

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**

Effectivity Date:

October 22, 2024Model Code/Part number **550B / 7L0061-7023**Customer: **TRJ**Car Model: **TOYOTA-HIGHLANDER**

Validity Date:

n/aPurpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-017A

Revision No.:

9

Page No.:

1 of 14**PARTS:**

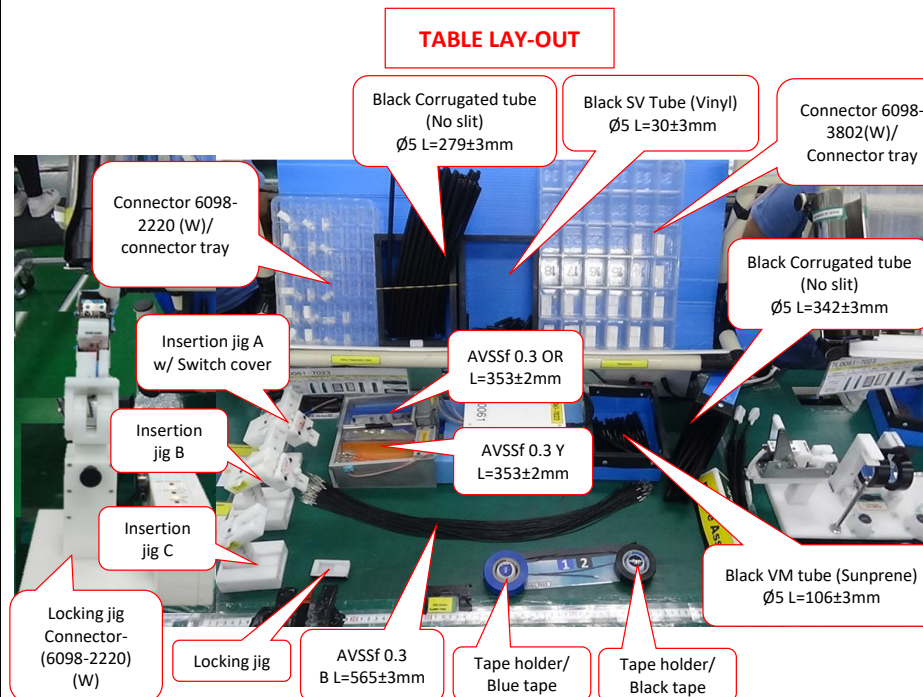
1. All parts: Connector 6098-2220 (W); AVSSf 0.3 Y/OR L=353±2mm; Black corrugated tube (no slit) Ø5 L=279±3mm; Black Sv tube (Vinyl) Ø5 L=30±3mm; Connector 6098-3802 (W); Black VM tube (Sunprene) Ø5 L=106±3mm; AVSSf 0.3 B L=565±3mm; Black Corrugated tube (no slit) Ø5 L=342±3mm; Black tape; Blue tape

JIG:

1. Insertion jig with and with/out Switch cover
2. Insertion jig
3. Locking jig

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****1****P1**

Table lay-out

**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.

1. No wrong usage of parts
2. No damaged rubber seal

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
10/22/24	9	Additional Work procedure/Illustration and notes on page 4-5 as countermeasure for the customer claim (Broken lock of connector 6098-2220 (W)).	D. Castillo	C. Villanueva	A. Arañes	n/a				
07/26/23	8	Update template; Inclusion of CAR MODEL "TOYOTA-HIGHLANDER" . Inclusion of Locking process of connector 6098-2220(W). Changed Wire color location from Y-OR to OR-Y.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
03/22/23	7	Correction of Work procedure/Illustration (Page 3 and 6).	D. Castillo	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 4, 2019		

