



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

February 7, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

930B

/

7N0205-7020A

Customer: TRJ

Car Model: TOYOTA-4RUNNER

Document No.:

WI-ENG-PDE-782B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1. Assy parts; Black SV tube (Vinyl) $\phi 4$, L=72 \pm 3mm; Black corrugated tube $\phi 7$, L=111 \pm 3mm (No slit); AVSSf 0.3 B-B wires L=643 \pm 3mm (No slit); Black tape

JIG:

1. Insertion jig
2. Locking jig
3. Terminal cover jig

NO.

PROCESS NAME

1

WORK PROCEDURE/ ILLUSTRATION

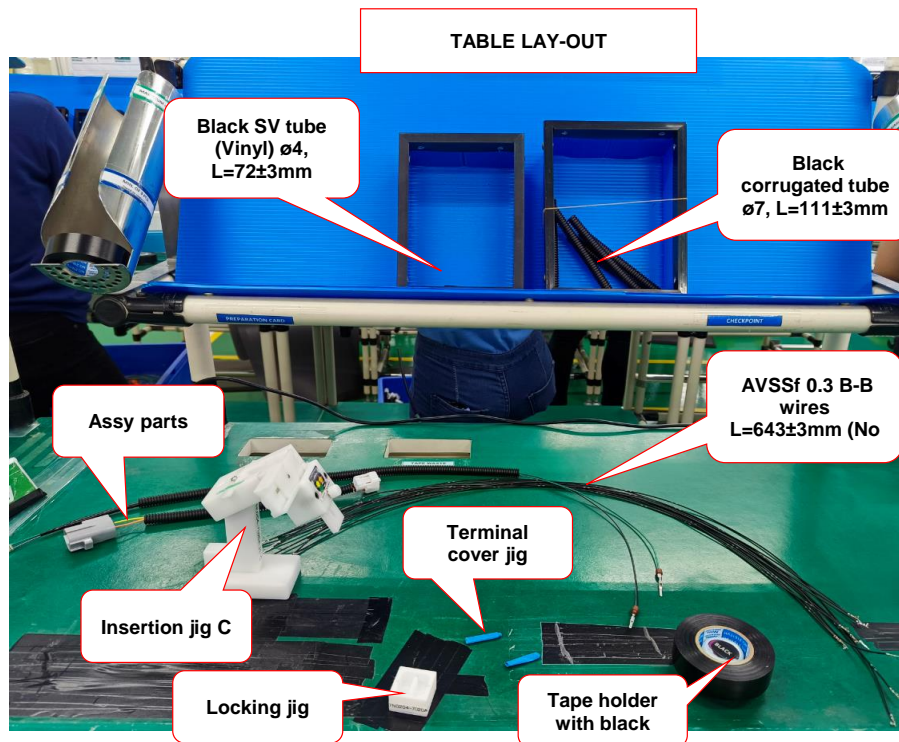
TOOLS/PPE

QUALITY POINTERS

1

P2

1
Table lay-out

**Safety Instruction**

Be sure to wear required 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 missing parts/tools
2. No excess parts/tools

Document references:

1. Refer to WI-PRO-CNC-017 for Wire Strip lenght tolerance.

Revision History

Prepared by

Reviewed by

Approved by

Noted by

02/07/24 1 Change purpose from Pre-launch to Masspro. Additional table layout and Inclusion of Quality Checkpoints;

M. Ariola C. Villanueva A. Arañes n/a

01/15/24 0 Initial issue

M. Ariola C. Villanueva A. Arañes n/a

Eff. Date Rev. No Details of Change

Revised Reviewed Approved Noted

Est. Date:

January 15, 2024

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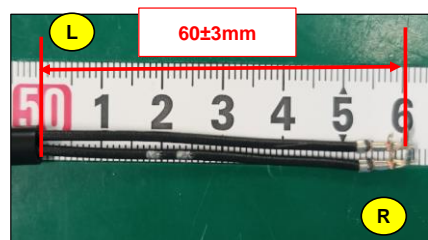
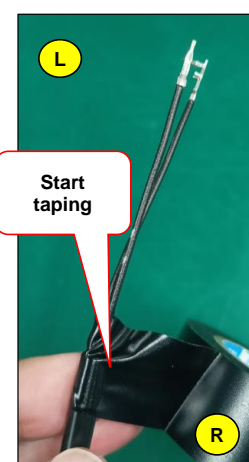

