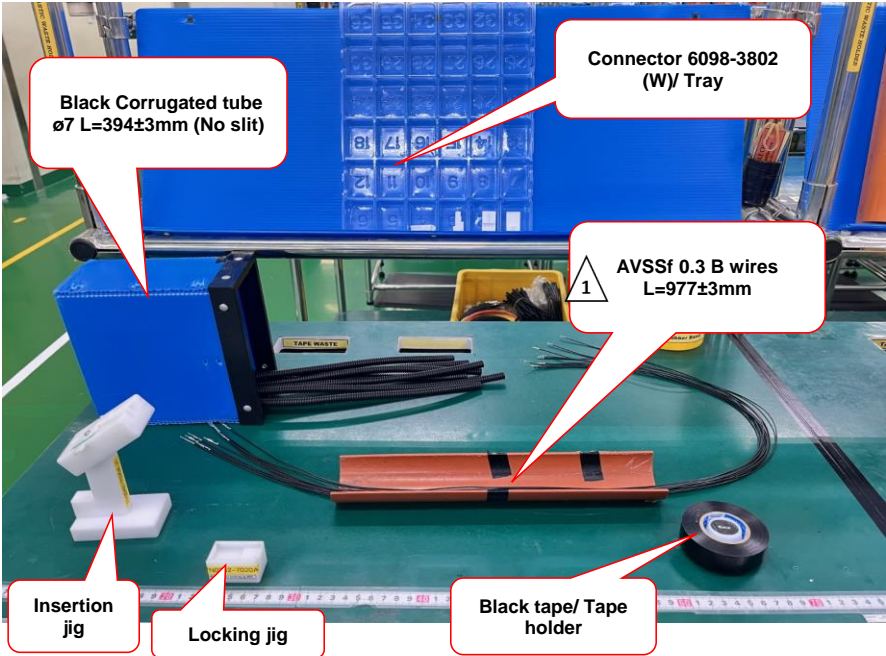





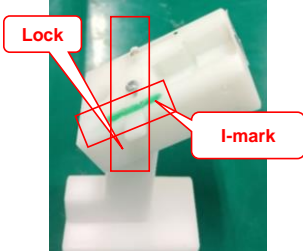
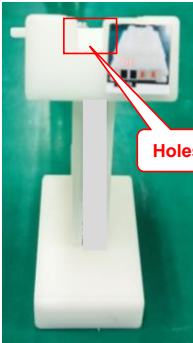
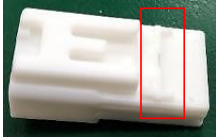
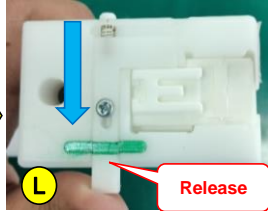
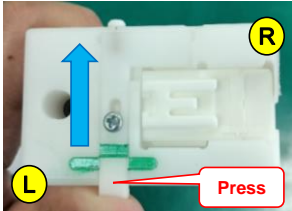
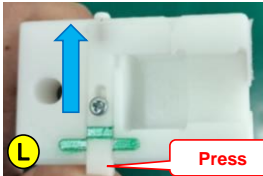

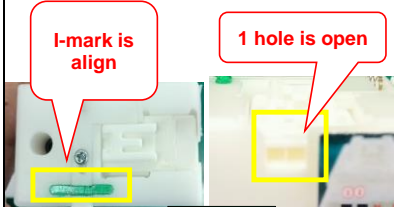
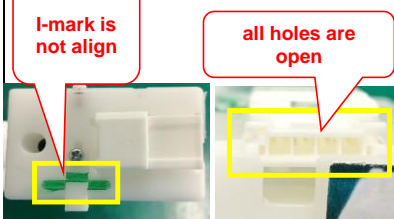
	WORK INSTRUCTION				Effectivity Date: May 05, 2025	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date: n/a	
	Model code/Part number: 559D / 7N0242-7020B		Customer: TRJ	Car Model: TOYOTA HI-ACE	Document No.: WI-ENG-PDE-1250A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: 1		Page No.: 1	of 6

