

**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**

Effectivity Date:

July 10, 2024

Validity Date:

n/a

Model code/Part number: **100B / 7M0595-7021**Customer: **TRJ**Car Model: **LEXUS (TOYOTA) UX**

Document No.:

WI-ENG-PDE-430A

Purpose:




☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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PARTS:		1. Connector 6098-2220 (W); AVSSf 0.3 Y-OR wires L=594±3mm; Black corrugated tube (no slit) ø5 L=249±3mm; Black Corrugated tube (no slit) ø7 L=94±3mm; Black corrugated tube (no slit) ø7 L=177±3mm; AVSSf 0.3 B-B wires L=673±3mm; MRSWCP G-B/W wires L=813±3mm; Connector 6098-3810 (W); Black tape						JIG:		1. Insertion jig with and w/o switch cover 2. Terminal cover jig 3. Locking jig													
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION						TOOLS/PPE		QUALITY POINTERS											
1		P1		<div><div>TABLE LAY-OUT</div><div><div>Connector 6098-2220 (W)/ Connector tray</div><div>Black corrugated tube (no slit) ø5 L=249±3mm</div><div>Black Corrugated tube (no slit) ø7 L=177±3mm</div><div>Black Corrugated tube (no slit) ø7 L=94±3mm</div><div>Connector 6098-3810 (W)/ Connector tray</div><div>AVSSf 0.3 OR wires L=594±3mm</div><div>AVSSf 0.3 Y wires L=594±3mm</div><div>AVSSf 0.3 B-B wires L=673±3mm</div><div>MRSWCP G-B/W wires L=813±3mm</div><div>Tape holder/ Black tape</div><div>Terminal cover jig</div><div>Locking jig</div><div>Insertion jig (C)</div><div>Locking jig 6098-2220 (W)</div><div>Insertion (B) jig</div><div>Insertion jig (A) with Switch cover</div></div></div> <div><div><div>Safety Instruction</div><div>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div></div><div><div>Housekeeping</div><div>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div></div><div><div>Alert level</div><div>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div></div> <td colspan="2"><div>1. No missing parts/tools 2. No excess parts/tools</div><div>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div></td>						<div>1. No missing parts/tools 2. No excess parts/tools</div> <div>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div>													
Revision History																							
07/10/24		3		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		<div>Prepared by</div> <div></div> <div>D. Castillo</div>		<div>Reviewed by</div> <div></div> <div>C. Villanueva</div>		<div>Approved by</div> <div></div> <div>A. Arañes</div>		<div>Noted by</div> <div>n/a</div>	
07/21/23		2		Updated template; Inclusion of CAR MODEL "LEXUS (TOYOTA) UX" as document improvements; Inclusion of Locking process of Connector (6098-2220). Update table lay-out. Change Wire color location from Y-OR to OR -Y.				M. Ariola		J. Loterte		C. Villanueva		A. Arañes									
03/07/23		1		Improve Work procedure/Illustration on process no.4 and 14 (Connector lock) due to process improvement. Improve quality pointers; Reminders, notes and references. Inclusion of Quality checkpoints.				M. Ariola		J. Loterte		C. Villanueva		A. Arañes									
Eff. Date		Rev. No						Revised		Reviewed		Approved		Noted		Est. Date:		March 1, 2022					

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☐ PROTOTYPE

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PARTS:

1. Connector 6098-2220 (W)
2. AVSSf 0.3 Y-OR wires L=594±3mm

JIG:

