



## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

November 13, 2023

Process Name/Title:

Model code/Part number:

310D / 7N0190-7020

Customer: TRJ

Car Model: TOYOTA RAV4

Validity Date:

n/a

Document No.:

WI-ENG-PDE-749

Purpose:


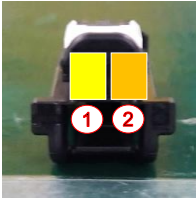


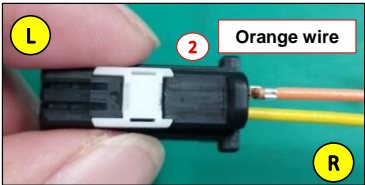
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PARTS:		1. Connector 6098-6663 (B) 2. AVSSf 0.3 wires Y-OR L=431±2mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	n/a	<div><p>CONNECTOR ORIENTATION</p></div> <div><p>VISUAL REFERENCE</p></div> <div><p>Wire facing</p></div> <div><p>Yellow wire</p></div> <div><p>Orange wire</p></div> <div><p>1. Get the connector <b>6098-6663 (B)</b> then hold the <b>Yellow wire</b> and insert to terminal <b>slot 1</b> of connector using right hand. Conduct <b>2x</b> push pull after wire insertion.</p></div> <div><p>2. Hold the connector <b>6098-6663 (B)</b> then get the <b>Orange wire</b> and insert to terminal <b>slot 2</b> of connector using right hand. Conduct <b>2x</b> push pull after wire insertion.</p></div>		<div><p><b>Safety Instruction</b> Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p></div> <div><p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p></div> <div><p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p></div>	<p>1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing</p> <p><b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal.</b> <b>2. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b></p> <p><b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b> <b>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b></p>
Revision History				Prepared by	Reviewed by
				Approved by	Noted by
11/13/23	0	Initial issue	A. Hernandez C. Villanueva A. Arañes n/a	A. Hernandez	C. Villanueva A. Arañes n/a
Eff. Date	Rev. No	Details of Change		Revised	Reviewed
				Approved	Noted
				Est. Date:	November 13, 2023

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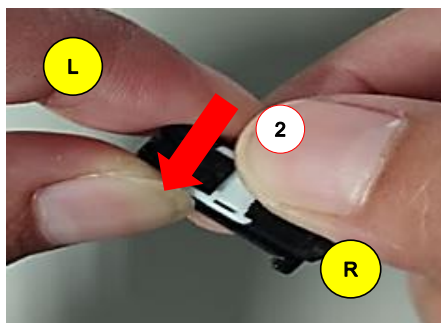
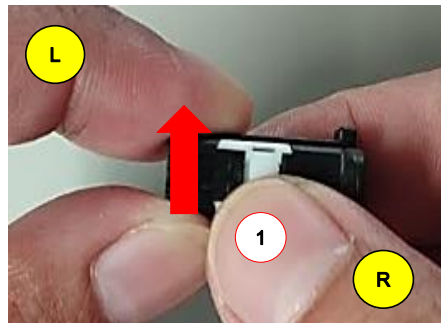




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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	n/a	Connector Lock	<div><p>1. Put the connector into locking jig using right hand then press to lock <b>2x</b> using both hands.</p><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><p>AFTER PRESSING</p></div> <div><p>LOCKING JIG</p></div>	<p><b>Important reminders/Note/s:</b></p> <p><b>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b></p> <p>1. Use the provided jig per connector 2. No unlock/half-locked connector</p>