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PARTS:		1.Connector 6098-2220 (W)			JIG	1. Insertion jig with switch cover	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	P1	Connector setting to insertion jig 6098-2220 (W)	<div><div><div><div><div>Insertion Jig with Switch Cover</div><div>Visual reference</div><div>OR-wire</div><div>Y-wire</div></div><div><div>I-mark</div><div>Lock</div></div><div><div>Connector Orientation</div><div>Insertion Jig Orientation</div></div></div><div><div><div><div>L</div><div>R</div></div><div>Press</div></div><div><div>L</div><div>R</div></div><div>Press</div></div><div><div>L</div><div>R</div></div><div>Release</div></div><div><div>1. Press the insertion jig lock using left hand.</div><div>2. Get the connector 6098-2220 (W) using right hand and insert to insertion jig. Release the lock after insertion.</div><div><div>L</div><div>R</div></div><div>3. Push the lower wire guide upward using right hand. Slot for yellow wire will be open.</div></div></div> <div>n/a</div> <td><div><div>CONNECTOR ORIENTATION ILLUSTRATION</div><div><div><div>I-mark is align</div><div>1 hole is open</div></div><div><div>GOOD</div></div></div><div><div><div>I-mark is not align</div><div>1 hole is open</div></div><div><div>NG</div></div></div></div><div><div>1. Use provided jig per model</div><div>2. No wrong orientation of connector</div></div></td>			<div><div>CONNECTOR ORIENTATION ILLUSTRATION</div><div><div><div>I-mark is align</div><div>1 hole is open</div></div><div><div>GOOD</div></div></div><div><div><div>I-mark is not align</div><div>1 hole is open</div></div><div><div>NG</div></div></div></div> <div><div>1. Use provided jig per model</div><div>2. No wrong orientation of connector</div></div>	

n/a

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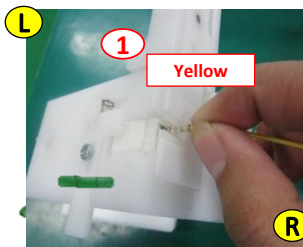
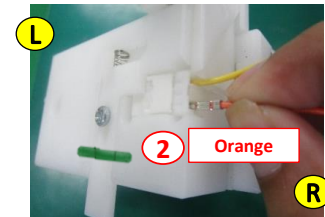
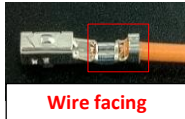
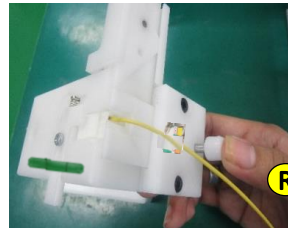
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PARTS:		1. AVSSf 0.3 Y L=353±2mm 2. AVSSf 0.3 OR L=353±2mm			JIG	1. Insetion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to Connector 6098-2220 (W)	<div><p>1. Get the Y wire then insert to terminal slot ① using right hand.</p></div> <div><p>3. Get the OR wire then insert to terminal slot ② using right hand.</p></div> <div><p>Wire facing</p></div> <div><p>2. After insertion of Y wire press the button using right thumb. The slot for OR wire will be opened.</p><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	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p>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.</p> <p>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</p>

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PARTS:

1. Assy parts

JIG

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

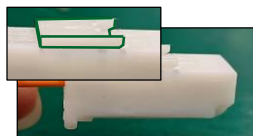
QUALITY POINTERS

4

P1

Connector lock

9

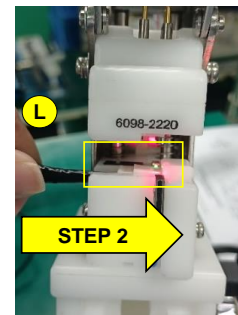
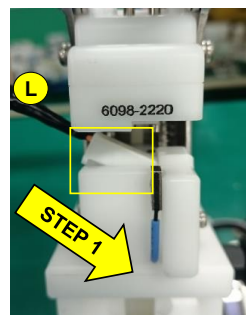
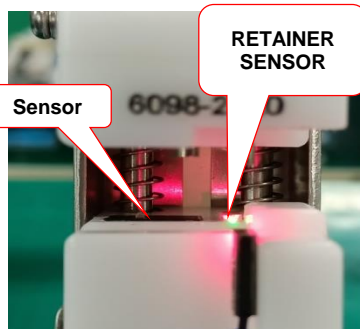
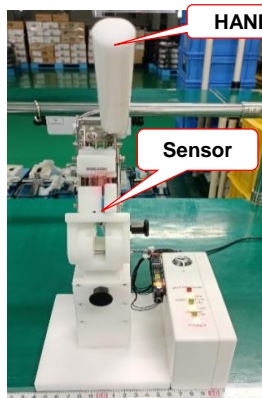
CONNECTOR RETAINER ILLUSTRATION
SIDE VIEW

GOOD



NG

1. Check the Retainer lock of connector before insertion to locking jig.
*Note: Must be **NO** half-locked condition prior connector locking.*



2. Hold the assy parts using left hand and insert into connector locking jig based on the direction of arrow. Make sure the connector touch the sensor. Sound will be heard if properly lock.