1. Insertion jig with switch cover

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

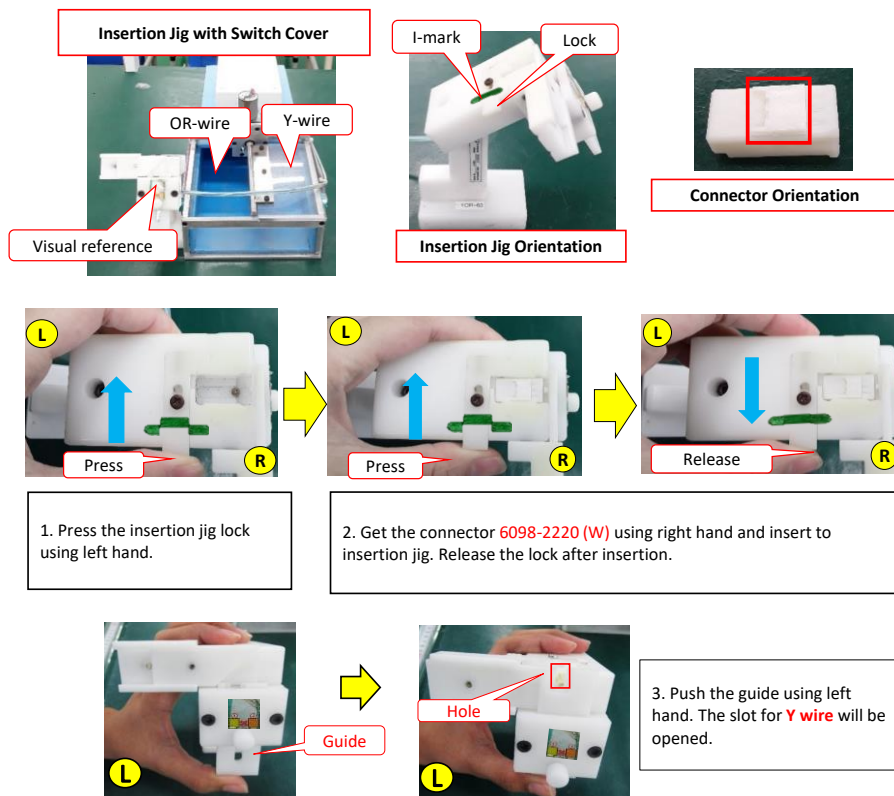
TOOLS/PPE

QUALITY POINTERS

2

P1

Connector setting to
insertion jig
6098-2220 (W)



n/a

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

Connector Orientation Illustration

I-mark was align

1 hole is open



I-mark was not align

All holes were open



Important reminders/Note/s:

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

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PROTOTYPE



PRE-LAUNCH




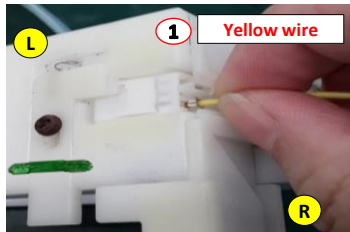
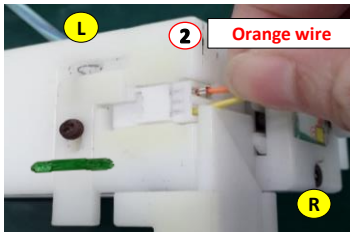
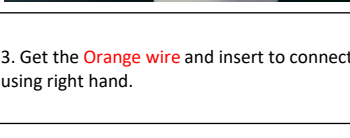
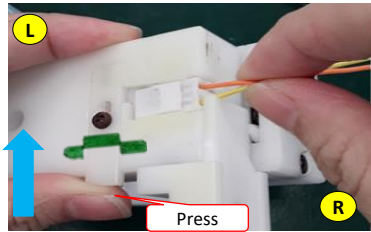
MASSPRO

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PARTS:		1.Connector 6098-2220 (W) 2. AVSSf 0.3 Y-OR wires L=594±3mm		JIG	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1	<div><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></div> <div>n/a</div> <td><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>Important reminders/Note/s: 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. Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Length tolerance. 2. Please refer to GL-PRO-ASSY-029 for Pull-Push procedure</div></td>		<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>Important reminders/Note/s: 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. Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Length tolerance. 2. Please refer to GL-PRO-ASSY-029 for Pull-Push procedure</div>	

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:

1. Assy parts

JIG

1. Locking jig

NO.

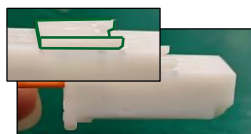
PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

CONNECTOR RETAINER ILLUSTRATION
SIDE VIEW

GOOD



NG

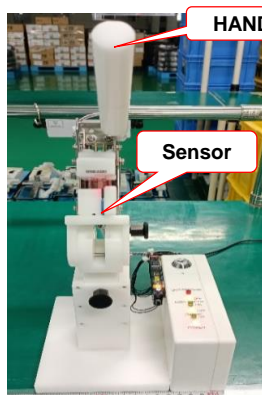
1. Check the Retainer lock of connector before insertion to locking jig.

