



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

February 16, 2024

Process Name/Title:

Model code/Part number:

310D / 7N0201-7020A

Customer: TRJ

Car Model: TOYOTA RAV 4

Validity Date:

n/a

Document No.:

WI-ENG-PDE-834

Purpose:

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Revision No.:

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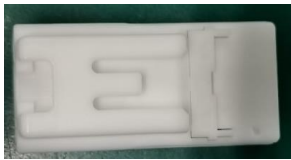


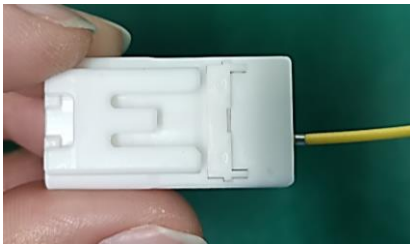
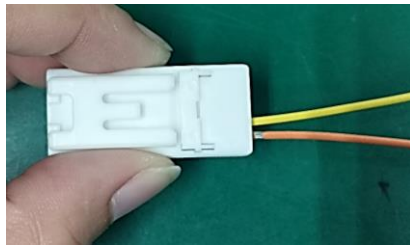
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PARTS:

1. Connector 6098-3802 (W)
2. AVSSf 0.3 wires Y-OR L=713±3mm

JIG:

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	n/a Wire Insertion to Connector 6098-3802 (W)	<div><p>Connector orientation</p></div> <div><p>VISUAL REFERENCE</p></div> <div><p>Wire facing</p></div> <div><p>1. Hold the connector 6098-3802 (W) then get the Yellow wire and insert to terminal slot 2 using right hand. Conduct 2x push-pull after wire insertion.</p></div> <div><p>2. Get the Orange wire and insert to terminal slot 1 using right hand. Conduct 2x push-pull after wire insertion.</p></div>	<div><p>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p></div> <div><p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p></div> <div><p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p></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. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. 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>

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	Prepared by	Reviewed by	Approved by	Noted by
02/16/24	0	Initial issue.	A.Hernandez	C.Villanueva	A. Arañes	n/a		A.Hernandez	C.Villanueva	A.Arañes	n/a
February 16, 2024											

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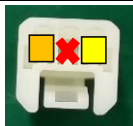
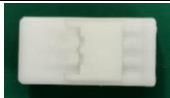

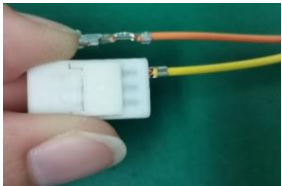

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PARTS:	1. Assy parts 2. Black Corrugated tube ø5 L=366±4mm (no slit) 3. Black Corrugated tube ø5 L=278±3mm (no slit) 4. Connector 6098-2220 (W)			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire Insertion to Black Corrugated tube ø5 L=366±4mm (no slit)	 <div>1. Get the Black corrugated tube ø5 L=366±4mm (no slit) using left hand and get Y-OR wires using right hand then insert.</div>		n/a	1. No wrong usage of parts. 2. No deformed terminal
3	Wire Insertion to Black Corrugated tube ø5 L=278±3mm (no slit)	 <div>1. Get the Black corrugated tube ø5 L=278±3mm (no slit) using left hand and get Y-OR wires using right hand then insert.</div>		n/a	1. No wrong usage of parts. 2. No deformed terminal
4	Wire Insertion to Connector 6098-2220 (W)	   <div>Wire facing</div>   <div>1. Hold the connector 6098-2220 (W) then get the Yellow wire and insert to terminal slot 3 using right hand. Conduct 2x push-pull after wire insertion.</div> <div>2. Get the Orange wire and insert to terminal slot 1 using right hand. Conduct 2x push-pull after wire insertion.</div>		n/a	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. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing

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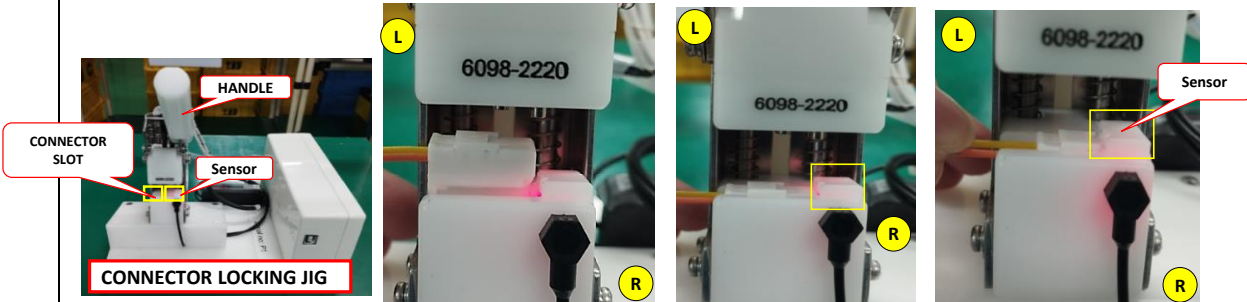
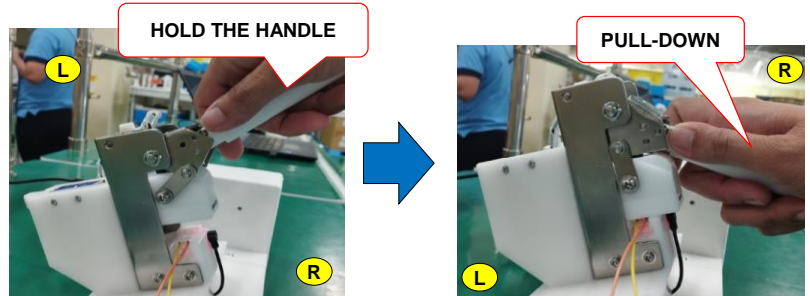
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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	n/a	Connector lock	<div><p>1. Hold the assy parts using left hand and insert into connector locking jig based on the direction of 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>2. 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></div>		<div>1. Maintain 10mm proper holding of wire to terminal. 2. Connector must be fully insert in connector slot. 3. Follow proper orientation of connector 4. Removal of locked connector must be sideways</div>

