

	WORK INSTRUCTION					Effectivity Date:		September 25, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS					Validity Date:		n/a	
	Model code/Part number: 895B / 7N0093-7020		Customer: TRJ	Car Model: TOYOTA-COROLLA CROSS	Document No.:		WI-ENG-PDE-521		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO					Revision No.:		6	Page No.:

PARTS:		1. Connector 6098-3802(W); Black corrugated tube Ø5 t=0.5 L=507+ 5mm; Black SV tube (Vinyl) Ø5 t=0.5 L= 240+3mm; AVVSf 0.3 B L=811+3mm; Black tape				JIG:		1. Insertion Jig 2. Locking Jig	
NO.	PROCESS NAME	<div style="border: 1px solid black; padding: 2px; display: inline-block;">6</div> WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	P1	<div style="text-align: center;"> Table Lay-out </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 reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.	

Revision History						Prepared by		Reviewed by		Approved by		Noted by	
09/25/24	6	Separate clamp assy to Clamp assembly process due to process improvement. Change process sequence due to removal of cover jig. Inclusion of car model "TOYOTA-COROLLA CROSS". Improved Table Lay-out, Measurement and Visual inspection/Quality checkpoints.				D.Castillo	C. Villanueva	A. Arañes	n/a		<div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;"> D. Castillo </div> <div style="text-align: center;"> C. Villanueva </div> <div style="text-align: center;"> A. Arañes </div> </div>		
04/24/23	5	Inclusion of quality checkpoints.				J. Loterte	C. Villanueva	A. Arañes	n/a				
11/15/22	4	Merge from P2 to P1 due to Process. Change P1 to T1; P2 to T2; Change table lay-out.				M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted		Est. Date: May 13, 2022		

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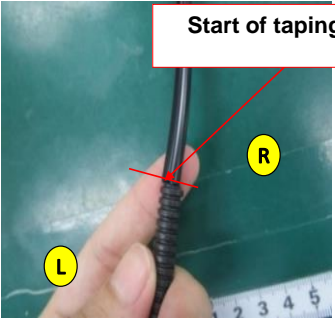
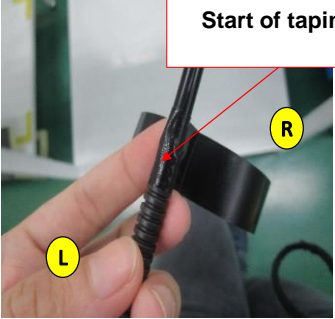

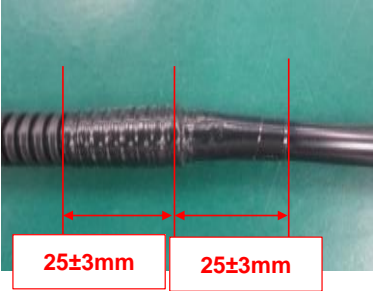

PARTS:	1. Connector 6098-3802 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Connector setting to insertion jig 6098-3802 (W)	<div><div><div><div>INSERTION JIG</div><div></div></div><div><div></div><div>INSERTION JIG ORIENTATION</div></div><div><div></div><div>CONNECTOR ORIENTATION</div></div></div><div><div><div></div><div>1. Press the lock of insertion jig using left thumb.</div></div><div><div></div><div>2. Insert the connector 6098-3802 (W) into jig using right hand then release the lock. Note: Follow the connector orientation.</div></div><div><div></div><div>3. Check the holes/terminal slot for B-B wires.</div></div></div></div> <div>n/a</div> <td><div><div><div>1. Use provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div></div><div><div>Connector Orientation Illustration</div><div><div></div><div></div></div><div><div></div><div></div></div><div><div>GOOD</div><div>NG</div></div><div>CONNECTOR ILLUSTRATION</div><div><div></div><div></div></div><div><div>6098-3802 (W)</div><div>6098-5668 (W)</div></div></div></div></td>	<div><div><div>1. Use provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div></div><div><div>Connector Orientation Illustration</div><div><div></div><div></div></div><div><div></div><div></div></div><div><div>GOOD</div><div>NG</div></div><div>CONNECTOR ILLUSTRATION</div><div><div></div><div></div></div><div><div>6098-3802 (W)</div><div>6098-5668 (W)</div></div></div></div>	

