



WORK INSTRUCTION

Effectivity Date:

February 07, 2025

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

400D / 7L0165-7020A

Customer:

TRQSS

Car Model: TOYOTA-bZ4X (BEV)

Document No.:

WI-ENG-PDE-1198

Purpose:



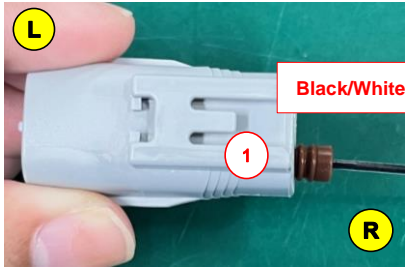
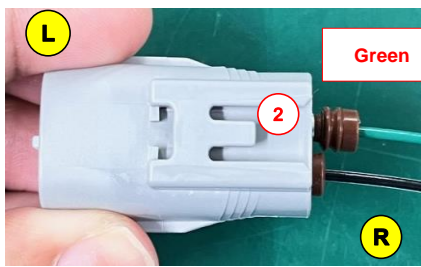
☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

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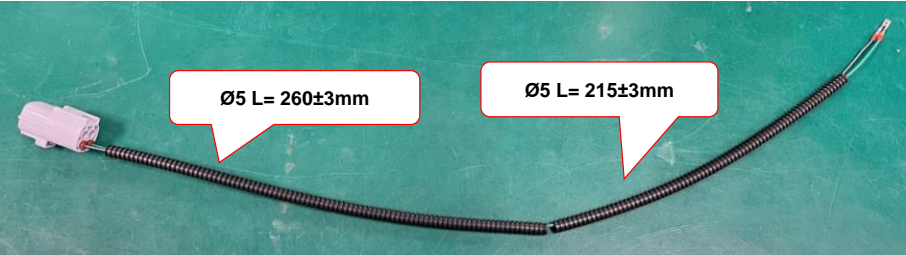
PARTS:		1. Connector 6188-0066 (GR) 2. TVSSf 0.3 G and B/W wires L=561±3mm				JIG:		n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS		
1	P1 Wire insertion to connector 6188-0066 (GR)	<div> CONNECTOR ORIENTATION</div> <div> VISUAL REFERENCE</div> <div> 1. Get the connector using left hand and get the Black/White wire and insert to connector using right hand.</div> <div> 2. Hold the connector using left hand. Get the Green wire and insert to connector using right hand.</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>Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</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>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div>		
Revision History										
						Prepared by	Reviewed by	Approved by	Noted by	
02/07/25 0 Initial issue.						D.Castillo	C. Villanueva	A. Arañes	n/a	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	
						Est. Date:	February 07, 2025			

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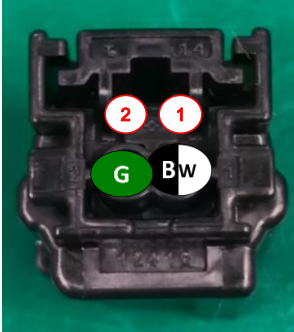
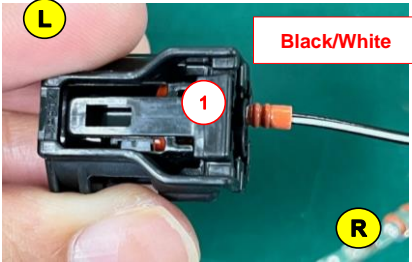
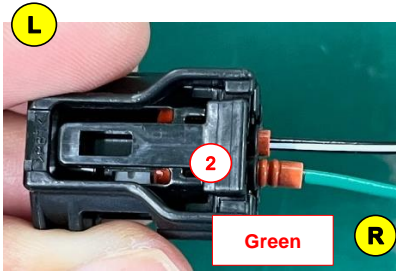
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	Process Name/Title:		Model code/Part number: 400D / 7L0165-7020A		Customer: TRQSS	Car Model: TOYOTA-bZ4X (BEV)	Document No.:	WI-ENG-PDE-1198			
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input checked="" type="checkbox"/> PRE-LAUNCH		<input type="checkbox"/> MASSPRO		Revision No.:	0	Page No.:

