



WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	February 05, 2025		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-177A		
Revision No.:	6	Page No.:	1 of 12

Process Name/Title:

Model code/Part number: **011B / 7M0366-7020B** Customer: **TRJ** Car Model: **TOYOTA-CAMRY**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO**PARTS:**

1.Connector 6098-2220 (W); Connector 6098-3802 (W); Black Corrugated tube Ø5 L=251±3mm (no slit); AVSSf 0.3 wires Y L=733±3mm, OR L=733±3mm; Black Corrugated tube Ø5 L=413±3mm (no slit);AVSSf 0.3 wires B-B L=816±3mm; Corrugated tube Ø5 L= 233±3mm (no slit);

JIG:

1. Insertion w/ and w/o switch cover
2. Locking jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	Table lay-out	<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	<div>1. No missing parts/tools. 2. No excess parts/tools.</div> <div>CONNECTOR ILLUSTRATION</div> <div><div>GOOD</div><div>NG</div><div>6098-3802 (W)</div><div>6098-5668 (W)</div></div>

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
02/05/25	6	Additional Quality pointers "No insufficient tape" as countermeasure to customer claim. Improved Visual inspection/Quality checkpoint.	D.Castillo	C.Villanueva	A. Arañes	N/A				n/a
10/18/24	5	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				
07/14/23	4	Updated template; Inclusion of CAR MODEL "TOYOTA-CAMRY" . Inclusion of Locking process 6098-2220 (W) (page no.4 and 5, process no.4); Inclusion of Quality Checkpoints; Improve Work procedure illustration (process no.10 and 12); Improve Quality Checkpoints: Reminders/Notes and references (pg. no.1-11);Change the wire color location from Y-OR to OR/Y.	M. Ariola	J. Loterte	C. Villanueva	A.Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	June 02, 2022		

Details of Change

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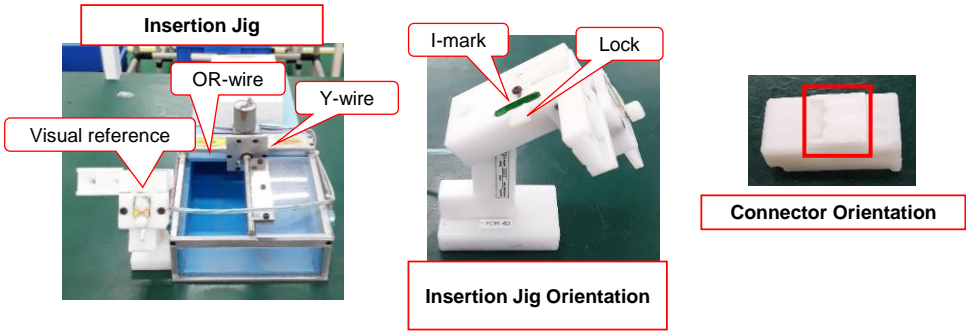
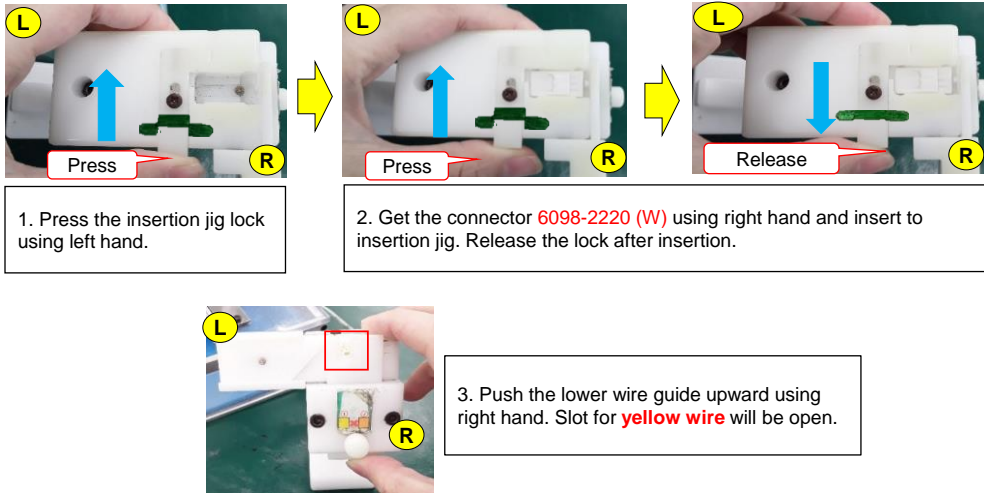
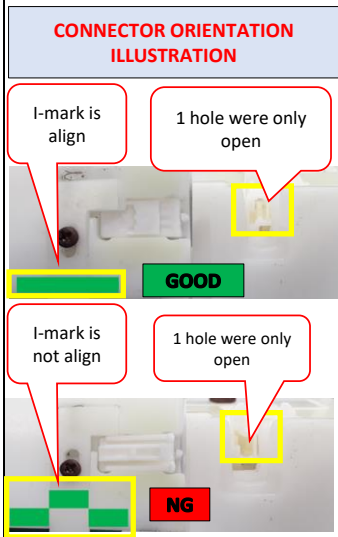
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PARTS:		1. Connector 6098-2220 (W)			JIG	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
2	P1	<p>Connector setting to insertion jig 6098-2220 (W)</p>   <p>1. Press the insertion jig lock using left hand.</p> <p>2. Get the connector 6098-2220 (W) using right hand and insert to insertion jig. Release the lock after insertion.</p> <p>3. Push the lower wire guide upward using right hand. Slot for yellow wire will be open.</p>			n/a	<p>CONNECTOR ORIENTATION ILLUSTRATION</p>  <p>1. Use the provided jig per model</p> <p>2. No wrong orientation of connector</p>