*Note: Must be **NO** half-locked condition prior connector locking.*

4

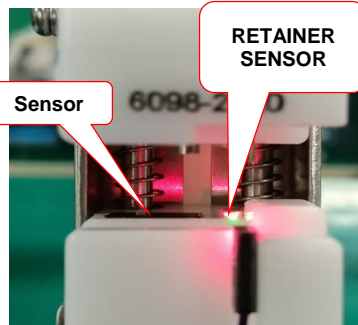
P1

Connector lock

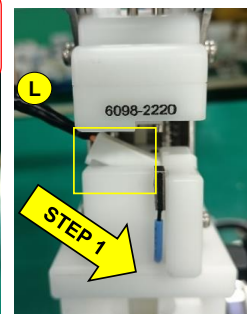


HANDLE

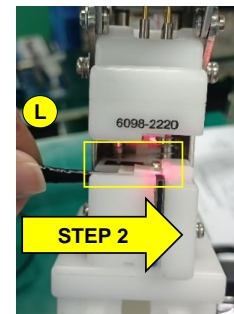
Sensor



Sensor

RETAINER
SENSOR

STEP 1



STEP 2

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.

NOTE: CONNECTOR LOCKING JIG WILL NOT FUNCTION IF CONNECTOR NOT REACH THE SENSOR.

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.

Important reminders/Note/s:*1. Incomplete locking process will alarm the jig.**2. No retainer in connector cannot proceed.**3. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction and continue the process.*

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☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:

1. Assy parts

JIG

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

4

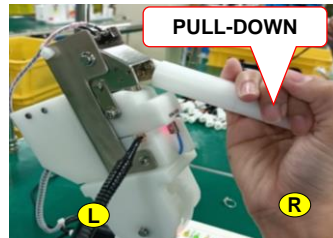
P1

Connector lock
(Continuation)

HOLD THE
HANDLE

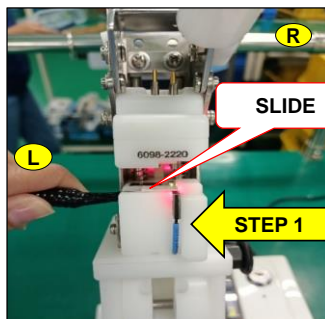


PULL-DOWN

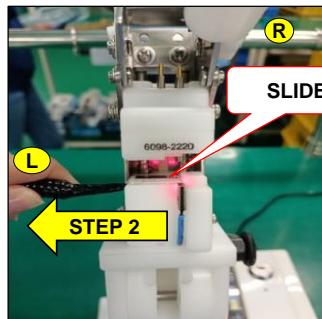


3. Hold the handle of the connector locking jig using right hand then gently pull down and bring back to original position after locking. Note: Pull down one time only.

SLIDE

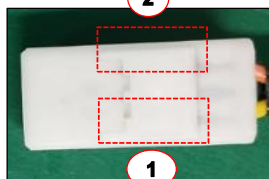


SLIDE

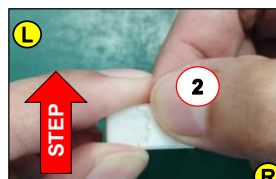


4. Remove the locked connector using left hand based on the illustration, follow the direction of arrow.

2



1



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

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 into 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

Important reminders/Note/s:

1. Incomplete locking process will alarm the jig.
2. No retainer in connector cannot proceed.
3. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.

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Car Model: LEXUS (TOYOTA) UX

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☐ PROTOTYPE☐

PRE-LAUNCH


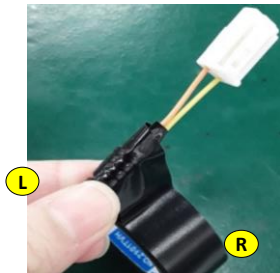
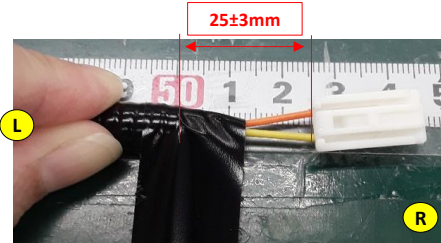
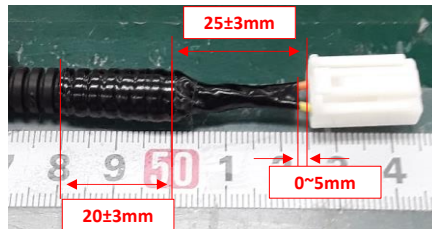

