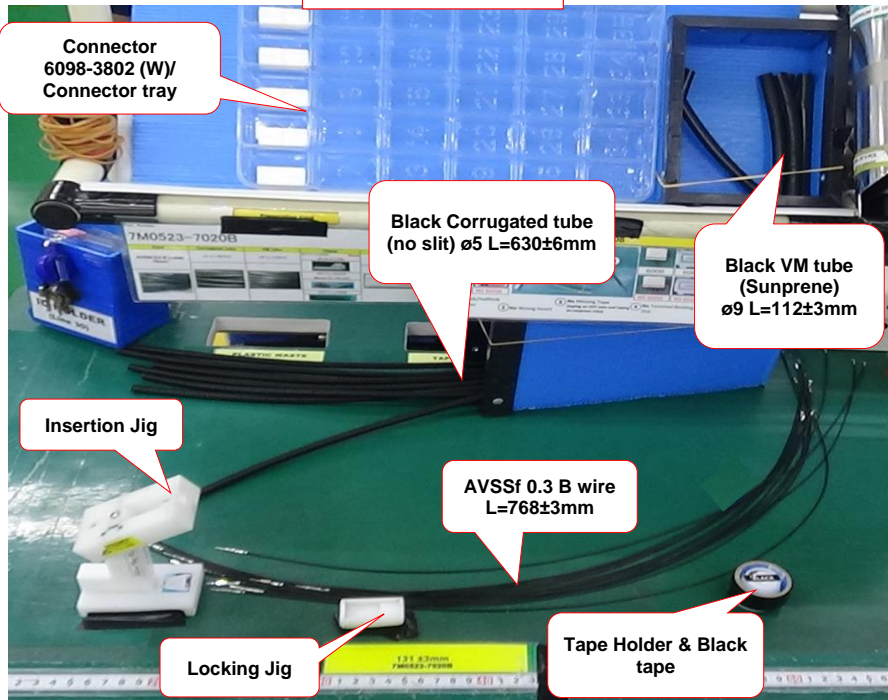

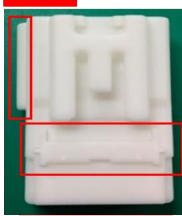
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	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 311D / 7L0151-7022		Customer: TRQSS	Car Model: TOYOTA RAV4	Document No.:	WI-ENG-PDE-984		
	Purpose: <input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	2	Page No.:	1 of 9

PARTS:		1. Connector 6098-3802 (W); AVSSf 0.3 Black Wires L=768±3mm; Black Corrugated tube ø5 L=630±6mm (no slit); Black VM tube (Sunprene) ø9 L=112±3mm; Black tape				JIG:		1. Insertion jig 2. Locking jig					
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS					
1	P1	<div> <div>TABLE LAY-OUT</div>  </div>				<div> <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>		<div> Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance </div> <div> 1. No missing parts/tools 2. No excess parts/tools </div> <div> <div>CONNECTOR ILLUSTRATION</div> <div> <div>GOOD</div>  <div>6098-3802 (W)</div> </div> <div> <div>NG</div>  <div>6098-5668 (W)</div> </div> </div>					
Revision History						Prepared by		Reviewed by		Approved by		Noted by	
01/13/25	2	Additional Quality pointers "No insufficient tape" and add document references (Page 6-7) as countermeasure to customer claim.				D. Castillo		C. Villanueva		A. Arañes		n/a	
08/28/24	1	Change from Pre-launch to Masspro. Update Visual Inspection/Quality Checkpoints				M.Ariola		C. Villanueva		A. Arañes		n/a	
07/19/24	0	Initial issue.				M.Ariola		C. Villanueva		A. Arañes		n/a	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	July 19, 2024		