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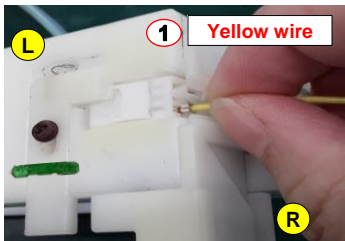
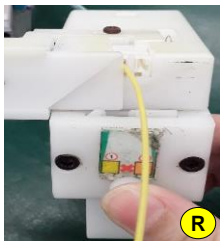
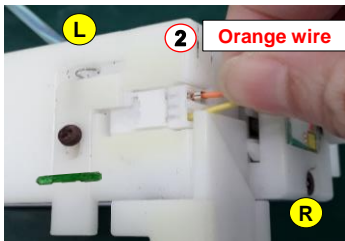
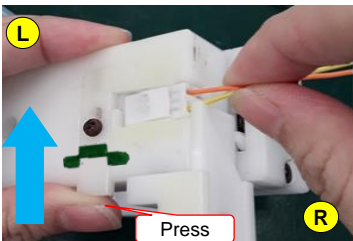
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PARTS:		1. AVSSf 0.3 wires Y L=733±3mm, OR L=733±3mm			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	P1	<div><p>Wire facing</p></div> <div><p>1. Hold the insertion jig using left hand. Get the Yellow wire and insert to connector using right hand.</p></div> <div><p>2. Press the button using right thumb. slot for Orange wire will be open.</p></div> <div><p>3. Get the Orange wire and insert to connector 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	<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:</p> <p>1. Please hold the wire near terminal during insertion. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 3. Insertion must be from left to right.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance. 2. Please refer to GL-PRO-ASY-029 for Pull-Push procedure</p>

