



WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:

September 8, 2023

Process Name/Title:

Validity Date:

n/a

Model code/Part number: 700B / 7N0039-7020A

Customer: TRJ

Car Model: TOYOTA-LAND CRUISER

Document No.:

WI-ENG-PDE-715A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

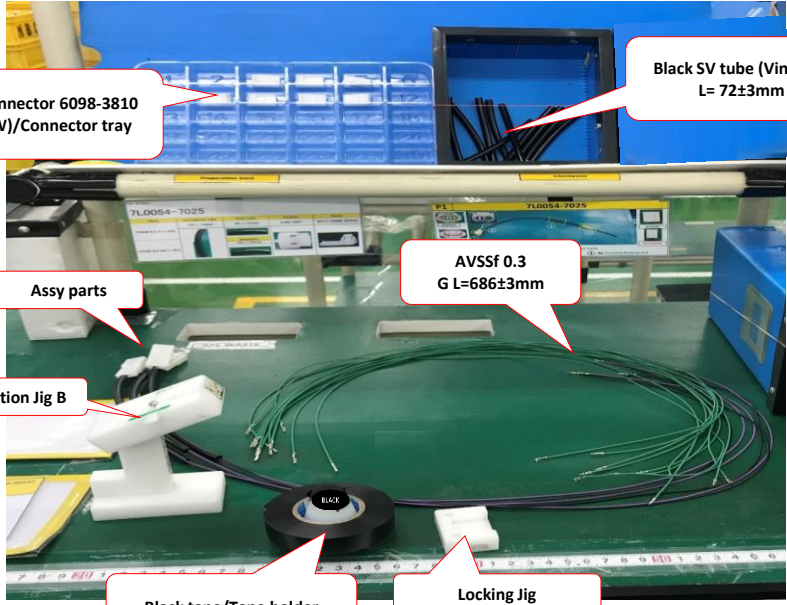
☒ MASSPRO

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| PARTS: | | 1. Assy parts; AVSSf 0.3 wires G L=643±3mm; Connector 6098-3810 (W); Black SV tube (Vinyl) ø5 L= 72±3mm; Black tape | | JIG: | 1. Insertion jig 2. Locking jig | | |
|------------------|---------------------|---|--|--|---|---------------|-----------|
| NO. | PROCESS NAME | 1 WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS | | |
| 1 | P1 Table lay-out | <div><p>TABLE LAY-OUT</p></div> | | <div><p>Safety Instruction</p><p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p><p>Housekeeping</p><p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p><p>Alert level</p><p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p></div> | <p>1. No missing parts/tools. 2. No excess parts/tools.</p> <p>Document references:</p> <p>1. Refer to WI-ENG-PDE-731 for OFFLINE ASSEMBLY PROCESS</p> <p>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> | | |
| Revision History | | | | | | | |
| 09/08/23 | 1 | Change purpose from pre-launch to Masspro. Additional Table lay-out and update Quality Checkpoint | | M. Ariola | J. Loterte | C. Villanueva | A. Arañes |
| 08/08/23 | 0 | Initial Issue. | | M. Ariola | J. Loterte | C. Villanueva | A. Arañes |
| Eff. Date | Rev. No | Details of Change | | Revised | Reviewed | Approved | Noted |
| | | | | Prepared by | Reviewed by | Approved by | Noted by |
| | | | | M. Ariola | J. Loterte | C. Villanueva | A. Arañes |
| | | | | Est. Date: | August 08, 2023 | | |

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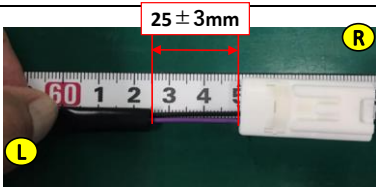

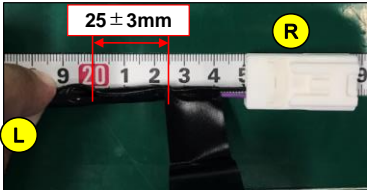
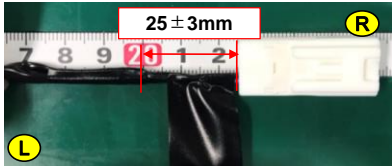
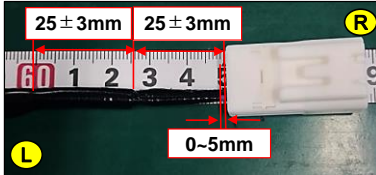

