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| | WORK INSTRUCTION | | | | | | Effectivity Date: | | February 05, 2024 | |
| | TAPING ASSEMBLY PROCESS | | | | | | Validity Date: | | n/a | |
| | Process Name/Title: | | | | | | Document No.: | | WI-ENG-PDE-785 | |
| | Model code/Part number: 311D / 7L0153-7021 | | | Customer: TRQSS | | Car Model: TOYOTA-RAV4 | | Revision No.: | | 0 |
| Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO | | | | | | | | | | |


| | | | | | | |
|---------------|--|---|--|--|---|--|
| PARTS: | 1. AVSSf 0.3 Black wires L=768±3mm 2. AVSSf 0.3 Violet wires L=768±3mm 3. Black Corrugated tube ø5 L=169±3mm (no slit) | | | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | | TOOLS/PPE | QUALITY POINTERS |
| 1 | n/a | <div style="text-align: center;"> </div> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> 1. Get the Black Corrugated tube ø5 L=169±3mm (no slit) using right hand then insert the Violet wire and Black wire using both hands. </div> | | | <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed 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 dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div> | 1. No wrong usage of parts. 2. No deformed terminal Document references: 1. Refer to WI-PRO-CNC-017 for Wire Strip lenght tolerance. |


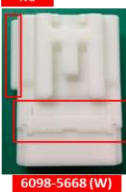
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|------------------|---------|-------------------|------------|--------------|-----------|-------------|-------------|-------------------|----------|
| Revision History | | | | | | Prepared by | Reviewed by | Approved by | Noted by |
| Eff. Date | Rev. No | Details of Change | Revised | Reviewed | Approved | Noted | Est. Date: | February 05, 2024 | |
| 02/05/24 | 0 | Initial issue | D.Castillo | C.Villanueva | A. Arañes | n/a | | | |

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| | | | | | |
|---------------|---|---|--|------------------|--|
| PARTS: | 1. Assy Parts 2. Connector 6098-3802 (W) | | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 2 | n/a | Wire insertion to connector 6098-3802 (W) | | n/a | <div>1. No wrong use of connector 2. No damaged connector 3. No wrong insertion of wires 4. No loose insertion 5. One by one insertion 6. No deformed terminal 7. No wrong wire facing</div> <div>Important reminder's/Note: 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 WI-PRO-CNC-017 for Wire Strip lenght tolerance. 2. Refer to GL PRO-ASY-029 for pull-push-pull-push procedure</div> <div><div>CONNECTOR ILLUSTRATION</div><div><div>GOOD</div><div>NG</div><div></div><div></div><div>6098-3802 (W)</div><div>6098-5668 (W)</div></div></div> |

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Customer:

TRJ

Car Model:

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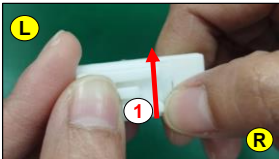


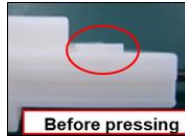



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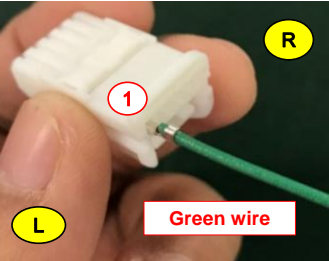

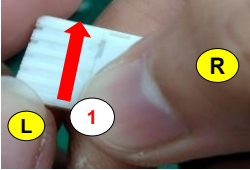
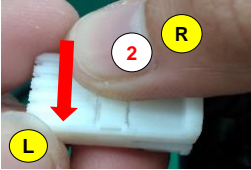
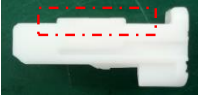


