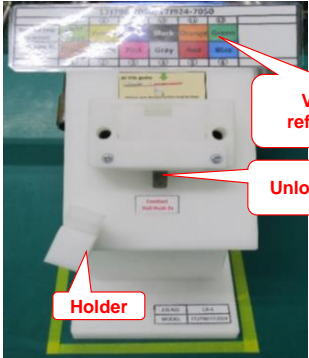
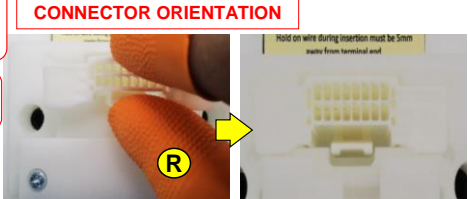

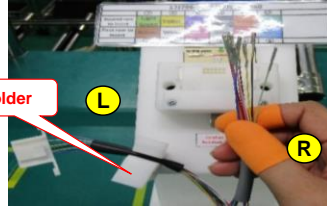

	WORK INSTRUCTION						Effectivity Date:		December 4, 2024			
	TAPING ASSEMBLY PROCESS						Validity Date:		n/a			
	Process Name/Title:		Model code/Part number:		Customer:	Car Model:	Document No.:		WI-ENG-PDE-091D			
	350B/320B/014B/ 360B/150B/		17J796-7051		TRP	TOYOTA-COROLLA/ RAV-4/ HIGHLANDER						
Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:		20	Page No.:	1 of 5

PARTS:		1. Connector 4F1640-000□ (W) 2. Assy parts						JIG:		1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION						TOOLS/PPE		QUALITY POINTERS	
1	P4 <div>20 HIGH</div> Connector setting to insertion jig 4F1640-000□ (W)	<div><div>INSERTION JIG</div><div>CONNECTOR ORIENTATION</div><div>1. Get the connector 4F1640-000□ (W) using right hand then set to insertion jig.</div><div><div>BEFORE PRESSING AFTER PRESSING</div><div>2. Press the guide lock using right thumb.</div><div>3. Hold the Group 1 wires (12pcs.) using right hand then put the Group 2 wires (11pcs.) (assy parts) in holder using left hand.</div></div></div>						<div>Safety Instruction Be sure to wear required 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>Important reminders/Note/s: 1. Automatically dispose and replace the unit if once encountered Bend terminal, Difficulty of insertion, Half-locked connector. 2. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process. Do not attempt to repair. 3. Follow the connector orientation.</div> <div><div>Connector must be no damaged/half-locked/locked</div><div><div>GOOD</div><div>UNLOCK</div></div><div><div>NG</div><div>HALF-LOCKED</div></div></div>	

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
12/04/24	20	Inclusion of Quality improvement measures (based on Mizen Boshi activity). Inclusion of Car model "TOYOTA-COROLLA/ RAV-4/ HIGHLANDER".						D.Castillo	C. Villanueva	A. Arañes	n/a				
02/13/24	19	Aligned process to TPS improvement.						D. Castillo	C. Villanueva	A. Arañes	n/a				
11/09/23	18	Transfer Connector lock process from Process 3 to Process 1 and additional visual checking for connector lock due to DCS (DC-0623-128).						D. Castillo	C. Villanueva	A. Arañes	n/a				
07/25/23	17	Transfer process of Connector lock from P2 due to TPS improvements.						M. Ariola	J. Loterte	C.Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change						Revised	Reviewed	Approved	Noted	Est. Date:	June 02, 2017		

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WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number: 350B/320B/014B/
360B/150B/

17J796-7051

Customer: TRP

Car Model: TOYOTA-COROLLA/
RAV-4/ HIGHLANDER

Effectivity Date:

December 4, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-091D

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

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PARTS:

1. Assy parts

JIG:

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

WIRE INSERTION ILLUSTRATION



SECOND
ROW TO
INSERT

7	8	9	10	11	12
LG	Y	V	B	OR	G
176	180	177	181	181	186
BR	W	P	GR	R	L
178	183	177	179	184	184
1	2	3	4	5	6

Standard hold in wire



TERMINAL FACING

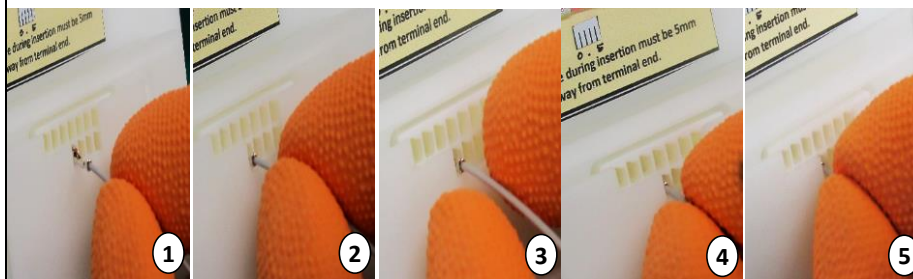


Finger COTS



MEDIUM

Wire insertion to connector
(Group 1 wires)
4F1640-000 (W)



1. Get the wire and hold it **5mm** away from terminal.
2. Half insert the wire.
3. Release wire to check the color.
4. Conduct point checking in visual
5. Hold again **5mm** away from terminal
6. Fully inserted wires (avoid bending during insertion)

1. No wrong wire insertion
2. No terminal backing out
3. No deformed terminal
4. Make sure wires are properly inserted.
5. Must have slight MOVEMENT after insertion
6. No bend terminal/wires

Important reminders/Note/s:

1. Automatically dispose and replace the unit if once encountered Bend terminal, Difficulty of insertion, Half-locked connector.
2. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process. Do not attempt to repair.
3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
4. Follow the insertion sequence based on the visual reference
5. Hold on wire during insertion must be **5mm** away from terminal end.

Document references:

1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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Car Model:

TOYOTA-COROLLA/
RAV-4/ HIGHLANDER

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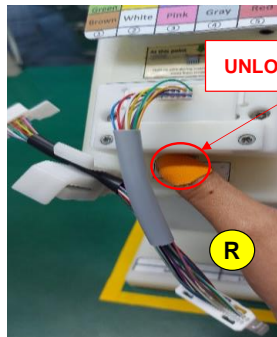
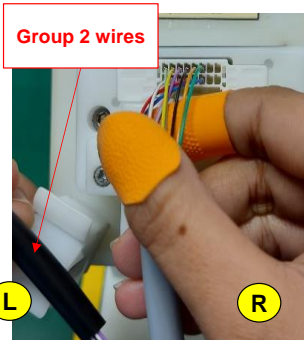
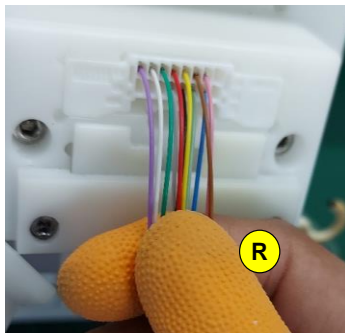

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	<div><div>20</div><div>P4</div><div>Wire insertion to connector (Group 1 wires) 4F1640-000 (W) (Continuation)</div><div>MEDIUM</div></div>	<div><div><div>UNLOCK LEVER</div><div>R</div><div>7. Press the unlock lever using right thumb.</div></div><div><div><div>Group 2 wires</div><div>L</div><div>R</div><div>8. Release the Group 2 wires [12pcs.] (Assy parts) using left hand.</div></div><div><div><div>R</div><div>9. Hold the wires using right hand then gently pull the connector from jig. Check the insertion condition.</div></div></div><div><div><div>Finger COTS</div><div></div></div></div><div><div>1. No wrong wire insertion 2. No terminal backing out 3. No deformed terminal 4. Make sure wires are properly inserted. 5. Must have slight MOVEMENT after insertion 6. No bend terminal/wires</div><div>Important reminders/Note/s: 1. Automatically dispose and replace the unit if once encountered Bend terminal, Difficulty of insertion, Half-locked connector. 2. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process. Do not attempt to repair. 3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 4. Follow the insertion sequence based on the visual reference 5. Hold on wire during insertion must be 5mm away from terminal end.</div><div>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div></div></div></div>		