PARTS:		1. Black corrugated tube ø5 L=260±3mm (No slit) 2. Black corrugated tube ø5 L=215±3mm (No slit)		3. Assy parts		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS	
2	P1	Wire insertion to Black corrugated tube ø5 L=260±3mm (No slit)	 <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> 1. Get the Black corrugated tube ø5 L=260±3mm (No slit) using right hand and insert B/W wire and G wire by using left hand. </div>				n/a	1. No wrong use of parts 2. No deformed terminal
3		Wire insertion to Black corrugated tube ø5 L=215±3mm (No slit)	 <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> 1. Get the Black Corrugated Tube ø5 L=215±3mm (No Slit) using left hand and insert B/W wire and G wire by using left hand. </div> 				n/a	1. No wrong use of parts 2. No deformed terminal

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	Model code/Part number: 400D / 7L0165-7020A		Customer: TRQSS	Car Model: TOYOTA-bZ4X (BEV)	Document No.:	WI-ENG-PDE-1198		
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PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 Wire insertion to connector 6189-1161 (B)	<div><div>CONNECTOR ORIENTATION</div></div> <div><div>TERMINAL FACING</div></div> <div><div>VISUAL REFERENCE</div></div> <div><div>1. Get the connector using left hand and get the Black/White wire and insert to connector using right hand.</div></div> <div><div>2. Hold the connector using left hand. Get the Green wire and insert to connector using right hand.</div></div>		n/a	<p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p>


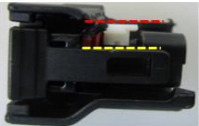



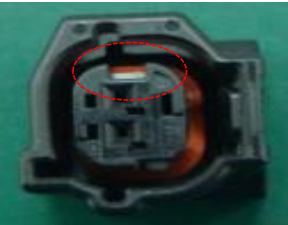

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PARTS:	1. Assy parts			JIG:	1. Locking jig				
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS			
5	P1	Connector lock	<div><div>LOCKING JIG 7M0594 A7045D 7M0610 A7047E 7M0521 A7057B A7043E A7059B</div></div> <div>1. Put the connector into locking jig using both hands and then press 2x. Check the connector if properly locked.</div> <div>Connector lock appearance<div><div>NG<div>Unlock Condition</div></div><div>NG<div>Half Lock Condition</div></div><div>GOOD<div>Full Lock Condition</div></div></div><div><div>BEFORE PRESSING</div><div>AFTER PRESSING</div></div></div>			<div>LOCKING JIG</div> 	<div>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</div> <div>1. Use the provided jig tool to lock the connector. 2. No unlock/half-locked connector</div>		

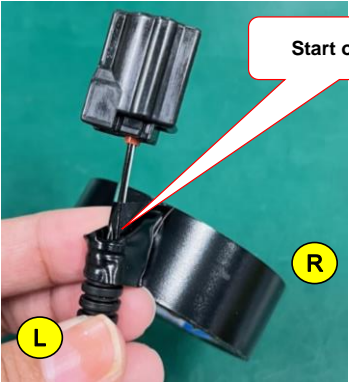
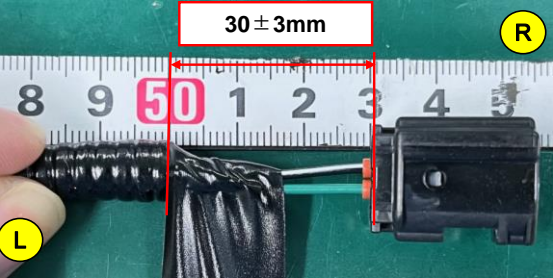
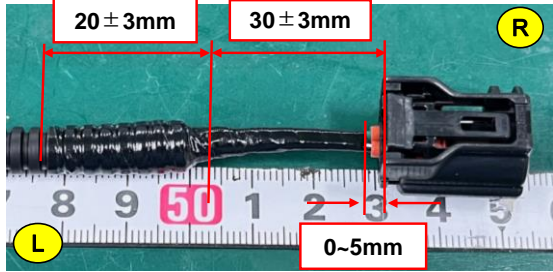

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
6	P1 Taping 1 Black corrugated tube to wire near connector	<div><p>Start of taping</p></div> <div><p>30 ± 3mm</p></div> <div><p>20 ± 3mm 30 ± 3mm 0~5mm</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>Document references:</p> <p>1. Refer to WI-PRO-ASY-001A for Taping process</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape 7. No insufficient tape</p>	

