



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

February 7, 2025

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

524D / 7N0241-7020

Customer:

TRJ

Car Model:

TOYOTA-PROBOX

Document No.:

WI-ENG-PDE-1112A

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

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PARTS:

1. Connector 6098-2220(W); AVSSf 0.3 Y Wire L=452±3mm; AVSSf 0.3 OR Wire L=452±3mm; Black SV tube (Vinyl) ø5, L=233±3mm; Black tape; Black SV tube (Vinyl) ø5 L=47±3mm; Black Corrugated tube ø5 L=140±3mm; Connector 6098-3802 (W) AVSSf 0.3 B-B Wire L=593±3mm.

JIG:

1. Insertion jig with switch cover
2. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

P1

Table lay-out

TABLE LAY-OUT

Connector 6098-2220
(W) /
Connector tray

Black SV tube (Vinyl)
ø5 L=47±3mm

Connector 6098-3802
(W)/Connector tray

Black SV tube
(Vinyl) ø5
L=47±3mm

Black Corrugated tube
ø5, L=304±3mm

Black Corrugated tube
ø5 L=140±3mm

Insertion jig A

AVSSf 0.3 OR-
Y Wires
L=452±3mm

AVSSf 0.3 B-B
Wire
L=593±3mm

Insertion jig B

Locking jig

Tape
holder/Black
tape

NBP
Locking jig

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.

1. No wrong orientation of the 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 facing

Important reminders/Note/s:

1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
2. Please hold the wire near terminal
Document references:
1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.
2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

Revision History

Prepared by

Reviewed by

Approved by

Noted by

02/07/25 1 Change Purpose from Pre-launch to Masspro. Update the Work Procedure/Illustration; Provided Insertion jig; Additional table lay-out; Update the Visual Inspection/ Quality Checkpoints

M. Ariola C. Villanueva A. Arañes n/a

11/19/24 0 Initial issue.

M. Ariola C. Villanueva A. Arañes n/a

Eff. Date Rev. No

Details of Change

Revised Reviewed Approved Noted

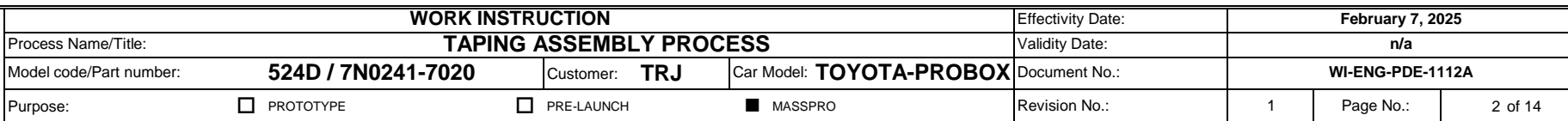
Est. Date:

November 19, 2024

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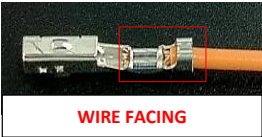
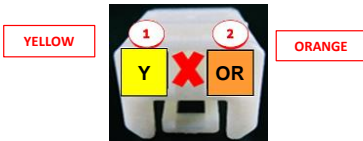
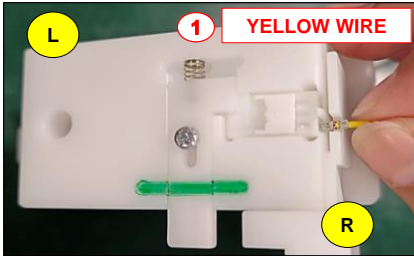
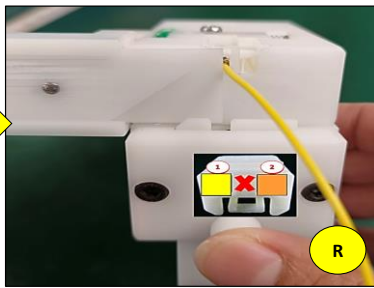
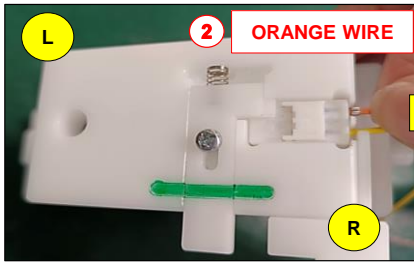
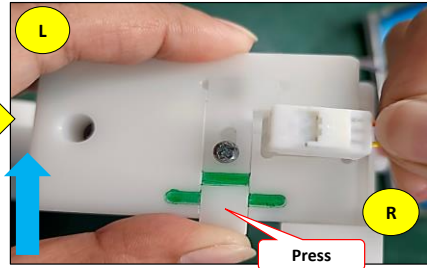
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PARTS:		1. Connector 6098-2220 (W) 2. AVSSf 0.3 Y Wire L=452±3mm 3. AVSSf 0.3 OR Wire L=452±3mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Connector setting to insertion jig 6098-2220(W)	<div><div><p>WIRE FACING</p></div><div><p>YELLOW OR</p></div><div><p>1 YELLOW WIRE</p></div><div><p>2 Press the button using right thumb the slot for OR wire will be opened.</p></div><div><p>2 ORANGE WIRE</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><p>1. Hold the insertion jig using left hand. Get the Y wire and insert to connector using right hand. Conduct 2x pull-push after insertion.</p><p>2. Press the button using right thumb the slot for OR wire will be opened.</p><p>3. Get the OR wire and insert to connector using right hand.</p><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>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</p> <p>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.</p> <p>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</p>