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PARTS:		1. Assy part 2. Black tape 3. Black SV tube (Vinyl) ø4, L=72±3mm		4. AVSSf 0.3 B-B wires L=643±3mm (No slit)		JIG:	n/a
NO.	PROCESS NAME		1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS
2	P2	Wire insertion to Black SV tube (Vinyl) ø4, L=72±3mm	<div></div> <div>1. Get the Black SV tube (Vinyl) ø4, L=72±3mm using right hand then insert the Black wires.</div>		n/a		1. No wrong usage of parts. 2. No deformed terminal
3		Taping 2 Black SV tube (Vinyl) to wire near terminal	<div></div> <div>1. Hold the Black SV tube (Vinyl) using left hand. Measure from end of SV tube (Vinyl) up to edge of hotmelted wires 60±3mm using right hand.</div> <div></div> <div>2. Hold the Black SV tube (Vinyl) using left hand. Get the black tape using right hand and start taping process.</div> <div><div>MEASURING TAPE</div></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 dimension 6. No wrong use of tape		

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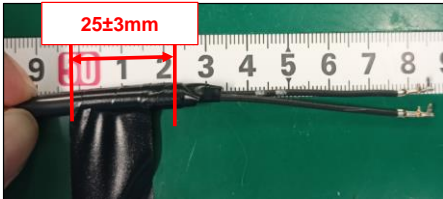
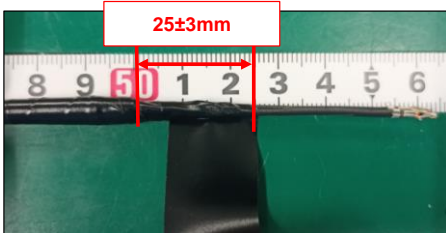
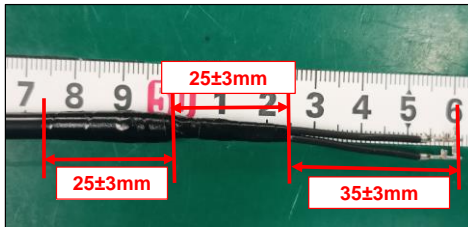

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PARTS:		1. Assy part 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 Taping 2 Black SV tube (Vinyl) to wire near terminal (Continuation)	<div><p>25±3mm</p></div> <div><p>3. Confirm the measurement from end of tape up to end of SV tube (Vinyl) 25±3mm then start taping using both hands.</p></div> <div><p>25±3mm</p></div> <div><p>4. Confirm the measurement from SV tube (Vinyl) up to end of tape 25±3mm then start taping using both hands.</p></div> <div><p>25±3mm 25±3mm 35±3mm</p></div> <div><p>5. After taping, check the measurement and taping condition.</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>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</p>

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PROTOTYPE



PRE-LAUNCH






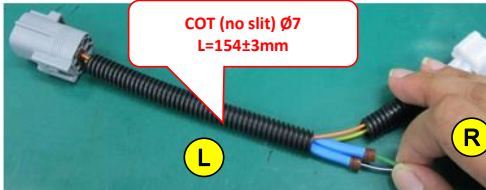
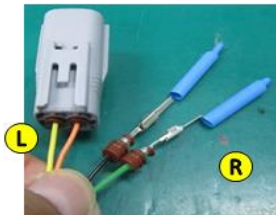