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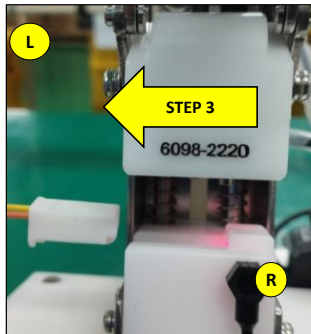
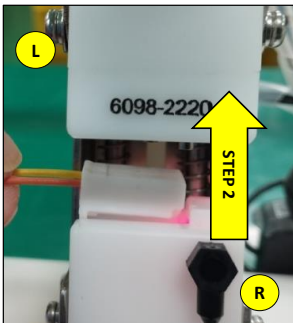

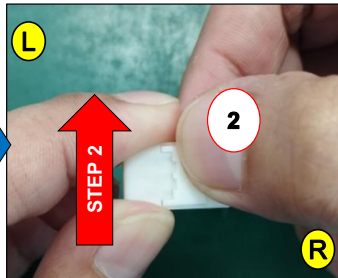
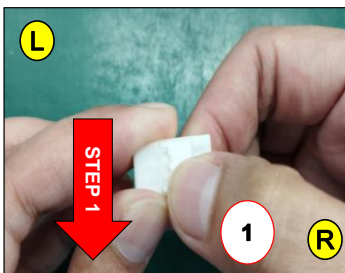
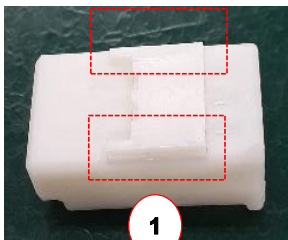
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	n/a	Connector lock (Continuation)	<div><p>3. Remove the locked connector using left hand based on the illustration, follow the direction of arrow.</p><p>4. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated</p></div>		<p>1. Maintain 10mm proper holding of wire to terminal. 2. Connector must be fully insert in connector slot. 3. Follow proper orientation of connector 4. Removal of locked connector must be sideways</p>

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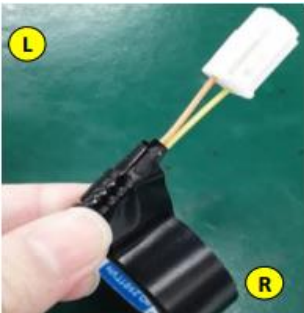

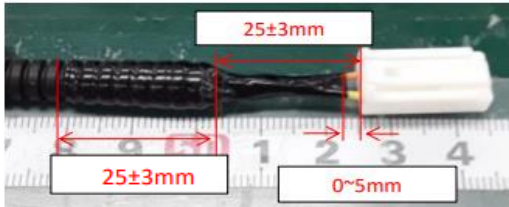

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	n/a Taping 1 Black Corrugated tube to wire near connector	 <p>1. Hold the assy parts using left hand. Get Black tape using right hand and start pre-tape.</p>  <p>2. Measure from COT to Connector 25±3mm usinf both hands and continue the taping process.</p>  <p>3. Check the measurement and taping condition after taping.</p>			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. Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.

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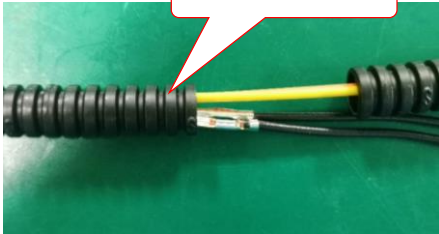
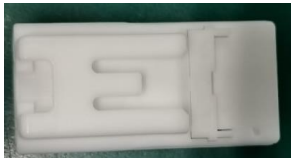
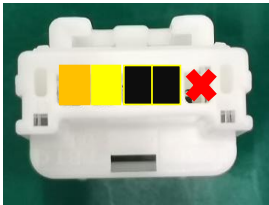
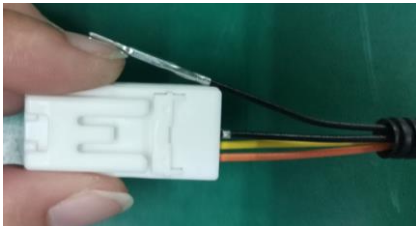

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PARTS:		1. Assy parts 2. AVSSf 0.3 wires B-B L=794±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	Wire insertion to Assy parts	<div><div></div><div><p>1. Hold the corrugated tube (no slit) Ø5 L=366±4mm using left hand then insert the B-B wire using right hand.</p></div></div>		n/a	1. No wrong use of parts 2. No deformed terminal 3. No wrong use of insertion
9	n/a Wire insertion to Connector 6098-3802 (W)	<div><div><p>Connector orientation</p></div><div><p>Wire facing</p></div><div></div><div><p>1. Hold the connector 6098-3802 (W) then get the Black wire and insert to terminal slot 3 using right hand. Conduct 2x push-pull after wire insertion.</p></div><div></div><div><p>2. Hold the connector 6098-3802 (W) then get the Black wire and insert to terminal slot 4 using right hand. Conduct 2x push-pull after wire insertion.</p></div></div>		n/a	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. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. 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.

