



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

February 12, 2025

Model code/Part number:

400D / 7L0163-7020

Customer:

TRQSS

Car Model:

TOYOTA-bZ4X (BEV)

Document No.:

WI-ENG-PDE-1196

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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PARTS:

1. Black Corrugated tube Ø5 L=69+3mm (No slit)
2. AVSSf 0.3 B-B wires L=209+3mm

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

P1

Wire insertion to
Black Corrugated tube Ø5
L=69+3mm (No slit)



1. Get the Black Corrugated tube **Ø5 L=69+3mm (No slit)** using right hand then insert the B-B wires.

Safety Instruction

Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

Document reference/s:

1. Refer to **WI-PRO-CNC-017** for Wire and Strip Length Tolerance

1. No deformed terminal
2. No wrong usage of parts

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
02/12/25	0	Initial issue.	M. Ariola	C. Villanueva	A. Arañes	n/a	M. Ariola	C. Villanueva	A. Arañes	n/a

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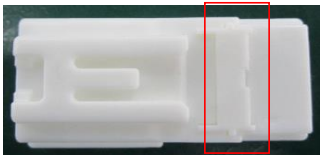

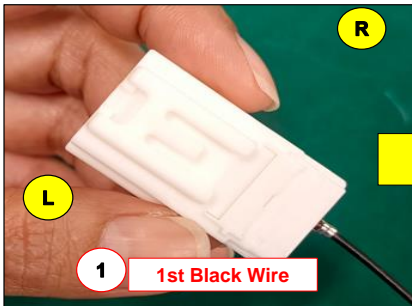
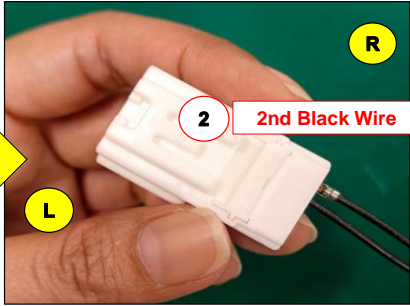
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PARTS:		1. Connector 6098-5668 (W)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1 Wire Insertion to Connector 6098-5668 (W)	<div><p>Connector Orientation</p></div> <div><p>TERMINAL FACING</p></div> <div><p>1 1st Black Wire</p></div> <div><p>2 2nd Black Wire</p></div> <div>1. Hold the Connector 6098-5668 (W) then get the 1st Black wire then insert to terminal slot 1 using right hand. Conduct 2x pull-push after wire insertion. Note: Insertion of wire must be from Left to right</div> <div>2. Get the 2nd Black wire then insert to terminal slot 2 using right hand. Conduct 2x pull-push after wire insertion. Note: Insertion of wire must be from Left to right</div>			1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector

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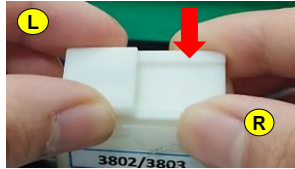



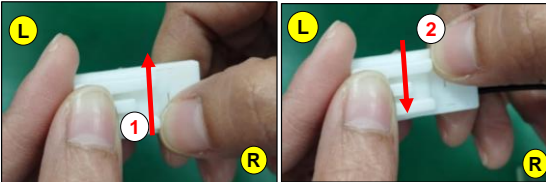

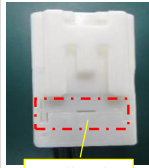



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PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1 Connector lock	<div><div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div><div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div><div><p>Right thumb-Lower Left thumb-middle</p></div><div><p>Right thumb-upper Left thumb-middle</p></div><div><p>Right thumb-middle Left thumb-middle</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>LOCKING JIG</div> 	<p>Important reminders/Note/s:</p> <p>1. Manual locking may cause damaged connector</p> <p>Document references:</p> <p>1.Refer WI-PRO-KIT-001 Proper locking and checking of connector lock</p> <p>1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p> <div><div>GOOD</div><p>Full Lock</p><div>NG</div><p>Half Lock</p></div> <div><p>Before pressing</p><p>After pressing</p></div>

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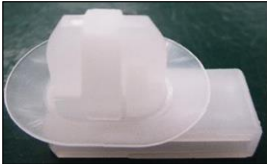
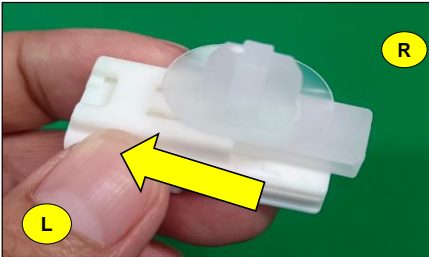
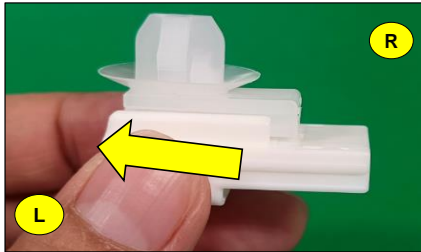
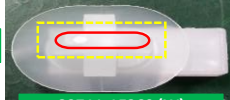