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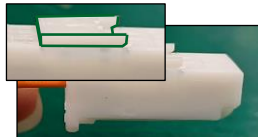
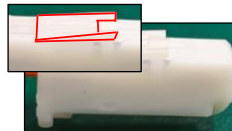
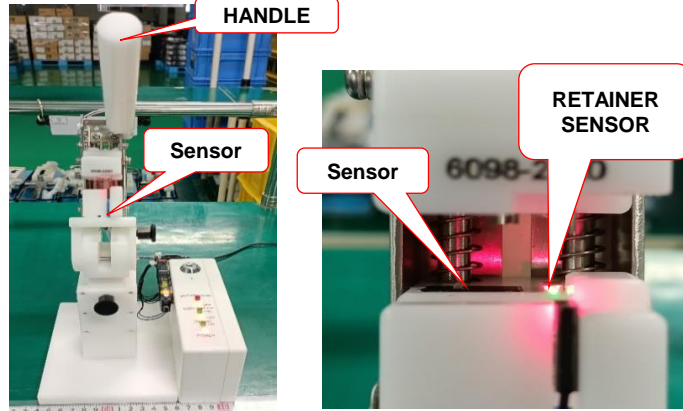
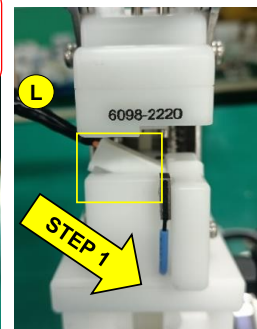
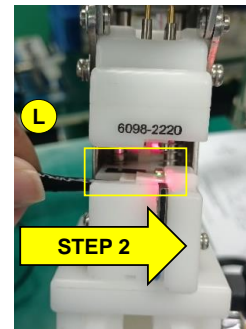
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PARTS:		1. Assy parts			JIG	1. Locking jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	Connector lock	<div><div><div>CONNECTOR RETAINER ILLUSTRATION SIDE VIEW</div><div><div></div><div></div></div><div><div>1.Check the Retainer lock of connector before insertion to locking jig. <i>Note: Must be NO half-locked condition prior connector locking.</i></div></div></div><div><div><div><div></div><div><div></div><div></div></div></div><div>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. <i>NOTE: CONNECTOR LOCKING JIG WILL NOT FUNCTION IF CONNECTOR NOT REACH THE SENSOR.</i></div></div></div></div>			<div>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.</div> <div>Important reminders/Note/s: <i>1. Incomplete locking process will alarm the jig.</i> <i>2. No retainer in connector cannot proceed.</i> <i>3. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</i></div>

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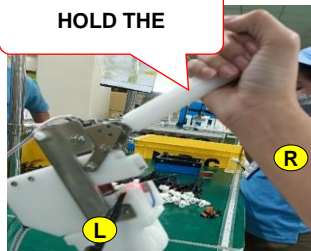
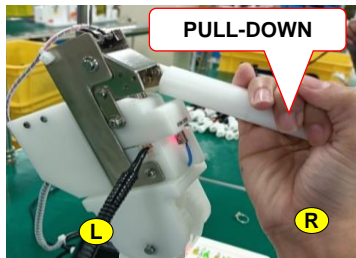
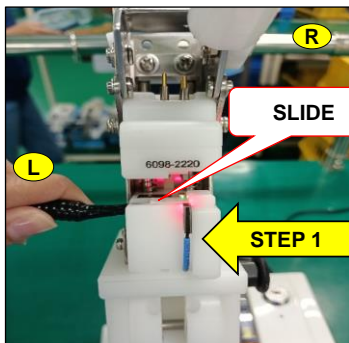
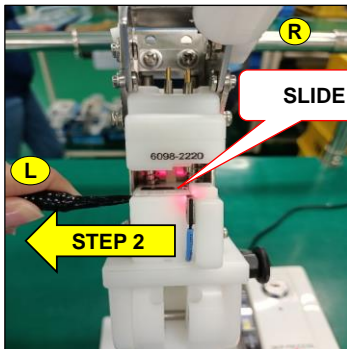
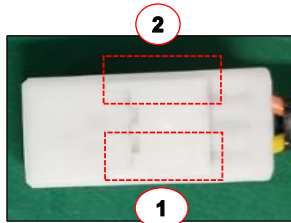