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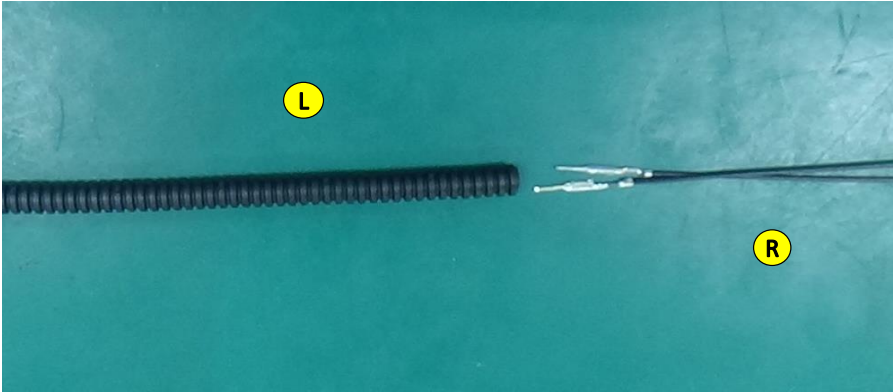
PARTS:	1. Connector 6098-3802 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1	<div><div><div><div><div>Insertion jig</div><div>Holes</div><div>Lock</div><div>I-mark</div></div><div><div>Holes</div><div>Lock</div><div>I-mark</div></div><div><div>Connector Orientation</div></div></div><div><div><div>L</div><div>Press</div></div><div><div>L</div><div>R</div><div>Press</div></div><div><div>L</div><div>Release</div></div></div><div><div>1. Press the lock of insertion jig using left thumb.</div></div><div><div>B</div><div>B</div><div>2. Insert the connector (6098-3802) into jig using right hand and release the lock.</div></div><div><div>3. Check the holes/terminal slot for B-B wires.</div></div></div></div> <div>N/A</div> <td><div><div>1. Use the provided jig per model</div><div>2. No wrong orientation of connector</div></div><div><div>Connector Orientation Illustration</div><div><div>I-mark is align</div><div>2 Holes are open</div><div>GOOD</div></div><div><div>I-mark is not align</div><div>All holes are open</div><div>NG</div></div></div></td>	<div><div>1. Use the provided jig per model</div><div>2. No wrong orientation of connector</div></div> <div><div>Connector Orientation Illustration</div><div><div>I-mark is align</div><div>2 Holes are open</div><div>GOOD</div></div><div><div>I-mark is not align</div><div>All holes are open</div><div>NG</div></div></div>	

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	Model code/Part number: 311D / 7L0151-7022		Customer: TRQSS	Car Model: TOYOTA RAV4	Document No.:		WI-ENG-PDE-984	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		2	Page No.: 3 of 9

PARTS:		1. AVSSf 0.3 Black Wires L=768±3mm [2pcs] 2. Black Corrugated tube ø5 L=630±6mm (no slit)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1	<div>Wire insertion to Black Corrugated tube ø5 L=630±6mm (no slit)</div>  <div>1. Get Black COT Ø5 L=630±6mm using left hand and insert Black wire AVSSf 0.3 L=768±3mm using right hand.</div>		N/A	1. No wrong use of parts 2. No deformed terminal

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311D / 7L0151-7022

Customer:

TRQSS

Car Model:

TOYOTA RAV4

Document No.:

WI-ENG-PDE-984

Purpose:


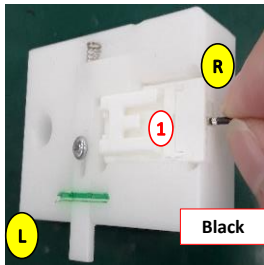
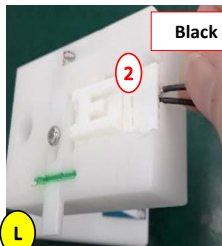
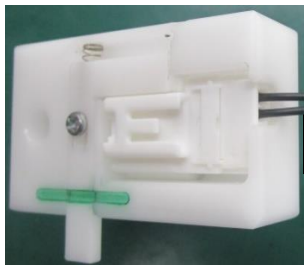
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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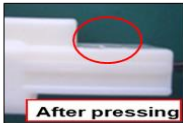
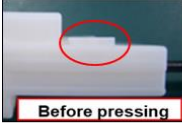