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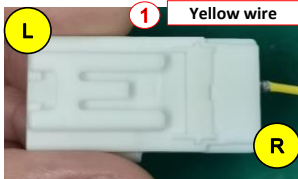
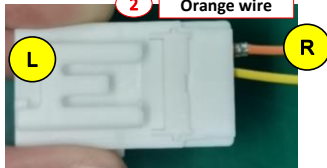
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PARTS:		1. Assy parts 2. Black Corrugated tube ø5 L=360±3mm (no slit)		3. Black SV tube (vinyl) ø5 L=18±3mm 4. Connector 6098-5668 (W)		JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	n/a	Wire Insertion to Black Corrugated tube ø5 L=360±3mm (no slit)	<div><div></div><div>1. Get the Black Corrugated tube <b>ø5 L=360±3mm (no slit)</b> using right hand then insert the <b>Y-OR wires</b> using left hand.</div></div>			n/a	1. No wrong use of parts 2. No deformed terminal
4		Wire Insertion to Black SV tube (vinyl) ø5 L=18±3mm	<div><div></div><div>1. Get the Black Vinyl tube <b>ø5 L=18±3mm</b> using right hand then insert the <b>Y-OR wires</b> using left hand.</div></div>			n/a	1. No wrong use of parts
5		Wire insertion to connector 6098-5668 (W)	<div><div><div>Connector orientation</div></div><div><div><div>VISUAL REFERENCE</div></div><div><div><div>1. Hold the connector <b>6098-5668 (W)</b> then get the <b>Yellow wire</b> and insert to terminal <b>slot 3</b> using right hand. Conduct <b>2x</b> push-pull after wire insertion.</div></div><div><div><div>2. Get the <b>Orange wire</b> and insert to terminal <b>slot 4</b> using right hand. Conduct <b>2x</b> push-pull after wire insertion.</div></div></div></div></div></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> <div><b>Important reminders/Note/s:</b> 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b></div> <div><b>Document references:</b> 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>

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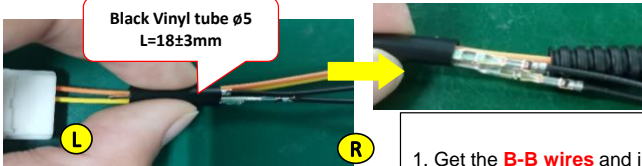



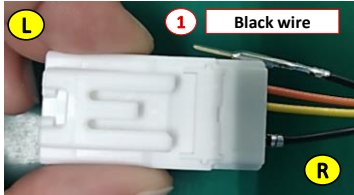
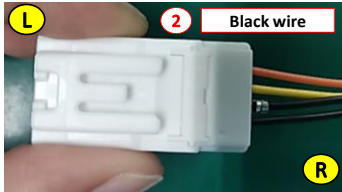
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PARTS:		1. Assy parts 2. IRRAX A ROPE-LAY (7/70.1) 0.3 wire B-B L=200±2mm 3. Connector 6098-5668 (W)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	n/a	Wire insertion to Black Vinyl tube ø5 L=18±3mm (Assy parts)	<div><div>1. Get the <b>B-B wires</b> and insert to Black Vinyl tube <b>ø5 L=18±2mm (Assy parts)</b> using right hand.</div></div>	n/a	1. No wrong use of parts
7		Wire insertion to connector 6098-5668 (W) (Assy parts)	<div><div><div>Connector orientation</div></div><div><div>VISUAL REFERENCE</div></div><div><div>Wire facing</div></div></div> <div><div><div>1. Hold the connector <b>6098-5668 (W)</b> then get the <b>Black wire</b> and insert to terminal <b>slot 1</b> using right hand. Conduct <b>2x</b> push-pull after wire insertion.</div></div><div><div><div>2. Get the <b>Black wire</b> and insert to terminal <b>slot 2</b> using right hand. Conduct <b>2x</b> push-pull after wire insertion.</div></div></div></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> <div><b>Important reminders/Note/s:</b> <b>1. Please hold the wire near terminal.</b> <b>2. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b></div> <div><b>Document references:</b> <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b> <b>2. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</b></div>

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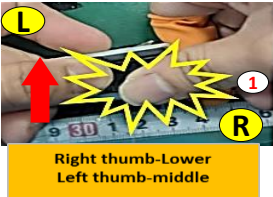
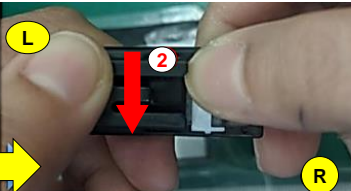
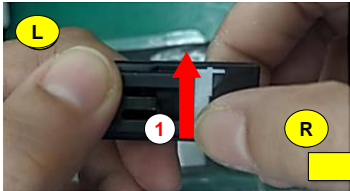