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PARTS:		1. AVSSf 0.3 B wire L=792±3mm [2pcs] 2. Assy part		JIG:	1. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
7	P1 Wire insertion to assy parts (Black corrugated tube ø5 L=260±3mm (No slit))	<div><p>1. Get 2 pcs of Black wire using left hand and insert terminal cover jig using right hand.</p></div> <div><p>2. Get the assy part using right hand then insert the wires in Black corrugated tube ø5 L=260±3mm (No slit) using right hand.</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div>		<div>TERMINAL COVER JIG</div> 	<p>Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No wrong usage of parts 2. No damaged rubber seal</p>	


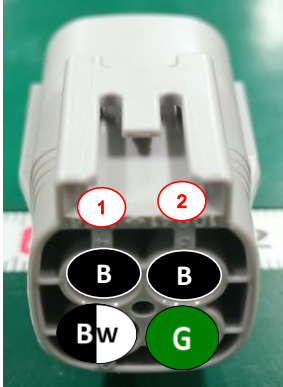

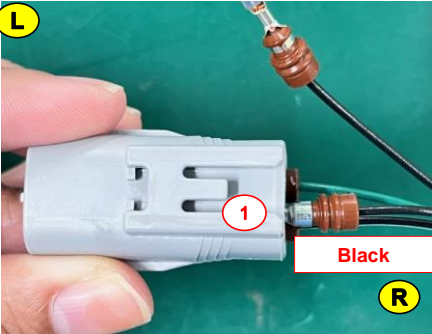
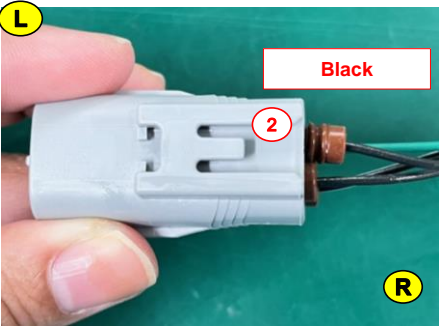
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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1 Wire insertion to connector 6188-0066 (GR)	<div>  <p>CONNECTOR ORIENTATION</p> </div> <div>  <p>VISUAL REFERENCE</p> </div> <div>  <p>TERMINAL FACING</p> </div> <div>  <p>1. Hold the connector part using left hand and hold the first Black wire then insert to connector using right hand.</p> </div> <div>  <p>2. Hold the connector using left hand and hold the second Black wire then insert to connector using right hand.</p> </div>		n/a	<p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p>

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Document No.:

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PROTOTYPE



PRE-LAUNCH



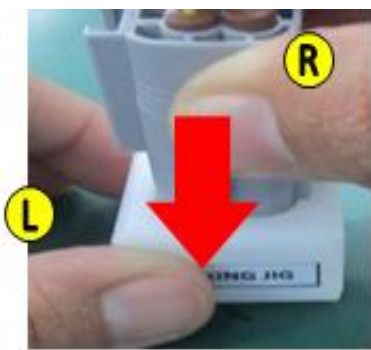




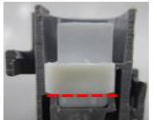

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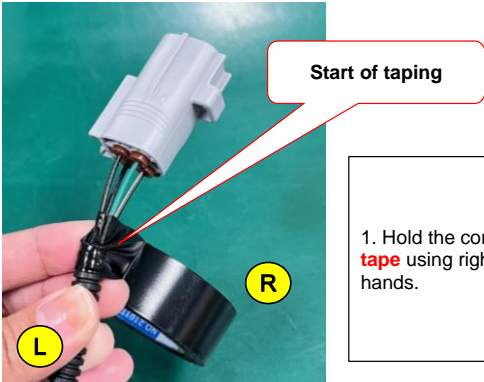
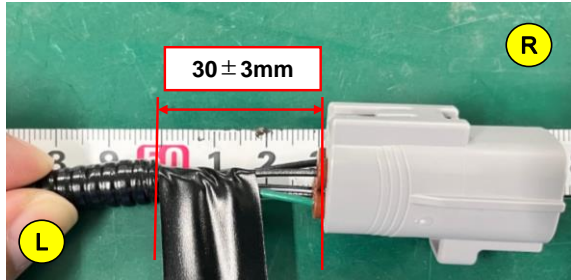
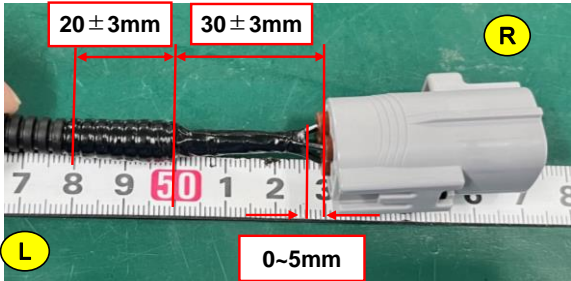

PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1	<div><div>1. Put the connector into locking jig using both hands and then conduct 2x pressing. Check the connector if properly locked.</div><div>Before pressing</div><div>After pressing</div><div>Connector Cross Sectional View<div>Unlock</div><div>Half Lock Condition</div><div>Full Lock Condition</div></div></div>		<div>LOCKING JIG</div> 	<p>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <p>1. No unlock/half-locked connector 2. No damage connector</p>

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
10	P1 Taping 2 Black Corrugated tube to wire near connector	<div><p>Start of taping</p><p>1. Hold the corrugated tube using left hand, get the Black tape using right hand then start pre-taping using both hands.</p></div> <div><p>30 ± 3mm</p><p>2. Measure from end of the corrugated tube up to connector 30±3mm then continue the taping process using both hands.</p></div> <div><p>20 ± 3mm 30 ± 3mm</p><p>0~5mm</p><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>Document references:</p> <p>1. Refer to WI-PRO-ASY-001A for Taping process</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape 7. No insufficient tape</p>	

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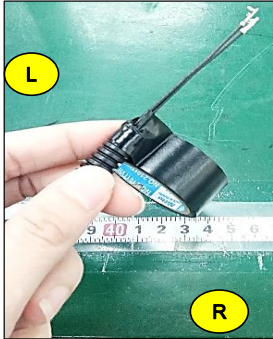
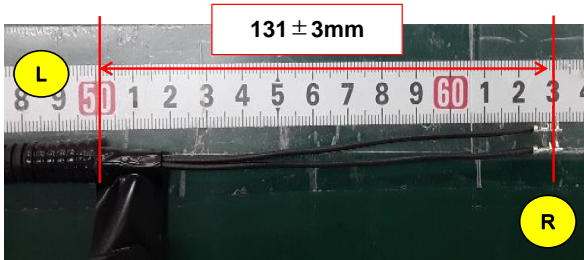
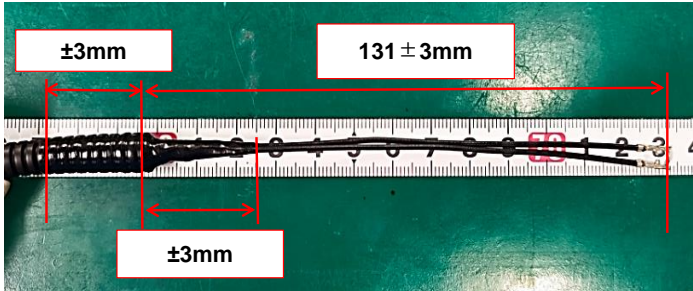

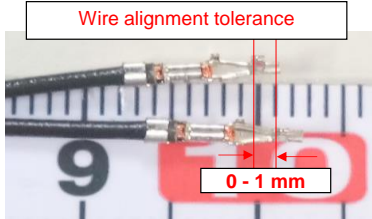
PARTS:		1. Black corrugated tube ø5 L=360±3mm (No slit) 2. Assy part		JIG:	1. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
11	P1 Wire insertion to Black corrugated tube ø5 L=360±3mm (No slit)	<div><p>1. Get the assy part using left hand and insert terminal cover jig using right hand.</p></div> <div><p>2. Get the Black corrugated tube ø5 L=360±3mm (No slit) using right hand and insert the terminal cover jig using left hand.</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div>		<div>TERMINAL COVER JIG</div> 	<p>Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No wrong usage of parts 2. No damaged rubber seal</p>	



