



WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	February 26, 2025		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-1182A		
Revision No.:	1	Page No.:	1 of 6


Process Name/Title: **559D / 7N0242-7020A**





Model code/Part number: **559D / 7N0242-7020A**

Customer: **TRJ**

Car Model: **TOYOTA HI-ACE**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:	1. AVSSf 0.3 B L=975±3mm [2pcs]; Black Corrugated tube ø7 L=394±3mm (No slit); Connector 6098-3802 (W); Black tape			JIG:	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1 Table lay-out	<p>TABLE LAY-OUT</p> 		<p>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>

Revision History								Prepared by	Checked by	Reviewed by	Approved by
								 D. Castillo	 J. Loterte	 C. Villanueva	 A. Arañes
02/26/25	1	Change from Pre-launch to Masspro. Provide Insertion jig and transfer process to P2. Inclusion of Table lay-out.	D. Castillo	J. Loterte	C. Villanueva a	A. Arañes					
01/10/25	0	Initial issue.	D. Castillo	C. Villanueva a	A. Arañes	n/a					
Eff. Date	Rev. No	Details of Change		Revised	Checked	Reviewed	Approved	Est. Date:	January 10, 2025		

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PARTS:

1. Connector 6098-3802 (W)

JIG:

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

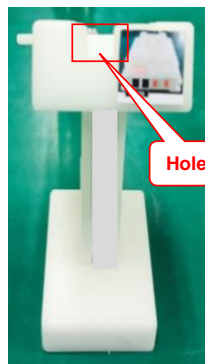
QUALITY POINTERS

2

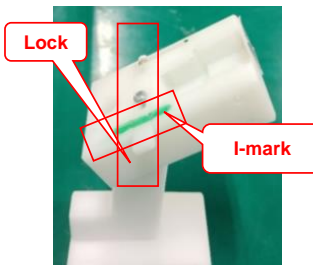
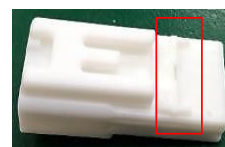
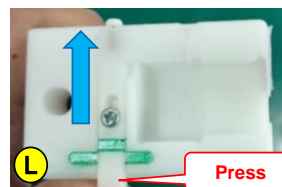
P1

Connector Setting to
insertion jig
6098-3802 (W)

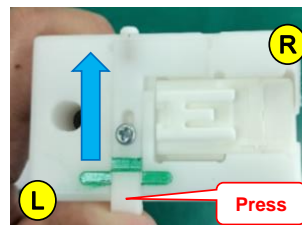
INSERTION JIG



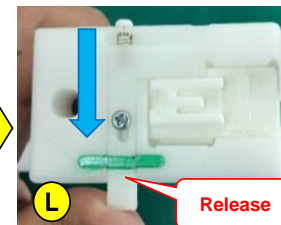
Holes

INSERTION JIG
ORIENTATIONCONNECTOR
ORIENTATION

Press



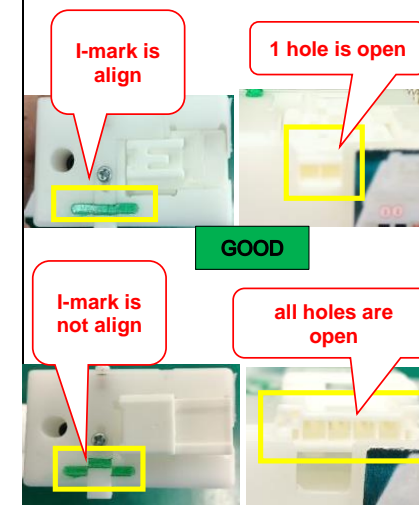
Press



Release

1. Press the lock of insertion jig
using left thumb.2. Insert the connector **6098-3802 (W)** into jig using right
hand then release the lock.3. Check the holes/terminal slot for **B-B wires**.

n/a

CONNECTOR ORIENTATION
ILLUSTRATION

GOOD

NG

1. Use the provided jig per model
2. No wrong orientation of connector
3. No wrong use of connector
4. No damaged connector

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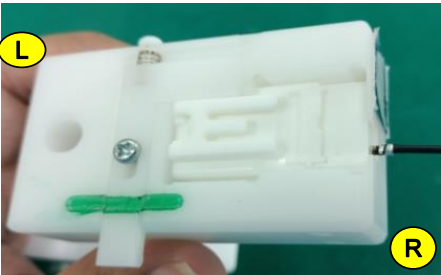
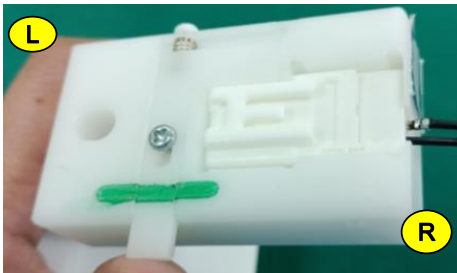