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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	n/a	<div><div></div><div><div>1. Load the connector into the jig holding both side of the connector, tip first.</div><div>2. Press the lower part of connector to fully insert into the locking jig.</div></div></div> <div><div></div><div><div>Right thumb-Lower Left thumb-middle</div><div>Right thumb-upper Left thumb-middle</div><div>Right thumb-middle Left thumb-middle</div></div><div><div>3. Press the lower parts of connector using right hand while left hand holding the middle.</div><div>4. Press the upper part of connector using right hand while left hand holding the middle.</div><div>5. Lift then press the connector in the middle using left and right hand.</div></div></div> <div><div></div><div><div>1</div><div>2</div></div><div><div>6. Ensure that connector is in locked condition by touching the connector lock based on the sequence illustrated.</div></div></div>		<div><div>LOCKING JIG</div></div>	<div>1. No Unlock and half-locked 2. Use provided jig tools per model to avoid damaged lock.</div> <div><b>Important reminders/Note/s:</b> 1. <b>Manual locking may cause damaged connector</b> 2. <b>Refer WI-PRO-KIT-001 Proper locking and checking of connector lock</b></div>

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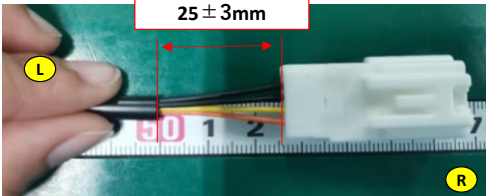
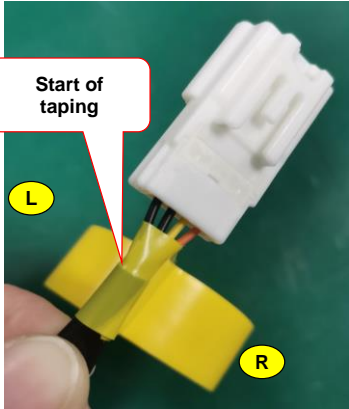
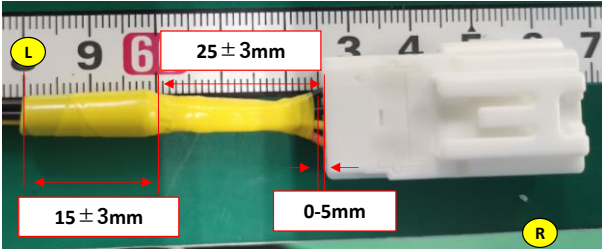

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PARTS:		1. Assy parts 2. Yellow tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	n/a Taping 1 Black SV tube (Vinyl) to wire near connector	 <p>1. Hold the Black vinyl tube using left hand and measure from end of vinyl tube up to connector <b>25±3mm</b>. <i>Note: Without folding in Vinyl tube</i></p>  <p>1. Hold the tube using left hand, get the <b>Yellow tape</b> using right hand then start pre-taping using both hands.</p>  <p>4. After taping, check the measurement and taping condition.</p>			<p><b>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"><li>1. Use <b>YELLOW TAPE</b> only</li><li>2. Please use calibrated/verified measuring tape when getting the measurement.</li></ol> <ol style="list-style-type: none"><li>1. No flip-out tape</li><li>2. No peel-off tape</li><li>3. No loose tape</li><li>4. No missing tape</li><li>5. No wrong dimension</li><li>6. No wrong use of tape</li></ol>

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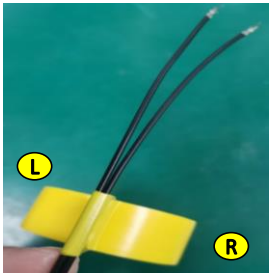
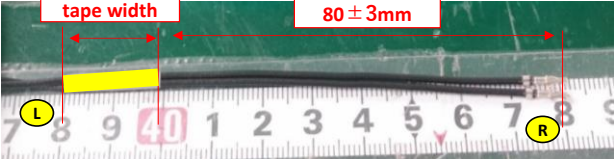

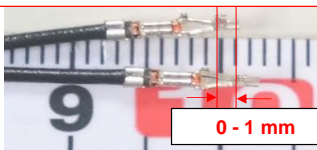

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Revision No.:

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PARTS:		1. Assy parts 2. Yellow tape		3. Black SV tube (vinyl) Ø5 L=107±3mm		JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
10	n/a  Spot taping 1		<div><div><p>1. Hold the wires using left hand and measure from wire up to terminal pointed tip <b>100±3mm</b>.</p></div><div><p>2. Get the <b>Yellow tape</b> and start taping on the Black wires. Conduct <b>2x windings</b> of tape before cutting using both hands.</p></div><div><p>3. After taping, check the measurement and taping condition.</p></div></div>			<div><div>MEASURING TAPE</div></div>	<div><div>Wire alignment tolerance</div><p>0 - 1 mm</p></div> <div><div>1. No flip-out tape</div><div>2. No peel-off tape</div><div>3. No loose tape</div><div>4. No missing tape</div><div>5. No wrong dimension</div><div>6. No wrong use of tape</div></div> <div><div>Important reminders/Note/s:</div><div>1. Use <u>Yellow TAPE</u> only</div><div>2. Please use calibrated/verified measuring tape when getting the measurement.</div></div>
11	Wire insertion to Black vinyl tube Ø5 L=107±3mm		<div><p>1. Get the Viny tube <b>Ø5 L=107±3mm</b> using right hand then insert the <b>B-B wire</b> using left hand.</p></div>			n/a	1. No wrong use of parts

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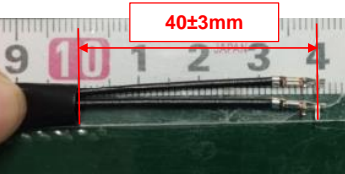


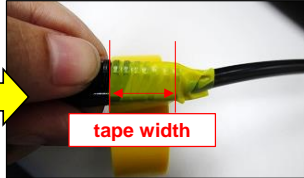

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PARTS:		1. Assy parts 2. Blue tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
12	n/a	Y-Taping			
		<div><div></div><div></div><div></div><div>2. Measurement from end of Vinyl tube up to terminal tip. Must be <b>40±3mm</b>.</div><div>1. Fix the COT and vinyl tube. Make sure no gap in between.</div></div>			<div><p><b>Important reminders/Note/s:</b></p><p>1. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines, but actual should be <b>BLUE TAPE</b>.</p><p>2. 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></div>
		<div><div></div><div></div><div></div><div>4. Make <b>1 shifting to the left</b> until tape width then wind the tape <b>2x</b>.</div><div>3. Get the tape and fix the COT to vinyl tube. Make <b>1 wind pre-taping</b> before shifting.</div></div>			
		<div><div></div><div>5. Make <b>1/3 shifting to the right</b> side until tape width on vinyl tube</div></div>			

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### PARTS:

JIG:

NO.

PROCESS NAME

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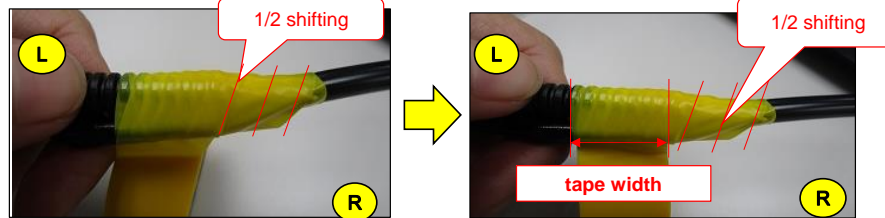
TOOLS/PPE

QUALITY POINTERS

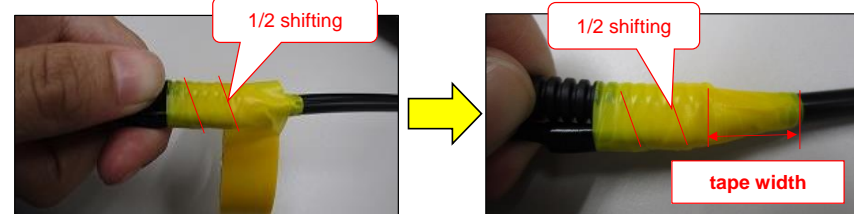
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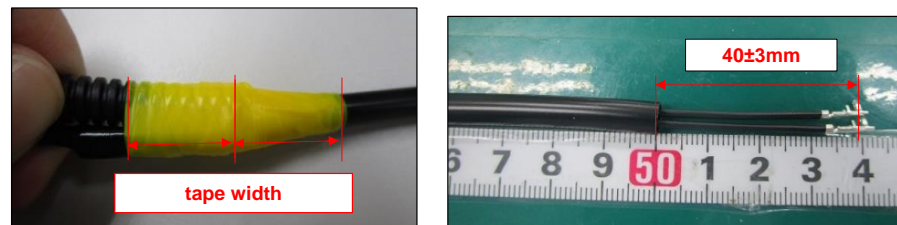
Y-Taping  
(Continuation)