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PARTS:	1. Assy parts			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	n/a	Connector lock		<div>LOCKING JIG</div> 	<p>Important reminders/Note/s:</p> <p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <p>1. Use the provided jig per connector 2. No unlock/half-locked connector</p>

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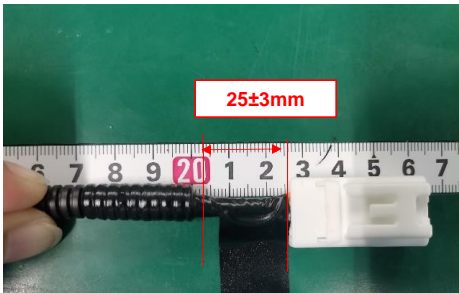
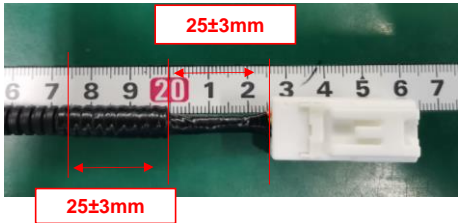

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PARTS:		1. Assy parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	n/a Taping 2 Black Corrugated tube to wire near connector	 <p>1. Hold the assy parts using left hand. Get Black tape using right hand and start pre-taping.</p>  <p>2. Measure from COT to Connector 25±3mm using both hands and continue the taping process.</p>  <p>3. Check the measurement and taping condition after taping.</p>			<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 use of tape 6. No wrong dimension</p>

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PARTS:		1. Assy parts 2. Black Corrugated tube (no slit) $\phi 5$ L=260 \pm 3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
12	n/a	<div><div></div><div></div><div></div></div> <div>1. Get the terminal cover jig using right hand and insert the Black wires using left hand.</div> <div>2. Get the Black Corrugated tube (no slit) $\phi 5$ L=260\pm3mm using right hand and insert the wires using left hand.</div> <div>3. After insertion, remove the terminal cover jig using right hand.</div>		<div>TERMINAL COVER JIG</div> <div></div>	1. No wrong use of parts 2. No deformed terminal

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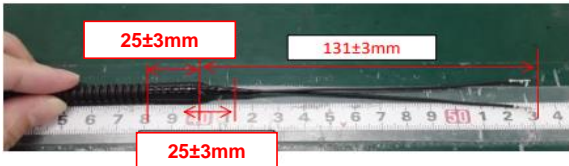

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PARTS:		1. Assy parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
13	n/a Taping 3 Black Corrugated tube to wire near terminal	 <p>1. Hold the assy parts using left hand. Get Black tape using right hand and start pre-taping.</p>  <p>2. Measure from COT to wire near terminal 131±3mm using both hands and continue the taping process.</p>  <p>3. Check the measurement and taping condition after taping.</p>		MEASURING TAPE 	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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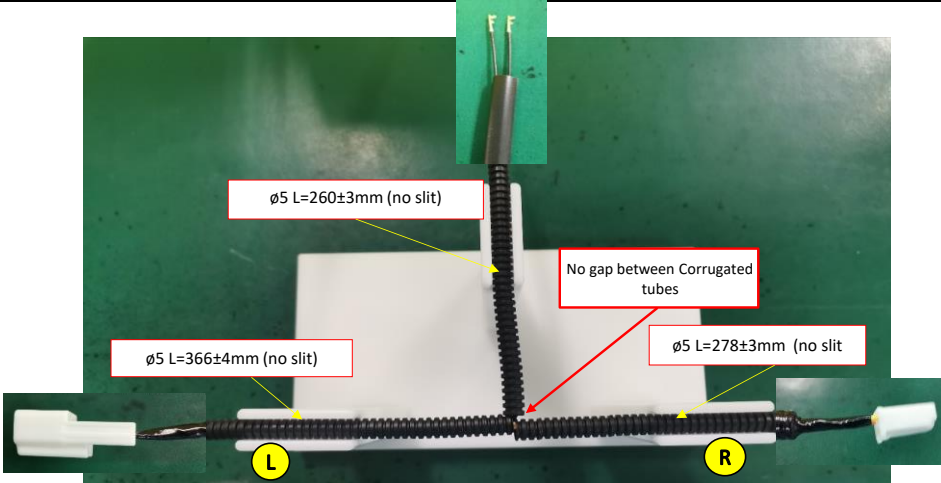
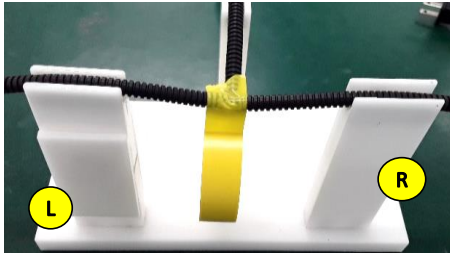