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	Model code/Part number: 895B / 7N0093-7020		Customer: TRJ	Car Model: TOYOTA-COROLLA CROSS	Document No.:	WI-ENG-PDE-521		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	6	Page No.:	3 of 9

PARTS:	1. Black Corrugated tube Ø5 L=507±5mm 2. Black tape		3. Black SV tube (Vinyl) Ø5 t=0.5 L= 240+3mm	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 <div>6</div> Taping 1 Black corrugated tube to Black SV tube (Vinyl)	<div> 1. Get the Corrugated tube L=507± 5mm and SV tube (Vinyl) L= 240±3mm using right hand. Then Fix the COT and VT using both hands. Note: Must be no gap in between.</div> <div> 2. Hold the assy parts using left hand. Get the Black tape and start taping process using both hands.</div> <div> Measuring tape</div> <div> 25±3mm 25±3mm</div> <div>3. After taping, check the measurement 25± 3mm and taping condition.</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 and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</div>

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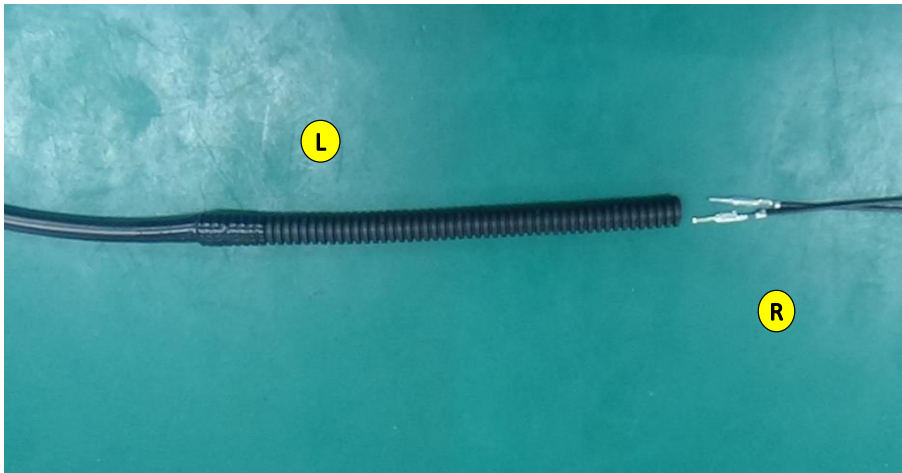
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PARTS:		1. AVSSf 0.3 B wires L=811±3mm [2pcs.] 2.Black Corrugated tube Ø5 L=507±5mm and Black SV tube (Vinyl) Ø5 L=240±3mm (Assy Parts)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 6 Wire insertion to Black COT (no slit) Ø5 L=507±5mm and Black SV tube (Vinyl) Ø5 L=240±3mm	 <div>1.Get combined (Black COT Ø5 L=507±5mm and SV tube (Vinyl) Ø5 L=240±3mm Black) using left hand and insert Black wires L=811mm using right hand.</div>		n/a	1. No wrong use of parts 2. No deformed terminal

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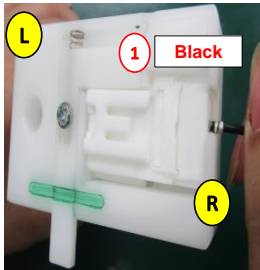
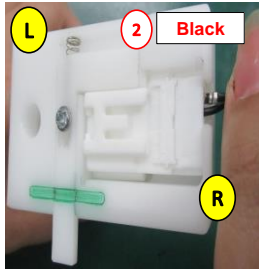
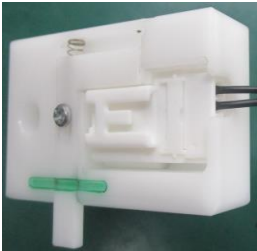
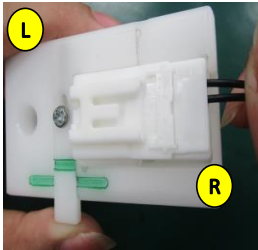
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PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1 Wire insertion to connector 6098-3802 (W)	<div> Wire facing</div> <div> 1. Get the 1st Black wire then insert to terminal slot 1 of connector using right hand. Note: Insertion of wires must be from left to right</div> <div> 2. Get the 2nd Black wire then insert to terminal slot 2 of connector using right hand.</div> <div>  3. After insertion, conduct push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</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> Important reminders/Note/s: <div>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> Document references: <div>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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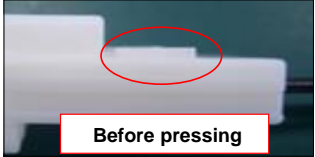