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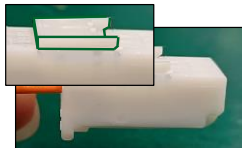
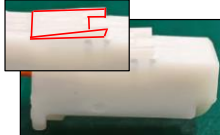
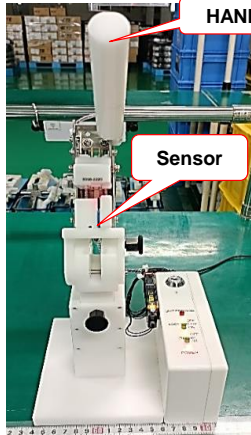
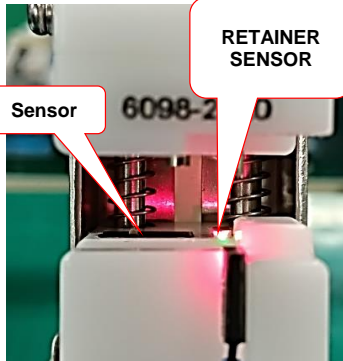
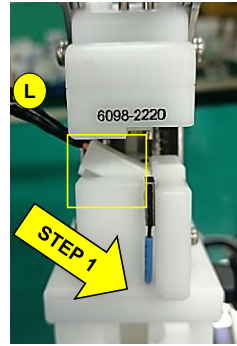
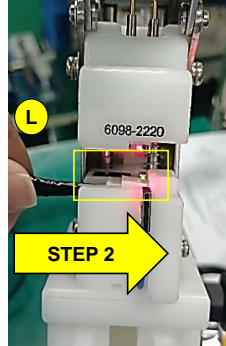
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PARTS:		1. Assy parts		JIG:	1. NBP Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	Connector lock 1	<div><h3>CONNECTOR RETAINER ILLUSTRATION</h3><h4>SIDE VIEW</h4><div><p>GOOD</p></div><div><p>NG</p></div></div> <div><p>HANDLE</p><p>Sensor</p><p>RETAINER SENSOR</p><p>Sensor</p><p>6098-2220</p><p>STEP 1</p><p>6098-2220</p><p>STEP 2</p></div> <p>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.</p>		<p>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.</p> <p>2. Maintain 10mm proper holding of wire to connector</p> <p>3.Connector must be fully inserted to connector slot.</p> <p>4. Make sure no offset setting before locking process.</p> <p>5.No wrong setting of connector.</p> <p>6. No damaged connector lock</p> <p>Important reminders/Note/s:</p> <p>1. Incomplete locking process will alarm the jig.</p> <p>2. No retainer in connector cannot proceed.</p> <p>3. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</p>