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PARTS:		1. Assy parts 2. Black Tape		JIG:	1. T-Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
14	n/a T-Taping	<div><p>1. Arrange the 3 corrugated tube to form inverted T using left and right hand.</p><p>2. Start taping at the middle to fix the 3 corrugated tubes using both hands.</p><p>3. Wind the tape from front to back at the right side.</p></div>		n/a	<p>Important reminders/Note/s:</p> <p>1. Use <u>YELLOW TAPE</u> for easy visualization of shifting lines, but actual should be <u>BLACK TAPE</u>.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No gap between the COT 5. No exposed wire</p>

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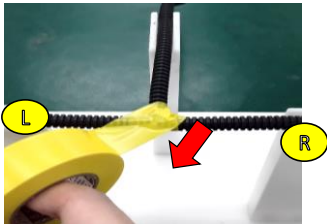
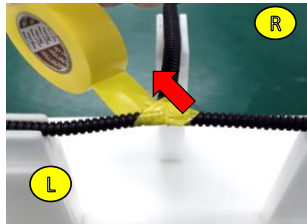
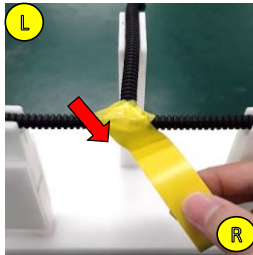
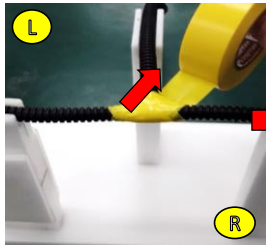
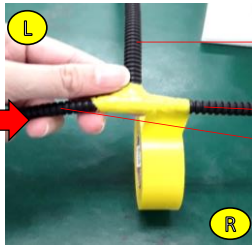


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PARTS:		1. Assy parts 2. Black Tape		JIG:	1. T-Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
14	n/a T-Taping (Continuation)	<div><div></div><div><p>4. Wind the tape from back to front (cross pattern)</p></div><div></div><div><p>5. Wind the tape from front to back at the left side</p></div><div></div><div><p>6. Wind the tape from back to front (cross pattern)</p></div><div><p>7. Repeat the process from ③~⑥ 3 times</p></div><div></div><div></div><div></div><div></div><div><p>8. Remove the harness for T-taping jig then tape the right side corrugated tube (3 winds), width must be (25mm)</p></div></div>		n/a	<p>Important reminders/Note/s:</p> <p>1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No gap between the COT 5. No exposed wire</p>

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

Effectivity Date:

February 16, 2024

Process Name/Title:

Model code/Part number:

310D / 7N0201-7020A

Customer: TRJ

Car Model: TOYOTA RAV 4

Validity Date:

n/a

Document No.:

WI-ENG-PDE-834

Purpose:

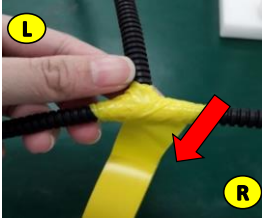
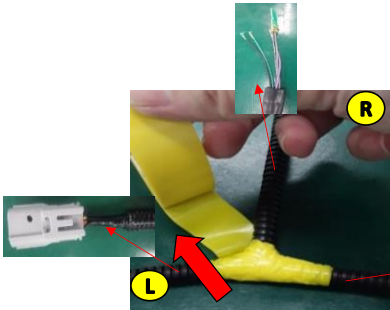
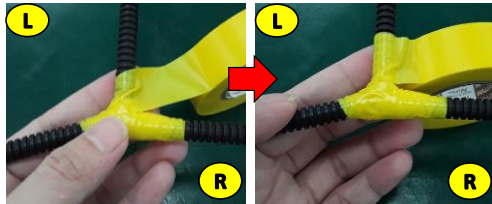
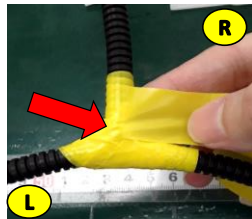
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PARTS:		1. Assy parts 2. Black Tape		JIG:	1. T-Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
14	n/a T-Taping (Continuation)	<div><p>9. From the right side, wind the tape 2/3 shifting going to center</p></div> <div><p>10. Wind the tape from front to back side (cross pattern)</p></div> <div><p>11. Tape the top side corrugated tube (3 winds), width must be (25mm)</p></div> <div><p>12. From the top side, wind the tape 2/3 shifting going to center</p></div>		n/a	<p>Important reminders/Note/s:</p> <p>1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No gap between the COT 5. No exposed wire</p>

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310D / 7N0201-7020A

Customer: TRJ

Car Model: TOYOTA RAV 4

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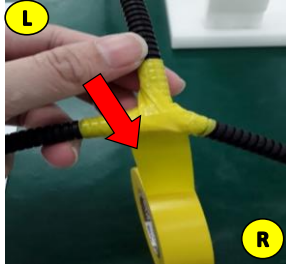
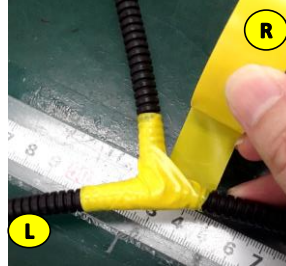
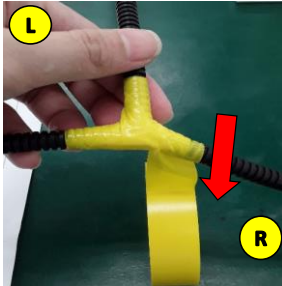
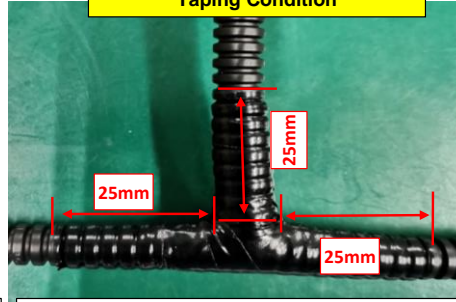
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PARTS:		1. Assy parts 2. Black Tape		JIG:	1. T-Taping jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
14	n/a T-Taping (Continuation)	<div></div> <div></div> <div></div> <div></div> <div>13. Wind the tape going to front side (cross pattern)</div> <div>14. Wind the tape from front to back side (cross pattern)</div> <div>15. Tape the right side corrugated tube (3 winds), width must be (25mm)</div> <div>16. After taping, check the measurement and condition of tape.</div>		n/a	<p>Important reminders/Note/s:</p> <p>1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No gap between the COT 5. No exposed wire</p>