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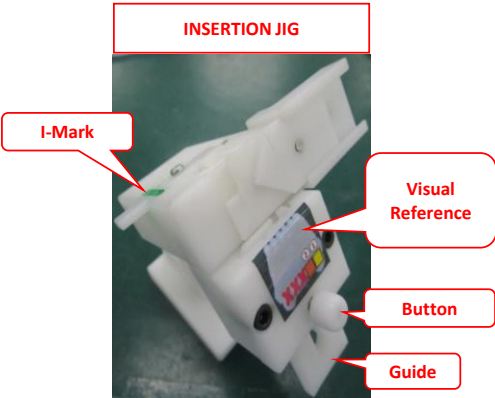



PARTS:		1. Black corrugated tube (no slit) $\phi 5$ L=249 \pm 3mm			JIG	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1	Wire insertion to Black corrugated tube (no slit) $\phi 5$ L=249 \pm 3mm	<div><div>1. Get the corrugated tube $\phi 5$ L= 249\pm3mm using right hand then insert the Y-OR wire by using left hand.</div></div>		n/a	1. No wrong use of parts
6		Taping 1 Black Corrugated tube to wire near connector	<div><div><div>1. Hold the assy parts using left hand. Get Black tape using right hand and start pre-taping.</div></div><div><div>2. Measure from COT to Connector 25\pm3mm using both hands and continue the taping process.</div></div><div><div>3. After taping, check the measurement and taping condition.</div></div></div> <div><div>MEASURING TAPE</div></div> <div>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</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	

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		3	Page No.:	7 of 15	

PARTS:		1. Black tape 2. Black Corrugated tube (no slit) $\phi 7$ L=94 \pm 3mm 3. Black corrugated tube(no slit) $\phi 7$ L=177 \pm 3mm			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
7	Wire insertion to Black corrugated tube (no slit) $\phi 7$ L=177 \pm 3mm $\phi 7$ L=94 \pm 3mm	<div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  <p>1. Get the corrugated tube $\phi 7$ L=177\pm3mm using right hand then insert the Y-OR wire using left hand.</p> </div> <div style="text-align: center;">  <p>2. Get the corrugated tube $\phi 7$ L=94\pm3mm using right hand then insert the Y-OR wire using left hand.</p> </div> </div>			<div style="border: 1px solid red; padding: 5px; text-align: center; color: red;"> MEASURING TAPE </div> 	Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 1. No wrong use of parts 2. No deformed terminal
8	P1 Connector setting to insertion jig 6098-3810 (W)	<div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <div style="border: 1px solid red; padding: 2px; color: red;">INSERTION JIG</div>  </div> <div style="text-align: center;">  <div style="border: 1px solid red; padding: 2px; color: red;">CONNECTOR ORIENTATION</div> </div> </div>			n/a	1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector <div style="text-align: center;"> <div style="border: 1px solid black; padding: 2px;">CONNECTOR ILLUSTRATION</div> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <div style="background-color: green; color: white; padding: 2px;">GOOD</div>  <div style="background-color: green; color: white; padding: 2px;">6098-3810 (W)</div> </div> <div style="text-align: center;"> <div style="background-color: red; color: white; padding: 2px;">NG</div>  <div style="background-color: red; color: white; padding: 2px;">6098-5677 (W)</div> </div> </div> </div>

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PARTS:

1. Connector 6098-3810 (W)

JIG

1. Insertion jig

NO.

PROCESS NAME

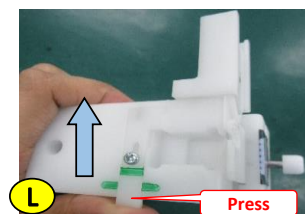
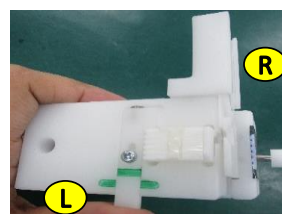
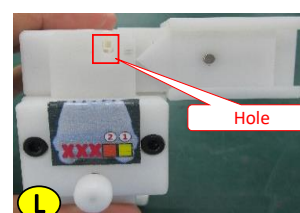
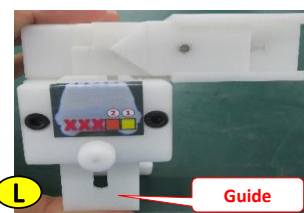
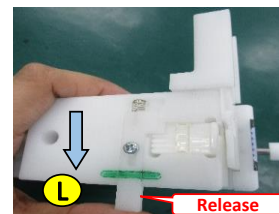
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