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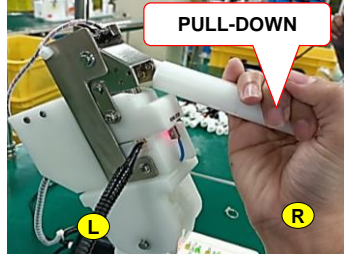
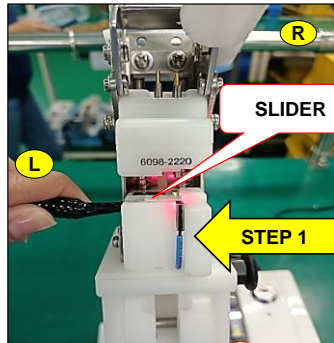
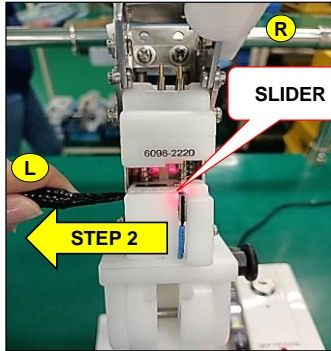
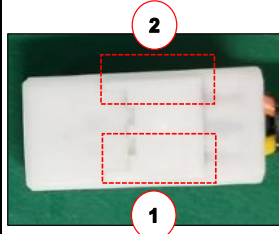
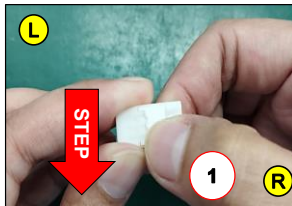
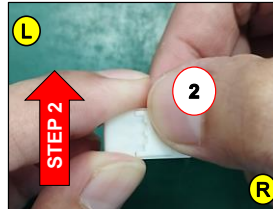
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 Connector lock 1 (Continuation)	<div><div><div></div><div></div><div></div><div></div><div></div><div></div><div></div></div><div><p>3. Hold the handle of the connector locking jig using right hand then gently pull down and bring back to original position after locking. Note: Pull down one time only.</p><p>4. Remove the locked connector using left hand based on the illustration, follow the direction of arrow.</p><p>5. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div><td><p>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.</p><p>2. Maintain 10mm proper holding of wire to connector</p><p>3.Connector must be fully inserted to connector slot.</p><p>4. Make sure no offset setting before locking process.</p><p>5.No wrong setting of connector.</p><p>6. No damaged connector lock</p><p>7. No unlocked/ half-locked connector.</p><p>Important reminders/Note/s:</p><p>1. Incomplete locking process will alarm the jig.</p><p>2. No retainer in connector cannot proceed.</p><p>3. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</p></td></div>		<p>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.</p> <p>2. Maintain 10mm proper holding of wire to connector</p> <p>3.Connector must be fully inserted to connector slot.</p> <p>4. Make sure no offset setting before locking process.</p> <p>5.No wrong setting of connector.</p> <p>6. No damaged connector lock</p> <p>7. No unlocked/ half-locked connector.</p> <p>Important reminders/Note/s:</p> <p>1. Incomplete locking process will alarm the jig.</p> <p>2. No retainer in connector cannot proceed.</p> <p>3. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</p>	

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PROTOTYPE



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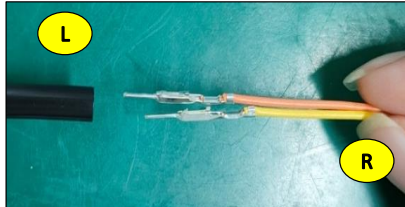
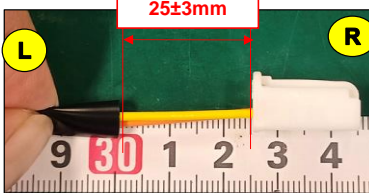
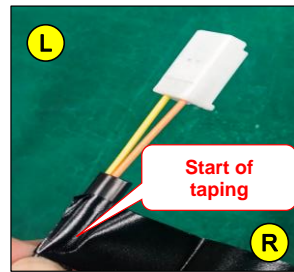
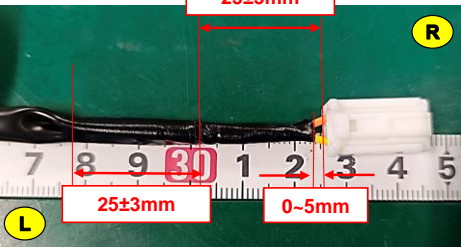

