



## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

February 12, 2025

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

400D / 7L0166-7020A

Customer:

TRQSS

Car Model:

TOYOTA Bz4x (BEV)

Document No.:

WI-ENG-PDE-1200

Purpose:



PROTOTYPE



PRE-LAUNCH



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Revision No.:

0

Page No.:


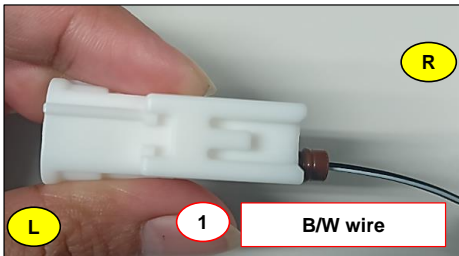
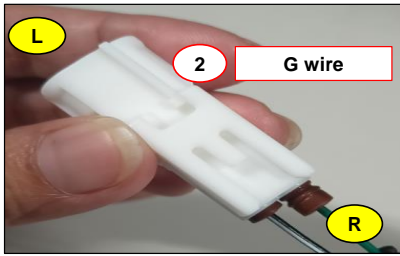
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## PARTS:

- Connector 6188-0407 (W)
- Wire TVSSF 0.3 G-B/W L=516±3mm

JIG:

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 Wire insertion to connector 6188-0407 (W)	<div><p>CONNECTOR ORIENTATION</p></div> <div><p>1. Hold the connector using left hand. Get the <b>Black/White wire</b> then insert to terminal <b>slot 1</b> using right hand.</p></div> <div><p>2. Get the <b>Green wire</b> and insert to terminal <b>slot 2</b>.</p></div>	<div><b>Safety Instruction</b> Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	<div>1. No wrong use of connector 2. No damaged connector 3. No wrong insertion 4. One by one insertion 5. No deformed terminal 6. No wrong wire facing</div> <div><b>Important reminder/Notes/:</b> <b>1. Please hold the wire near terminal during insertion.</b> <b>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</b></div> <div><b>Document reference/s:</b> <b>1. Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</b> <b>2. Please refer to GL-PRO-ASY-029 for Pull-Push procedure.</b></div>

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
02/12/25	0	Initial issue.	A.Hernandez	C.Villanueva	A.Arañes	n/a	A.Hernandez	C.Villanueva	A.Arañes	n/a
Est. Date:							February 12, 2025			

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**2 of 11****PARTS:**

1. Assy parts
2. Clip Clamp 82711-1E360 (W)

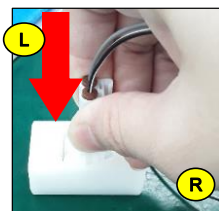
JIG:

1. Locking jig

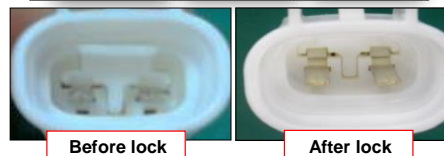
**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

2

Connector lock



1. Put the connector into locking jig using right hand then press **2x** to lock using both hands. Check the lock if properly locked.

**LOCKING JIG**

1. Use the provided jig per model
2. No unclocked/half-locked connector.

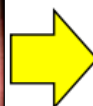
**Important reminders/Notes**

1. Manual locking may cause damaged connector lock

3

P1

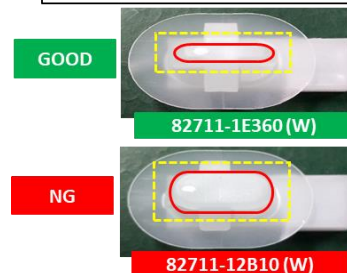
Clamp attachment (Clip type clamp)



1. Hold the connector using left hand, get the clip type clamp **82711-1E360 (W)** then insert the clamp to connector using right hand. Note: Sound will be heard if properly inserted.

n/a

1. Must be fully inserted

**CLIP CLAMP ILLUSTRATION**

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PARTS:		1. Assy Parts 2. Black corrugated tube (no slit) $\varnothing 5$ L=375 $\pm$ 3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1  Wire insertion to Black corrugated tube (no slit) $\varnothing 5$ L=375 $\pm$ 3mm	<div><div></div><div>1. Hold the assy parts using left hand and get the terminal cover jig using right hand.</div></div> <div><div></div><div>2. Hold the assy parts using left hand and get the <b>Black corrugated tube (no slit) <math>\varnothing 5</math> L=375<math>\pm</math>3mm</b> then insert using right hand.</div></div> <div><div></div><div>3. Remove the terminal cover jig.</div></div>		<div>TERMINAL COVER JIG</div> 	1. No wrong use of parts 2. No wires left between COT with slit