8

P1

Connector setting to
insertion jig
6098-3810 (W)
(Continuation)1. Press the lock of insertion jig using
left thumb.2. Insert the connector **6098-3810 (W)** into jig using right hand
and release the lock.**Note: Follow the connector orientation.**3. Push the guide using left hand. The slot for **Y wire** will
be opened.

n/a

Connector Orientation
Illustration

I-mark is align

1 hole is open

I-mark is not
align1 hole is
open

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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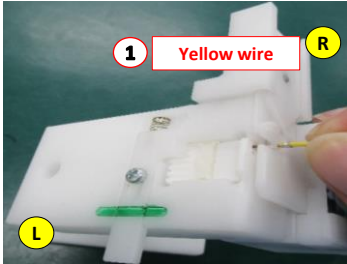
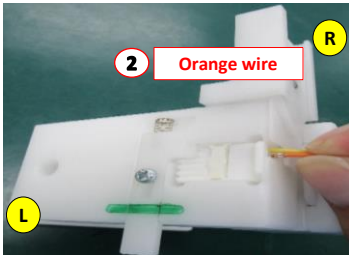
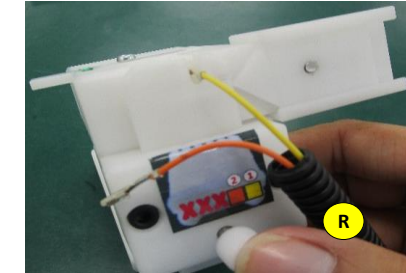
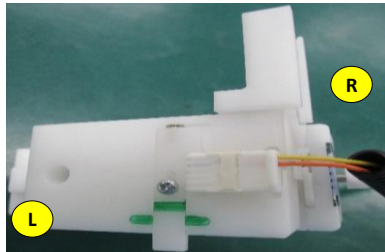
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PARTS:	1. Assy parts			JIG	1. Insertion jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P1	Wire insertion to connector 6098-3810 (W)	<div><div>WIRE FACING</div></div> <div><div><div>1</div><div>Yellow wire</div><div>R</div></div><div>L</div></div> <div><div>1. Hold the insertion jig using left hand. Get the Y wire and insert to open slot of connector using right hand.</div></div> <div><div><div>2</div><div>Orange wire</div><div>R</div></div><div>L</div></div> <div><div>3. Get the OR wire and insert to open slot of connector using right hand.</div></div> <div><div><div>R</div><div>R</div></div><div>2. Press the button using right thumb the slot for OR wire will be opened.</div><div><div><div>R</div><div>L</div></div><div>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.</div></div></div> <td>n/a</td> <td><div>1. No loose insertion</div><div>2. No wrong insertion</div><div>3. One by one insertion</div><div>4. No deformed terminal</div><div>5. No wrong wire facing</div><div>Important reminders/Note/s:</div><div>1. Please hold the wire near terminal during insertion.</div><div>2. Insertion of wire must be from left to right.</div><div>3. Make sure wires are properly inserted.</div><div>Conduct Pull-Push-Pull-Push after insertion.</div><div>Do not exert extra force.</div><div>Document reference/s:</div><div>1. Refer to WI-PRO-CNC-017 for Wire and Length tolerance.</div><div>2. Please refer to GL-PRO-ASSY-029 for Pull-Push procedure</div></td>	n/a	<div>1. No loose insertion</div> <div>2. No wrong insertion</div> <div>3. One by one insertion</div> <div>4. No deformed terminal</div> <div>5. No wrong wire facing</div> <div>Important reminders/Note/s:</div> <div>1. Please hold the wire near terminal during insertion.</div> <div>2. Insertion of wire must be from left to right.</div> <div>3. Make sure wires are properly inserted.</div> <div>Conduct Pull-Push-Pull-Push after insertion.</div> <div>Do not exert extra force.</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-CNC-017 for Wire and Length tolerance.</div> <div>2. Please refer to GL-PRO-ASSY-029 for Pull-Push procedure</div>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

