



WORK INSTRUCTION

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

Effectivity Date:

January 26, 2024

Model code/Part number: **700B / 7N0037-7020B** Customer: **TRJ** Car Model: **TOYOTA-LAND CRUISER**

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-758B

Revision No.:

1

Page No.:

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PARTS: 1. Assy parts

JIG:

1. Insertion Jig
2. Locking jig

NO.

PROCESS NAME

1

WORK PROCEDURE/ ILLUSTRATION

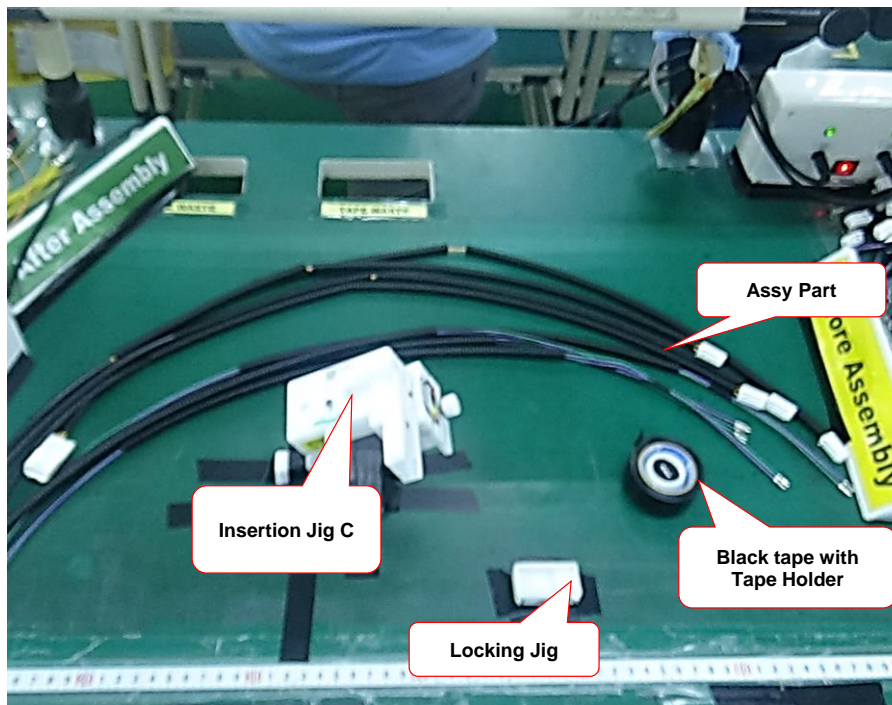
TOOLS/PPE

QUALITY POINTERS

1

P2

Table Lay-out

**Safety Instruction**

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

Document reference/s:
1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

1. No missing parts/tools
2. No excess parts/tools

Revision History

Prepared by

Reviewed by

Approved by

Noted by

01/26/24 1 Changed purpose from pre-launch to masspro. Improve Work procedure/illustration on pages 1 to 7. Additional table lay-out and Quality checkpoints

M. Ariola C. Villanueva A. Arañes n/a

12/13/23 0 Initial issue.

M. Ariola J. Loterte C. Villanueva A. Arañes

Eff. Date Rev. No

Details of Change

Revised Reviewed Approved Noted

Est. Date:

December 13, 2023

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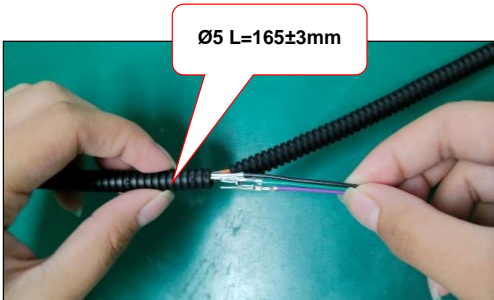
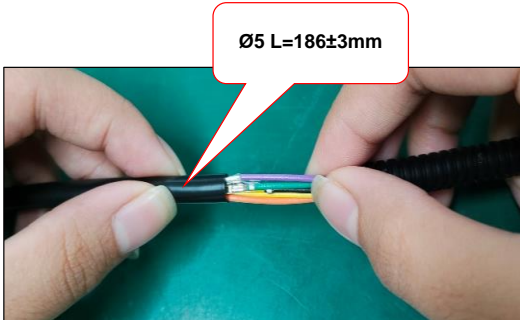
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy Parts 2. AVSSf 0.3 V L=768±3mm	3. AVSSf 0.3 G L=768±3mm 4. AVSSf 0.3 B L=768±3mm	JIG:	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2 Wire Insertion to assy part	  <p>1. Hold the corrugated tube (no slit) Ø5 L=165±3mm using left hand then insert the assy part using right hand.</p> <p>2. Hold the SV tube (Vinyl) Ø5 L=186±3mm using left hand then insert the assy part using right hands.</p>		N/A	<p>Document reference/s:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No wrong use of parts 2. No deformed terminal 3. No wrong use of insertion</p>

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PARTS:		1. Assy Parts 2. Connector 6098-3802 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	<div><div><div><div>Visual reference</div><div>INSERTION JIG</div><div>Button</div><div>Guide</div></div><div><div>I-MARK</div><div>Lock</div><div>INSERTION JIG ORIENTATION</div></div><div><div>CONNECTOR ORIENTATION</div></div></div><div><div><div><div>L</div><div>Press</div></div><div><div>L</div><div>Press</div></div><div><div>R</div><div>Release</div></div></div><div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6098-3802 (W) into jig using right hand and release the lock. <i>Note: Follow the connector orientation.</i></div><div><div>3. Push the guide using left hand. The slot for G wire will be opened.</div></div></div></div></div>		N/A	1. No wrong use of parts 2. No deformed terminal 3. No wrong use of insertion

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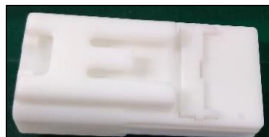


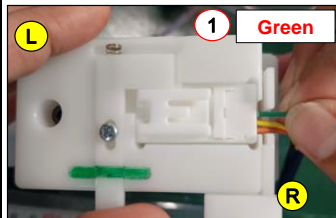
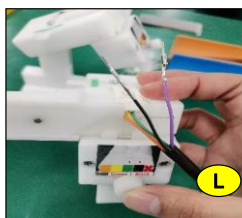
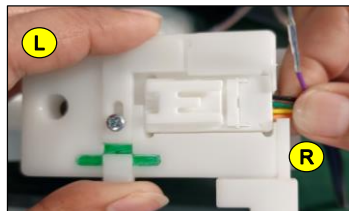
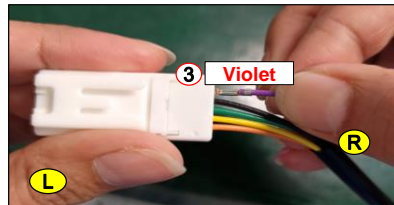
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PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	<div><div><p>CONNECTOR ORIENTATION</p></div><div><p>VISUAL REFERENCE</p></div><div><p>WIRE FACING</p></div></div> <div><div><p>1. Hold the insertion jig using left hand. Get the Green wire and insert to connector using right hand.</p></div><div><p>2. Push the guide using left hand. The slot for Black wire will be opened. Get the B wire and insert to connector using right hand.</p></div><div><p>3. After insertion, hold the wires and gently pull out the connector from jig using right hand.</p></div><div><p>5. Get the Violet wire and insert to connector using right hand.</p></div></div> <div>N/A</div> <div><p>1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. One by one insertion 7. No deformed terminal 8. No wrong wire facingthe</p><p>Important reminders/Note/s:</p><p>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p><p>2. Please hold the wire near terminal</p><p>Document references:</p><p>1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</p></div>			

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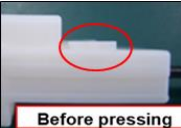