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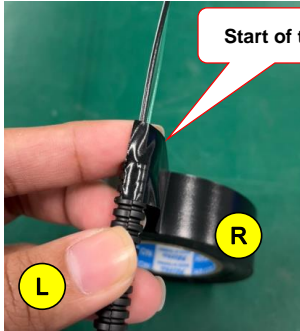
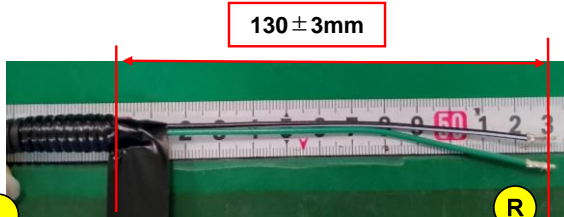
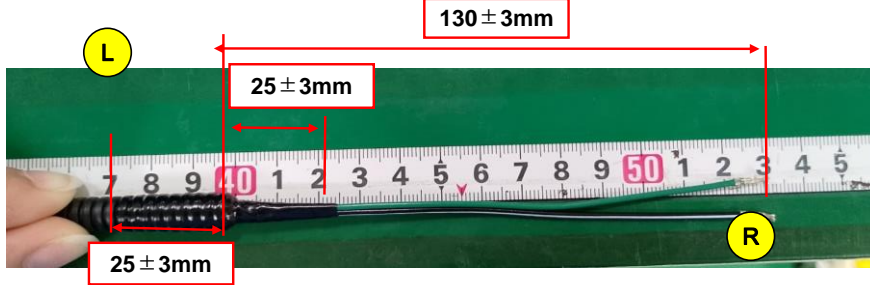

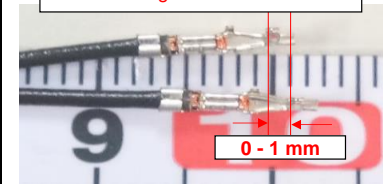
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PARTS:		1. Assy Parts 2. Black Tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1 Taping Corrugated tube to wire near terminal	<div><p>Start of taping</p></div> <div><p>130 ± 3mm</p></div> <div><p>1. Hold the assy parts using left hand. Get the <b>Black tape</b> using right hand then start taping between COT to wire using both hands.</p></div> <div><p>2. Measure from end of COT up to terminal pointed tip <b>130±3mm</b> then continue the taping process using both hands</p></div> <div><p>130 ± 3mm</p><p>25 ± 3mm</p><p>25 ± 3mm</p></div> <div><p>3. After taping, check the measurement, terminal alignment and taping condition.</p></div>	<p><b>MEASURING TAPE</b></p> 	<p><b>Important reminders/Note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p><b>Document references:</b></p> <p>1. Refer to WI-PRO-ASY-001A for Taping process</p> <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> <div><p>Wire alignment tolerance</p><p>0 - 1 mm</p></div>

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<b>PARTS:</b>		1. Assy parts 2. Black VM tube (Sunprene) $\varnothing 9$ L=112 $\pm$ 3mm	JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
6	P1	<div>Wire insertion to Black VM tube (sunprene) <math>\varnothing 9</math> L=112<math>\pm</math>3mm</div> <div><div>1. Hold the assy parts using left hand and get the Black VM tube (sunprene) <math>\varnothing 9</math> L=112<math>\pm</math>3mm then insert using right hand.</div><div>2. Measure end of VM tube (Sunprene) up to end of COT inside VM tube (Sunprene) 20<math>\pm</math>5mm</div></div>	n/a	1. No wrong use of parts 2. No deformed terminal

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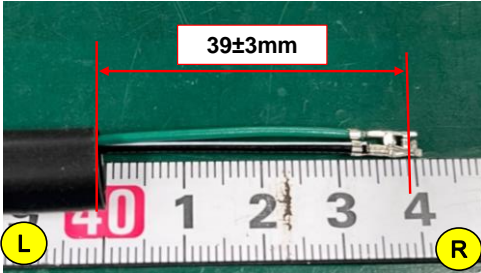
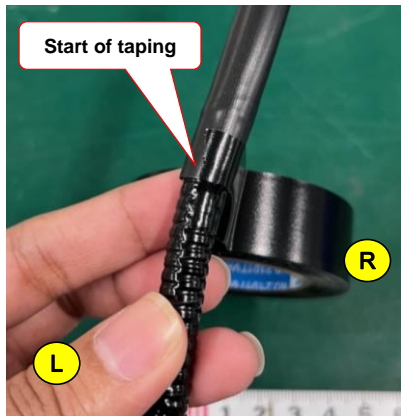