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PARTS:		1. Assy parts 2. Black SV tube (Vinyl) ø5, L=233±3mm 3. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5		Wire insertion to Black SV tube (Vinyl) ø5 L=233±3mm	<div></div> <div>1. Get the Black SV tube (Vinyl) ø5 L=233±3mm using right hand and insert Y-OR using left hand.</div>	n/a	1. No wrong use of parts 2. No deformed terminal
6	P1	Taping 1 Black SV tube (Vinyl) to wire near connector 6098-2220 (W)	<div></div> <div>1. Measure from end of Black SV tube (Vinyl) up to end of connector 25±3mm using both hands.</div> <div></div> <div>2. Get the Black tape using right hand then start taping process using both hands.</div> <div></div> <div>3. After taping, check the measurement and taping condition.</div>	<div>MEASURING TAPE</div> 	<div>Important reminders/Note/s:</div> <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</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document reference/s:</div> <div>1. Please refer to WI-PRO-ASY-0001A for COT to wire near terminal/connector taping procedure.</div>

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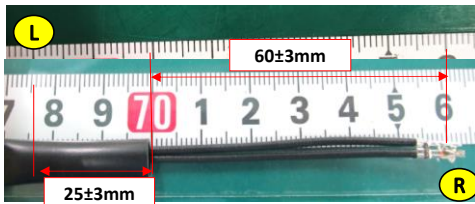
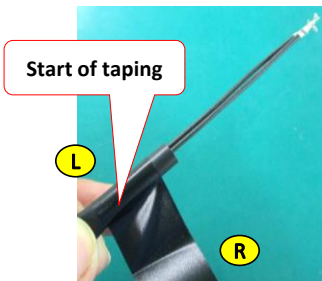
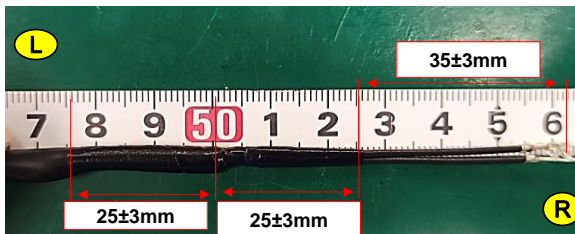


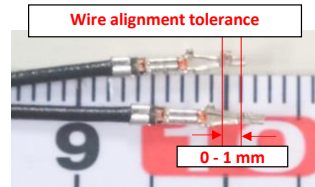
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PARTS:		1. Assy parts 2. Black SV tube (Vinyl) Ø5 L=47±3mm 3. AVSSf 0.3 B-B Wire L=593±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Wire Insertion to Black SV tube (Vinyl) Ø5 L=47±3mm	 <div>1. Get the Black SV tube (Vinyl) Ø5 L=47±3mm using left hand and insert B-B wires using right hand.</div>		n/a	1. No wrong use of parts 2. No deformed terminal
4	P1 Taping 2 Black SV tube (Vinyl) to wire near terminal	 <div>1. Hold the SV tube (Vinyl) using left hand, measure from end of SV tube (Vinyl) up to terminal tip 60±3mm.</div>  <div>2. Hold the assy parts using left hand, get the Black tape using right hand then start taping process using both hands.</div>  <div>3. After taping, check the measurement, taping condition and wire alignment.</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 Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 

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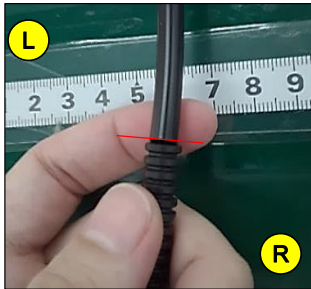
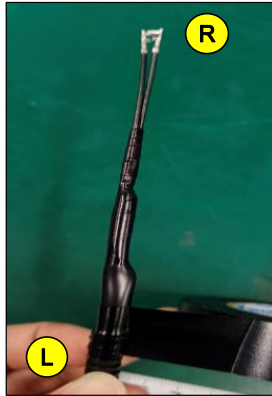