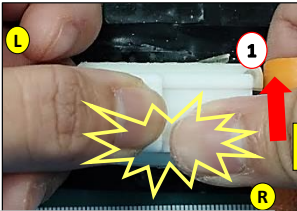


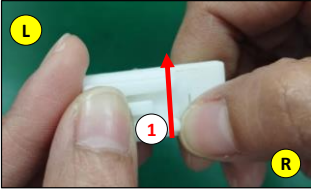
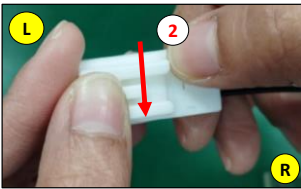
PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1 Wire insertion to connector 6098-3802 (W)	<div><p>WIRE FACING</p></div> <div><p>1</p><p>Black</p><p>L</p><p>R</p></div> <div><p>2</p><p>Black</p><p>L</p><p>R</p></div> <div><p>L</p><p>R</p><p>Press</p></div> <div><p>1. Get the first Black wire and insert to Slot 1 of connector using right hand.</p><p>2. Get the second Black wire and insert to Slot 2 of connector using right hand.</p><p>3. After insertion, push the lock button using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div>	N/A	<p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal during insertion.</p> <p>2. insertion must ber from left to right.</p> <p>3. Make sure wires are properly inserted.</p> <p>Conduct <u>Pull-Push-Pull-Pull</u> after insertion.</p> <p>Do not exert extra force.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</p> <p>2. Refer to GL-PRO-ASY for pull-push procedure.</p> <p>1. No loose insertion</p> <p>2. No wrong insertion</p> <p>3. One by one insertion</p> <p>4. No deformed terminal</p> <p>5. No wrong wire facing</p>

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	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 311D / 7L0151-7022		Customer: TRQSS	Car Model: TOYOTA-RAV4	Document No.: WI-ENG-PDE-984		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	2	Page No.:	5 of 9

PARTS:	1. Assy parts			JIG:	1. Locking jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
5	P1	Connector Lock			<div>LOCKING JIG</div> 	<div> GOOD NG  1. Use the provided jog per model 2. No unlocked/half-locked connector Important reminders/Note/s: 1. Manual locking may cause damaged connector lock. Document reference/s: 1. Refer to WI-PRO-KIT-001 for Proper locking and checking of connector lock.</div>		
<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> <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> <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></div>								

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Car Model:

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Purpose:

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☐ PRE-LAUNCH

☒ MASSPRO

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n/a

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PARTS:

1. Assy parts
2. Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

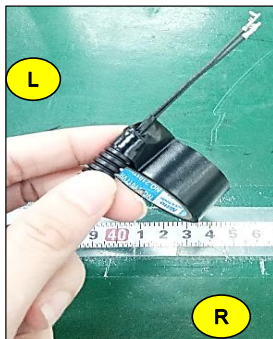
TOOLS/PPE

QUALITY POINTERS

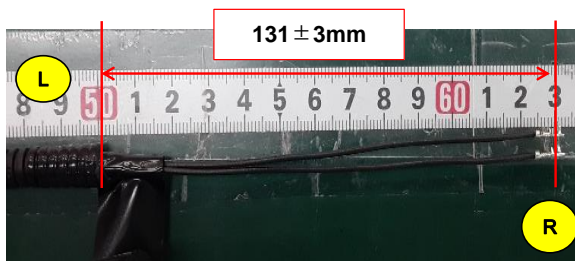
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P1

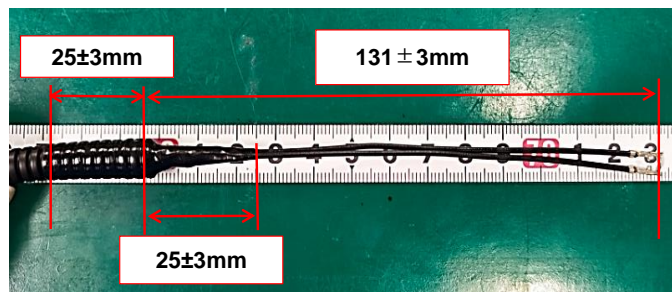
Taping 1
Corrugated tube to wire
near terminal



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.