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PARTS:		1. Assy parts			JIG	1. Locking jig 6098-2220	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	P1	Connector lock (Continuation)	<div><div><div></div><div></div><div></div><div></div><div></div><div></div><div></div></div><div><p>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.</p><p>4. Remove the locked connector using left hand based on the illustration, follow the direction of arrow.</p><p>5. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div><div><p>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.</p><p>2. Maintain 10mm proper holding of wire to connector</p><p>3.Connector must be fully inserted to connector slot.</p><p>4. Make sure no offset setting before locking process.</p><p>5.No wrong setting of connector.</p><p>6. No damaged connector lock</p><p>7. No unlocked/ half-locked connector.</p><p>Important reminders/Note/s:</p><p>1. <i>Incomplete locking process will alarm the jig.</i></p><p>2. <i>No retainer in connector cannot proceed.</i></p><p>3. <i>If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</i></p></div></div>				

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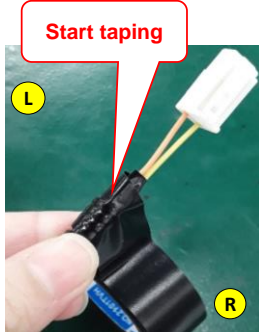
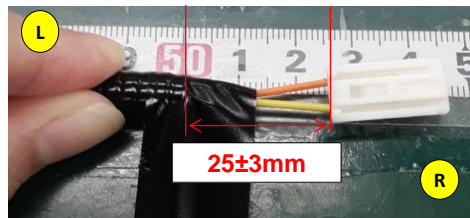
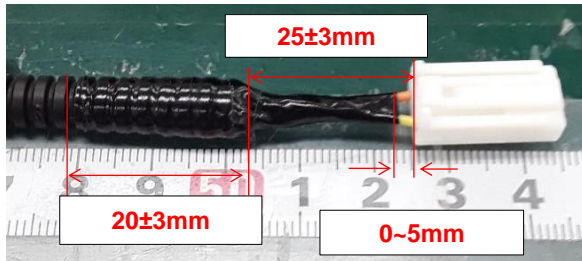

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PARTS:		1. Black Corrugated tube Ø5 L=251±3mm (no slit) 2. Assy parts			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
5	P1	Wire insertion to Black Corrugated tube Ø5 L= 251±3mm (no slit)		1. Get the corrugated tube Ø5 L= 251±3mm (no slit) using right hand then insert the yellow wire and orange wire by using left hand.	n/a	1. No wrong use of parts 2. No deformed terminal
6		Taping 1 Black Corrugated tube to Wire near connector	<div><p>Start taping</p></div> <div><p>1. Hold the assy parts using left hand. Get Black tape using right hand and start pre-taping.</p></div> <div><p>25±3mm</p></div> <div><p>2. Measure from COT to Connector 25±3mm using both hands and continue the taping process.</p></div> <div><p>20±3mm</p><p>0~5mm</p></div> <div><p>3. Check the measurement and taping condition after taping.</p></div> <div><p>MEASURING TAPE</p></div> <div><p>6</p><p>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 7. No insufficient tape</p><p>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p><p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p></div>			

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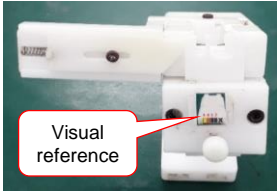
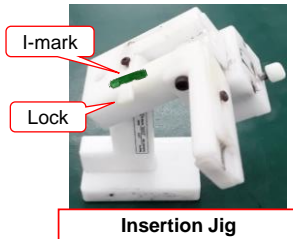