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|---------------|---------------------|--|--|---|---|
| PARTS: | 1. Assy Parts | | | JIG: | 1. Locking jig |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 3 | n/a | <div><p>1. Load the connector into the jig 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>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></div> <div><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> <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></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>LOCKING JIG</div>  | <p>1. Use the provided jog per model 2. No unlocked/half-locked connector</p> <p>Important reminders/Note/s:</p> <p>1. Manual locking jig may caused damaged connector lock.</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-017 for the verification of connector lock.</p> <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> |



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| | Process Name/Title: TAPING ASSEMBLY PROCESS | | | | Validity Date: | n/a | | |
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|---|---------------------|---|---|---|
| PARTS: 1. Connector 6098-3810 (W) 2. AVSSf 0.3 wires Green L=659±3mm | | JIG: | n/a | |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
| 4 | n/a | <div>  <p>CONNECTOR ORIENTATION</p> </div> <div>  <p>VISUAL REFERENCE</p> </div> <div>  <p>WIRE FACING</p> </div> <div>  <p>Green wire</p> </div> <div> <p>1. Get the connector 6098-3810 (W) then hold the Green wire and insert to terminal slot 1 of connector using right hand. Conduct 2x push pull after wire insertion.</p> </div> | n/a | 1. No wrong use of connector 2. No damaged connector 3. No wrong insertion of wires 4. No loose insertion 5. One by one insertion 6. No deformed terminal 7. No wrong wire facing |
| 5 | Connector lock | <div>  <p>LOCKING JIG</p> </div> <div> <p>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.</p> </div> <div>  <p>1</p> </div> <div>  <p>2</p> </div> <div> <p>2. 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> </div> <div>  <p>After Pressing</p> </div> | <div>  <p>LOCKING JIG</p> </div> | 1. No wrong usage of parts 2. No deformed terminal Important reminders/Note/s: 1. Manual locking may cause damaged connector lock |

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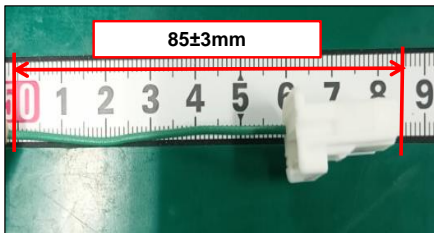
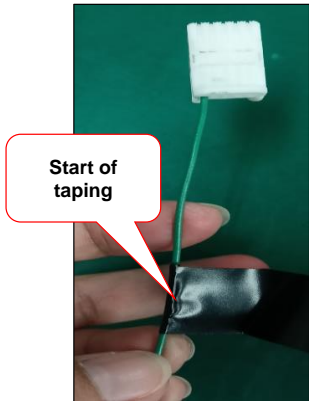
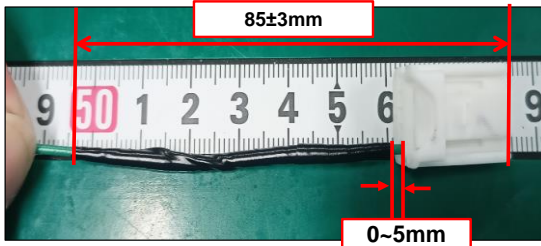
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|--------|--------------|---|--|---|--|
| PARTS: | | 1. Black tape [1pc] | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 6 | n/a | Half wrap taping | | <div>MEASURING TAPE</div>  | 1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension |
| | |  <div>1. Hold the wire using left hand, Measure from wire up to end of connector 85±3mm using both hands.</div>  <div>2. Get the Black tape. Start pre-taping make 1 winding of tape then conduct 1/2 shifting until you reach the edge of the connector. Make 2 windings of tape before end of tape. <i>(Taping must be 1/2 shifting)</i></div>  <div>3. After taping, check the measurement and tape condition.</div> | | | |