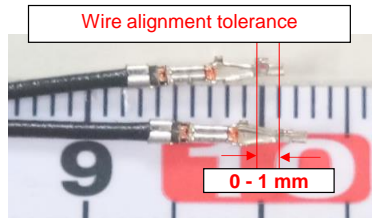
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PARTS:		1. Assy Parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1  Taping 2 COT to VM tube (Sunprene)	<div><div><p>39±3mm</p></div><div><p>1. Measure from end of the VM tube (Sunprene) up to terminal tip <b>39±3mm</b>.</p></div><div><p>Start of taping</p></div><div><p>2. Hold the assy parts using left hand and start taping using right hands.</p></div><div><p>25 ± 3mm    25 ± 3mm    39 ± 3mm</p></div><div><p>3. After taping, check the dimension, terminal appearance and taping condition.</p></div></div> <div><div>MEASURING TAPE</div></div> <div><div>Wire alignment tolerance</div><p>0 - 1 mm</p></div>			

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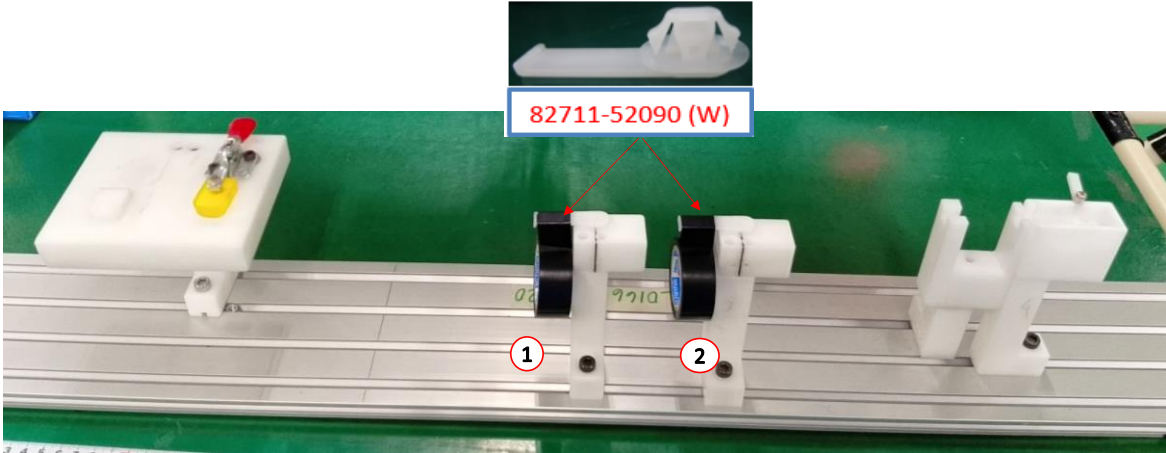
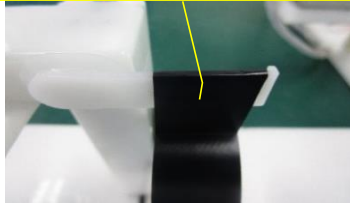
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PARTS:		1. Assy parts 2. Clamp 82711-52090 (W) 3. Black Tape [2 pcs.]		JIG:	1. Temporary Assembly Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1  Clamp Setting	<div></div> <div>1. Get 1pc of clamp <b>82711-52090 (W)</b> using right hand and set to clamp location <b>1</b> using both hands.</div> <div>2. Get 1pc of clamp <b>82711-52090 (W)</b> using right hand and set to clamp location <b>2</b> using both hands.</div> <div>3. Initially attach <b>Black tape</b> to clamp location <b>1 and 2</b> using both hands.</div>			<div><b>Important reminders/Note/s:</b> <b>1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</b></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><div>One wind for under tape</div></div>