NOTE: CONNECTOR LOCKING JIG WILL NOT FUNCTION IF CONNECTOR NOT REACH THE SENSOR.

1. Please ensure that Connector lock/retainer will not touch or hit by any object prior insertion into locking jig to avoid half-lock connector.
2. Maintain 10mm proper holding of wire to connector
3. Connector must be fully inserted to connector slot.
4. Make sure no offset setting before locking process.
5. No wrong setting of connector.
6. No damaged connector lock
7. No unlocked/ half-locked connector.

Important reminders/Note/s:

1. *Incomplete locking process will alarm the jig.*
2. *No retainer in connector cannot proceed.*
3. *If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction and continue the process.*

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PARTS:

1. Assy parts

JIG

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

P1

Connector lock
(Continuation)

HOLD THE HANDLE

PULL-DOWN

SLIDE

SLIDE

STEP 1

STEP 2

2

1

STEP

1

2

STEP

3. Hold the handle of the connector locking jig using right hand then gently pull down and bring back to original position after locking. Note: Pull down one time only.

4. Remove the locked connector using left hand based on the illustration, follow the direction of arrow.

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

1. Please ensure that Connector lock/retainer will not touch or hit by any object prior insertion into locking jig to avoid half-lock connector.
2. Maintain 10mm proper holding of wire to connector
3. Connector must be fully inserted to connector slot.
4. Make sure no offset setting before locking process.
5. No wrong setting of connector.
6. No damaged connector lock
7. No unlocked/ half-locked connector


Important reminders/Note/s:



1. Incomplete locking process will alarm the jig.
2. No retainer in connector cannot proceed.
3. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.


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PARTS:		1. Assy parts 2. Black corrugated tube (no slit) $\phi 5$ L=279 \pm 3mm 3. Black SV tube (Vinyl) $\phi 5$ L=30 \pm 3mm				JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS
5	Wire insertion to Black corrugated tube (no slit) $\phi 5$ L=279 \pm 3mm	<div>  </div> <div> 1. Get the corrugated tube (no slit) $\phi 5$ L=279\pm3mm using right hand then insert the Y-OR wires using left hand. </div>				n/a	1. No wrong usage of parts 2. No deformed terminal
6	Wire insertion to Black SV tube (Vinyl) $\phi 5$ L=30 \pm 3mm	<div>  </div> <div> 1. Get the Black SV tube (Vinyl) $\phi 5$ L=30\pm3mm using right hand then insert the Y-OR wires using left hand. </div>				n/a	1. No wrong usage of parts 2. No deformed terminal