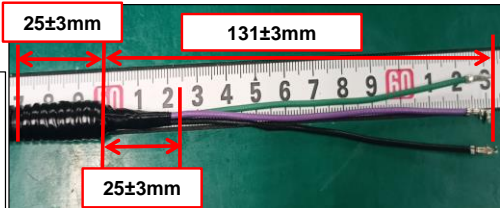

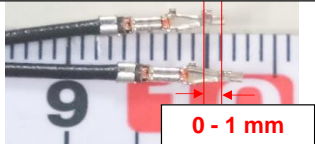
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|---|-------------------------------|
| PARTS: 1. Assy parts 2. Black Corrugated tube ø5 L=459±3mm (no slit) 3. Black tape [1pc] | JIG: 1. Terminal cover jig |
|---|-------------------------------|

| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|-----|--|--|---|---|
| 7 | Wire Insertion to Black Corrugated tube ø5 L=459±3mm (no slit) |  <p>1. Combine the B-V-G wires using both hands. Get the terminal cover jig using right hand then insert to B-V-G wires both hands.</p>  <p>2. Get the Corrugated tube ø5, L=459±3mm using right hand then insert to B-V-G wires using both hands.</p>  <p>3. After insertion, remove the terminal cover jig using right hand.</p> | <div>Terminal cover Jig</div>  | 1. No wrong usage of parts. 2. No deformed terminal |
| 8 | n/a Taping 2 COT to wire near terminal |  <p>1. Hold the assy parts using left hand. Get Black tape using right hand and start pre-taping.</p>  <p>2. Measure from COT to terminal tip 131±3mm using both hands and continue the taping process.</p>  <p>3. After taping, check the measurement and taping condition.</p> | <div>MEASURING TAPE</div>  | 1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension Important reminders/Notes/: 1. Please use calibrated/verified measuring tape when getting the measurement. Document references: 1. Refer to WI-PRO-ASY-001 for Taping process <div>Wire alignment tolerance</div>  <p>0 - 1 mm</p> |

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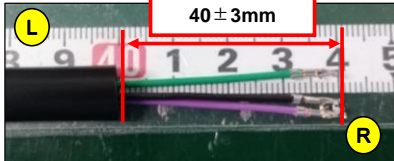

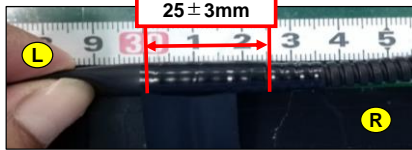
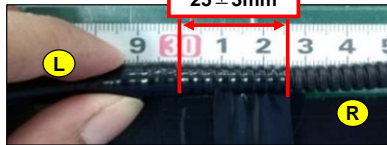


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|--------|--------------|--|---|--|-----------------------------|---|--|
| PARTS: | | 1. Assy parts 2. Black tape [1pc] | | 3. Black VM tube (Sunprene) Ø9 L=112±3mm | JIG: | n/a | |
| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS | |
| 9 | | Wire insertion to Black VM tube (Sunprene) Ø9 L=112±3mm | <div></div> <div>1. Get the Black VM tube (Sunprene) Ø9 L=112±3mm using right hand then insert the B-G-V wires.</div> | | | 1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension-out tape | |
| 10 | n/a | Taping 3 Black Corrugated tube to Balck VM tube (Sunprene) | <div><div></div><div>1. Measure from end of VM tube (Sunprene) up to terminal pointed tip 40±3mm using both hands.</div><div></div><div>Start of taping</div><div>2. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.</div><div></div><div>3. Confirm measurement of 25±3mm from end of tape up to end of tube then continue the taping process using both hands.</div><div></div><div>4. Confirm measurement of 25±3mm from end of tube up to end of tape then continue the taping process using both hands.</div><div></div><div>5. After taping, check the measurement, terminal appearance and taping condition.</div></div> <div>MEASURING TAPE</div> <div></div> | | Important reminders/Notes/: | 1. Please use calibrated/verified measuring tape when getting the measurement. | 1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension |

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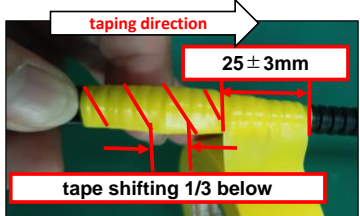