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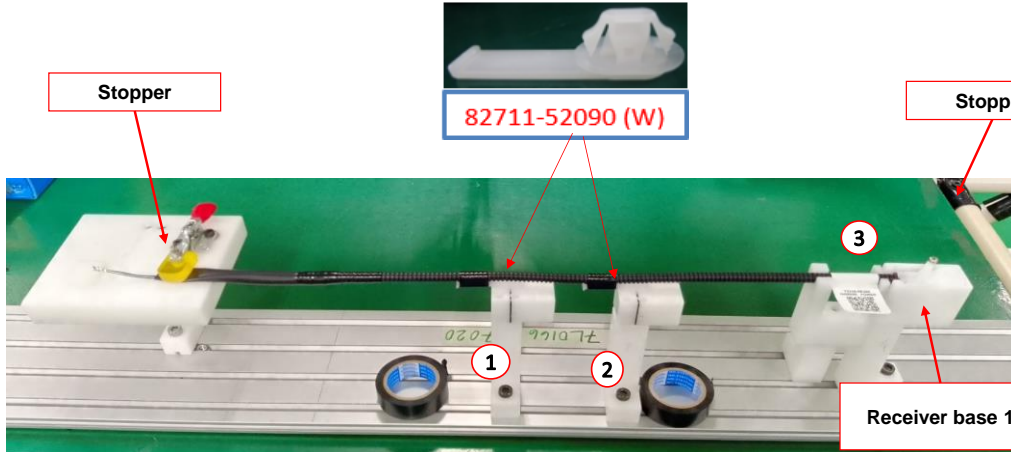
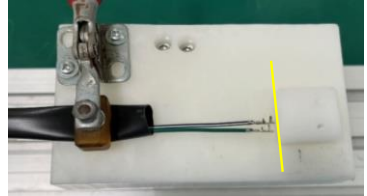
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<b>PARTS:</b>		1. Assy parts 2. Clamp 82711-52090 (W) 3. Black Tape [2 pcs.]	JIG:	1. Temporary Assembly Jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
9	P1 Clamp Assembly	<div></div> <div>1. Put the assy into jig. <i>(See above picture for the correct setting)</i>. First, set the connector 6188-0407 (W) to Receiver base 1 continue to set the harness in jig. Last, set the terminals within stopper then press by toggle clamp.</div> <div>2. Hold the tape on clamp location 1, make 3 windings of tape then cut the tape using both hands.</div> <div>3. Hold the tape on clamp location 2, make 3 windings of tape then cut the tape using both hands.</div> <div>4. For Label attachmentment <i>(Refer to the next page)</i>.</div> <div>5. Conduct <b>POINT CHECKING</b> before removing the harness from jig.</div> <div>6. After point checking, remove the toggle clamp up to connector receiver base 1.</div>		<div></div> <p><b>Important reminders/Note/s:</b></p> <ul style="list-style-type: none"><li>1. Make sure no gap between terminal and stopper jig</li><li>2. Make 2-3 windings for clamp taping</li></ul> <ul style="list-style-type: none"><li>1. No wrong use of parts</li><li>2. No wrong use of tape</li><li>3. No damaged clamp</li><li>4. No wrong clamp position</li></ul>

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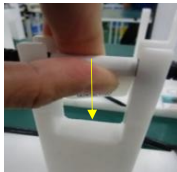
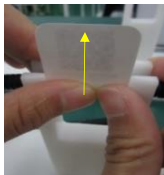



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PARTS:		1. Assy Parts 2. QR Code Label 72320-0E360		JIG:	1. Temporary assembly jig												
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS												
10	P1 Label attachment	<table border="1"><thead><tr><th>Model</th><th>Item No</th><th>Item Name</th></tr></thead><tbody><tr><td>7L0165-7020A</td><td>73230-0E320</td><td>Driver POWER</td></tr><tr><td>7L0166-7020A</td><td>73230-0E360</td><td>Passenger POWER</td></tr><tr><td>7L0167-7020C</td><td>73230-0E310</td><td>Driver PWR+MEM</td></tr></tbody></table> <div><p>Model code</p><p>Item no. &amp; name</p></div> <div><p>1. Get the label. <b>Note: Check the model code, item no. &amp; name</b></p></div> <div><p>2. Align the end part of label in the jig.</p></div> <div><p>3. Fold the center part of the label</p></div> <div></div> <div><p>4. Align both end part of label</p></div> <div><p>5. After alignment , Press the label with both fingers .</p></div> <div></div> <div><p>6. Press the label upside down using finger.</p></div> <div><div><p>GOOD</p></div><div><p>Acceptable overlap</p></div><div><p>NG</p></div></div>		Model	Item No	Item Name	7L0165-7020A	73230-0E320	Driver POWER	7L0166-7020A	73230-0E360	Passenger POWER	7L0167-7020C	73230-0E310	Driver PWR+MEM	n/a	<div><div>1. No bubbles</div><div>2. No damage</div><div>3. No peel off</div><div>4. No wrong use of label</div><div>5. No missing parts</div><div>6. No loose attachment</div><div>7. No wrong usage of label</div></div> 
Model	Item No	Item Name															
7L0165-7020A	73230-0E320	Driver POWER															
7L0166-7020A	73230-0E360	Passenger POWER															
7L0167-7020C	73230-0E310	Driver PWR+MEM															