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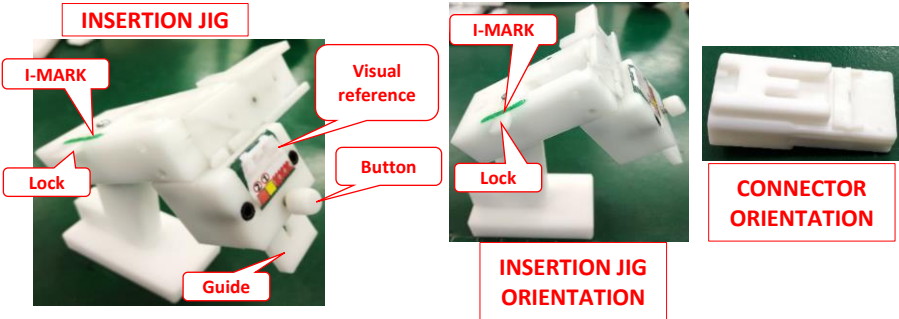
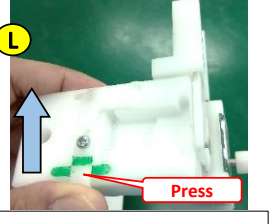
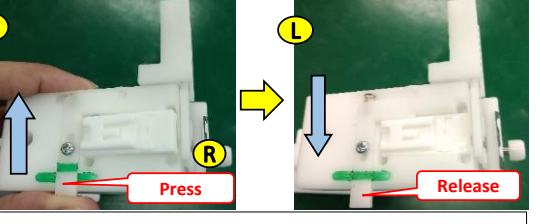
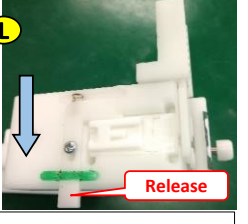
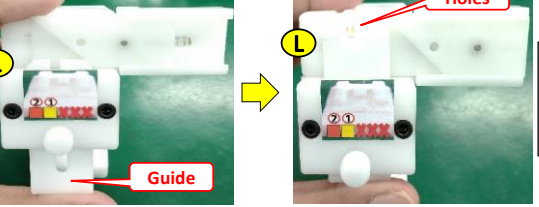

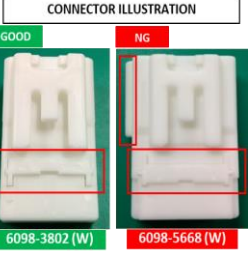
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PARTS:		1. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1	<p>Connector setting to insertion jig 6098-3802 (W)</p>     		n/a	<p>Connector Orientation Illustration</p>  <p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p> <p>CONNECTOR ILLUSTRATION</p> 

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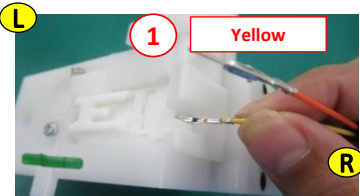
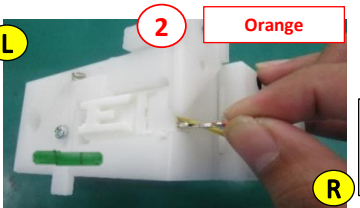
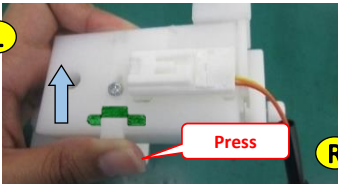


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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) $\phi 5$ L=106 \pm 3mm 3. AVSSf 0.3 B L=565 \pm 3mm [2pcs.]			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
8	Connector setting to insertion jig (Assy part) P1	    			n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing.</p> <p>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.</p> <p>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>
9	Wire insertion to Black VM tube (Sunprene) $\phi 5$ L=106 \pm 3mm				n/a	<p>1. No wrong usage of parts 2. No deformed terminal</p>


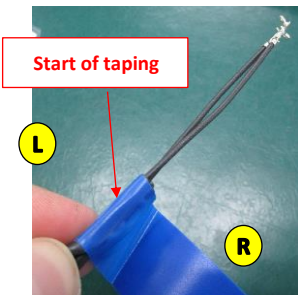
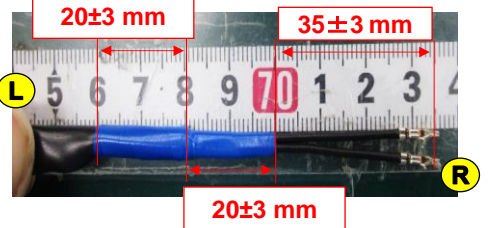