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PARTS:		1. Assy parts 2. Black tape 3. Black Corrugated tube $\phi 5$, L=304 \pm 3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	Wire insertion to Black Corrugated tube $\phi 5$, L=304 \pm 3mm	 <div>1. Get the Black Corrugated tube $\phi 5$, L=304\pm3mm using left hand then insert the Y-OR wires using right hand.</div>		n/a	1. No wrong use of parts 2. No deformed terminal
8	P1 Taping 3 Black Corrugated tube to SV tube (Vinyl)	 <div>1. Fix the corrugated tube and SV tube (Vinyl) using both hands.</div>  <div>2. Get the Black tape using right hand then start taping process using both hands.</div>  <div>3. After taping, check the measurement and taping condition.</div>		<div>MEASURING TAPE</div> 	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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PARTS:

1. Assy parts
2. Black Corrugated tube $\phi 5$ L=140 \pm 3mm

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

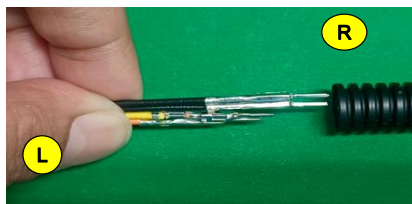
TOOLS/PPE

QUALITY POINTERS

9

P1

Wire Insertion to
Black Corrugated tube $\phi 5$
L=140 \pm 3mm
(Assy part)



1. Combined the assy parts (Y-OR wires with SV tube (Vinyl) and B-B wires with Tubes) using right hand then get the **Black Corrugated tube $\phi 5$ L=140 \pm 3mm** using left hand and insert the wires using both hands.

n/a

1. No wrong use of parts
2. No deformed terminal

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Car Model: TOYOTA-PROBOX

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1112A

Purpose:



PROTOTYPE



PRE-LAUNCH



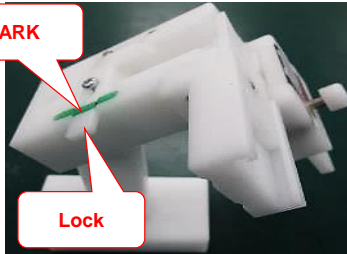


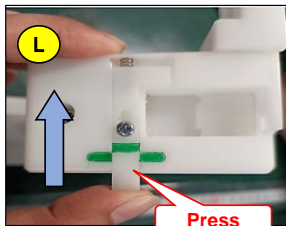
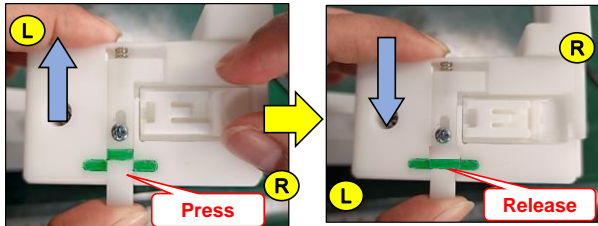
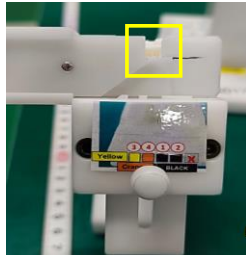












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PARTS:		1. Connector 6098-3802 (W) 2. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	P1 Connector setting to insertion jig 6098-3802 (W)	<div><div><p>I-MARK</p><p>Lock</p></div><div><p>CONNECTOR ORIENTATION</p></div><div><p>INSERTION JIG ORIENTATION</p></div><div><div><p>1. Press the lock of insertion jig using left hand.</p></div><div><p>2. Get the connector using then Insert the connector 6098-3802 (W) using right hand into jig using and release the lock. Note: Follow the connector orientation.</p></div><div><p>3. Do not push the lower wire guide upward. Slot for 2 Black wires must be open.</p></div></div><div>n/a</div><td><div>1. Use the provided jig per model 2. No wrong orientation of the connector. 3. No wrong use of connector 4. No damaged connector.</div><div><div>Connector Orientation Illustration</div><div><div><p>I-mark is align</p></div><div><p>1 Hole is open</p></div><div>GOOD</div></div><div><div><p>I-mark is not align</p></div><div><p>1 Hole is open</p></div><div>NG</div></div><div>CONNECTOR ILLUSTRATION</div><div><div><p>GOOD</p><p>6098-3802 (W)</p></div><div><p>NG</p><p>6098-5668 (W)</p></div></div></div></td></div>		<div>1. Use the provided jig per model 2. No wrong orientation of the connector. 3. No wrong use of connector 4. No damaged connector.</div> <div><div>Connector Orientation Illustration</div><div><div><p>I-mark is align</p></div><div><p>1 Hole is open</p></div><div>GOOD</div></div><div><div><p>I-mark is not align</p></div><div><p>1 Hole is open</p></div><div>NG</div></div><div>CONNECTOR ILLUSTRATION</div><div><div><p>GOOD</p><p>6098-3802 (W)</p></div><div><p>NG</p><p>6098-5668 (W)</p></div></div></div>	