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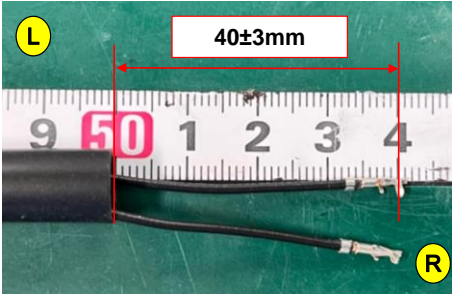
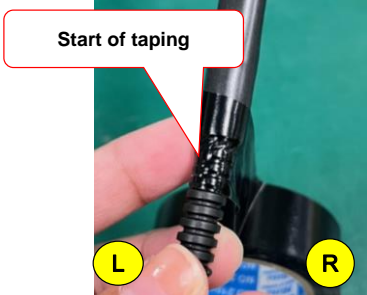


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PARTS: 1. Assy parts 2. Black tape		JIG:		n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
12	P1 Taping 3 Black Corrugated tube to wire near terminal	<div>  </div> <div> <p>1. Hold the assy parts using left hand. Get the Black tape using right hand then start taping between COT to wire using both hands.</p> </div> <div>  </div> <div> <p>2. Measure form end of COT up to terminal pointed tip 131±3mm then continue the taping process using both hands</p> </div> <div>  </div> <div> <p>3. After taping, check the measurement, terminal alignment and taping condition.</p> </div>	<div>  </div> <div> <p>MEASURING TAPE</p> </div>	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document references:</p> <p>1. Refer to WI-PRO-ASY-001A for Taping process</p> <ul style="list-style-type: none"> 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>


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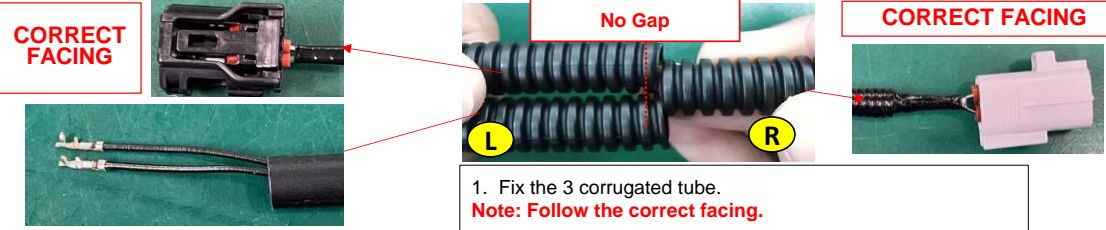
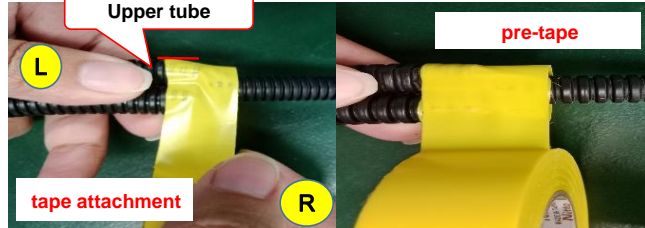
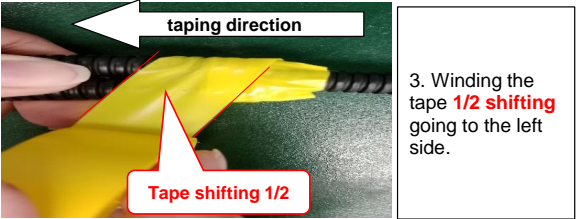
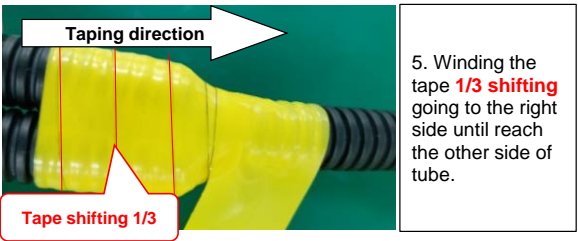
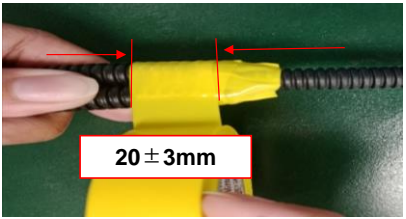
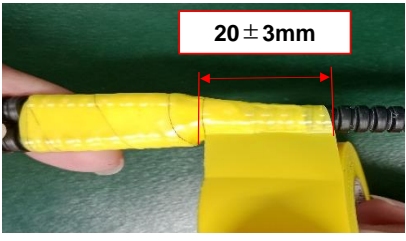
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	TAPING ASSEMBLY PROCESS				Validity Date:	n/a					
	Process Name/Title:		Model code/Part number: 400D / 7L0165-7020A		Customer: TRQSS	Car Model: TOYOTA-bZ4X (BEV)	Document No.:	WI-ENG-PDE-1198			
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input checked="" type="checkbox"/> PRE-LAUNCH		<input type="checkbox"/> MASSPRO		Revision No.:	0	Page No.:

PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
13	Wire insertion to Black VM tube (Sunprene) ø9 L=112±3mm	 <div> <p>1. Get the Black VM tube (Sunprene) ø9 L=112±3mm using right hand then insert the wires using left hand.</p> </div>		n/a	1. No wrong use of parts 2. No deformed terminal
14	P1 Taping 4 Black VM tube (Sunprene) to Black corrugated tube (no slit)	<div>  <p>1. Measure from end of Black VM tube (Sunprene) up to terminal pointed tip 31±3mm using both hands.</p> </div> <div>  <p>2. Hold the Black VM tube (Sunprene) using left hand, get the Black tape then start taping using right hand.</p> </div> <div>  <p>3. After taping, check the taping condition and measurement.</p> </div>		<div> <p>MEASURING TAPE</p>  </div>	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001B for taping procedure.</p> <p>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape 7. No insufficient tape</p>

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	WORK INSTRUCTION			Effectivity Date:	February 07, 2025		
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	Model code/Part number: 400D / 7L0165-7020A		Customer: TRQSS	Car Model: TOYOTA-bZ4X (BEV)	Document No.:	WI-ENG-PDE-1198	
	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	13 of 16

PARTS: 1. Assy parts 2. Black tape		JIG: n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
15	P1 Y-Taping	<div>  <p>CORRECT FACING</p> <p>No Gap</p> <p>CORRECT FACING</p> <p>1. Fix the 3 corrugated tube. Note: Follow the correct facing.</p> </div> <div>  <p>Upper tube</p> <p>pre-tape</p> <p>tape attachment</p> </div> <div>  <p>taping direction</p> <p>Tape shifting 1/2</p> <p>3. Winding the tape 1/2 shifting going to the left side.</p> </div> <div>  <p>Taping direction</p> <p>Tape shifting 1/3</p> <p>5. Winding the tape 1/3 shifting going to the right side until reach the other side of tube.</p> </div> <div>  <p>20 ± 3mm</p> <p>4. Make 2 windings, width must be 20±2mm.</p> </div> <div>  <p>20 ± 3mm</p> <p>6. Make 2 windings, width must be 20±3mm.</p> </div>	<p>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>Important reminders/Note/s: 1. Use yellow tape for easy visualization of tape shifting, but actual should be <u>BLACK TAPE</u>. 2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension-out tape 6. No exposed wire 7. No gap between tubes</p>

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TAPING ASSEMBLY PROCESS

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Car Model:

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Document No.:

WI-ENG-PDE-1198

Purpose:



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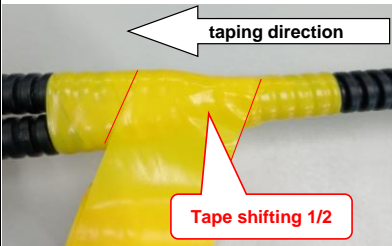
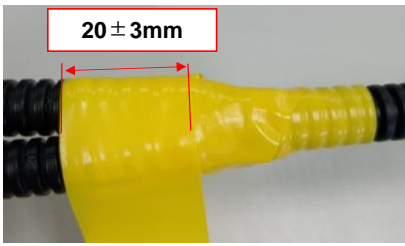
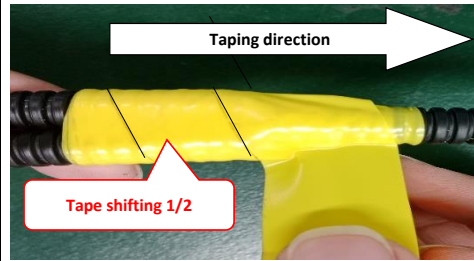
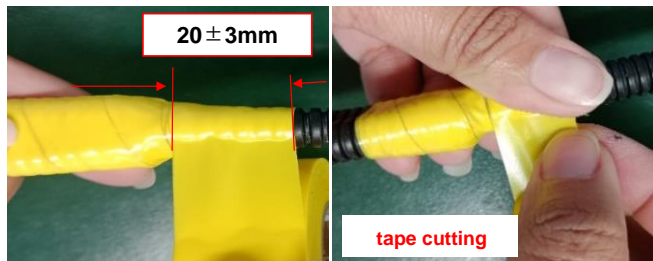
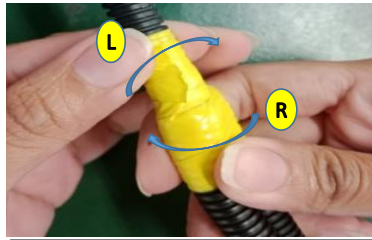
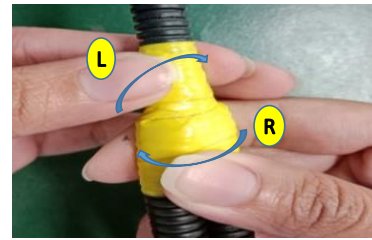
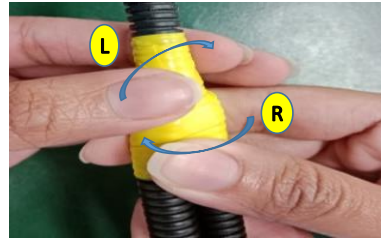
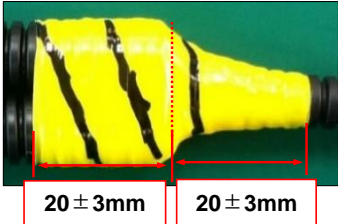
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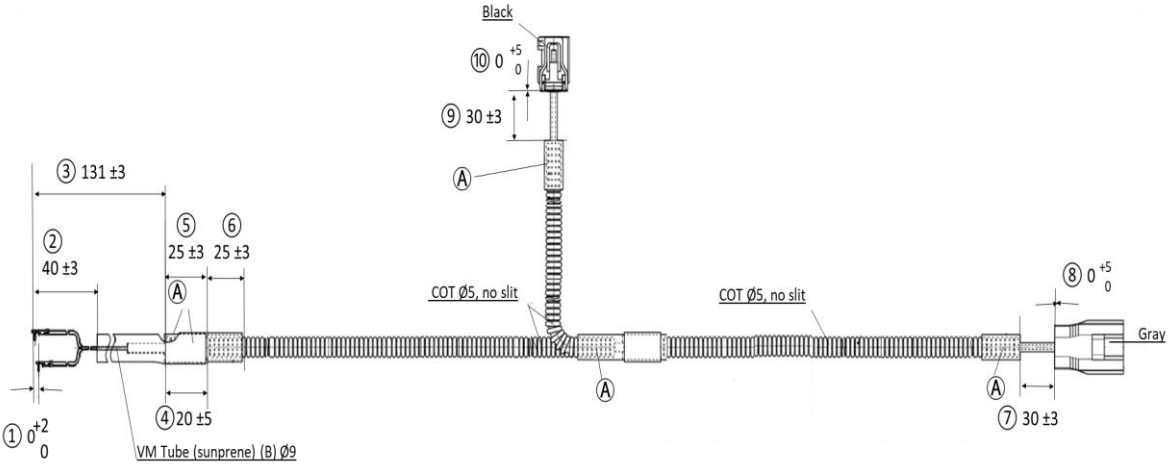
PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
15	P1	Y-Taping (Continuation)	<div></div> <div>7. Winding the tape 1/2 shifting going to the left side.</div>	<div></div> <div>8. Make 2 windings, width must be 20±3mm.</div>	<p>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>Important reminders/Note/s: 1. Use <u>yellow tape</u> for easy visualization of tape shifting, but actual should be <u>BLACK TAPE</u>. 2. Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none">1. No loose tape2. No flip-out tape3. No peel-off tape4. No wrong use of tape5. No wrong dimension-out tape6. No exposed wire7. No gap between tubes
			<div></div> <div>9. Winding the tape 1/2 shifting going to the right side until it reach the other side of tube</div>	<div></div> <div>10. Make 3 winds, width must be 20±3mm. Then cut the tape.</div>	
			<div></div> <div>11. conduct proper pressing of end tape using left hand (top part). Note: Reference only.</div>	<div></div> <div>12. conduct proper pressing of end tape using left hand (Middle part). Note: Reference only.</div>	
			<div></div> <div>13. conduct proper pressing of end tape using left hand (bottom part). Note: Reference only.</div>	<div></div> <div>14. Check the Measurement and condition of tape.</div>	