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PARTS:		1. Assy parts 2. Clip type clamp 82711-1E360 (W)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 Clip attachment (Clip type clamp)	<div></div> <div>CLAMP ORIENTATION</div> <div></div> <div></div> <div>1. Hold the Connector using left hand, get the clip type clamp 82711-1E360 (W) then insert the clamp using right hand. Note: Sound will be heard if properly inserted.</div>			<div>CLIP CLAMP ILLUSTRATION</div> <div></div> <div>GOOD</div> <div>82711-1E360 (W)</div> <div></div> <div>NG</div> <div>82711-12B10 (W)</div> <div>1. No wrong used of clamp 2. No damaged clamp 3. No missing clamp</div>

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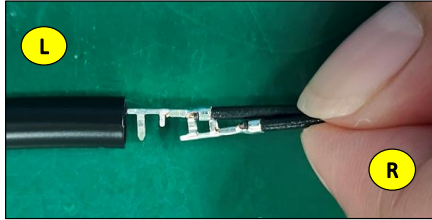
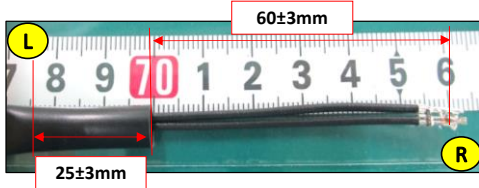
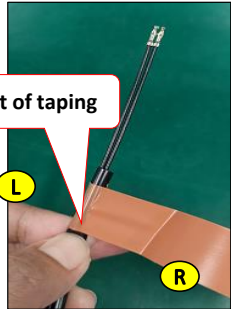
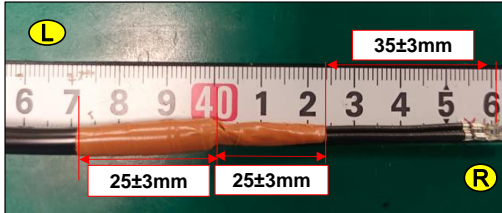

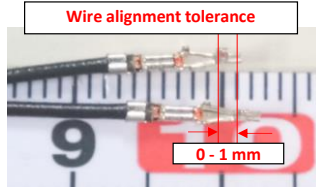
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PARTS:		1. Assy parts 2. Black SV tube (Vinyl) Ø4, L=76±3mm 3. Brown tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Wire Insertion to Black SV tube (Vinyl) Ø4, L=76±3mm	 <div>1. Get the Black SV tube (Vinyl) Ø4, L=76±3mm using left hand and insert B-B wires using right hand.</div>		n/a	1. No wrong use of parts 2. No deformed terminal
6	P1 Taping 1 Black SV tube (Vinyl) to wire near terminal	 <div>1. Hold the SV tube (Vinyl) using left hand, measure from end of SV tube (Vinyl) up to terminal tip 60±3mm.</div>  <div>2. Hold the assy parts using left hand, get the Brown tape using right hand then start taping process using both hands.</div>  <div>3. After taping, check the measurement, taping condition and wire alignment.</div>		 <div>MEASURING TAPE</div>	1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. 2. Refer to WI-PRO-ASY-0001B for the SV tube (Vinyl) to wire near terminal taping method. Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.  <div>Wire alignment tolerance 0 - 1 mm</div>

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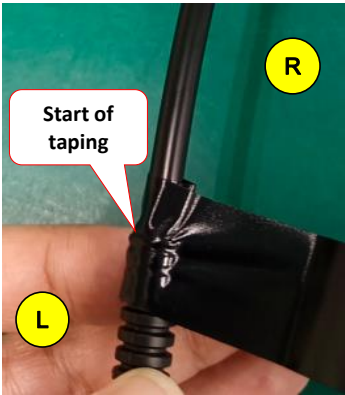
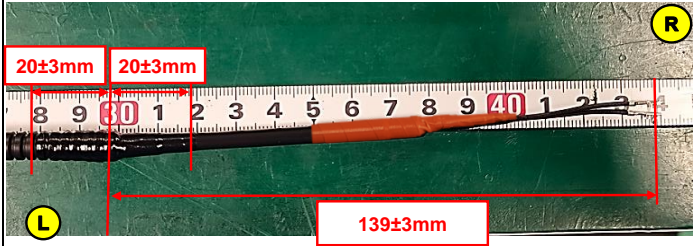

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1 Taping 2 Black Corrugated tube to SV tube (Vinyl)	 <p>1. Measure from COT to terminal pointed tip L=139±3mm using both hands.</p>  <p>1. Fix the corrugated tube and SV tube (Vinyl) using both hands. Hold the COT using left hand. Get the Black tape using right hand and start taping process using both hands.</p>  <p>3. After taping, check the measurement and taping condition.</p>			<p>Document reference/s:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. 2. Refer to WI-PRO-ASY-0001B for Combined COT to SV tube (Vinyl) taping method.</p> <p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p>