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| PARTS: | | 1. Assy parts 2. Black tape | | JIG: | n/a |
|--------|---|---|--|---|--|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 2 | P1 Taping 1 Black SV tube (Vinyl) to Wire near connector | <div><p>1. Measure from end of SV tube (Vinyl) up to edge of connector $25 \pm 3\text{mm}$ using both hands.</p></div> <div><p>2. Hold the SV tube (Vinyl) using left hand, get the Black tape using right hand then start pre-taping using both hands.</p></div> <div><p>3. Confirm measurement of $25 \pm 3\text{mm}$ from end of tape up to SV tube (Vinyl) then continue the taping process using both hands.</p></div> <div><p>4. Confirm measurement of $25 \pm 3\text{mm}$ from end of SV tube (Vinyl) to Wire near terminal then continue the taping process using both hands.</p></div> <div><p>5. After taping, Check the taping condition and measurement.</p></div> | | <div>MEASURING TAPE</div>  | <p>Important reminders/Note/s:</p> <p>1. 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 dimension 6. No wrong use of tape</p> |

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| PARTS: | | 1. Connector 6098-3810 (W) | | JIG: | 1. Insertion jig |
|--------|---|---|--|-----------|---|
| NO. | PROCESS NAME | 1 WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 3 | P1 Connector setting to insertion 6098-3810 (W) | <div><div>INSERTION JIG</div><div></div><div></div><div></div><div></div></div> | | n/a | <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><div>Connector Orientation Illustration</div><div> </div><div>CONNECTOR ILLUSTRATION</div><div></div></div> |

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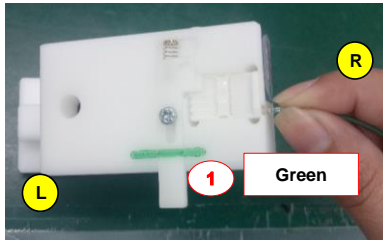

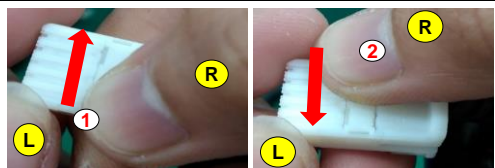



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| PARTS: | | 1. Connector 6098-3810 (W) 2. AVSSf 0.3 wires G L=643±3mm | | JIG: | 1. Insertion jig 2. Locking jig |
|--------|---|--|--|---|---|
| NO. | PROCESS NAME | 1 WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 4 | Wire insertion to Connector 6098-3810 (W) |  WIRE FACING VISUAL REFERENCE  Green Press 1. Get the Green wire and insert to terminal slot ① using right hand. 2. After insertion, press the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand. | | n/a | 1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector Important reminders/notes: 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. Document reference/s: 1. Refer to WI-PRO-CNC-017 for wire and Strip length tolerance |
| 5 | Connector lock |  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.  2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.  Before Pressing  After Pressing | | LOCKING JIG  | Important reminders/Note/s: 1. Manual locking may cause damaged connector lock 1. No wrong usage of parts 2. No deformed terminal |

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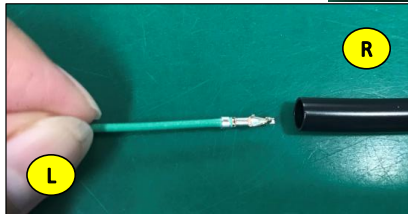