July 10, 2024

Process Name/Title:

Model code/Part number:

100B / 7M0595-7021

Customer:

TRJ

Car Model: LEXUS (TOYOTA) UX

Validity Date:

n/a

Document No.:

WI-ENG-PDE-430A

Purpose:






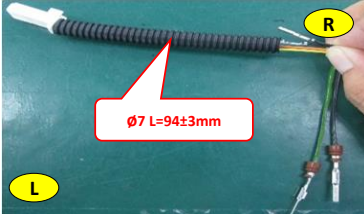
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PARTS:		1. Assy parts 2. MRSWCP G-B/W wires L=813±3mm 3. AVSSf 0.3 B-B wires L=673±3mm [2pcs.]	JIG	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	P1 Wire insertion to assy parts	 <p>1. Get the terminal cover jig using right hand then insert to both terminals (G-B/W wires) using right hand.</p>  <p>2. Hold the COT $\phi 7$ L=177±3mm using left hand then insert the G-B/W wires using right hand.</p>  <p>3. After insertion, remove the cover jig using left hand.</p>		1. No wrong usage of parts 2. No damaged rubber seal
11	Wire insertion to assy parts	 <p>1. Get the B wires L=673±3mm [2pcs.] using right hand and then insert to COT $\phi 7$ L=177±3mm.</p>  <p>2. Continue insertion of B-B wires to COT $\phi 7$ L=94±3mm using right hand.</p>	n/a	1. No wrong use of parts 2. No deformed terminal

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

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Process Name/Title:

Model code/Part number: **100B / 7M0595-7021**

Customer: **TRJ**

Car Model: **LEXUS (TOYOTA) UX**

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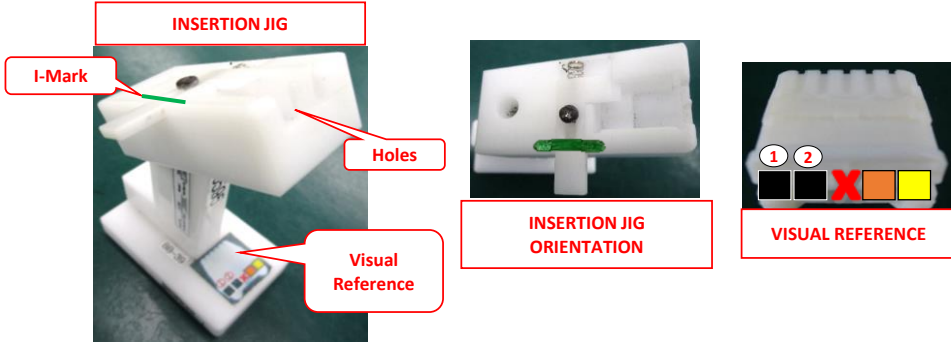
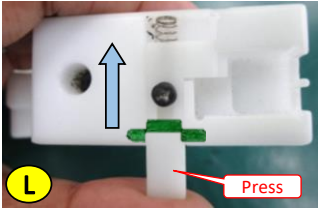
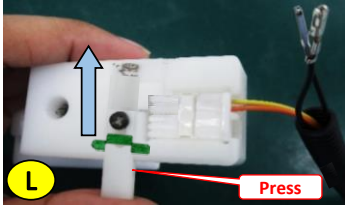
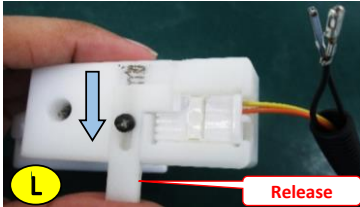
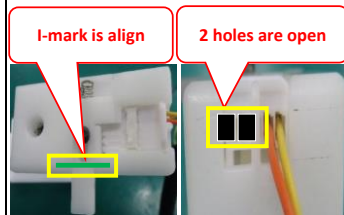
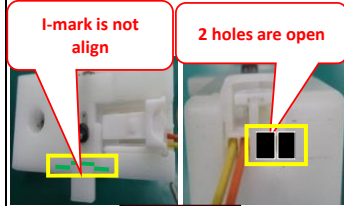
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PARTS:		1. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
12	P1	<p>Connector setting to insertion jig (assy parts) 6098-3810 (W)</p>     <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector 6098-3810 (W) with inserted Y-OR wires into jig using right hand and release the lock. Holes/terminal slot for B-B wires are opened.</p>		n/a	<p>Connector Orientation Illustration</p>  <p>GOOD</p>  <p>NG</p> <p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