2. Measure form end of COT up to terminal pointed tip **131±3mm** then continue the taping process using both hands



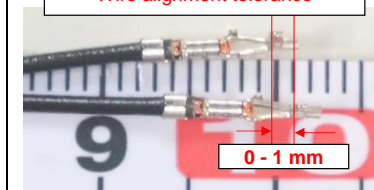
3. After taping, check the measurement, terminal alignment and taping condition.

MEASURING
TAPE



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


Wire alignment tolerance

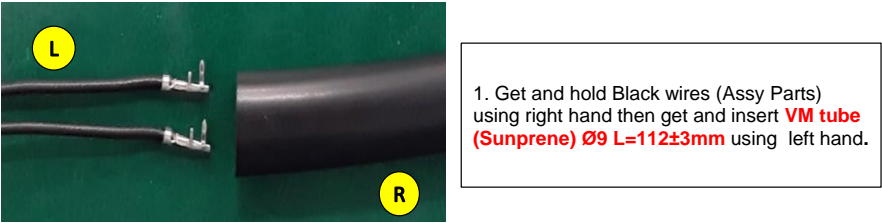
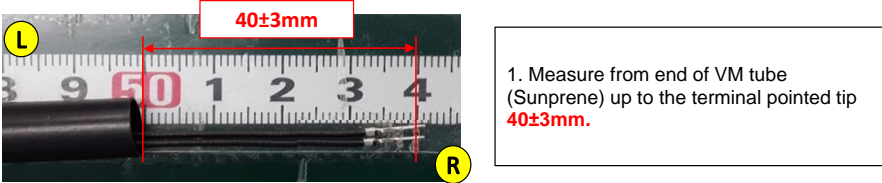
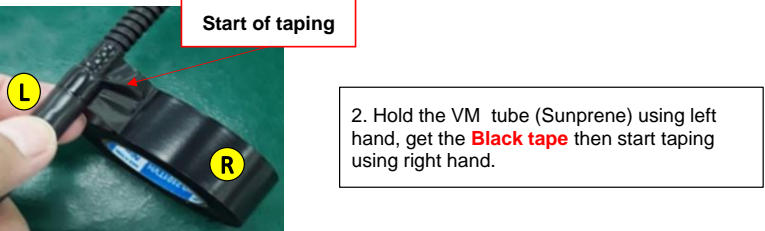
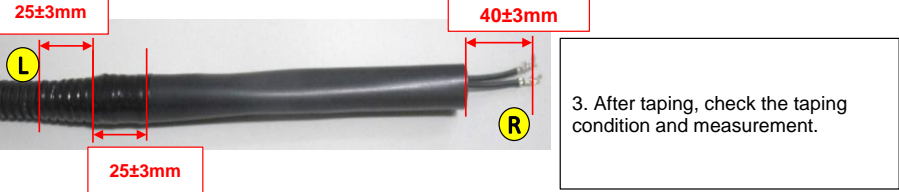



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	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:	2	Page No.:

PARTS:		1. Assy parts 2. Black tape		3. VM tube (Sunprene) Ø9 L=112±3mm		JIG:	n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS		
7		Wire insertion to Black VM tube (Sunprene) ø9 L=112±3mm				n/a	1. No wrong use of parts 2. No deformed terminal		
8	P1	<div>  </div>							
		<div>  </div>				<div>  </div>	<div>  </div>	<div>  </div>	Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. Document reference/s: 1. Refer to WI-PRO-ASY-001A for taping procedure.