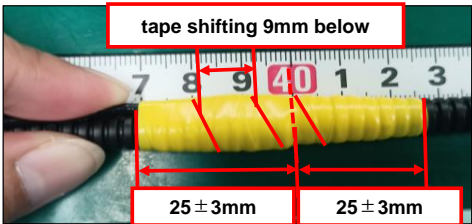

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| PARTS: | | 1. Assy parts 2. Black tape | | JIG: | n/a |
|--------|--------------|--------------------------------|--|---|---|
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 11 | n/a | Y-taping | <div><p>No gap between the tubes and wires</p><p>1. Fix the tubes and wires.</p></div> <div><p>Do not exert excessive force during pulling & winding of tape.</p><p>Start of taping</p></div> <div><p>taping direction</p><p>25 ± 3mm</p><p>tape shifting 1/3 below</p><p>3. Wind the tape 1/3 shifting until it reach the other side of the tubes and wires (must be 25±3mm)</p></div> <div><p>tape shifting 1/2 below</p><p>taping direction</p><p>4. Wind the tape 1/2 shifting</p></div> <div><p>tape shifting 9mm below</p><p>25 ± 3mm</p><p>25 ± 3mm</p><p>5. Wind the tape 1/2 shifting going to other side of tubes and wires then cut the tape. After taping, check the measurement and taping condition.</p></div> | <p>MEASURING TAPE</p>  | <p>Important reminders/Note/s:</p> <p>1. Use yellow tape for easy visualization of tape shifting, but actual should be BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension-out tape</p> |

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| PARTS: | | 1. Clamp 82711-52090 (W) 2. Clamp 82711-48210 (B) 3. Clamp 82711-34490 (B) 4. Clamp 82711-3A540 (W) 5. Clamp 82711-33650 (B) 6. Black tape [5 pcs.] | | | JIG: | 1. Temporary Clamp assembly jig |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | | TOOLS/PPE | QUALITY POINTERS |
| 12 | n/a | Clamp Setting | | | | <div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div> <div>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div><div>CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>82711-52090 (W)</div></div><div><div>NG</div><div>82711-12A80 (W)</div></div></div> <div><div>BAND CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>82711-34490 (B)</div></div><div><div>NG</div><div>82711-16830 (B)</div></div></div> |

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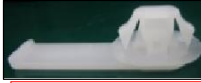



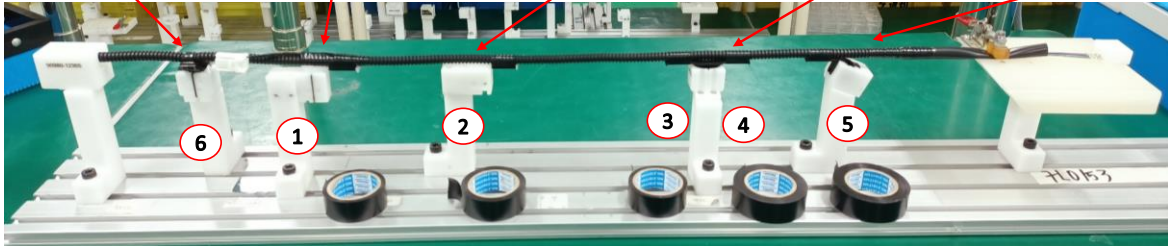
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|--------|--------------|------------------------------|---|------|---------------------------------|------------------|---|
| PARTS: | | 1. Assy parts | | JIG: | 1. Temporary Clamp assembly jig | | |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | | TOOLS/PPE | QUALITY POINTERS | |
| 13 | n/a | Clamp assembly | <div><div><p>82711-34490 (B)</p></div><div><p>82711-52090 (W)</p></div><div><p>82711-3A540 (W)</p></div><div><p>82711-48210 (B)</p></div><div><p>82711-33650 (B)</p></div></div> <div><p>1. Put the assy into jig. <i>(See above picture for the correct setting)</i>. First, set the connector 6098-3802 (W) to Receiver base 1. Second, set the B-B wires together within stopper then press by toggle clamp.</p></div> <div><p>2. On clamp location 1, hold the tape then make 3 windings of tape then cut the tape using both hands. Proceed to clamp location 2.</p></div> <div><p>3. On clamp location 2, hold the tape then make 3 windings of tape then cut the tape using both hands. Proceed to clamp location 3 and 4.</p></div> <div><p>4. On clamp location 3 and 4, hold the tape then make 3 windings of tape then cut the tape using both hands. Proceed to Clamp location 5.</p></div> <div><p>5. On clamp location 5, hold the tape then make 3 windings of tape then cut the tape using both hands. Proceed to clamp location 6.</p></div> | | | | <div>1. No wrong use of parts</div> <div>2. No wrong use of tape</div> <div>3. No damaged clamp</div> <div>4. No wrong clamp position</div> |