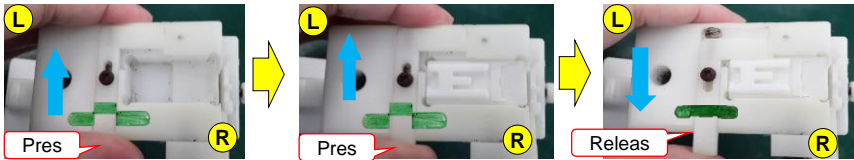
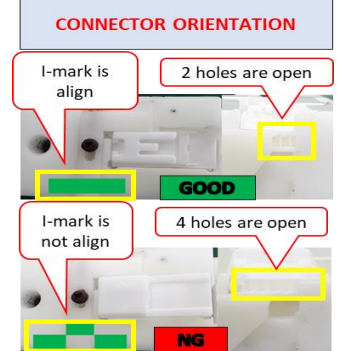
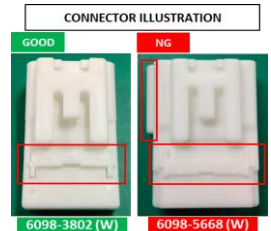
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PARTS:		1. Black Corrugated tube Ø5 L= 413±3mm (no slit) 2. AVSSf 0.3 wires B-B L=816±3mm [2pcs]			3. Assy parts 4. Connector 6098-3802 (W)		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE		QUALITY POINTERS	
7		Wire insertion to Corrugated tube Ø5 L= 413±3mm (no slit)				n/a	1. No wrong use of parts 2. No deformed terminal Document reference/s: 1. Refer to WI-PRO-CNC-017 For Wire and Strip length tolerance.	
8	P1	Connector setting to insertion jig 6098-3802 (W)	<div><div>Insertion  Visual reference</div><div> Insertion Jig</div><div> Connector</div></div> <div> 1. Press the insertion jig lock using left hand. 2. Get the connector 6098-3802 (W) using right hand and insert to insertion jig. Release the lock after insertion. 3. Do not push the lower wire guide upward. Slot for 2 Black wires must be open.</div>			n/a	<div>CONNECTOR ORIENTATION </div> <div>CONNECTOR ILLUSTRATION </div> 1. Use provided jig per model 2. No wrong orientation of connector	

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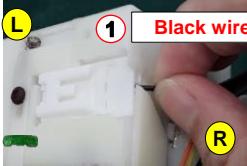
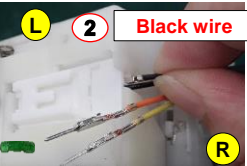


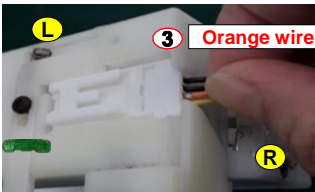
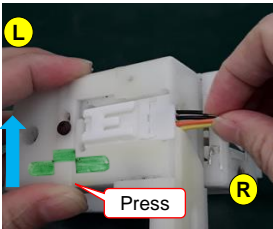
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PARTS:		1. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1 Wire insertion to Connector 6098-3802 (W) (Assy parts)	<div><p>Wire facing</p></div> <div><p>1. Hold the insertion jig using left hand. Insert the 2 Black wires one by one to connector using right hand.</p></div> <div><p>2. Press the lower wire guide upward using right hand. Slot for Yellow wire will be open.</p></div> <div><p>3. Insert the Yellow wire using right hand.</p></div> <div><p>4. Press the button using right thumb. Slot for Orange wire will be open.</p></div> <div><p>5. Insert the Orange wire using right hand.</p></div> <div><p>6. 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:</p> <p>1. Please hold the wire near terminal during insertion 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.</p> <p>Document reference/s:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>

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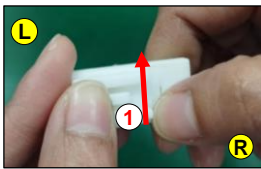


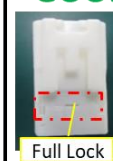

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PARTS:		1. Assy parts		JIG	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	P1	<div><div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div><div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div><div><p>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>		LOCKING JIG	<p>1. Use the provided locking jig per model 2. No unlock/half-lock connector</p> <p>Important reminders/Note/s:</p> <p>1. Manual locking may cause damaged connector lock.</p> <div></div> <div><div>GOOD</div><div>Full Lock</div><div>NG</div><div>Half Lock</div></div>

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model code/Part number:

011B

/ 7M0366-7020B

Customer:

TRJ

Car Model:

TOYOTA CAMRY

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

February 05, 2025

Validity Date:

n/a

Document No.:

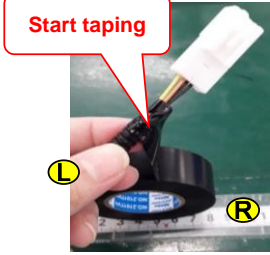
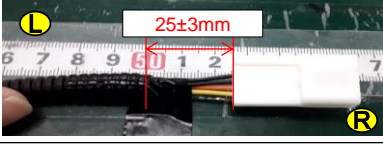
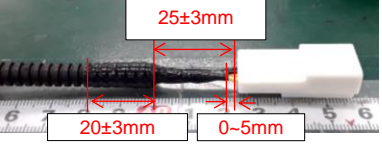





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PARTS:		1. Black tape 2. Corrugated tube Ø5 L= 233±3mm (no slit)	3. Assy parts	JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1	Taping 2 COT to wire near connector	<div><p>Start taping</p></div> <div><p>25±3mm</p></div> <div><p>1. Hold the assy parts using left hand. Get Black tape using right hand and start pre-taping.</p></div> <div><p>2. Measure from COT to Connector 25±3mm using both hands and continue the taping process.</p></div> <div><p>25±3mm 20±3mm 0-5mm</p></div> <div><p>3. Check the measurement and taping condition after taping.</p></div>	<p>MEASURING TAPE</p> 	<p>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 7. No insufficient tape</p> <p>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p>
12		Wire insertion to Black corrugated tube (no slit) Ø5 L=233±3mm	<div><p>1. Get the terminal cover jig using right hand and insert the Black wires using left hand.</p></div> <div><p>2. Get the Black corrugated tube (no slit) Ø5 L=233±3mm using right hand and insert the wires using left hand.</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand</p></div>	<p>TERMINAL COVER JIG</p> 	<p>1. No wrong use of parts 2. No deformed terminal</p>

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model code/Part number:

011B

/ 7M0366-7020B

Customer: TRJ

Car Model:

TOYOTA CAMRY

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

February 05, 2025

Validity Date:

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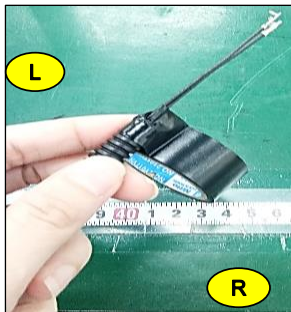
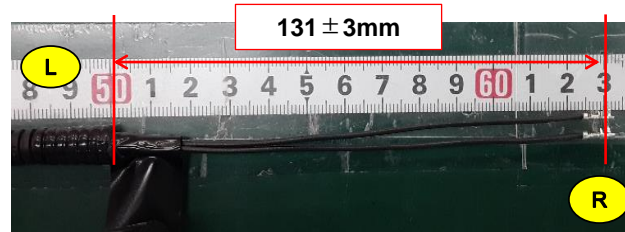
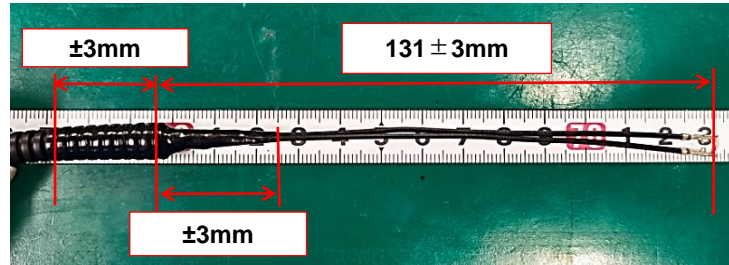