MASSPRO

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PARTS:	1. Assy parts		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	<div>1</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Wire insertion to Black corrugated tube $\varnothing 7$, L=111 \pm 3mm (No slit)	<div><div><div>L</div><div>R</div></div><div><div>L</div><div>R</div></div></div> <div><div>1. Get the MRSW CP (TVSSf 0.3 G-B/W wires L=784\pm3mm) using right hand then insert the terminal cover jig using left hand.</div><div>2. Get the Black corrugated tube $\varnothing 7$, L=111\pm3mm (No slit) using left hand then insert the wires using right hand.</div></div>	<div>TERMINAL COVER JIG</div> 	1. No wrong usage of parts. 2. No deformed terminal
6	P2 Wire insertion to black corrugated tube $\varnothing 7$, L=154 \pm 3mm (No slit) (Assy parts)	<div><div><div>COT (no slit) $\varnothing 7$ L=154\pm3mm</div><div>L</div><div>R</div></div><div><div>L</div><div>R</div></div></div> <div><div>1. Hold the COT (no slit) $\varnothing 7$ L=154\pm3mm using left hand then insert the MRSW CP TVSSf 0.3 G-B/W wires L=784\pm3mm using right hand.</div><div>2. After insertion, remove the cover jig using right hand.</div></div>	<div>TERMINAL COVER JIG</div> 	1. No wrong usage of parts. 2. No deformed termina

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☐ PRE-LAUNCH

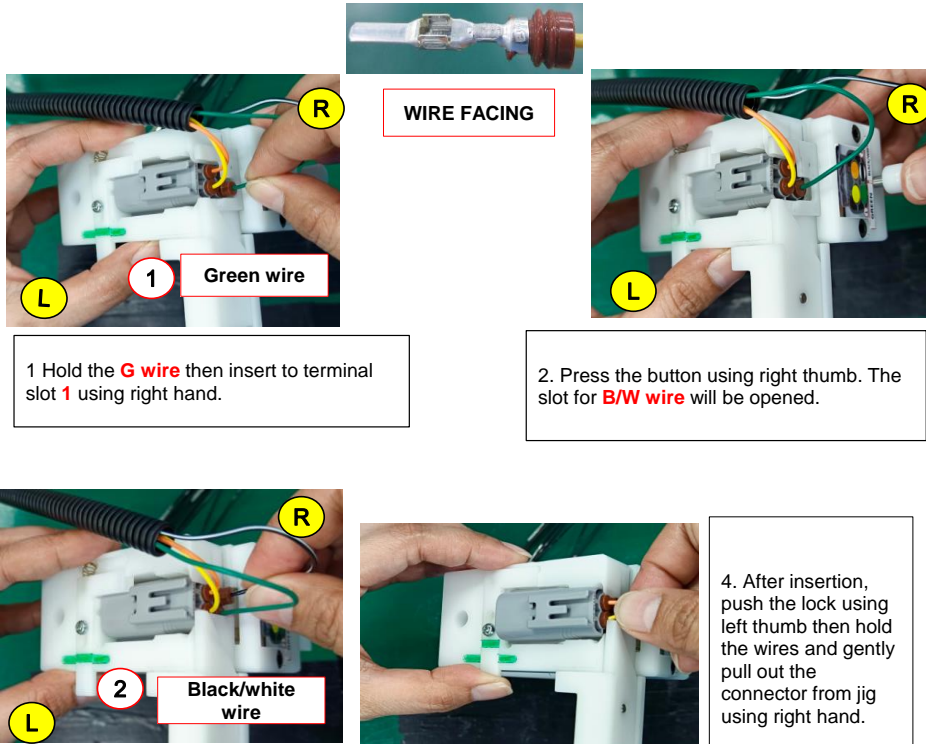
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PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P2	<div>Wire insertion to connector 6188-0066 (GR) (Assy parts)</div> <div><p>1 Hold the G wire then insert to terminal slot 1 using right hand.</p><p>2 Press the button using right thumb. The slot for B/W wire will be opened.</p><p>3 Hold the B/W wire then insert to terminal slot 2 using right hand.</p><p>4 After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</p></div>			<p>Important reminders/Note/s:</p> <ul style="list-style-type: none">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>Document references:</p> <ul style="list-style-type: none">1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. <ul style="list-style-type: none">1. No loose insertion2. No wrong insertion3. One by one insertion4. No deformed terminal5. No wrong wire facing