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DCC Stamp



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

February 05, 2024

Model code/Part number:

311D

/

7L0153-7021

Customer: TRJ

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-785

Purpose:






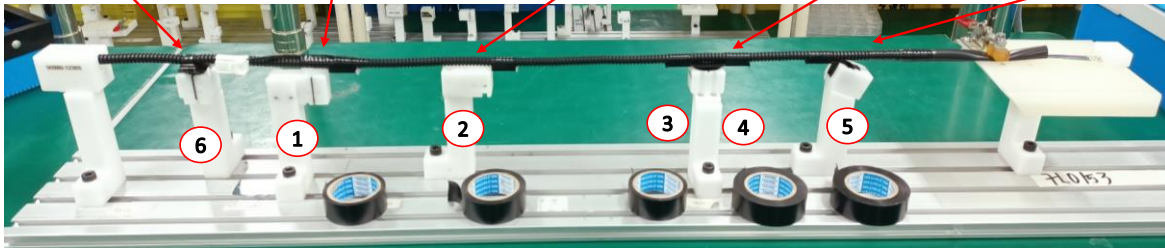


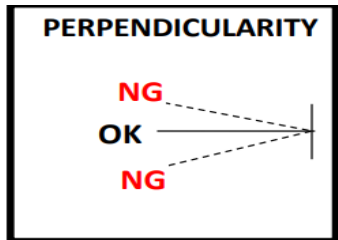
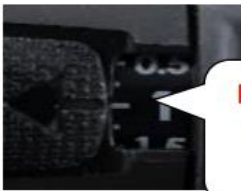

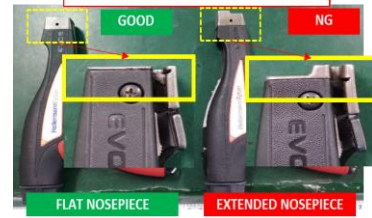
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| | | | | | |
|--------|--------------|--|--|-----------|--|
| PARTS: | | 1. Assy parts | | JIG: | 1. Temporary Clamp assembly jig |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 13 | n/a | Clamp assembly (Continuation) | | | |
| | | <div><div> 82711-34490 (B)</div><div> 82711-52090 (W)</div><div> 82711-3A540 (W)</div><div> 82711-48210 (B)</div><div> 82711-33650 (B)</div><div>6. Initially tighten the band clamp on location 6 using both hands. Get the bando gun using right hand then cut the band clamp using both hands.</div><div>7. After taping, CONDUCT POINT CHECKING before removing the harness from jig.</div><div> PROPER CUTTING POSITION OF BANDO GUN  IMPROPER CUTTING POSITION OF BANDO GUN BANDO GUN ALIGNMENT PERPENDICULARITY <div> Fixed setting of band clamp cutter: 1~ 2</div></div></div> | | | <div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div> <p>Important reminders/Note/s:</p> <div>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div>2. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).</div> <div>3. Setting of band clamp cutter depends on the size of the COT/SV tube (Vinyl) ø5- 1~2, ø7- 3~4</div> <div> BANDO GUN ILLUSTRATION  GOOD NG FLAT NOSEPIECE EXTENDED NOSEPIECE</div> |