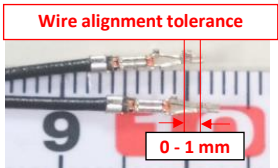


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PARTS:	1. Assy parts 2. Blue tape 3. Black Corrugated tube (no slit) $\phi 5$ L=342 \pm 3mm			JIG	1. Insertion jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	P1 Taping 1 Black VM tube (Sunprene) to wire near terminal	 <p>1. Hold the VM tube (Sunprene) using left hand. Measure from end of VM tube (Sunprene) up to the terminal pointed tip 55\pm3mm.</p>  <p>2. Hold the VM tube (Sunprene) using left hand. Get the Blue tape using right hand and begin taping process.</p>  <p>3. After taping, check the measurement, wire alignment and taping condition.</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 Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Please refer to WI-PRO-ASY-001 for taping procedure.  <p>Wire alignment tolerance 0 - 1 mm</p>
11	Wire insertion to Black Corrugated tube (no slit) $\phi 5$ L=342 \pm 3mm	 <p>1. Get the black corrugated tube $\phi 5$ L=342\pm3mm using right hand then insert the B-B wires using left hand.</p> 	n/a	1. No wrong usage of parts 2. No deformed terminal

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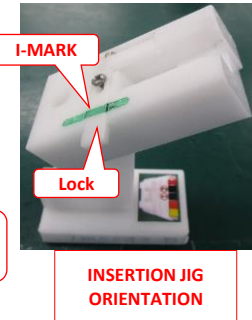
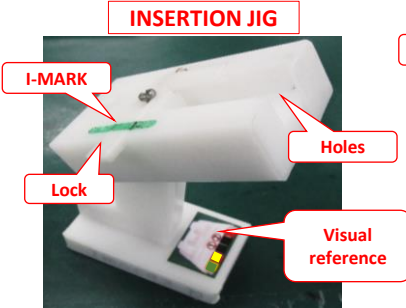
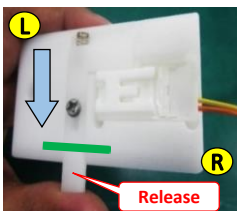
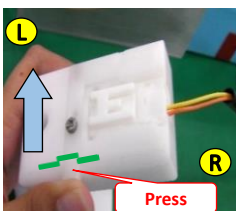
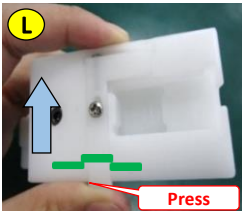

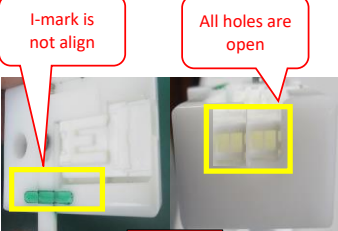
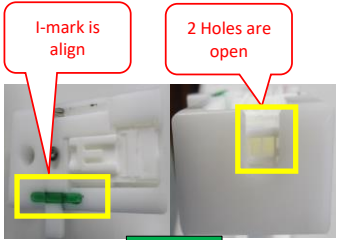
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PARTS:		1. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
12	P1 Connector setting to insertion jig (Assy part)	<div></div> <div></div> <div></div> <div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Get the assy part and insert the connector 6098-3802 (W) into jig using right hand and release the lock.</p><p>3. Check the holes for B-B wires, it must be opened.</p></div>		n/a	<div></div> <div><p>GOOD</p><p>NG</p></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>

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**WORK INSTRUCTION**

Effectivity Date:

October 22, 2024

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number: **550B / 7L0061-7023**Customer: **TRJ**Car Model: **TOYOTA-HIGHLANDER**

Document No.:

WI-ENG-PDE-017A

Purpose:

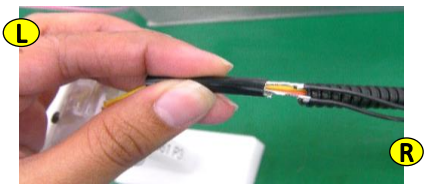
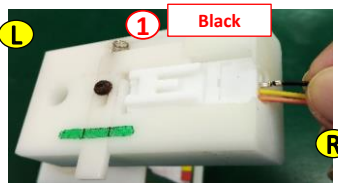
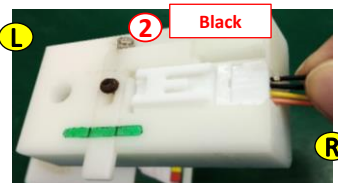
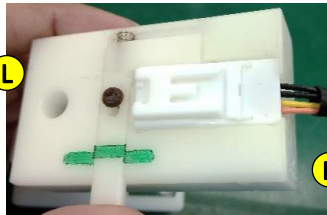
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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PARTS:		1. Assy parts			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
13		Assy part insertion		1. Hold the assy parts using left hand then insert the wires into SV tube (Vinyl) using right hand.	n/a	1. No wrong usage of parts 2. No deformed terminal Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
14	P1	Wire insertion to connector 6098-3802 (W)	  	1. Hold the 1st B wire then insert to terminal slot 1 using right hand. 2. Hold the 2nd B wire then insert to terminal slot 2 using right hand. 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.	n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing. Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Insertion of wire must be from left to right. 3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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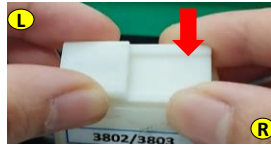