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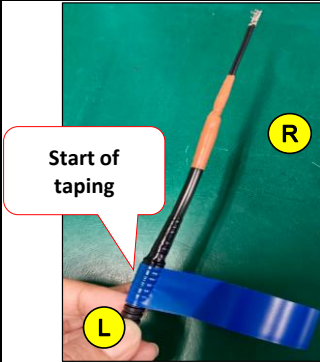



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PARTS:		1. Assy parts 2. Blue tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1	Spot taping	<div><p>1. Hold the harness using left hand. Get the BROWN TAPE Initially attach the tape on the top of the Black tape (COT taping) using right hand. (Must be 20±3mm)</p></div> <div><p>2. Measure from end of tape up to terminal pointed tip. L=154±3mm then conduct 2 windings of spot tape using both hands.</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>	<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</p>

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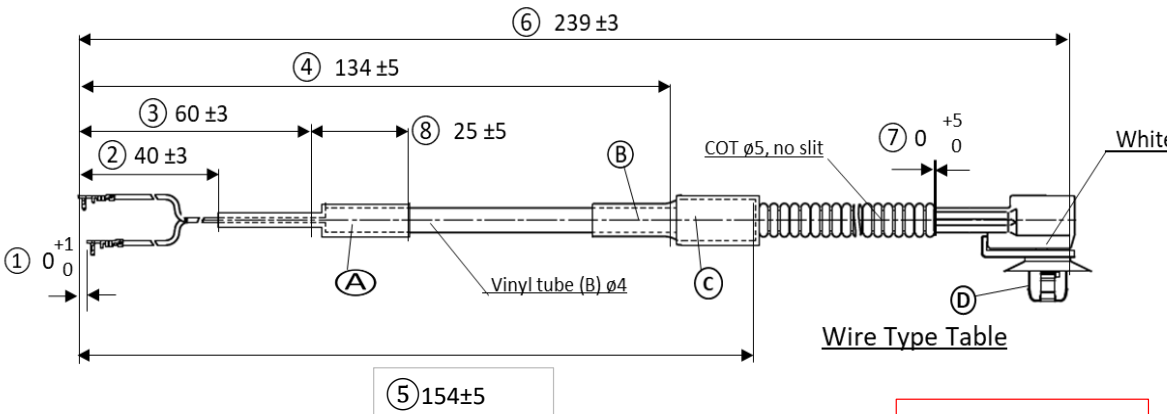
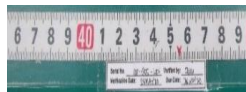
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P1 Measurement	<div></div> <div><div>MEASURING TAPE</div></div>		<div>1. No wrong dimension.</div> <div>Important reminders and note/s: 1. Please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

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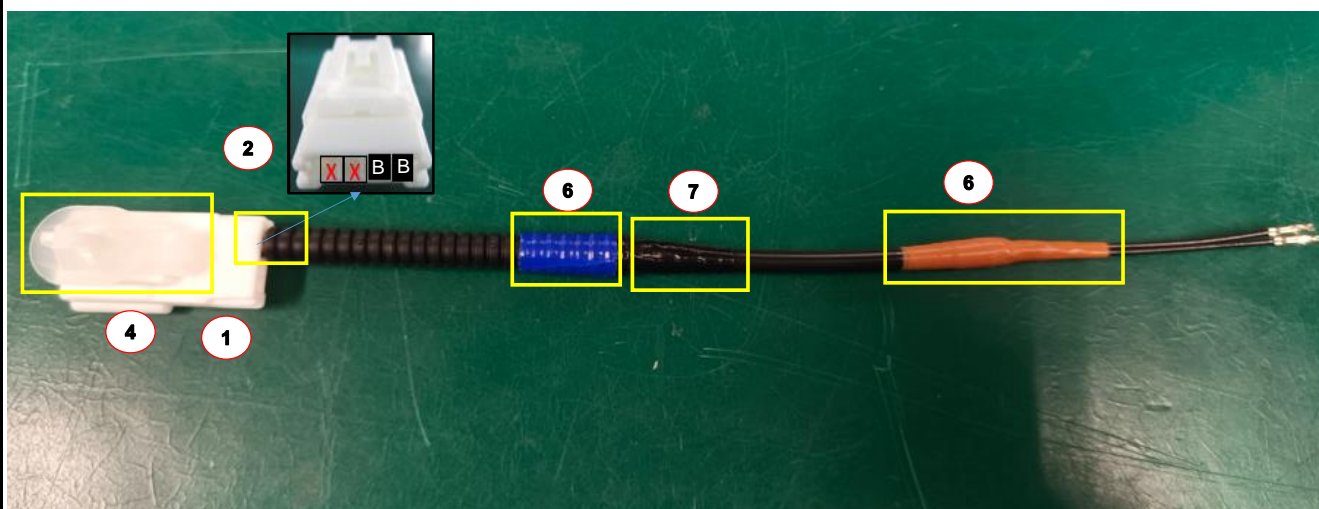
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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**P1****7L0163-7020**

- ① No Unlocked/Half-locked connector
- ② No Wrong Insert
- ③ No Terminal Backing Out
- ④ No Missing clip
- ⑤ No Deformed Terminal
- ⑥ No Wrong used of tape
- ⑦ No Missing tape

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