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PARTS:

1. Assy parts

JIG:

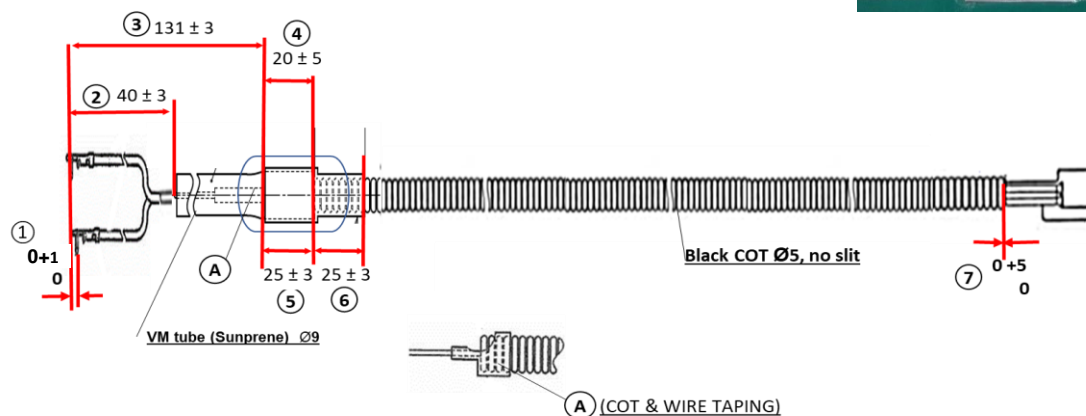
n/a

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

9

P1

Measurement

**Important reminders and note/s:**

1. Please use calibrated/verified measuring tape when getting the measurement.

2. For Hatsumono, Nakamono and Owarimono.

Document reference/s:

1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection

1. No wrong dimension.

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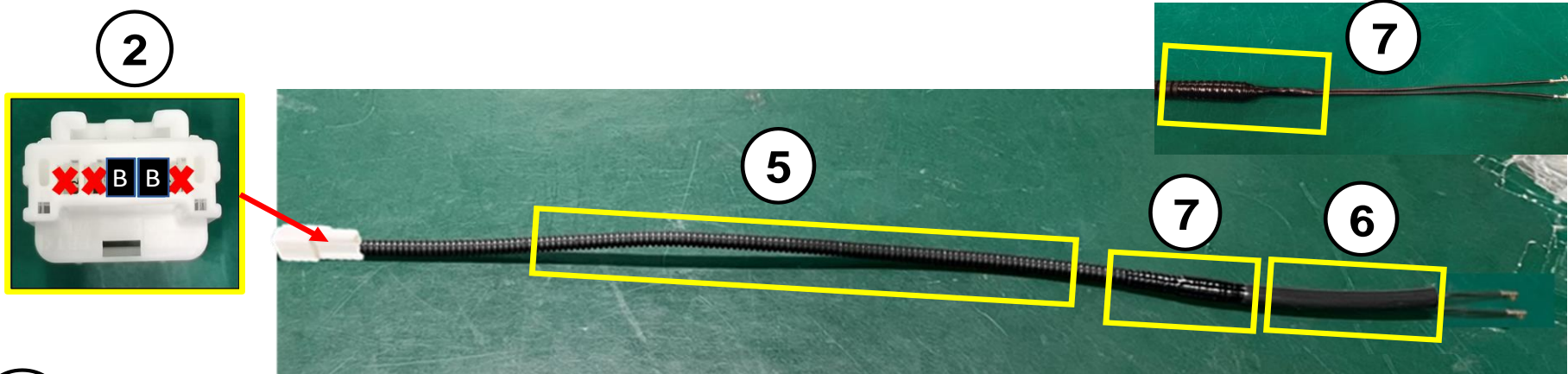
9 of 9

PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING P1****7L0151-7022****1 No Unlocked/half-locked connector****2 No Wrong insert****3 No Deformed terminal****4 No Terminal Backing out****5 No Missing COT****6 No VM Tube (Sunprene****7 No Missing tape**

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