PARTS: 1	1. AVSSf 0.3 B L=977±3mm 2. Black Corrugated tube ø7 L=394±3mm (No slit)		3. Connector 6098-3802 (W) 4. Black tape		JIG:	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
1	P1	<div style="text-align: center;"> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;">TABLE LAY-OUT</div>  </div>			<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px solid red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	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	Checked by	Reviewed by	Approved by	
05/05/25	1	Change from pre-launch to masspro. Aligned wire length based on Cutting ledger from L=975±3mm to 977±3mm. Change dimension from L=575±3mm to 577±3mm.	D.Castillo	J. Loterte	C.Villanueva	 D. Castillo	 J. Loterte	 C. Villanueva	 A. Arañes	
04/16/25	0	Initial issue.	D.Castillo	J. Loterte	C.Villanueva					A. Arañes
Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed					Approved

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	WORK INSTRUCTION			Effectivity Date:	May 05, 2025		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 559D / 7N0242-7020B		Customer: TRJ	Car Model: TOYOTA HI-ACE	Document No.: WI-ENG-PDE-1250A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	2 of 6

PARTS:	1. Connector 6098-3802 (W)			JIG:	1. Insertion jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
2	P1 Connector Setting to insertion jig 6098-3802 (W)	<div><div>INSERTION JIG</div><div>CONNECTOR ORIENTATION</div><div>INSERTION JIG ORIENTATION</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 then release the lock.</div><div>3. Check the holes/terminal slot for B-B wires.</div></div>			n/a	<div>CONNECTOR ORIENTATION ILLUSTRATION</div> <div>GOOD</div> <div>NG</div> <div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div>		

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 05, 2025

Process Name/Title:

Model code/Part number:

559D / 7N0242-7020B

Customer: TRJ

Car Model: TOYOTA HI-ACE

Document No.:

WI-ENG-PDE-1250A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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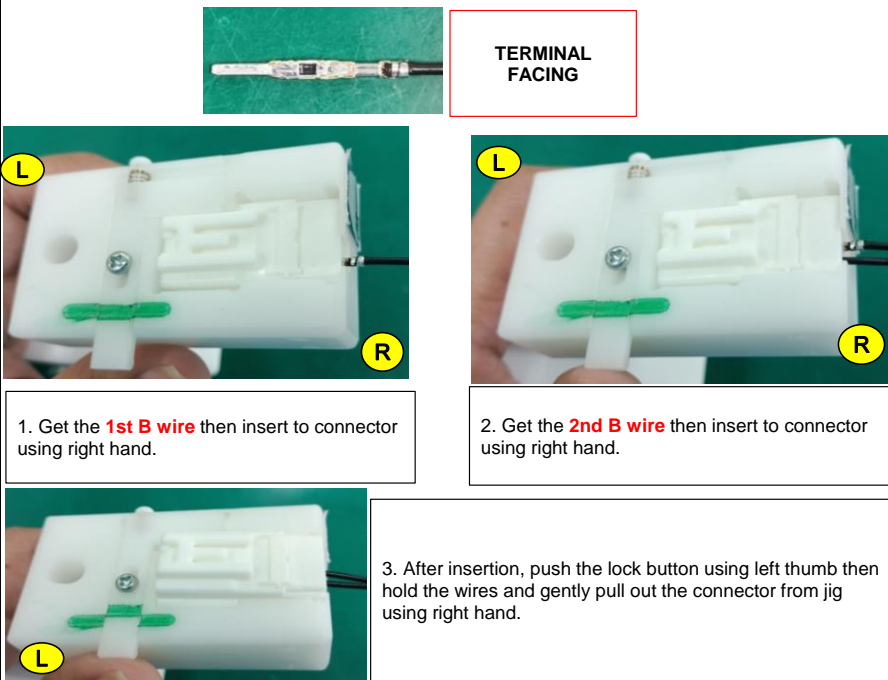
PARTS:

1

1. AVSSf 0.3 B L=977±3mm [2pcs]
2. Black Corrugated tube $\phi 7$ L=394±3mm (No slit)

JIG:

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to Black Corrugated tube $\phi 7$ L=394±3mm (No slit)	 <p>1. Get the Black corrugated tube (no slit) $\phi 7$ L=394±3mm using left hand and get 2pcs of Black wire using right hand then insert.</p>	n/a	Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 1. No wrong usage of parts 2. No deformed terminal
4	Wire Insertion to Connector 6098-3802 (W)	 <p>TERMINAL FACING</p> <p>1. Get the 1st B wire then insert to connector using right hand.</p> <p>2. Get the 2nd B wire then insert to connector using right hand.</p> <p>3. After insertion, push the lock button using left thumb then hold the wires and gently pull out the connector from jig using right hand.</p>	n/a	Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance Important reminders/note/s: 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing

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WORK INSTRUCTION

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TAPING ASSEMBLY PROCESS

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559D / 7N0242-7020B

Customer:

TRJ

Car Model:

TOYOTA HI-ACE

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Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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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



1. Load the connector into the jig holding both side of the connector, tip first.



2. Press the lower part of connector to fully insert into the locking jig.



Right thumb-Lower
Left thumb-middle

3. Press the lower parts of connector using right hand while left hand holding the middle.



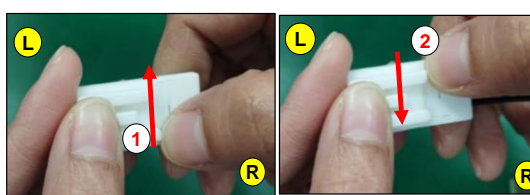
Right thumb-upper
Left thumb-middle

4. Press the upper part of connector using right hand while left hand holding the middle.



Right thumb-middle
Left thumb-middle

5. Lift then press the connector in the middle using left and right hand.



6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.

LOCKING JIG



1. No Unlock and half-locked
2. Use provided jig tools per model to avoid damaged lock.

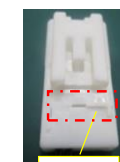
Important reminders/note/s:

1. MANUAL LOCKING MAY CAUSED DAMAGED LOCK
2. Use provided jig tool per model to avoid damaged lock.



GOOD


NG

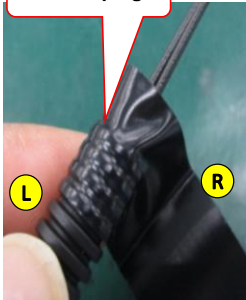

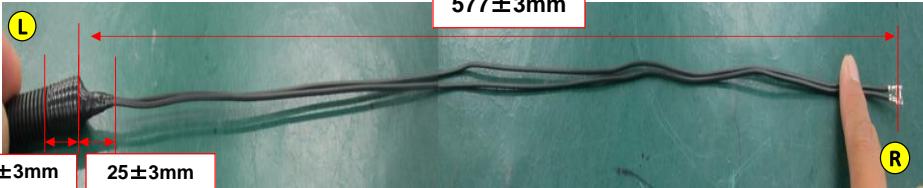
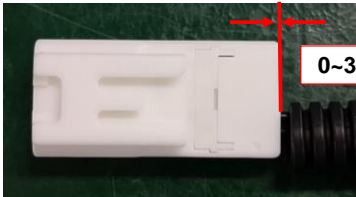



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	WORK INSTRUCTION				Effectivity Date:	May 05, 2025		
	TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Process Name/Title:		Model code/Part number: 559D / 7N0242-7020B	Customer: TRJ	Car Model: TOYOTA HI-ACE	Document No.:	WI-ENG-PDE-1250A	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:

PARTS:		1. Assy part 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	1	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1 Taping 1 Corrugated tube to wire near terminal	<div><div><p>Start taping</p></div><div><p>577±3mm</p></div><div><p>1. Hold the COT using left hand, get the Black tape using right hand then initially start pre-taping at the middle of COT and wire.</p><p>2. Measure from end of COT up to terminal pointed tip 577±3mm then continue the taping process using both hands.</p></div><div><p>577±3mm</p><p>25±3mm 25±3mm</p></div><div><p>0~3mm</p><p>3. After taping, check the measurement, taping condition and wire alignment.</p></div></div> <div><p>MEASURING TAPE</p></div>			<div><p>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</p><p>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p><p>Document reference/s: 1. Refer to WI-PRO-ASY-001A for taping procedure.</p></div>