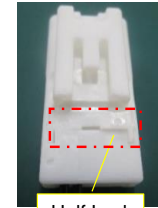

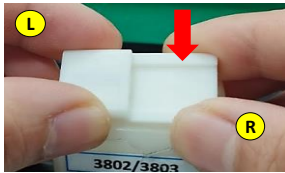
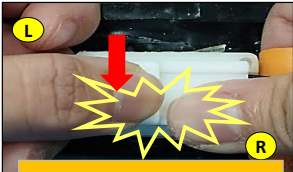


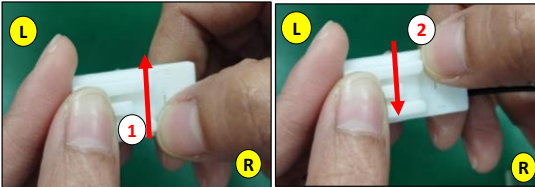
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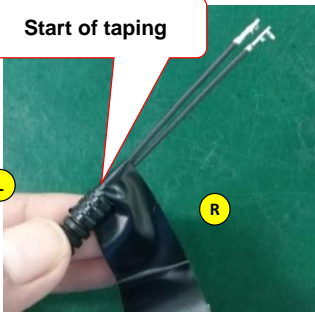
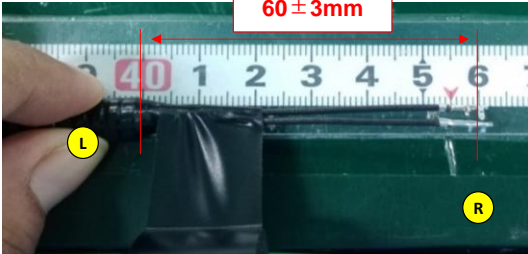

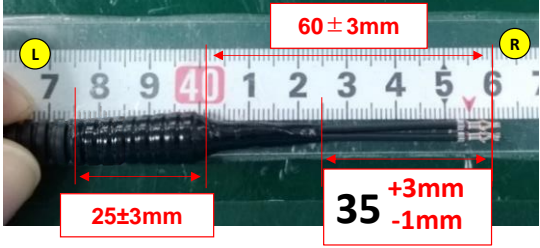

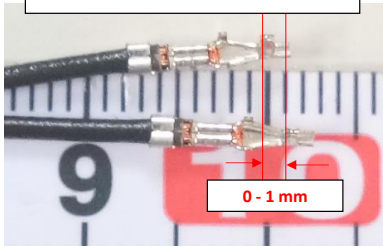
PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1	Connector Lock	<div>LOCKING JIG</div> 	<div><p>Before pressing</p><p>After pressing</p></div> <div><div>GOOD</div><p>Full Lock</p><div>NG</div><p>Half Lock</p></div> <div><p>Important reminders/Note/s:</p><p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR.</p><p>1. Use the provided jig tool to lock the connector.</p><p>2. No unlock/half-locked connector</p></div>
		<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p><p>2. Press the lower part of connector to fully insert into the locking jig.</p><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><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><p>Right thumb-middle Left thumb-middle</p><p>5. Lift then press the connector in the middle using left and right hand.</p><p>6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div></div></div>		

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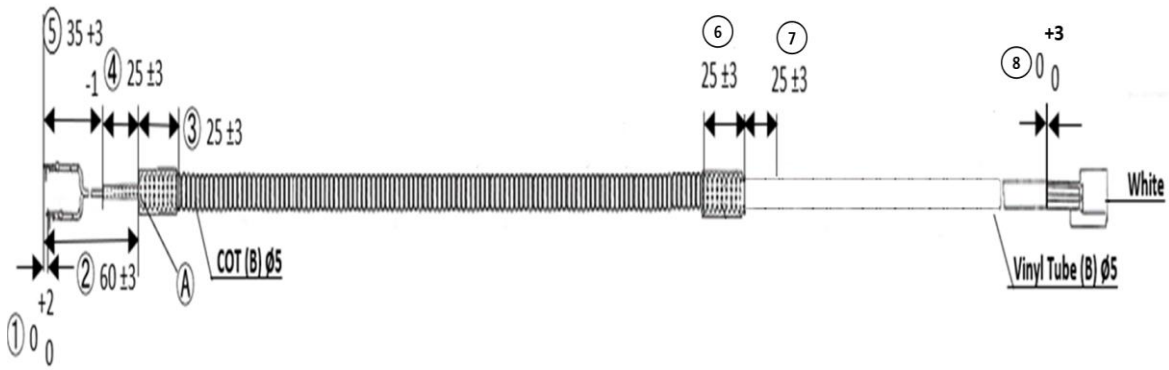