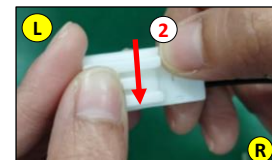

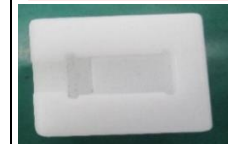




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PARTS:		1. Assy parts		JIG	1. Locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
15	P1	Connector lock	<div><div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div><div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div><div><p>3. Press the lower parts of connector using right hand while left hand holding the middle.</p></div><div><p>4. Press the upper part of connector using right hand while left hand holding the middle.</p></div><div><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> <div><div></div><div></div><div><div><p>GOOD</p><p>Full Lock</p></div><div><p>NG</p><p>Half Lock</p></div></div></div>			<div>1. Use the provided locking jig per model</div> <div>2. No unlock/half-lock connector</div> <div>Important reminders/Note/s:</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
16	P1 Y-taping	<div><div>No Gap</div><div>1. Fix the corrugated tube and SV tube (Vinyl). Follow the correct connector orientation.</div><div>20±3mm</div><div>2. Start taping at the middle of combined COT & SV tube (vinyl), then wind the tape going to 2 corrugated tubes (3 windings) width must be 25mm.</div><div>20±3mm</div><div>3. Wind the tape 1/3 shifting until it reach the SV tube (Vinyl), width must be tape width.</div><div>4. Wind the tape backward 1/2 shifting</div><div>taping direction</div><div>tape shifting 1/2 below</div><div>Tape shifting 9mm below</div><div>20±3mm</div><div>tape shifting 1/3 below</div><div>25±3mm</div><div>20±3mm</div><div>0 ~ 5mm</div><div>5. Wind the tape 1/2 shifting going to vinyl tube. Cover the SV tube (Vinyl) & wire 1/3 shifting. Measure SV tube (Vinyl) up to connector 25±3mm then make 3 winds on wire before cutting of tape.</div><div>6. Check the measurement and taping condition.</div></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>BLACK TAPE</div>

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☐ PROTOTYPE

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PARTS:

n/a

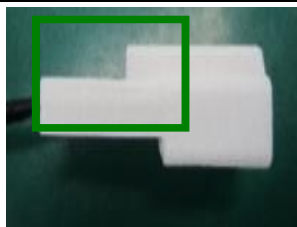
JIG

n/a

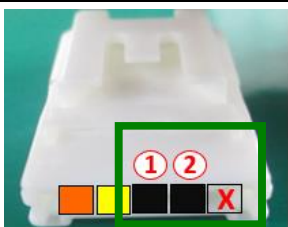
QUALITY

P1

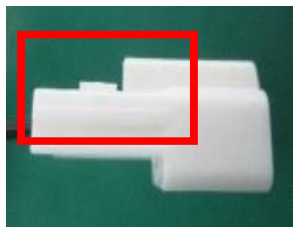
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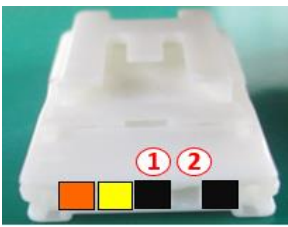
GOOD



GOOD



NO GOOD



NO GOOD



①

No Unlock/Halflock
Connector

②

No Wrong Insert
(on 2 connector)

③

No Terminal
Backing Out

④

No Missing tape
(y-taping)

⑤

No Wrong Used of
Tape (blue tape)

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