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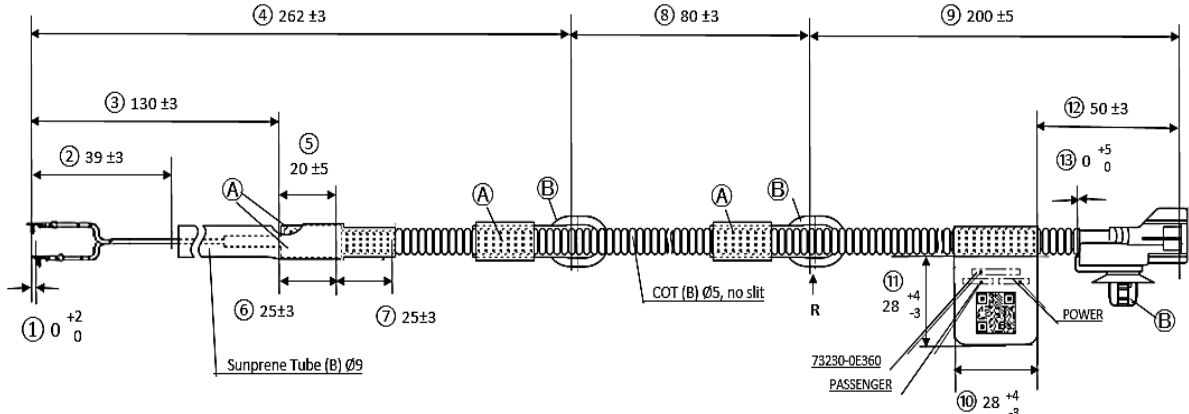
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PARTS:	1. Assy Parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
11	P1	Measurement	<div>MEASURING TAPE</div>  	<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>

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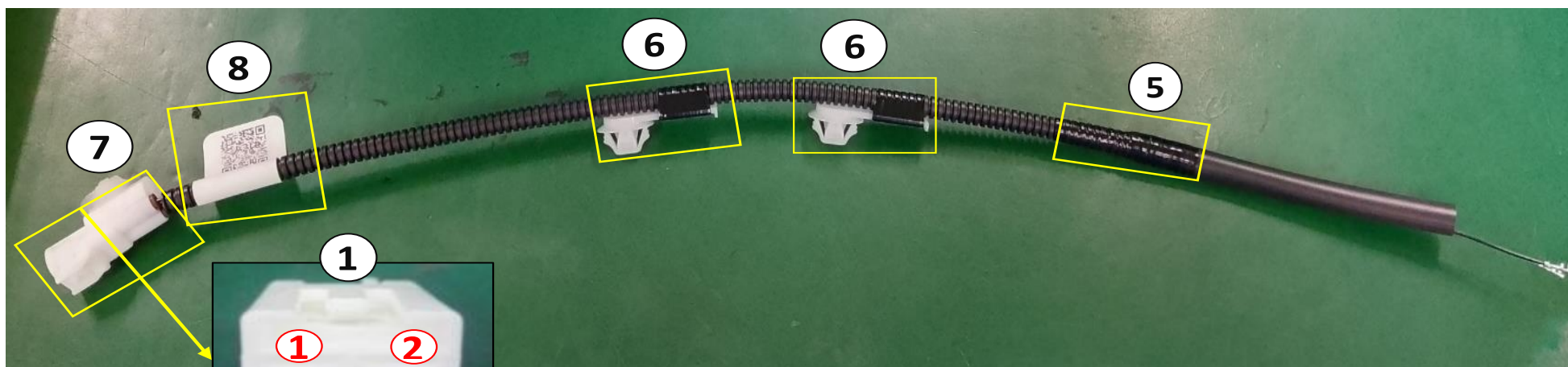
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PARTS:

n/a

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P1****7L0166-7020A**

① **No Unlock/Halflock Connector**

② **No Wrong Insert**

③ **No Terminal Backing Out**

④ **No Deformed Terminal**

⑤ **No Missing tape**

⑥ **No Missing Clamp**

⑦ **No Missing Clip Clamp Type**

⑧ **No Wrong Facing/ Missing QR Code**

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