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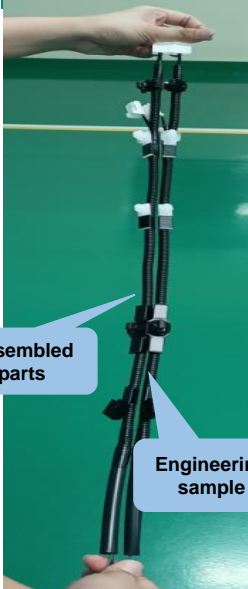


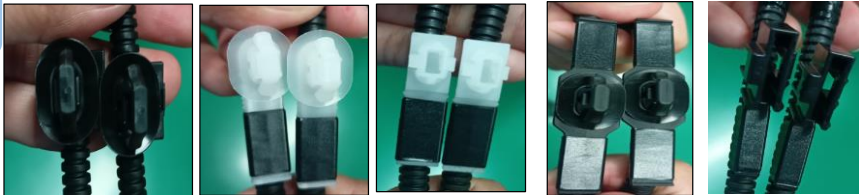
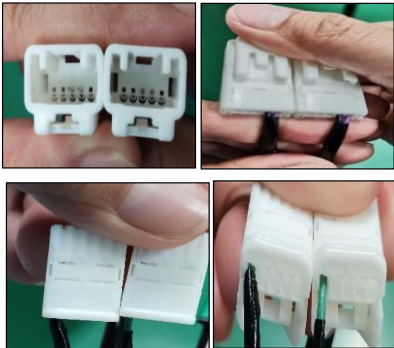






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|--------|--------------|--|--|-----------|--|
| PARTS: | | 1. Assy parts 2. Engineering sample | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 14 | n/a | <div>Visual/By Two's Inspection</div> <div><p>Assembled parts</p><p>Engineering sample</p><p>ACTUAL PRODUCT</p><p>1. Conduct alignment of harness (Engineering sample vs. Assembled parts) using both hands.</p><p>2. Check the connector lock condition, insertion and terminal appearance</p><p>3. Check the presence of clamp attachment, taping condition and band clamp cut. Conduct bending of parts with wing-type clamp.</p></div> | | | <div>1. No skip checking during inspection.</div> <div>ENGINEERING SAMPLE</div> <div></div> <div>Important reminders/Note/s:</div> <div>1. Using steel rule, check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).</div> <div><p>0 ~ 2mm</p></div> <div>CLAMP ILLUSTRATION</div> <div><div>GOOD</div><div><p>82711-52090 (W)</p></div><div>NG</div><div><p>82711-12A80 (W)</p></div></div> <div>CONNECTOR ILLUSTRATION</div> <div><div>GOOD</div><div><p>6098-3802 (W)</p></div><div>NG</div><div><p>6098-5668 (W)</p></div></div> |

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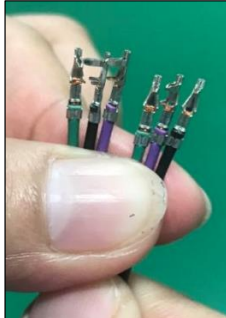
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|--------|--------------|---|--|--|------------------|
| PARTS: | | 1. Assy parts 2. Engineering sample | | JIG: | n/a |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 14 | n/a | Visual/By Two's Inspection (Continuation) | | 1. No skip checking during inspection. | |
| | | <div><p>ACTUAL PRODUCT</p></div> <div><p>5. Conduct slightly pulling (UP and Down) of VM tube (Sunprene) to confirm the presence of tape.</p><p>7. Check the terminal appearance. Must be no deformed terminal</p><p>4. Check the half-wrap taping and Y-taping condition.</p></div> | | | |

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n/a

JIG:

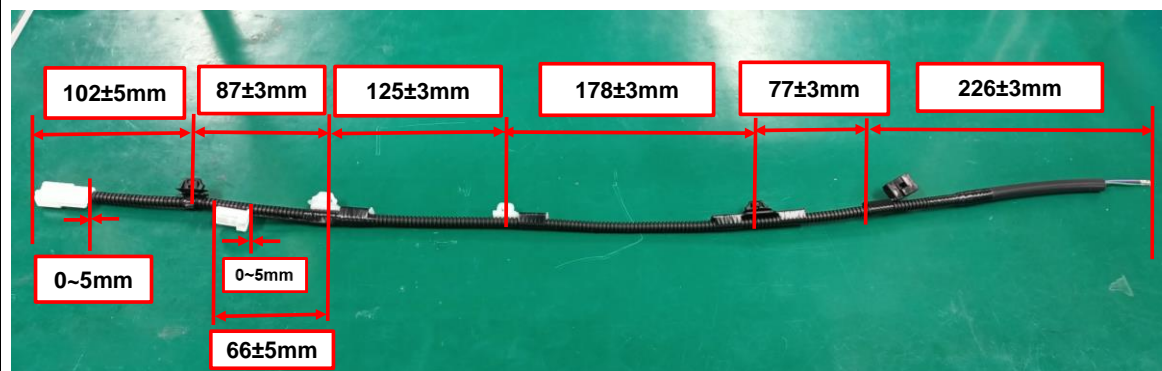
n/a

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

15

n/a

Measurement

**MEASURING TAPE**

1. No wrong dimension

Important reminders/Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.
2. For Hatsumono, Nakamono and Owarimono.

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PARTS:

n/a

JIG:

n/a

QUALITY CHECKPOINTS

n/a

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GOOD



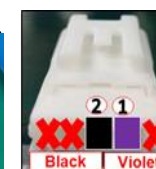
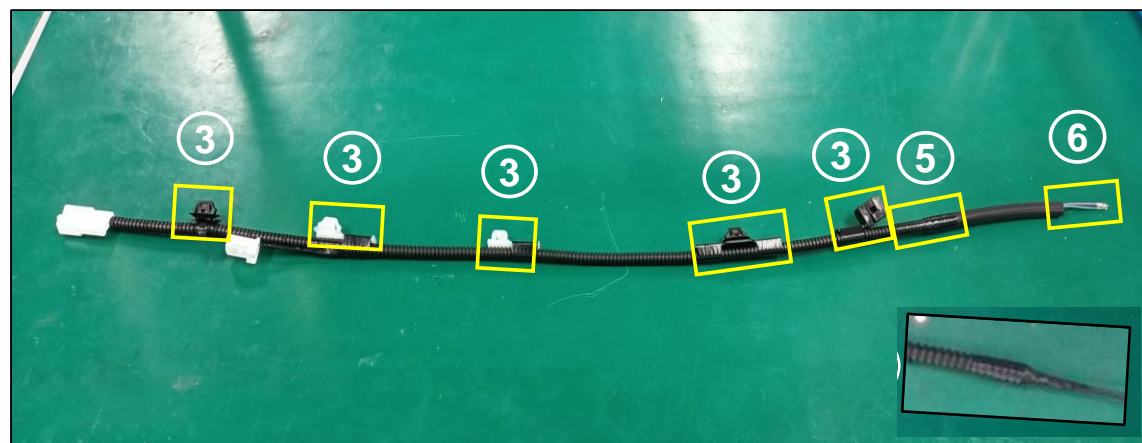
GOOD



NO GOOD



NO GOOD



NO GOOD



GOOD



GOOD



NO GOOD

1

**No Unlock/Halflock
Connector**

(On 2 connectors)

2

No Wrong Insert

(On 2 connectors)

4

No Missing tape

6

**No deformed
terminal**

3

No missing clamps

5

**No missing parts [VM tube
(Sunprene)]**

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