PARTS:	1. Assy parts 2. Black tape			JIG:	n/a			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
7	P1 Taping 2 Black corrugated tube to wire near terminal	<div><div><p>Start of taping</p></div><div><p>60 ± 3mm</p></div><div><p>1. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.</p></div><div><p>2. Measure from end of COT up to terminal pointed tip 60±3mm then continue the taping process using both hands.</p></div><div><p>35 +3mm -1mm</p></div><div><p>3. Confirm measurement of 35+3mm/-1mm from end of tape up to terminal pointed tip then continue the taping process using both hands.</p></div><div><p>60 ± 3mm</p><p>25±3mm</p><p>35 +3mm -1mm</p></div><div><p>4. After taping, check the measurement, taping condition and terminal appearance.</p></div></div> <div><p>Measuring tape</p></div>			<div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div> <div><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></div> <div><p>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p></div> <div><p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p></div>			

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PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	6	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P1	Measurement	<div><p>NOTE: ⑧ - Taping (B)</p></div>	<div><div>MEASURING TAPE</div></div>	<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p>

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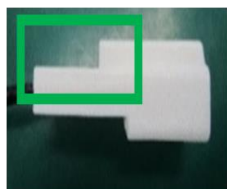
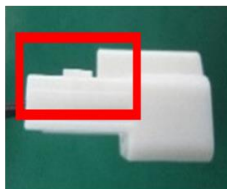
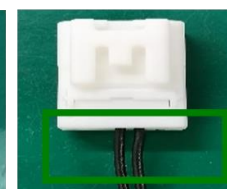
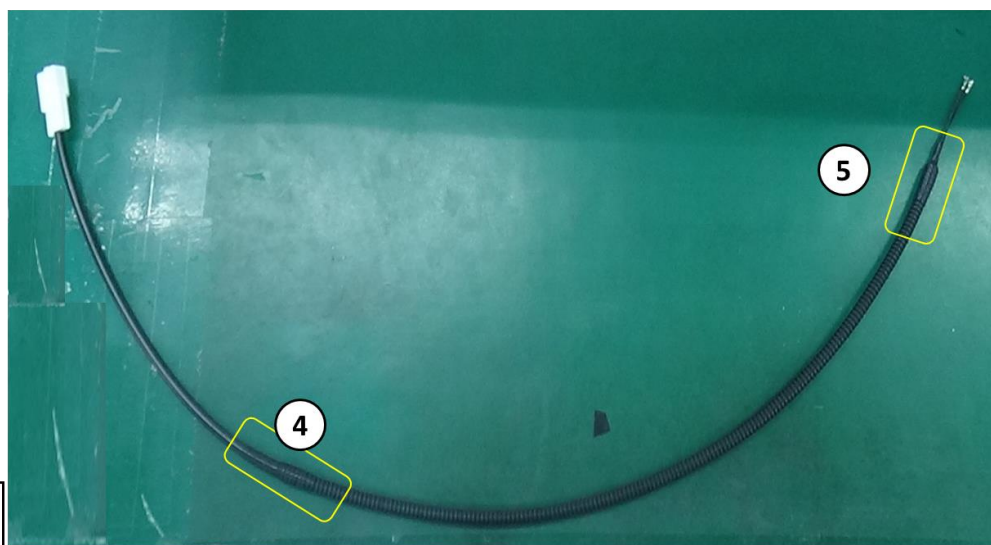
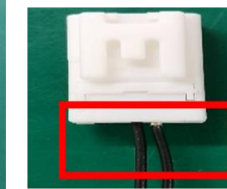
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1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P1****7N0093-7020****GOOD****GOOD****NO GOOD****NO GOOD****GOOD****GOOD****NO GOOD****NO GOOD****1 No Unlock / Halflock Connector****3 No Terminal Backing Out****2 No Wrong Insert****4 5 No Missing Tape(Black Tape)**

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