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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2	Connector lock	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div> <div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div> <div><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><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></div>	<p>1. Use the provided jog per model 2. No unlocked/half-locked connector</p> <p>Important reminders/Note/s:</p> <p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR LOCK 2. Use provided jig tool per model to avoid damaged lock.</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-017 for the verification of connector lock.</p> <div><p>Before pressing</p><p>After pressing</p></div> <div><p>GOOD Full Lock</p><p>NG Half Lock</p></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	P2 Y-Taping	<div><p>1</p><p>No gap between COTs</p><p>1. Fix the 3 corrugated tube .</p><p>2. Start taping at the middle of combined Corrugated tubes, then wind the tape to left side, width must be same with tape (19mm)</p><p>3. Wind the tape 1/3 shifting until it reach the other side of corrugated tube (must be tape width).</p><p>4. Wind the tape backward 1/2 shifting.</p><p>5. Wind the tape 1/2 shifting going to other side of corrugated tube then cut the tape. After taping, check the condition of tape.</p></div>	<p>MEASURING TAPE</p> 	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <ul style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension

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PARTS:

n/a

JIG:

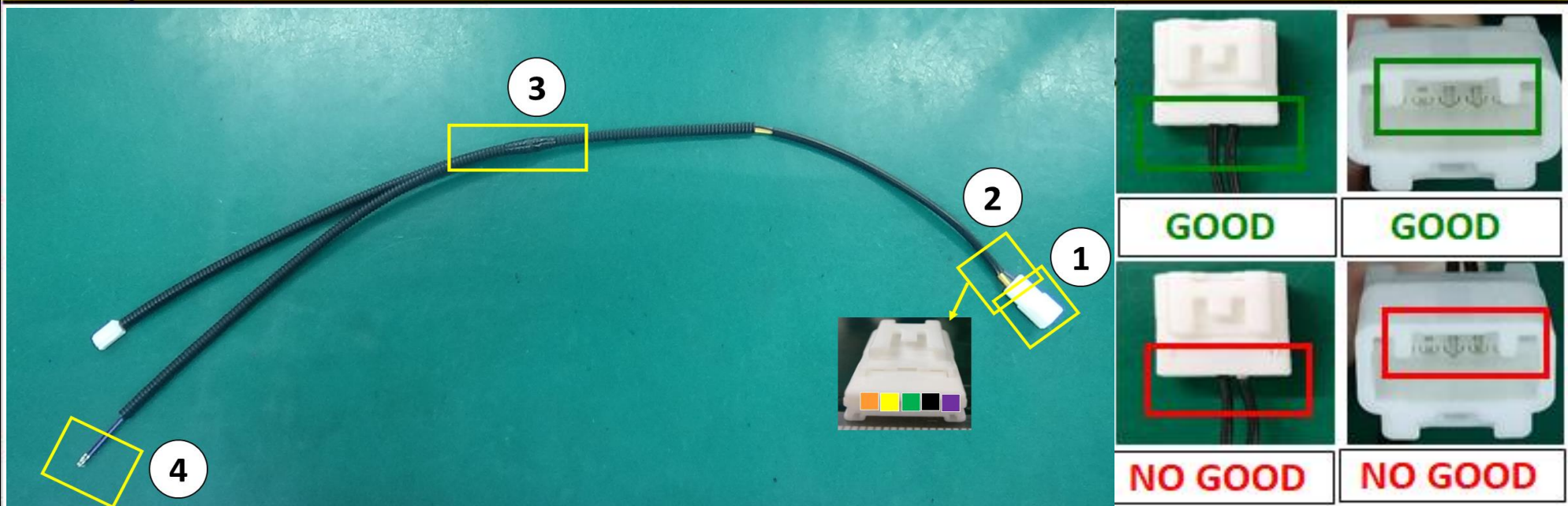
n/a



QUALITY CHECKPOINTS

P2

7N0037-7020B



- 1 No Unlock/Half-locked Connector (on 2 Connector)**
- 2 No Wrong insert (On 2 connector)**
- 3 No Missing tap**
- 4 No Deformed terminal**

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