



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

September 21, 2024

Model code/Part number:

310B / 7M0529-7020C

Customer:

TRJ

Car Model:

TOYOTA-RAV4

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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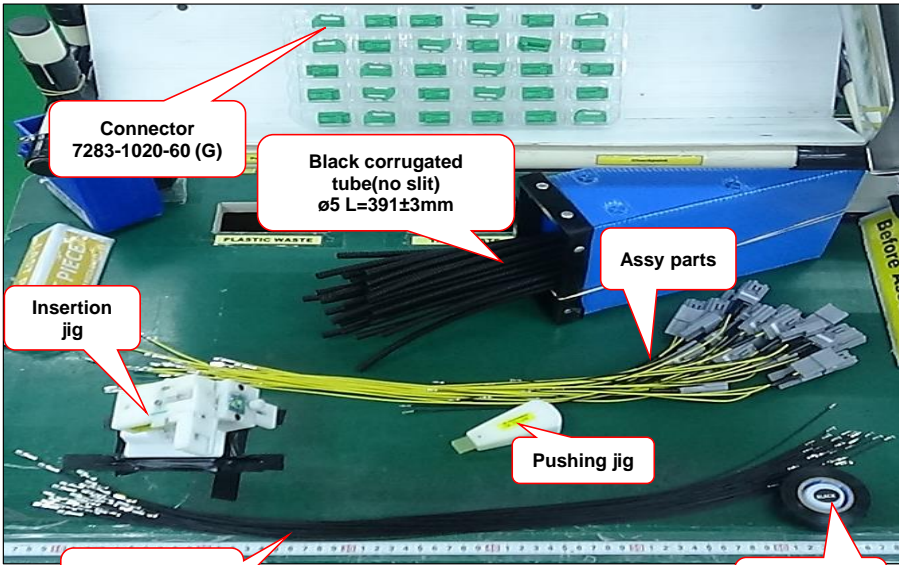
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PARTS:

1. Assy parts: Connector 7283-1020-60 (G); Avssf 0.3 B L= 563mm; Black corrugated tube(no slit) ø5 L=391±3mm;Black tape 20mm

JIG:

1. Insertion jig
2. Pushing jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Table Lay-out		<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<ol style="list-style-type: none">1. No missing parts/tools2. No excess parts/tools <p>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length tolerance.</p>

Revision History

							Prepared by	Reviewed by	Approved by	Noted by
09/21/24	9	Change table lay-out illustration. Inclusion wire insertion to black corrugated tube transferred from offline process. Batching the process no. 5, 7, 8, 9 and 11. Remove Visual/By two's inspection. Improvement of Visual inspection/Quality Checkpoints.	A. Hernandez	C. Villanueva	A. Arañes	n/a				
02/28/23	8	Set new std. taping of vinyl tube 24mm and below. Change measurement Taping 1 Taping 1 Black SV tube (Vinyl) to wire near connector from tape width to 15±3mm.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
02/17/23	7	Work instruction improvement: Change MP from 2MP to 1MP. Inclusion of table lay-out, batching and Quality checkpoint (Page 11). Change term of Vinyl tube to SV tube (Vinyl). Update quality pointers. Update connector lock process (Page 4). Improved By two's inspection.	D. Castillo	J. Loterte	C. Villanueva	A. Arañes	A. Hernandez	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	December 16,2022		

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WI-ENG-PDE-034A

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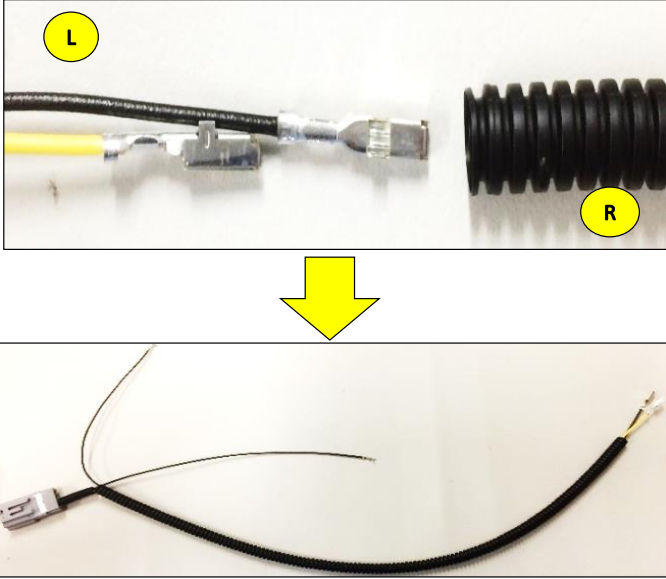
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PARTS:		1. Assy parts 2. Black Corrugated tube (no slit) $\varnothing 5$ L=391 \pm 3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1	<div></div> <div>1. Get the B wire L=563\pm3mm using right hand and combine it to Y wire then get the corrugated tube (no slit) $\varnothing 5$ L=391\pm3mm using right hand then insert the B-Y wires using left hand.</div>		n/a	1. No wrong use of parts 2. No deformed terminal