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**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 05, 2025

Validity Date:

n/a

Model code/Part number:

559D / 7N0242-7020BCustomer: **TRJ**

Car Model:

TOYOTA HI-ACE

Document No.:

WI-ENG-PDE-1250A

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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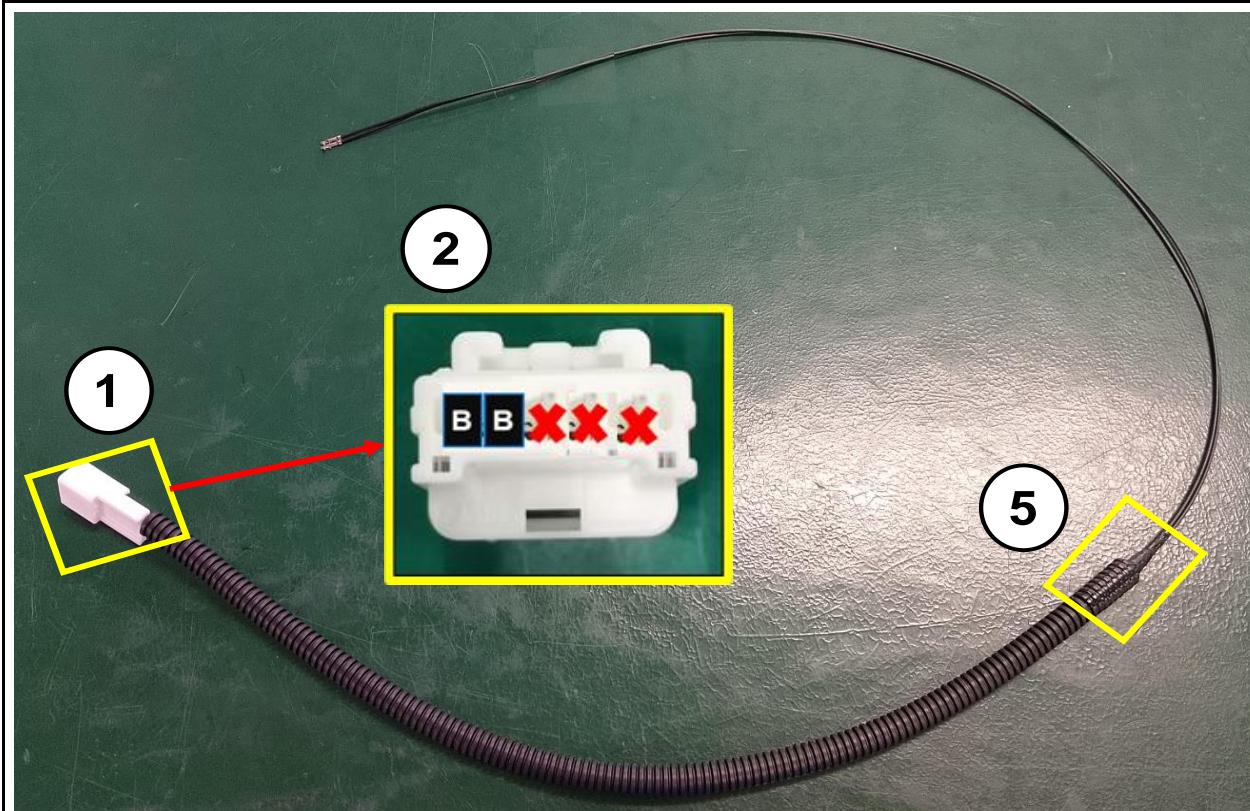
6 of 6

PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P1****7N0242-7020B**

- ① No Unlocked/
Half-locked connector
- ② No Wrong insert
- ③ No Deformed terminal
- ④ No Terminal Backing
out
- ⑤ No Missing tape

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