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Car Model:

TOYOTA RAV 4

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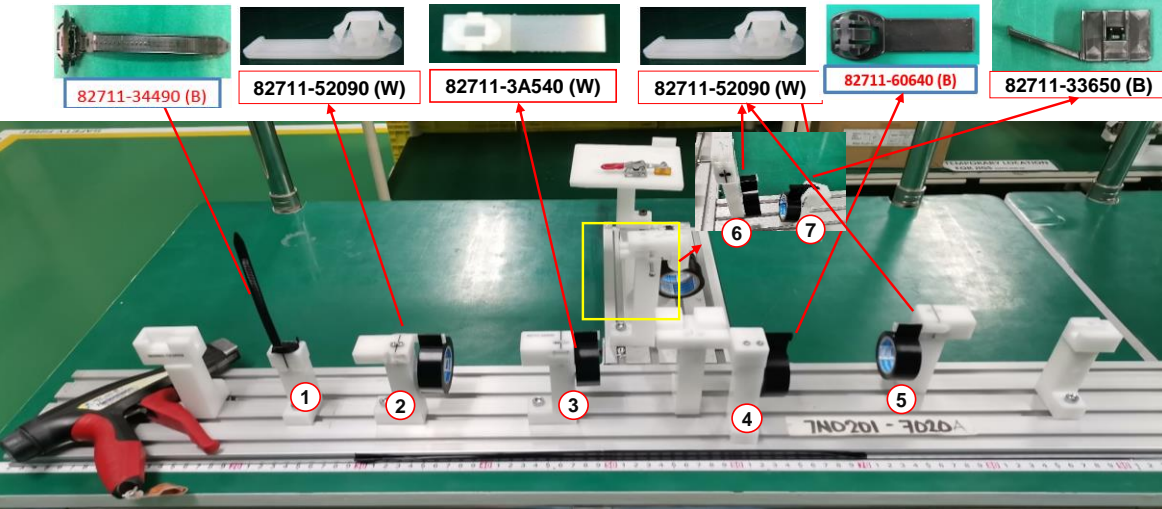
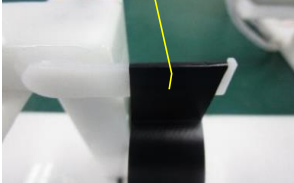

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PARTS:	1. Assy parts 2. Clamp 82711-52090 (W) [3 pcs.] 3. Clamp 82711-3A540 (W)	4. Clamp 82711-60640 (B) 5. Clamp 82711-33650 (B) 7. Clamp 82711-34490 (B) 6 Black tape [6 pcs.]	JIG:	1. Temporary jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
15	n/a Clamp Assembly Jig	 <div>1. Get 1pc. of clamp 82711-34490 (B) using right hand and set to clamp location 1 using both hands.</div> <div>2. Get 2pcs. of clamp 82711-52090 (W) using right hand and set to clamp location 2, 5 and 6 using both hands.</div> <div>3. Get 1pc. of clamp 82711-3A540 (W) using right hand and set to clamp location 3 using both hands.</div> <div>4. Get 2pcs. of clamp 82711-60640 (B) using right hand and set to clamp location 4 using both hands.</div> <div>5. Get 1pcs. of clamp 82711-33650 (B) using right hand and set to clamp location 7 using both hands.</div> <div>6. Initially attach Black tape to clamp location 2, 3, 4, 5, 6, and 7 using both hands.</div>		<div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div> <div>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div> <div> One side tape under clamp</div> <div> CLAMP ILLUSTRATION GOOD NG 82711-52090 (W) 82711-12A80 (W)</div>

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WORK INSTRUCTION

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Purpose:

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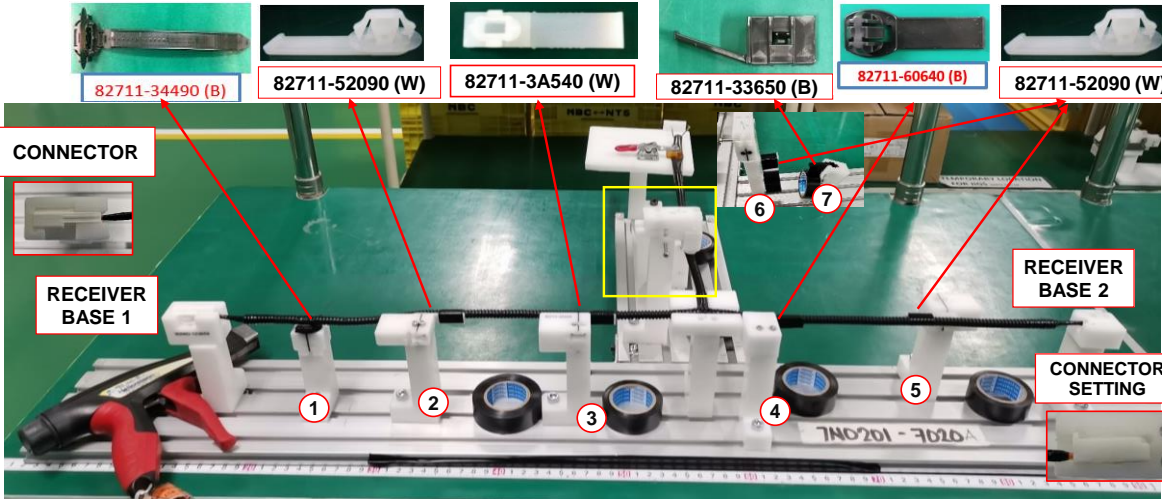
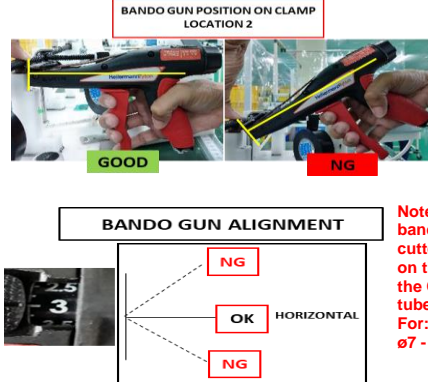
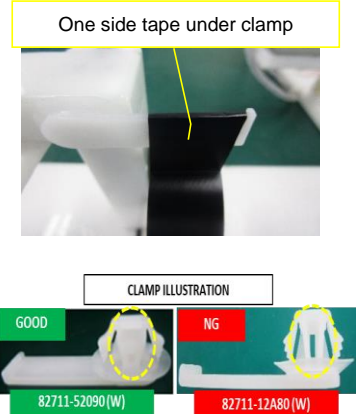
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PARTS:		1. Assy parts		JIG:	1. Temporary jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
16	n/a	Clamp Assembly Jig	<div></div> <div><p>1. Put the assy into jig. (<i>See above picture for the correct setting</i>). First, set the connector 6098-3802 (W) to Receiver base 1. Second, set the next connector 6098-2220 (W) to Receiver base 2. Continue to set the harness in jig. Last, set the B-B wires together within stopper then press by toggle clamp.</p><p>2. Initially tighten the band clamp on location 1 using both hands. Continue to clamp location 2.</p><p>3. Hold the tape on clamp location 2, make 3 windings of tape then cut the tape using both hands. Continue to clamp location 3.</p></div> <div><p>BANDO GUN POSITION ON CLAMP LOCATION 2</p><p>BANDO GUN ALIGNMENT</p><p>GOOD, NG, OK, NG, HORIZONTAL</p><p>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1-2, ø7 - 3-4</p></div>		<div><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><p>Important reminders/Note/s:</p><p>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp. 2. Make sure no gap between terminal and stopper jig</p><p>One side tape under clamp</p></div>

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WORK INSTRUCTION

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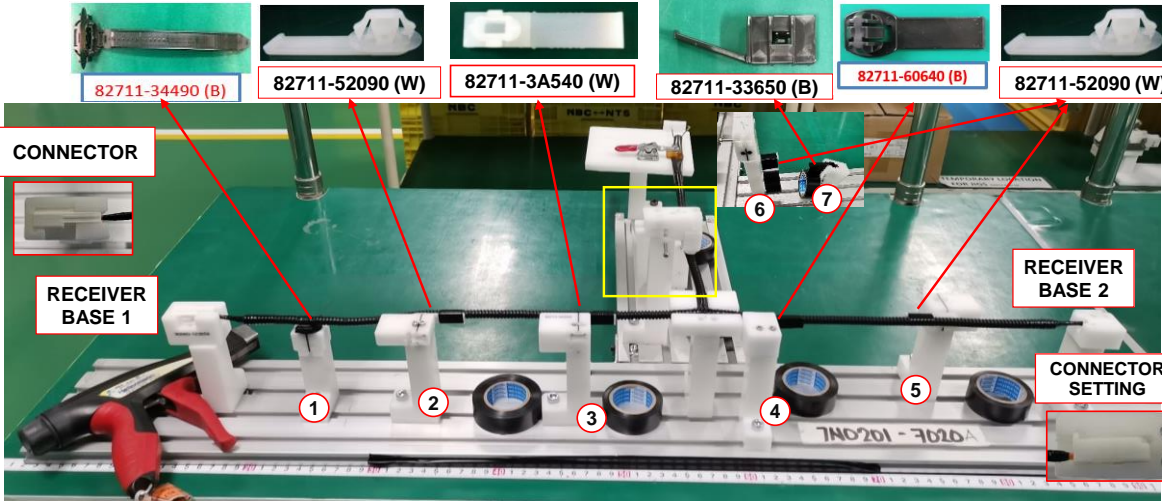
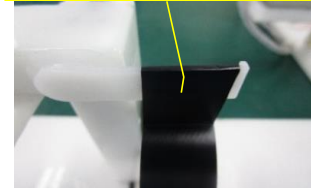
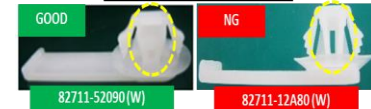
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PARTS:		1. Assy parts		JIG:	1. Temporary jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
16	n/a	<div>Clamp Assembly Jig (Continuation)</div>  <div>4. Hold the tape on clamp location 3, make 3 windings of tape then cut the tape using both hands. Continue to clamp location 4.</div> <div>5. Hold the tape on clamp location 4, make 3 windings of tape then cut the tape using both hands. Continue to clamp location 5.</div> <div>6. Hold the tape on clamp location 5 make 3 windings of tape then cut the tape using both hands. Continue to clamp location 7.</div> <div>7. Hold the tape on clamp location 7, make 3 windings of tape then cut the tape using both hands.</div> <div>8. Conduct POINT CHECKING before removing the harness from jig.</div>			<div>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</div> <div>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp. 2. Make sure no gap between terminal and stopper jig</div> <div>One side tape under clamp</div>  <div>CLAMP ILLUSTRATION</div> 