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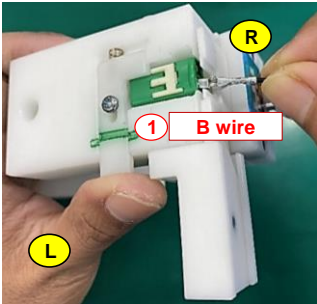
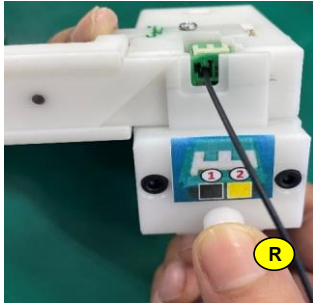
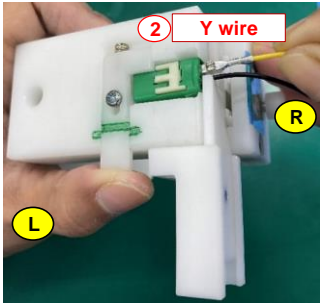
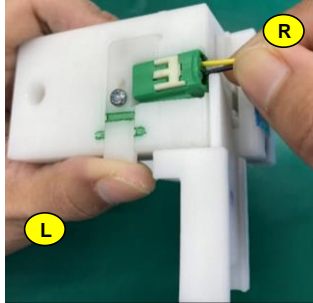
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PARTS:	1. Assy parts 2. Connector 7283-1020-60 (G)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1 Wire insertion to connector 7283-1020-60 (G)	<div><p>TERMINAL FACING</p></div> <div><p>1. Hold the B wire then insert to terminal slot 1 using right hand.</p></div> <div><p>2. After insertion of B wire press the button using right thumb. The slot for Y wire will be</p></div> <div><p>3. Hold t the Y wire then insert to terminal slot 2 using right hand.</p></div> <div><p>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.</p></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 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. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div>

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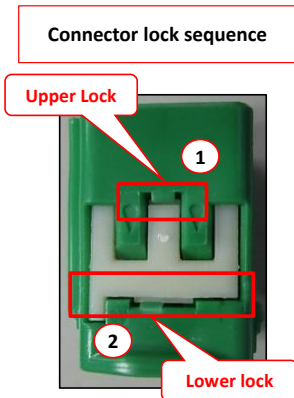




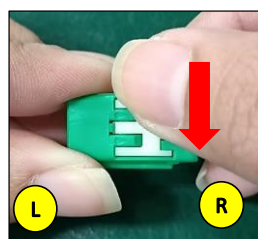
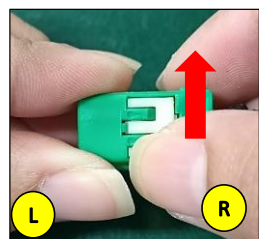
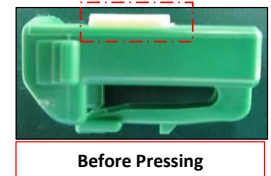
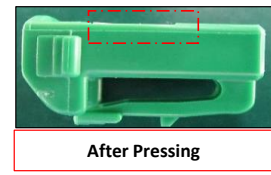

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PARTS:		1. Assy parts		JIG:	1. Pushing jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1	Connector Lock	<div><p>Connector lock sequence</p><p>Upper Lock</p><p>Lower lock</p></div> <div><p>1. Hold the connector using left hand and then place it on the table. Get the pushing jig and hit the upper lock of the connector and then push down to lock.</p><p>2. Hit the lower lock of the connector and then push down to lock.</p></div> <div><p>3. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div> <div><p>Before Pressing</p><p>After Pressing</p></div>	<p>PUSHING JIG</p> 	<p>1. Use the provided jig per connector</p> <p>2. No unlock/half-locked connector</p> <p>Important reminders/Note/s:</p> <p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p>

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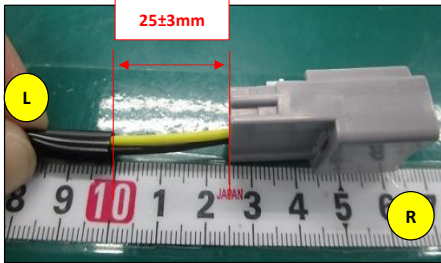
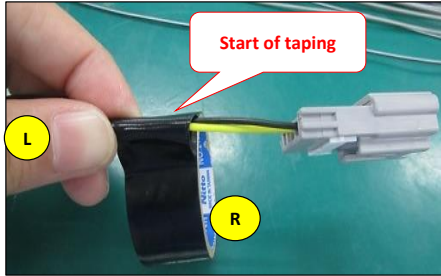
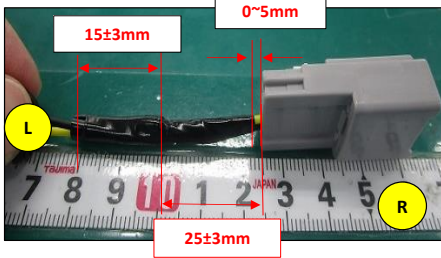