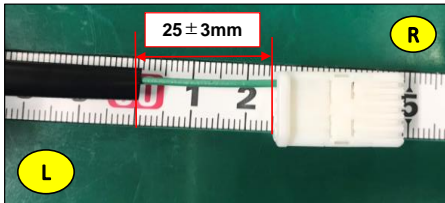
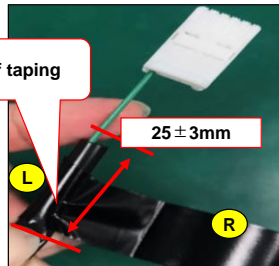
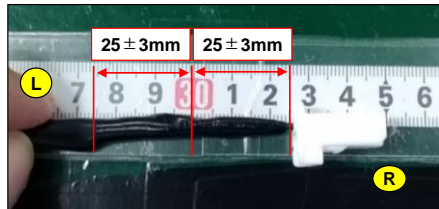

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| | | | | | |
|---------------|---|---|---|--|---|
| PARTS: | 1. Assy parts 2. Black SV tube (Vinyl) $\phi 5$, L=72 \pm 3mm | | 1. Black tape | JIG: | 1. Locking jig |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 6 | | Wire insertion to Black SV tube (Vinyl) $\phi 5$ L=72 \pm 3mm |   <div>WIRE TAPING</div> <div>1. Get the SV tube (Vinyl) $\phi 5$ L=72\pm3mm using left hand then get the G L=643\pm3mm wires and insert using right hand.</div> | n/a | 1. No wrong use of parts. 2. No damaged terminal |
| 7 | P1 | Taping 2 Black SV tube (Vinyl) to Wire near connector |  <div>25 \pm 3mm</div> <div>1. Measure from end of tube up to edge of connector 25\pm3mm using both hands.</div>  <div>Start of taping</div> <div>25 \pm 3mm</div> <div>2. Hold the tube using left hand, get the Black tape using right hand then start taping process using both hands. Must be 25\pm3mm.</div>  <div>25 \pm 3mm 25 \pm 3mm</div> <div>3. After taping, check the measurement and taping condition.</div> | <div>MEASURING TAPE</div>  | Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 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 |

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PARTS:

n/a

JIG:

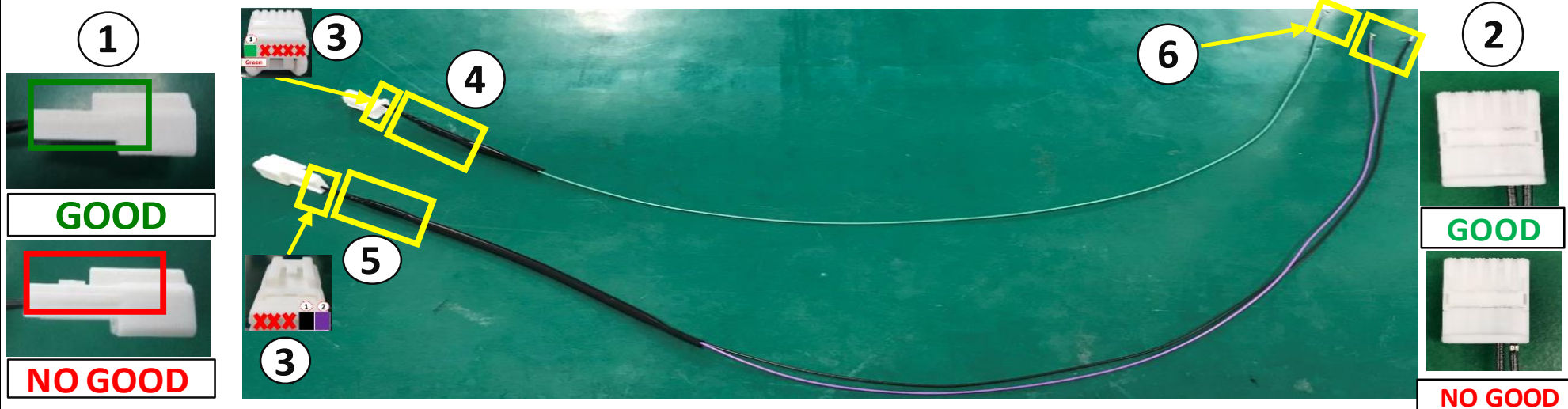
n/a



QUALITY CHECKPOINTS

P1

7N0039-7020A



1 No Unlock/Halflocked Connector

4 5 No Missing Tape

2 No Terminal Backing Out

6 No Deformed Terminal

3 No Wrong Insert

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