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

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Model code/Part number:

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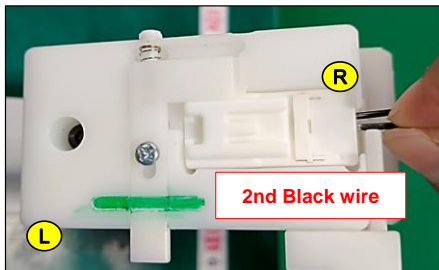

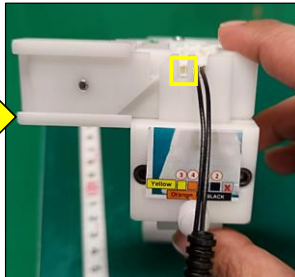
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PARTS:		1. Connector 6098-3802 (W) 2. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1 Connector setting to insertion jig 6098-3802 (W)	<div><div></div><div></div><div></div><div></div><div></div><div></div><div>1. Hold the insertion jig using left hand. Insert the 1st Black wire to connector using right hand. Conduct 2x push-pull after insertion.</div><div>2. Get the 2nd Black wire then insert to connector using right hand. Conduct 2x push-pull after insertion.</div><div>3. Press the lower guide using right hand. Slot for Yellow wire will be open.</div></div>		n/a	<div>1. Use the provided jig per model</div> <div>2. No wrong orientation of the connector.</div> <div>3. No wrong use of connector</div> <div>4. No damaged connector.</div> <div>Important reminders/Note/s:</div> <div>1. Please hold the wire near terminal.</div> <div>2. Make sure wires are properly inserted.</div> <div>3. Conduct Pull-Push-Pull-Push after insertion.</div> <div>4. Do not exert extra force.</div> <div>5. Insertion of wires must be from left to right</div> <div>Document references:</div> <div>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>

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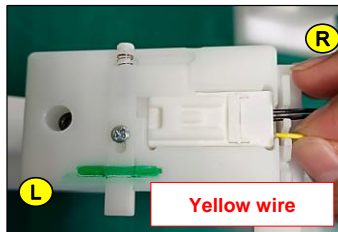
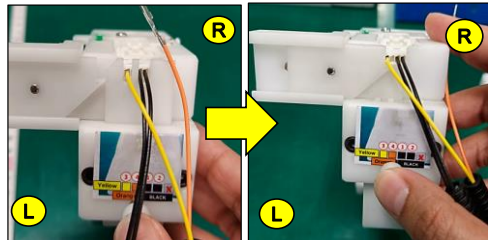
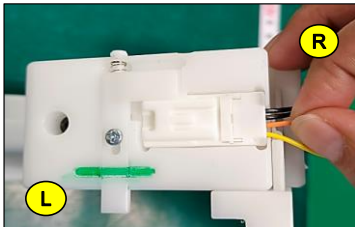

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PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
12	P1 Connector setting to insertion jig 6098-3802 (W)	<div><div></div><div><div>WIRE FACING</div></div></div> <div><div><div>Yellow wire</div></div><div></div></div> <div><div></div><div></div></div> <div>4. Hold the insertion jig using left hand. Get the Yellow wire to connector using right hand. Conduct 2x push-pull after insertion.</div> <div>5. Press the button of insertion jig using right hand and slot for Orange wire will be open.</div> <div>6. Hold the insertion jig using left hand. Get the Orange wire to connector using right hand. Conduct 2x push-pull after insertion.</div> <div>7. 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>	n/a	<div>1. Use the provided jig per model 2. No wrong orientation of the connector. 3. No wrong use of connector 4. No damaged connector.</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. 3. Insertion of wires must be from left to right</div>