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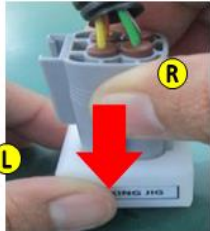
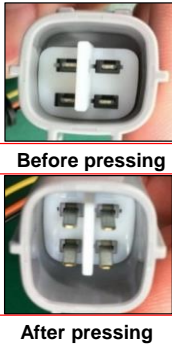
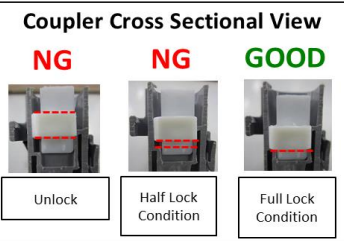


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PARTS:		1. Assy parts 2. AVSSf 0.3 B-B wires L=643±3mm (No slit), 3. Black Corrugated tube (no slit) Ø5, L=132±3mm		JIG:	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	Connector lock	 1. Put the connector into locking jig using both hands and then press 2x . Check the connector if properly locked.  Coupler Cross Sectional View NG NG GOOD 			Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR 1. No wrong usage of parts. 2. No deformed terminal
9	P2 Wire insertion to Assy parts (2)	 1. Hold the assy parts using left hand, Get the B-B wires using left hand then insert to COT (no slit) Ø7 L=391±3mm (Assy parts) using right hand.		n/a	1. No wrong usage of parts. 2. No deformed terminal

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PARTS:

n/a

JIG:

n/a



QUALITY CHECKPOINTS

P2

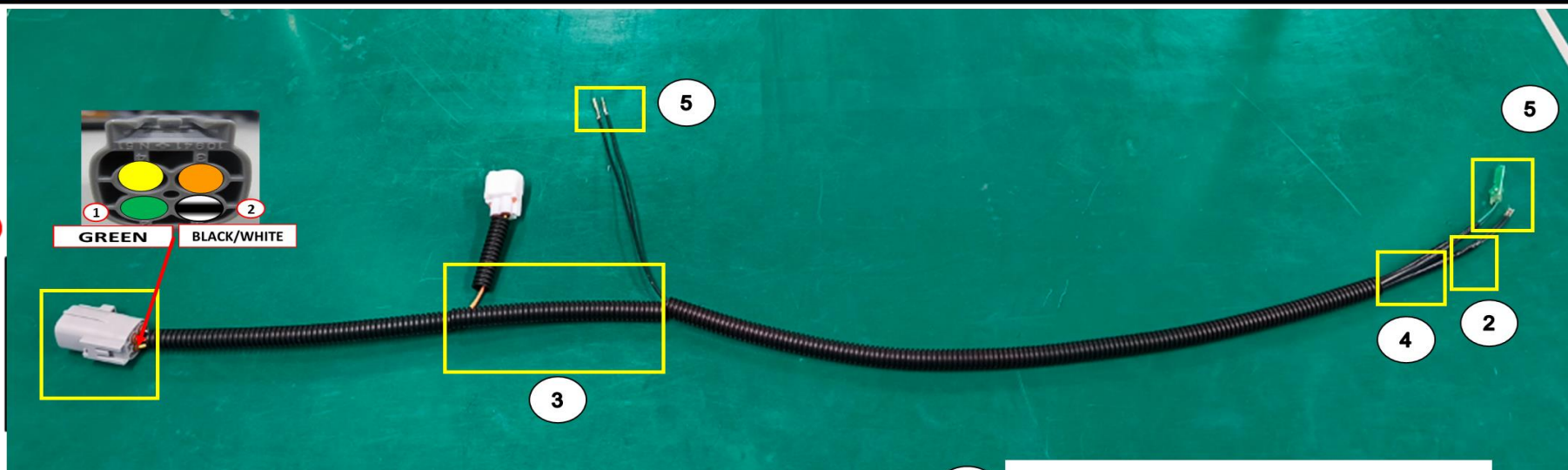
7N0205-7020A



NO GOOD



GOOD



1 No WRONG INSERT
No UNLOCK/HALF-LOCKED
No TBO

2 No MISSING TAPE

3 No MISSING COT

4 No MISSING SV TUBE (VINYL)

5 No DEFORMED TERMINAL/PCB

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