July 10, 2024

Process Name/Title:

Model code/Part number: **100B / 7M0595-7021**

Customer: **TRJ**

Car Model: **LEXUS (TOYOTA) UX**

Document No.:

WI-ENG-PDE-430A

Purpose:

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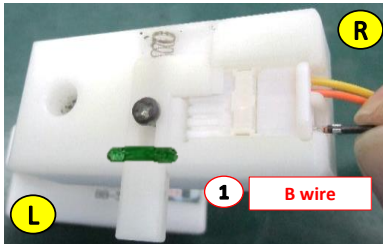
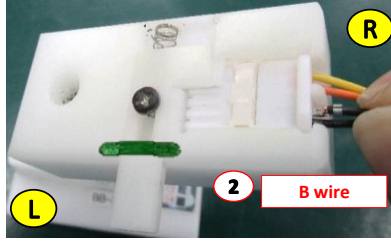
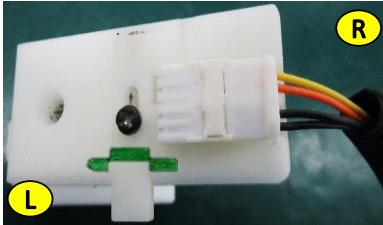
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PARTS:	1. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
13	P1 Wire insertion to connector (assy parts) 6098-3810 (W)	<div><div>WIRE FACING</div></div> <div><div>1. Hold the insertion jig using left hand. Get the 1st B wire and insert to connector using right hand.</div></div> <div><div>2. Hold the 2nd B wire and insert to connector using right hand.</div></div> <div><div>3. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</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>Important reminders/Note/s:</div> <div>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.</div> <div>Document reference/s:</div> <div>1. Please refer to GL-PRO-ASSY-029 for Pull-Push procedure</div>

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Purpose:

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PARTS:

1. Assy parts

JIG

1. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

14

P1

Connector lock



1. Put the connector into locking jig using right hand then press to lock **2x**.



Before Pressing



After Pressing



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



LOCKING JIG



Important reminders/Note/s:

1. Manual locking may cause damaged connector lock.

1. Use the provided jog per model
2. No unlocked/half-locked connector

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TAPING ASSEMBLY PROCESS

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Purpose:

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PARTS:

1. Assy parts
2. Black tape

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

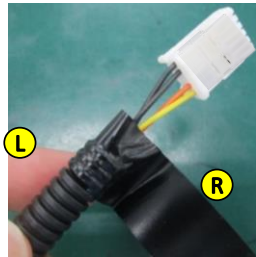
TOOLS/PPE

QUALITY POINTERS

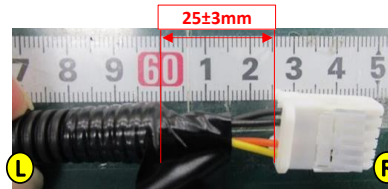
15

P1

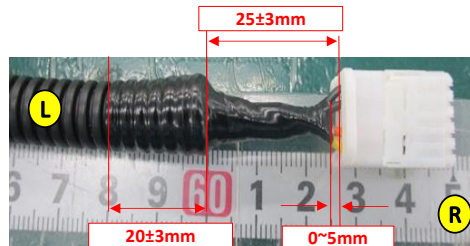
Taping 2
Black corrugated tube to
wire near Connector



1. Hold the assy parts using left hand. Get the Black tape using right hand and start pre-taping.



2. Measure from COT to Connector **25±3mm** using both hands and continue the taping process.



3. After taping, check the measurement and taping condition.

MEASURING TAPE



Important reminders/Note/s:
1. 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 use of tape
6. No wrong dimension

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Purpose:

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PARTS:

1. Assy parts

JIG

n/a

QUALITY CHECKPOINTS

P1

7M0595-7021



GOOD



NO GOOD



GOOD



NO GOOD



1

No **WRONG INSERT**
No **UNLOCKED/HALFLOCKED**
No **TBO**

2

No **Missing Tape**

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