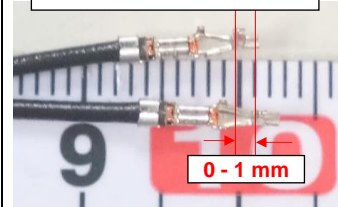
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PARTS:		1. Black tape 2. Assy parts		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
13	P1	Taping Corrugated tube to wire near terminal	<div></div> <div><p>1. Hold the assy parts using left hand. Get the Black tape using right hand then start taping between COT to wire using both hands.</p></div> <div></div> <div><p>2. Measure from end of COT up to terminal pointed tip 131±3mm then continue the taping process using both hands</p></div> <div></div> <div><p>3. After taping, check the measurement, terminal alignment and taping condition.</p></div>	<div><p>MEASURING TAPE</p></div>	<div><p>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 7. No insufficient tape</p><p>Important reminders/Note/s: 1. <i>Please use calibrated/verified measuring tape when getting the measurement.</i></p><p>Document references: 1. <i>Refer to WI-PRO-ASY-001A for Taping process</i></p><div><p>Wire alignment tolerance</p></div></div>

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model code/Part number: **011B / 7M0366-7020B**

Customer: **TRJ**

Car Model: **TOYOTA CAMRY**

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

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Document No.:

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PARTS:

1. Assy parts

JIG

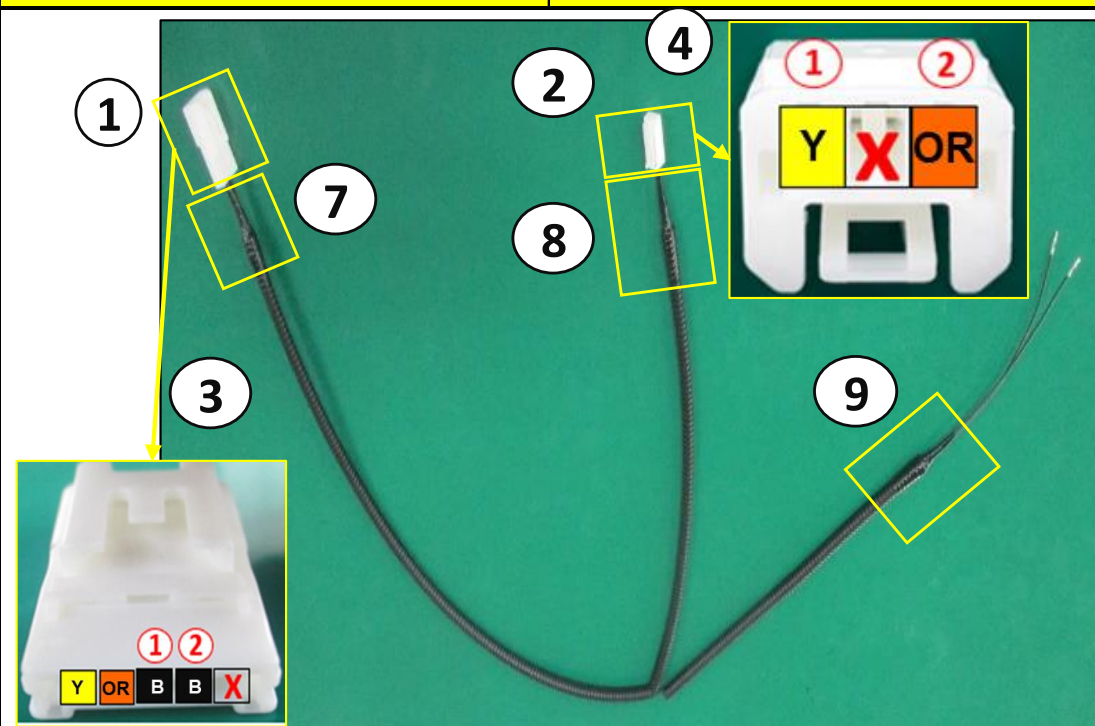
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VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING - P1

7M0366-7020B



① ② No Unlocked/
Half-locked connector

③ ④ No Wrong Insert

⑤ No Deformed terminal

⑥ No Terminal backing
out

⑦ ⑧ ⑨ No Missing Tape
No wrong use tape

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