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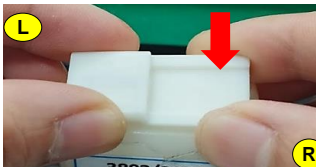



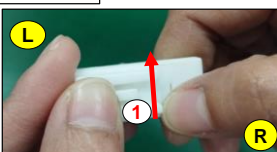

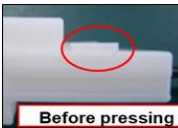



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PARTS:	1. Assy part			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
13	P1 Connector lock 2	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div> <div><p>2. 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>LOCKING JIG</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 jig may caused damaged connector 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:

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JIG:

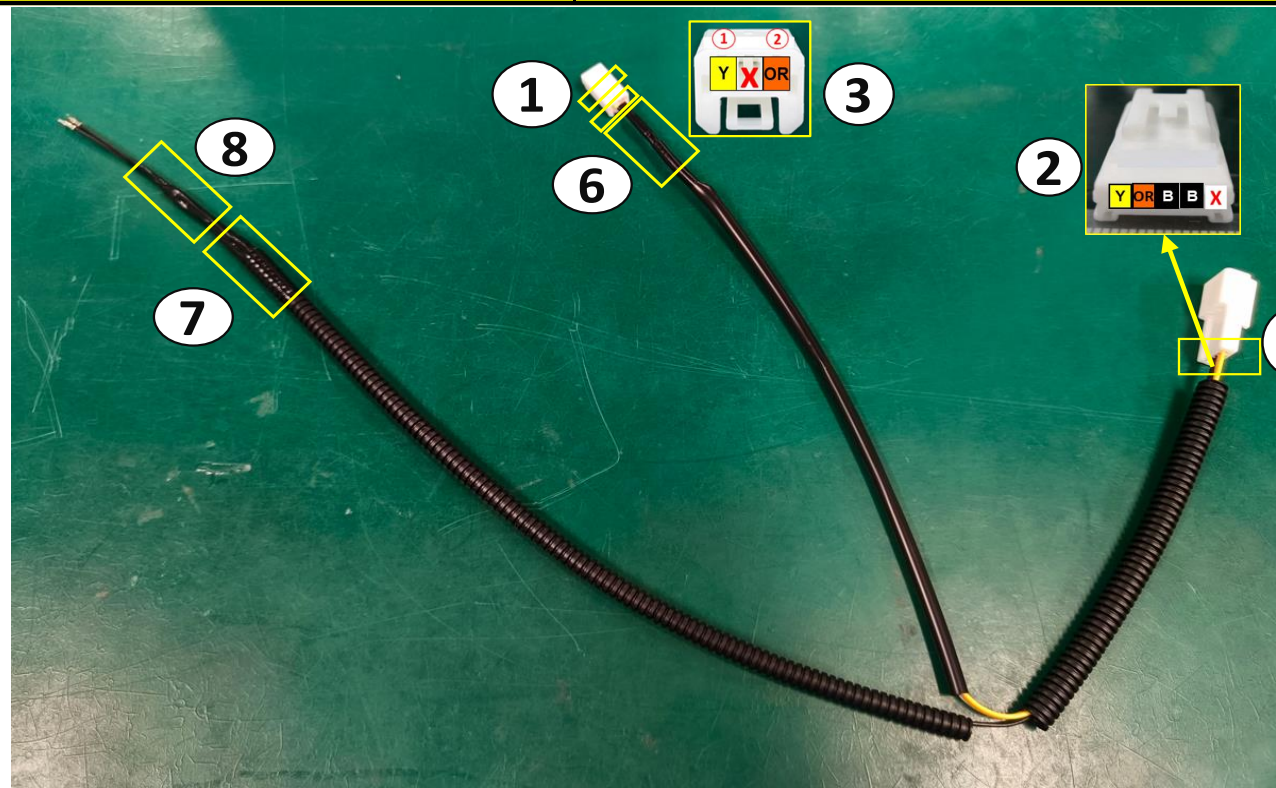
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VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING - P1

7N0241-7020



- 1 No Unlocked/ Half-locked
- 2 3 No Wrong Insert
- 4 No Deformed terminal
- 5 No Terminal backing out
- 6 7 8 No Missing Tape
- 9 No Missing parts

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