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	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 400D / 7L0165-7020A		Customer: TRQSS	Car Model: TOYOTA-bZ4X (BEV)	Document No.: WI-ENG-PDE-1198		
	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	15 of 16

PARTS:	1. Assy parts			JIG:	n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
16	P1	Measurement	<div><div>MEASURING TAPE</div></div>  <div>NOTE: (A) - Taping (B) (4) - Overlapped COT and Sunprene Tube *Unit of dimension is in millimeter (mm)</div>			<div>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.</div> 1.No wrong dimension	

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PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Assy parts

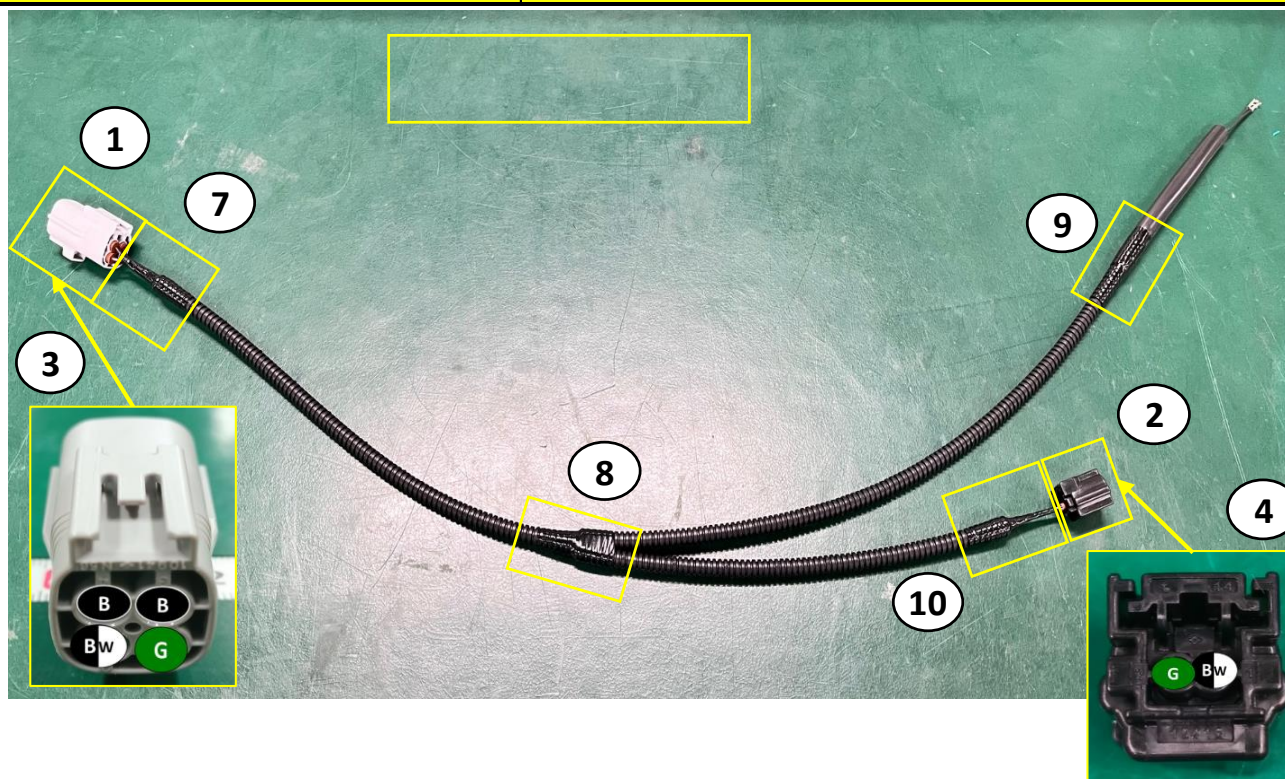
JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING - P1

7L0165-7020A



- 1 2 No Unlocked / Half-locked Connector
- 3 4 No Wrong Insert
- 5 No Deformed Terminal
- 6 No Terminal Backing out
- 7 8 9 10 No Missing tape/
No Wrong color of tape

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