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

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310D / 7N0201-7020A

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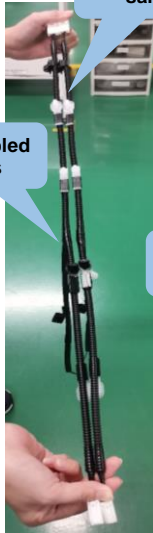
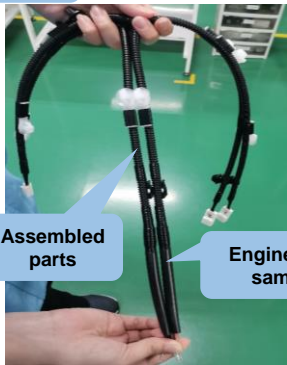





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PARTS:		1. Assembled parts 2. Engineering sample		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
17	n/a	<div><div>Visual/By two's inspection</div><div><div><div><div><div></div><div><div><div><div><div></div><div><div><div><div><div></div><div><div><div><div><div></div><div><div><div><div><div></div><div><div><div><div><div></div><div><div><div><div><div></div></div></div></div></div></div></div></div></div><div><div>1. Conduct alignment of harness (Engineering sample vs. Assembled parts) using both hands.</div><div>2. Check the terminal and lock condition.</div><div>3. Check the Insertion and taping condition.</div></div></div></div></div></div></div></div></div></div></div></div></div></div></div></div></div></div></div></div></div></div></div>		<div><div>ENGINEERING SAMPLE</div><div></div></div> <div>1. No skip checking during inspection</div>	

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Car Model: TOYOTA RAV 4

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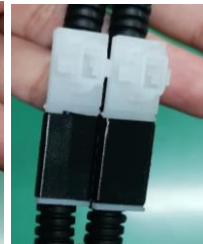

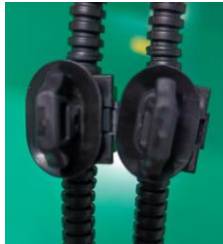



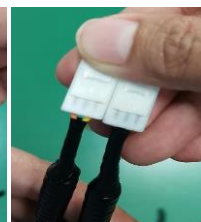
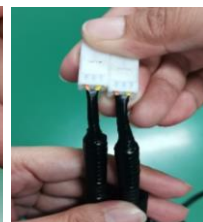






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PARTS:		1. Assembled parts 2. Engineering sample		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
17	n/a	Visual/By two's inspection (Continuation)	<div></div> <div>4. Check the presence of clamp attachment and taping condition.</div>	<div></div> <div>5. Check the T-Taping condition.</div>	<div>ENGINEERING SAMPLE</div>  1. No skip checking during inspection
			<div></div> <div>6. Check the presence of clamp attachment and taping condition.</div> <div></div> <div>7. Check the Insertion, connector lock and taping condition.</div> <div>8. Check the presence of clamp attachment and taping condition.</div>	<div></div> <div>9. Check the Taping condition. Conduct slightly bending to avoid overlook of missing tape.</div> <div></div> <div>10. Check the terminal. Must no deformed terminal.</div>	

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Process Name/Title:

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310D / 7N0201-7020ACustomer: **TRJ**Car Model: **TOYOTA RAV 4**

