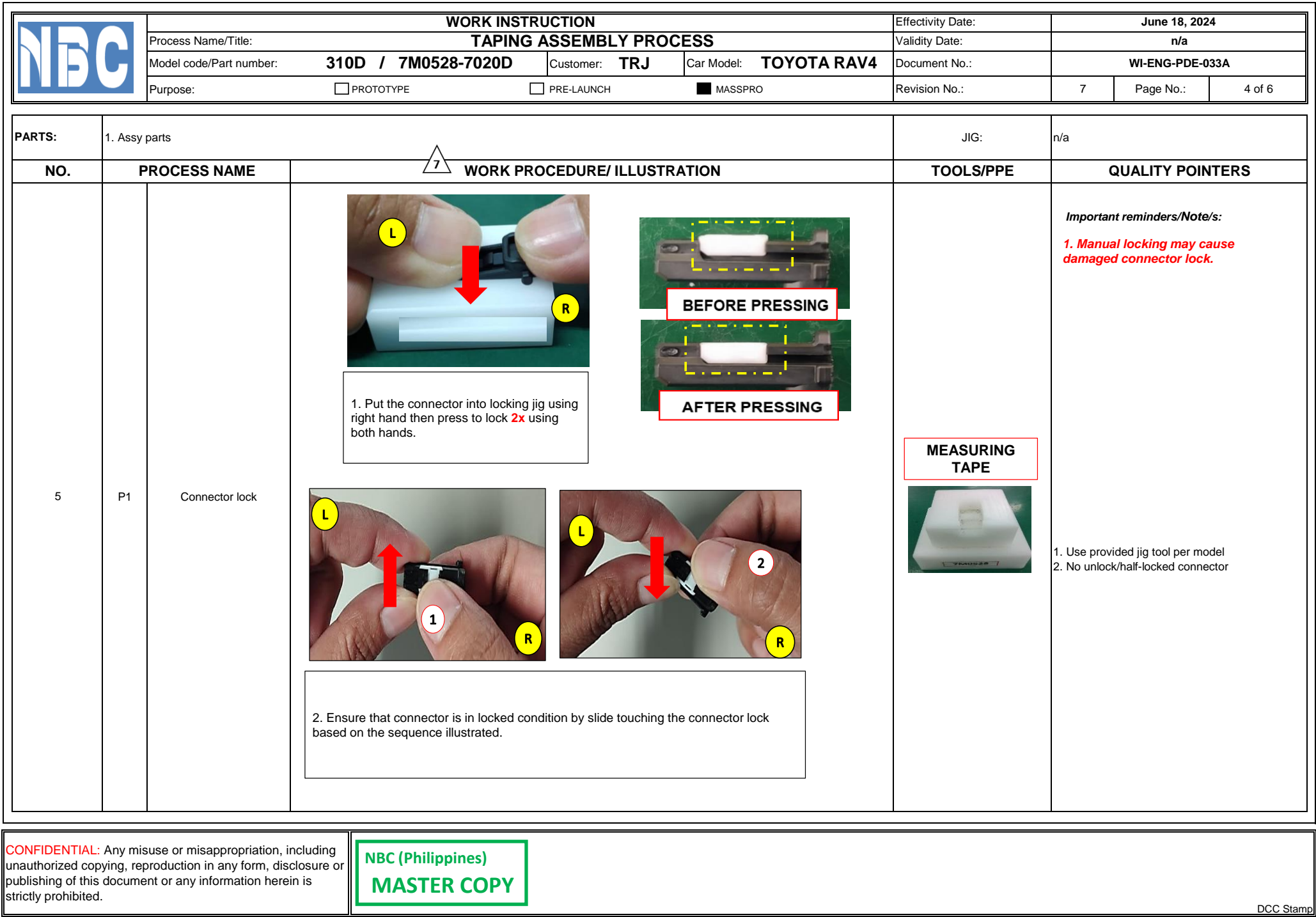
PARTS:	1. Assy parts 2. Black Corrugated tube (no slit) ø5 L=399±3mm		JIG:	1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	<div>7</div> Wire insertion to Black Corrugated tube (no slit) ø5 L=399±3mm	<div> 1. Get the B wire L=569±3mm using left hand and combine to Y wire.</div> <div> 2. Get the corrugated tube (no slit) ø5 L=399±3mm using right hand then insert the B-Y wires using left hand.</div>	n/a	1. No Wrong used of parts 2. No deformed terminal	
4	P1 Wire insertion to connector 6098-6663 (B)	<div> Wire facing</div> <div> 1. Get the B wire and insert to terminal slot 1 using right hand.</div> <div> 2. After insertion of B wire press the button using right hand. The slot for Y wire will be opened.</div> <div> 3. Get the Y wire then insert to terminal slot 2 using right hand.</div> <div> 4. After insertion , push the lock using left hand and then hold the wire and gently pull out the connector from jig using right hand.</div>	n/a	Important reminders/Note/s: 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing.	

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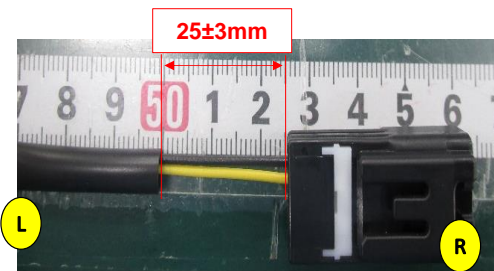
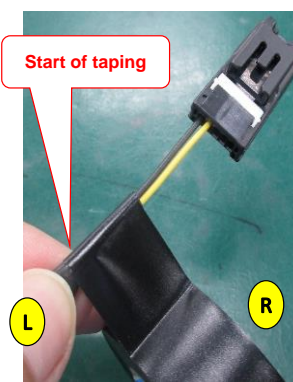
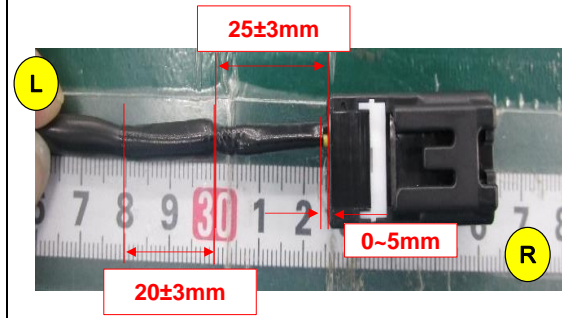

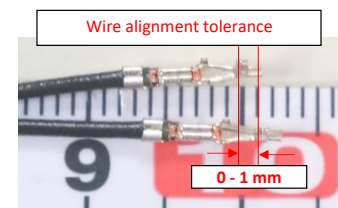
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PARTS:		1. Assy parts 2. Black tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1 Taping 1 Black SV tube (Vinyl) to wire near connector	<div><p>1. Hold the SV tube (Vinyl) using left hand and measure from end of SV tube (Vinyl) up to connector 25±3mm.</p></div> <div><p>2. Hold the SV tube (Vinyl) using left hand and begin taping using right hand.</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>	<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document references: 1. Refer to WI-PRO-ASY-001 for Taping process</p> <ol style="list-style-type: none">1. No loose tape2. No flip-out tape3. No peel-off tape4. No wrong dimension5. No wrong use of tape <div></div>

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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P1****7M0528-7020D**

1

**GOOD****NO GOOD**

3

**GOOD****NO GOOD**

2

4

5

1 No Unlocked/Half-locked Connector**2 No Wrong Insert****4 No Deformed Terminal****3 No Terminal Backing Out****5 No Missing Of Tape**

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