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. AVSSf 0.3 B L=975±3mm [2pcs] 2. Black Corrugated tube ø7 L=394±3mm (No slit)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to Black Corrugated tube ø7 L=394±3mm (No slit)	 <div>1. Get the Black corrugated tube (no slit) ø7 L=394±3mm using left hand and get 2pcs of Black wire using right hand then insert.</div>		n/a	Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 1. No wrong usage of parts 2. No deformed terminal
4	<div>1</div> P1 Wire Insertion to Connector 6098-3802 (W)	 <div>TERMINAL FACING</div>   <div>1. Get the 1st B wire then insert to connector using right hand.</div> <div>2. Get the 2nd B wire then insert to connector using right hand.</div>  <div>3. After insertion, push the lock button using left thumb then hold the wires and gently pull out the connector from jig using right hand.</div>		n/a	Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance Important reminders/note/s: 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing

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☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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PARTS:

1. Assy parts

JIG:

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

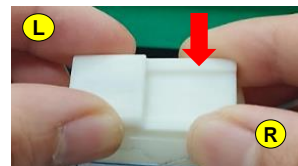
5

P1

Connector lock



1. Load the connector into the jig holding both side of the connector, tip first.



2. Press the lower part of connector to fully insert into the locking jig.



Right thumb-Lower
Left thumb-middle

3. Press the lower parts of connector using right hand while left hand holding the middle.



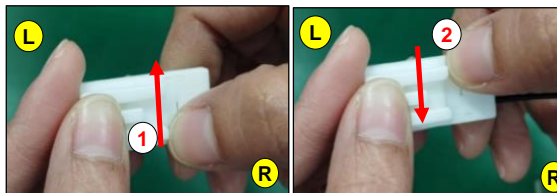
Right thumb-upper
Left thumb-middle

4. Press the upper part of connector using right hand while left hand holding the middle.



Right thumb-middle
Left thumb-middle

5. Lift then press the connector in the middle using left and right hand.



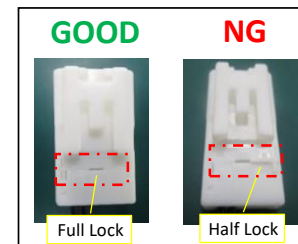
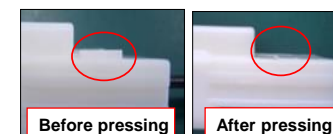
6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.

LOCKING JIG



1. No Unlock and half-locked
2. Use provided jig tools per model to avoid damaged lock.


Important reminders/note/s:
1. **MANUAL LOCKING MAY CAUSED DAMAGED LOCK**
2. Use provided jig tool per model to avoid damaged lock.

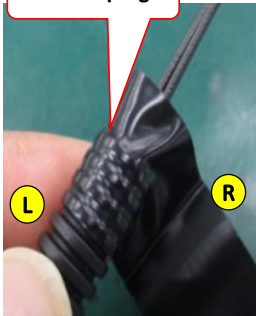

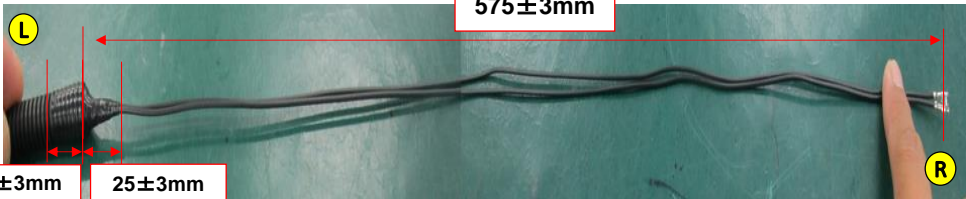
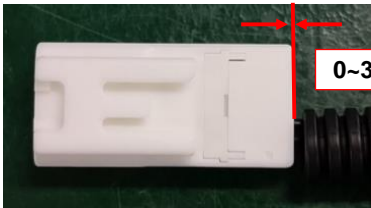