6. Make 1/2 shifting to the left until tape width then wind the tape 2x.



7. Make 1/2 shifting to the right until tape width on vinyl tube, wind the tape 2x then cut the tape.



8. After taping, check the measurement from vinyl tube up to terminal pointed 40±3mm and taping condition.

MEASURING TAPE



**Important reminders/Note/s:**

1. Use **YELLOW TAPE** for easy visualization of shifting lines, but actual should be **BLUE TAPE**.
2. 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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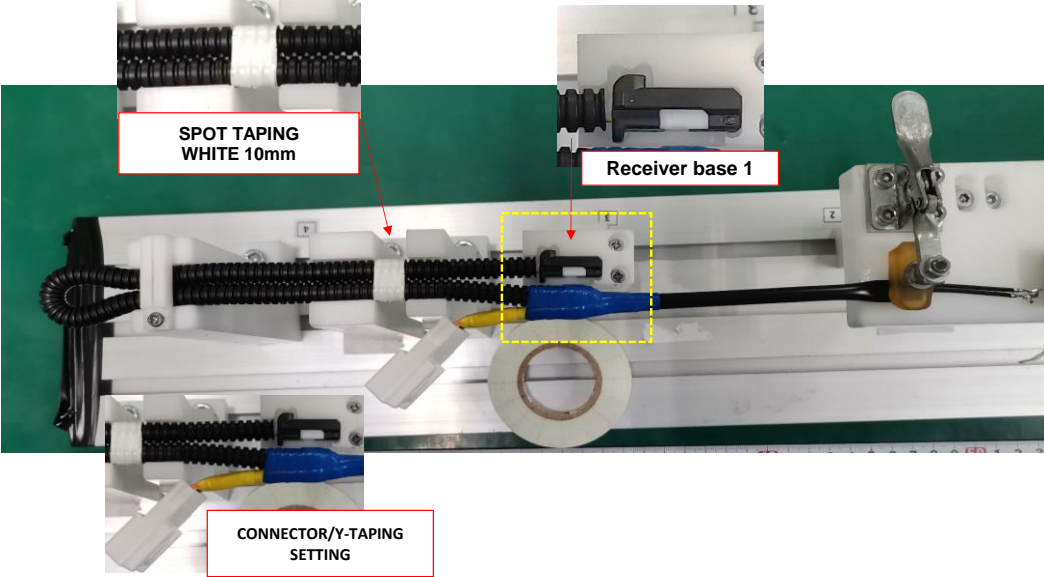
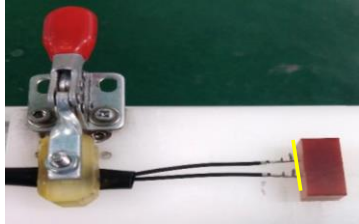

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PARTS:		1. Assy parts 2. White (10mm with slit)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
13	n/a  Spot taping White (10mm with slit)	<div></div> <div>1. Get the assy parts the set into jig. (See above illustration). First, set the connector 6098-5668 (W) to Receiver base 1. Continue to set the Y-taping then set the B-B wires into stopper then press by toggle clamp. Second, conduct folding of COT then set the connector 6098-6663 (B) to Receiver base 2.</div> <div>2. Hold the tape (White 10mm with slit) then conduct 1.5 windings of tape then cut using both hands.</div> <div>3. Conduct POINT CHECKING before removing the harness from jig.</div>			<div></div> <div>Important reminders/Note/s: 1. Make sure no gap between stopper and terminals</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><div>REFERENCE AFTER TAPING USING NITTO TAPE 2107TVH</div><div></div></div>

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Process Name/Title:

Effectivity Date:

November 13, 2023

Model code/Part number:

310D / 7N0190-7020

Customer: TRJ

Car Model: TOYOTA RAV4

Validity Date:

n/a

Purpose:


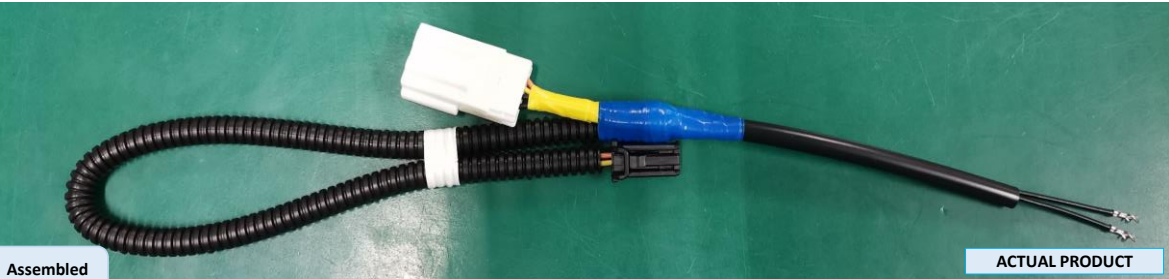



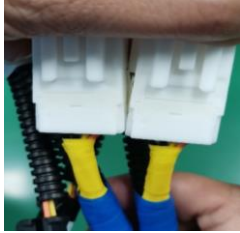

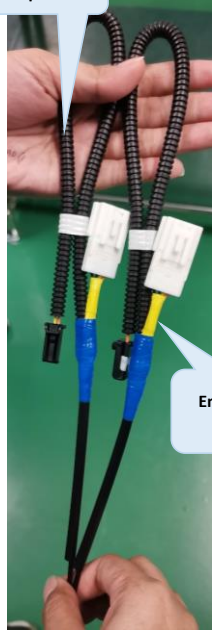
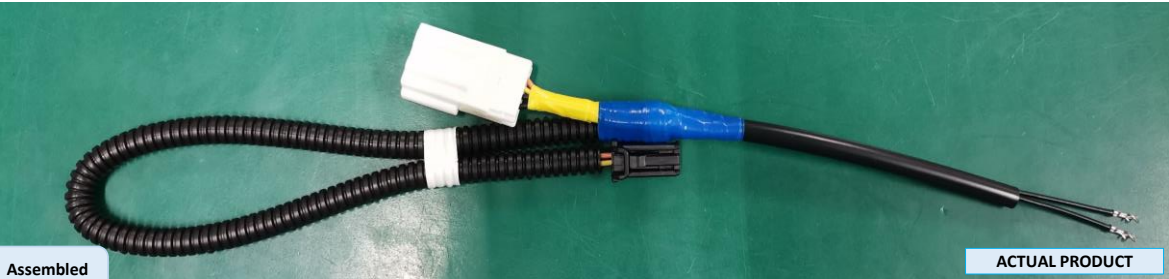
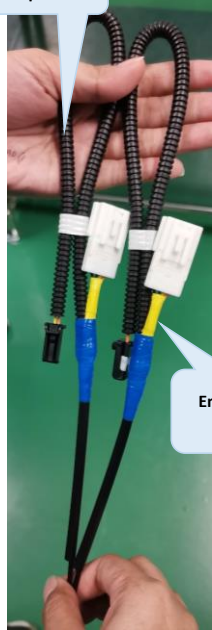
☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

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<b>PARTS:</b>		1. Assy parts 2. Engineering Sample		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
14	n/a	<div>Visual/By two's inspection</div> <div></div> <div>1. Conduct <b>alignment of harness (Engineering sample vs. assembled parts)</b> using both hands.</div> <div>2. Check the <b>terminal, connector lock, insertion and taping condition.</b></div> <div>3. Check the <b>Y-taping condition.</b></div> <div>4. Check the <b>connector lock and insertion.</b></div> <div>5. Check the <b>presence of spot tape (White 10mm)</b></div> <div>6. Check the <b>terminal appearance.</b> Must be <b>no deformed terminal.</b></div>			1. No skip checking during inspection

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Process Name/Title:

Effectivity Date:

November 13, 2023

Model code/Part number:

310D / 7N0190-7020

Customer: TRJ

Car Model: TOYOTA RAV4

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Document No.:


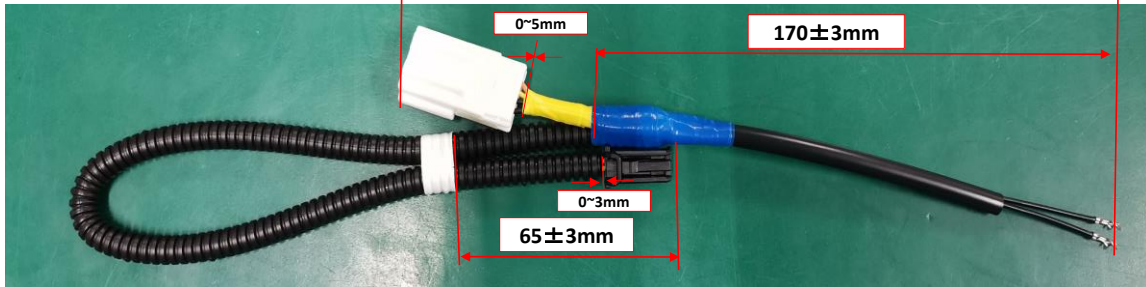
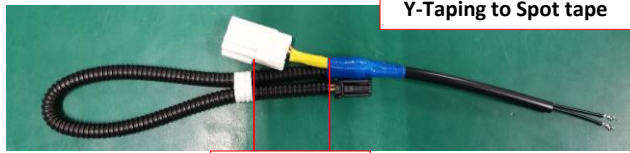
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
15	n/a	Measurement	<div><div>MEASURING TAPE</div><div></div><div>Note: Please use calibrated/verified measuring tape when getting the measurement.</div><div></div><div></div><div>Y-Taping to Spot tape</div><div>45±3mm</div></div> <div><div>Important reminders/Note/s:</div><div>1. Please use calibrated/verified measuring tape when getting the measurement.</div><div>2. For Hatsumono, Nakamono and Owarimono.</div><div>Document reference/s:</div><div>1. Refer to WI-PRO-ASY-056 for Sub assembly Hatsomono, Nakamono, and Owarimono Inspection.</div><div>1. No wrong dimension</div></div>	

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# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

310D / 7N0190-7020

Customer: TRJ

Car Model: TOYOTA RAV4

Purpose:

☐ PROTOTYPE

☒ PRE-LAUNCH

☐ MASSPRO

Effectivity Date:

November 13, 2023

Validity Date:

n/a

Document No.:

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PARTS:

n/a

JIG:

### QUALITY CHECKPOINTS

n/a

7N0190-7020



GOOD



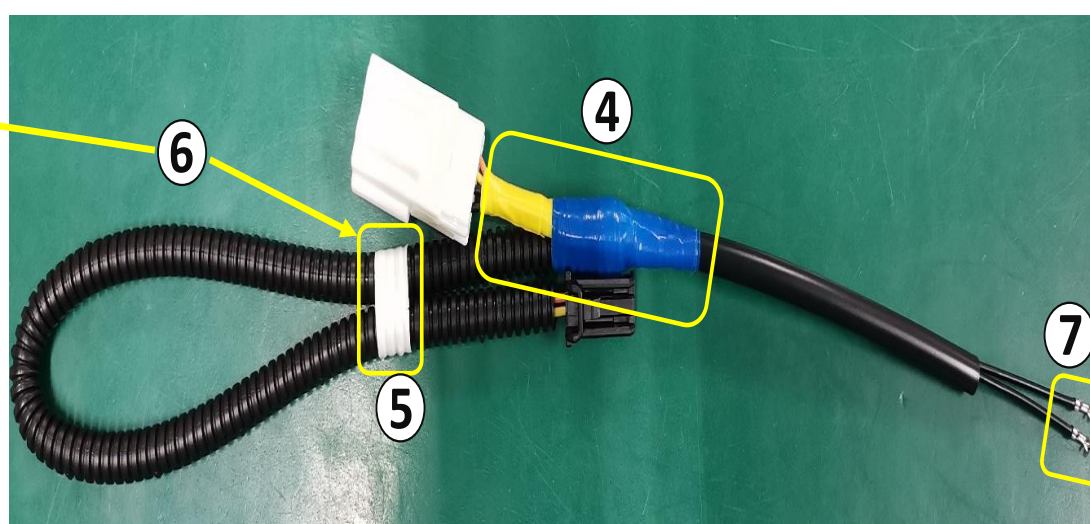
GOOD



GOOD: 1.5 windings



NG: 1 winding



GOOD



NO GOOD

NO GOOD

NO GOOD

② No Wrong Insert

④ No Missing Tape (for Y-Taping)

⑥ Spot Taping must be 1.5 windings

① No Unlock/Halflock Connector (2 connector)

③ No Terminal Backing Out

⑤ No Wrong Used of Tape (Spot Taping white tape)

⑦ No Deformed Terminal

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