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

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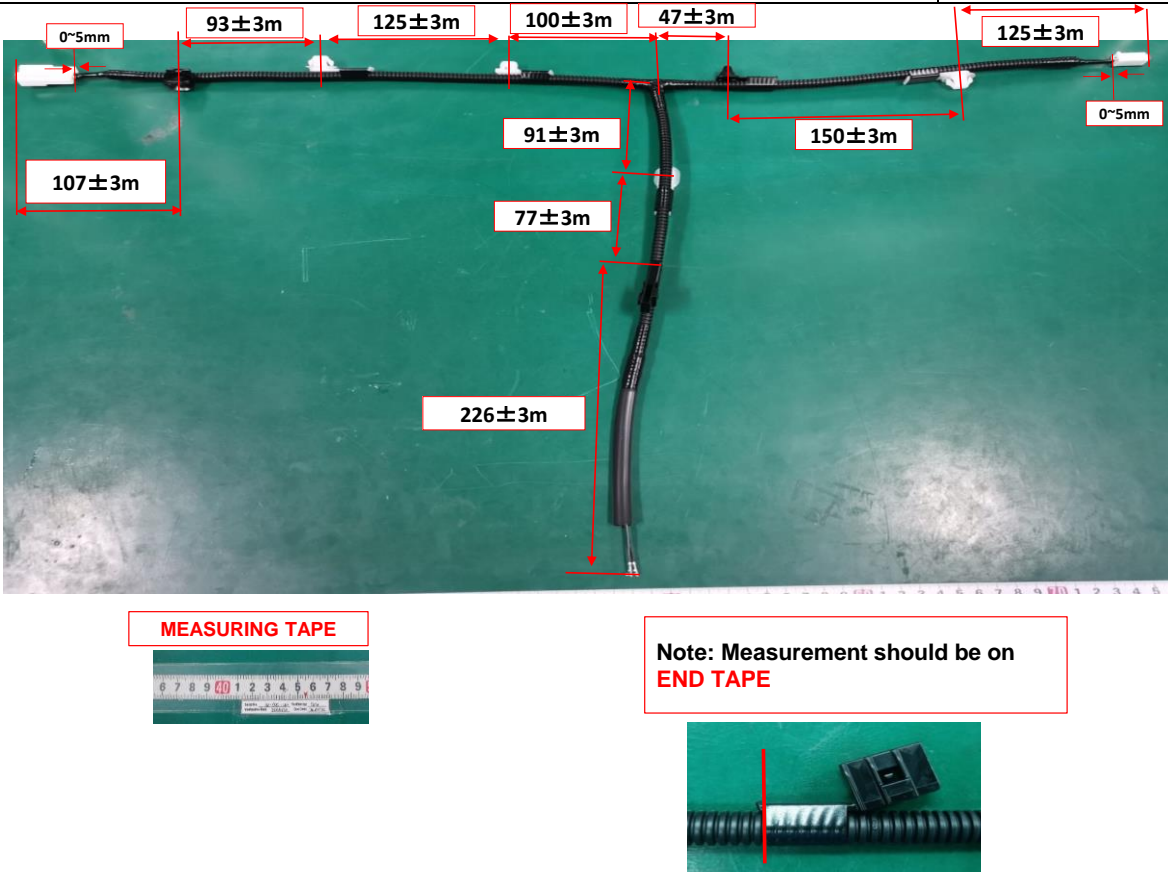
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PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
18	n/a	Measurement	<div></div>	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub assembly Hatsomono, Nakamono, and Owarimono Inspection.</p> <p>1. No wrong dimension</p>

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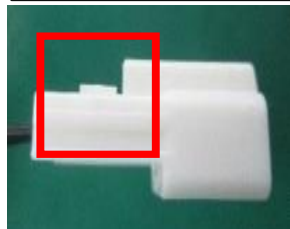
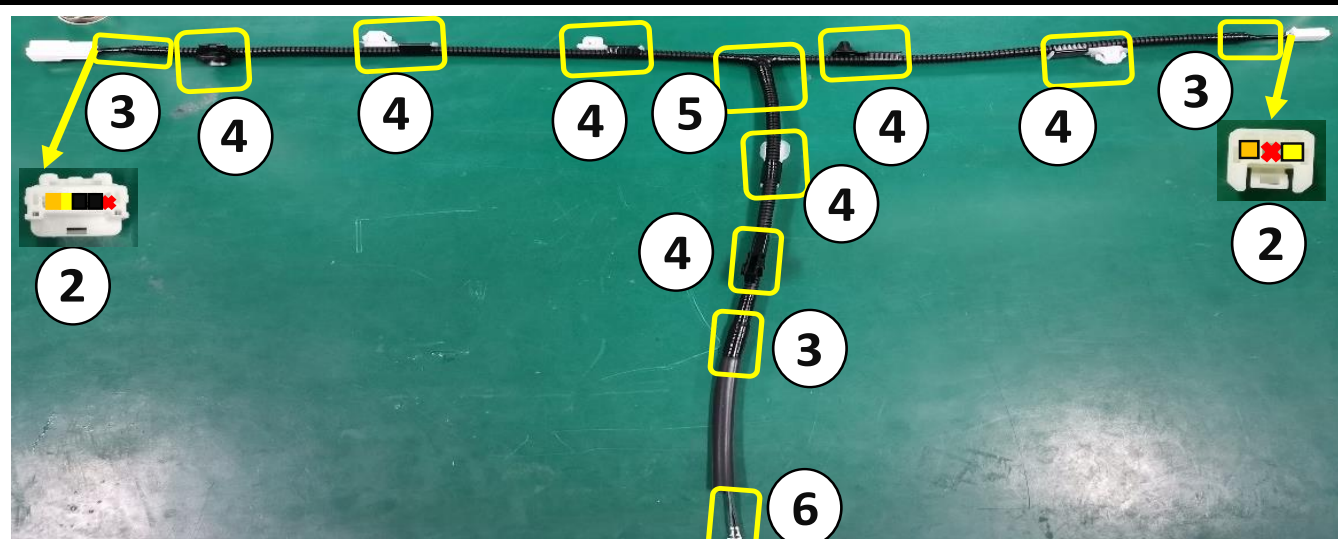
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PARTS:

n/a

JIG:

n/a

QUALITY CHECKPOINTS**n/a****7N0201-7020A****GOOD****GOOD****NO GOOD****NO GOOD**

① **No Unlock/Halflock Connector**
(on 2 connector)

② **No Wrong Insert**

③ **No Missing tape Conduct Bending on Sunprene tube**

④ **No Missing Clamp Check the Clamp Alignment**

⑤ **No Missing Tape (T-Taping)**

⑥ **No Deformed Terminal**

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