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1 Taping 1 Black SV tube (Vinyl) to wire near connector	<div></div> <div></div> <div></div> <div>1. Hold the Black SV tube(Vinyl) using left hand and measure from vinyl tube to connector 25±3mm.</div> <div>2. Hold the Black SV tube(Vinyl) using left hand, get the Black tape and begin taping using both hands.</div> <div>3. After taping, check the measurement and taping condition.</div>		<div></div>	<div>1. No flip-out tape 2.No peel-off tape 3. No loose tape 4. No wrong dimension 5. No wrong use of tape 6. No missing tape</div> <div>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Refer to WI-PRO-ASY-001 for taping procedure.</div>

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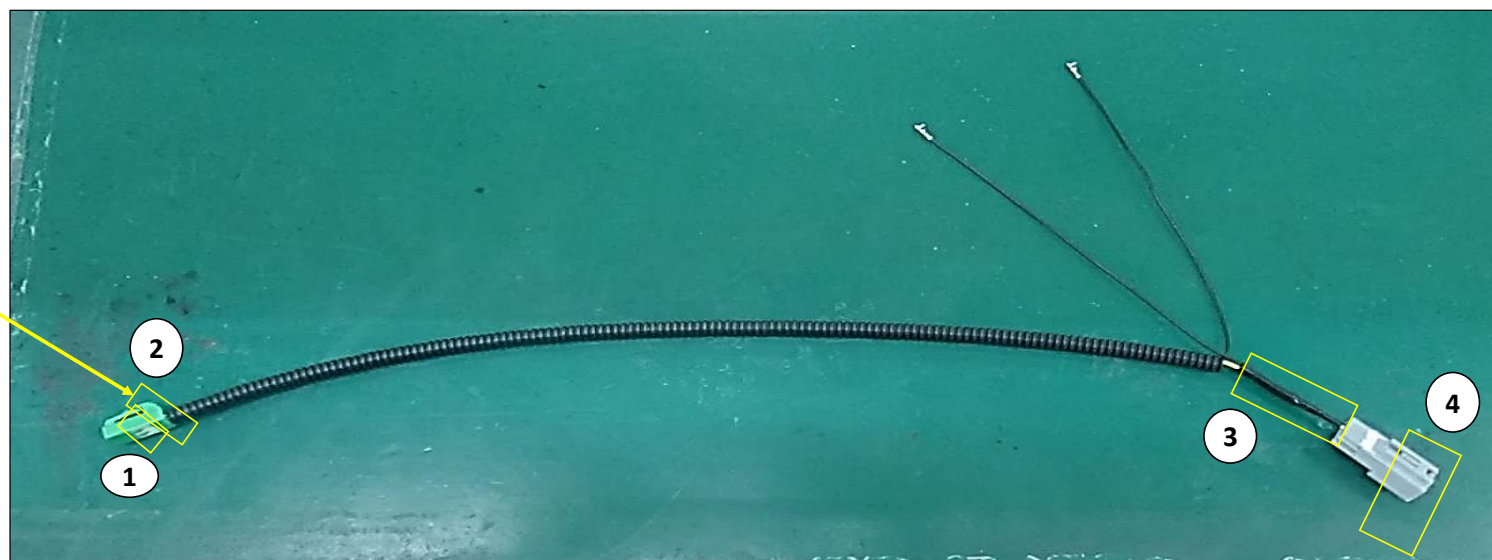
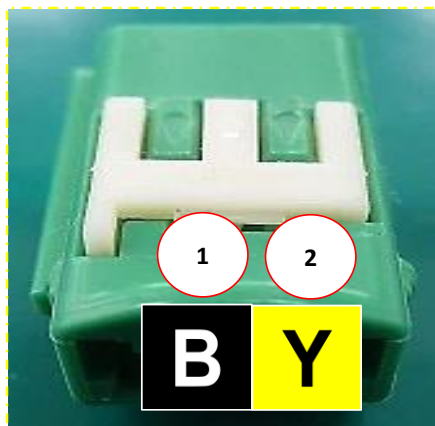
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n/a

JIG:

n/a

**VISUAL INSPECTION QUALITY CHECKPOINTS****P1****7M0529-7020C****1 No Unlocked/Half-locked Connector****3 No Missing tape (Black)****5 No Terminal****2 No Wrong Insert****4 No Deformed Terminal****Backing Out**

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