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PARTS:		1. Assy part 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1	<div><div><div><div><div>Start taping</div><div></div></div></div><div><div><div>575±3mm</div><div></div></div></div><div><div><div>1. Hold the COT using left hand, get the Black tape using right hand then initially start pre-taping at the middle of COT and wire.</div><div>2. Measure from end of COT up to terminal pointed tip 575±3mm then continue the taping process using both hands.</div></div></div><div><div><div><div><div>575±3mm</div><div></div></div></div><div><div><div>25±3mm</div><div>25±3mm</div></div></div></div><div><div><div><div><div>0~3mm</div><div></div></div></div><div><div>3. After taping, check the measurement, taping condition and wire alignment.</div></div></div></div><div><div>MEASURING TAPE</div><div></div></div></div></div></div>		<div>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</div> <div><div>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div><div>Document reference/s: 1. Refer to WI-PRO-ASY-001B for taping procedure.</div></div>	

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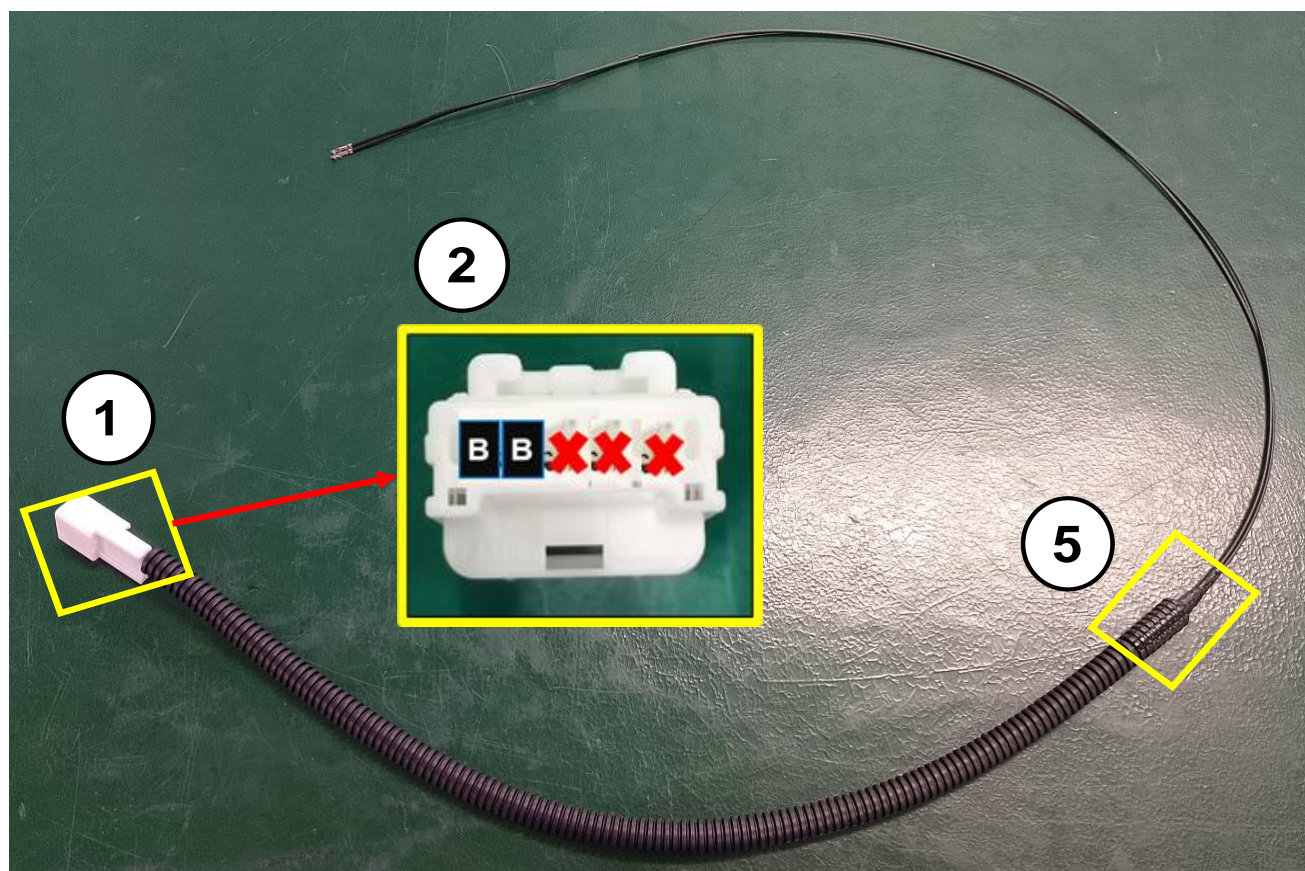
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1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P1****7N0242-7020A**

- ① **No Unlocked/
Half-locked connector**
- ② **No Wrong insert**
- ③ **No Deformed terminal**
- ④ **No Terminal Backing
out**
- ⑤ **No Missing tape**

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