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WORK INSTRUCTION

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TAPING ASSEMBLY PROCESS

Effectivity Date:

December 4, 2024

Validity Date:

n/a

Model code/Part number:

350B/320B/014B/
360B/150B/

17J796-7051

Customer: TRP

Car Model:

TOYOTA-COROLLA/
RAV-4/ HIGHLANDER

Document No.:

WI-ENG-PDE-091D

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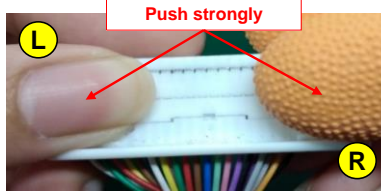

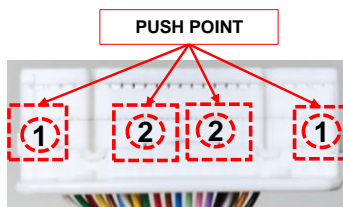
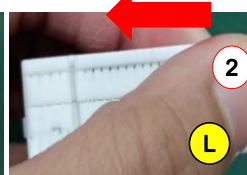
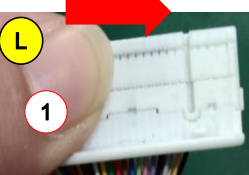
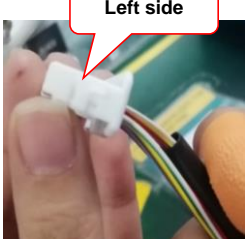
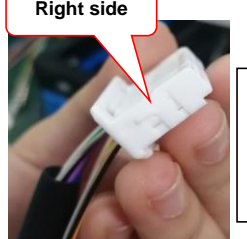
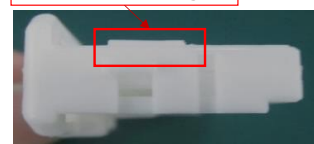
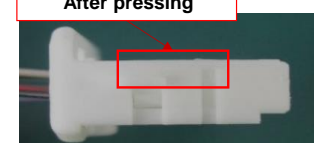
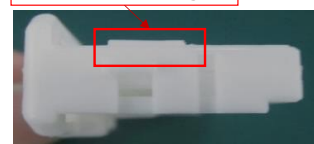
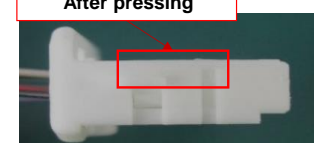
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P4 <div>20</div> <div>LOW</div> Connector lock	<div><div></div><div></div><div></div><div><p>Sequence of Pressing the Double Lock: ① - ① ~ ② - ② Method: Press same timing using both thumbs</p><p>1. Push the double lock using left & right thumb ①-① (Same timing) and press the center using left and right thumb ②-② (Same timing). 2. Check the connector lock after locking.</p></div><div></div><div><p>3. Ensure that connector is in locked condition by slide touching the connector lock from left to right based on the sequence illustrated.</p></div><div><div></div><div></div><div><p>4. Conduct visual checking of connector (1827842-1) (W) from side to side (Left to right).</p></div></div></div> <div>n/a</div> <td><div><div></div><div></div></div><div>1. No damaged double lock. 2. No half-locked connector</div></td>	<div><div></div><div></div></div> <div>1. No damaged double lock. 2. No half-locked connector</div>	

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TAPING ASSEMBLY PROCESS

Effectivity Date:

December 4, 2024

Validity Date:

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Model code/Part number:

**350B/320B/014B/
360B/150B/****17J796-7051**Customer: **TRP**

Car Model:

**TOYOTA-COROLLA/
RAV-4/ HIGHLANDER**

Document No.:

WI-ENG-PDE-091D

Purpose:



☐ **PROTOTYPE**☐ **PRE-LAUNCH**☒ **MASSPRO**

Revision No.:

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PARTS:	1. Assy parts			JIG:	1. WIP Holder
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P4 Pass WIP to P5	<div>3 PIECES FLOW</div>  <div>1. Pass WIP to WIP Holder. Note: Three pieces flow.</div>		<div>WIP HOLDER</div> 	1. No WIP overflow

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