



WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number: 291B / 7L0036-7021

Customer: TRQSS

Car Model: TOYOTA-SEQUOIA

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

May 10, 2024

Validity Date:

n/a

Document No.:

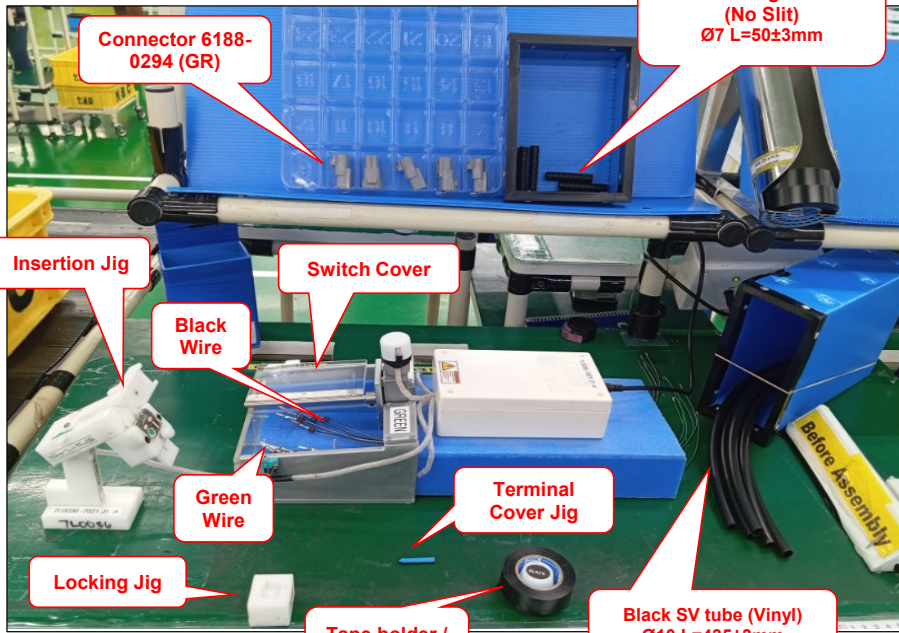
WI-ENG-PDE-888

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PARTS:		1. Connector 6188-0294 (GR) 2. AVSSf 0.3 B/W-G wires L=549±3mm 3. Black Corrugated tube (no slit) Ø7 L=50±3mm		4. Black SV tube (Vinyl) Ø10 L=435±3mm 5. Black tape [19mm]		JIG:	1. Insertion Jig with cover 2. Locking Jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
1	P1	Tab e lay-out	<div><div>TABLE LAY OUT</div></div>			<div><div>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div><div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div><div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>	1.No missing parts/tools 2.No excess parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
05/10/24	1	Change from Pre-launchh to Masspro. Inclusion of table lay-out. Improved Measurement and Visual Inspection.	A.Hernandez	C.Villanueva	A. Arañes	n/a	A. Hernandez	C. Villanueva	A. Arañes	
05/07/24	0	Initial issue.	A.Hernandez	C.Villanueva	A. Arañes	n/a	A. Hernandez	C. Villanueva	A. Arañes	n/a

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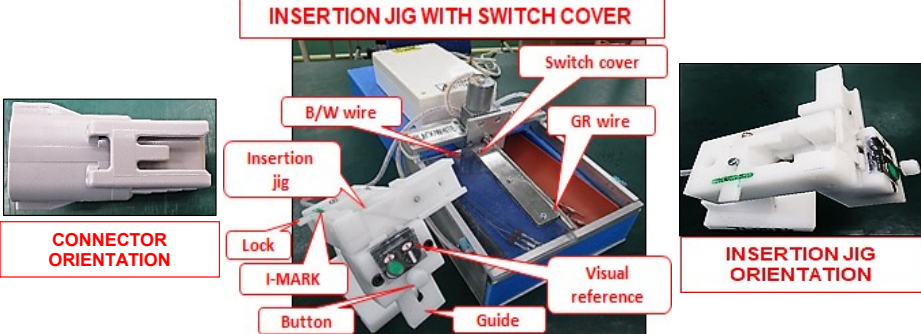
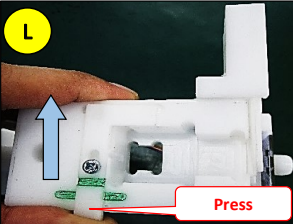
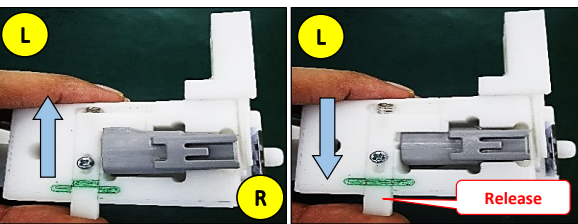

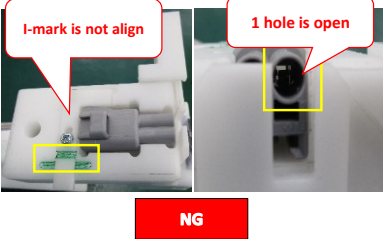
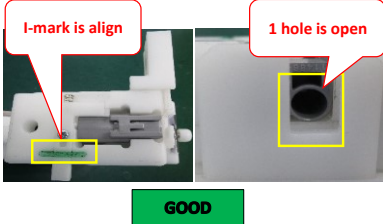
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PARTS:		1. AVSSf 0.3 B/W-G wires L=549±3mm		JIG:	1. Insertion jig with switch cover 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<div><p>INSERTION JIG WITH SWITCH COVER</p><p>CONNECTOR ORIENTATION</p><p>INSERTION JIG ORIENTATION</p><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the connector 6188-0294 (GR) into jig using right hand and release the lock. <i>Note: Follow the connector orientation.</i></p><p>3. Check the holes/terminal slot for B/W wires.</p></div>		n/a	<div><p>Connector Orientation Illustration</p></div>

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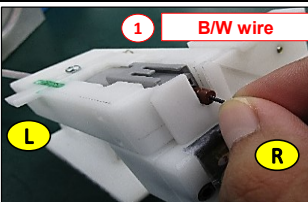

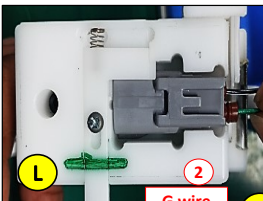
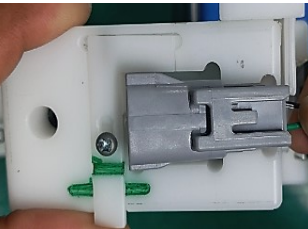

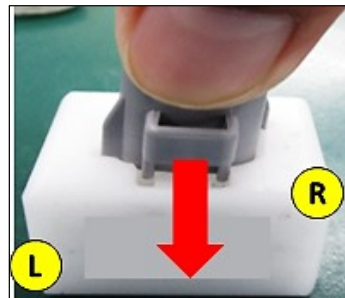











☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS												
3	Wire insertion to connector 6188-0294 (GR)	<div><div><p>WIRE FACING</p></div><div><p>1. Get the B/W wire then insert to terminal Slot 1 using right hand.</p></div><div><p>2. After insertion of B/W wire, press the button using right thumb. The slot for G wire will be opened.</p></div><div><p>3. Get the G wire then insert to terminal Slot 2 using right hand.</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>		<div>LOCKING JIG</div> 	<p>1. No deformed terminal 2. No terminal backing out 3. No wrong insertion</p> <p>Important reminder's/Note:</p> <p>1. Make sure wires are properly inserted. 2. Conduct Pull-Push-Pull-Push after insertion. 3. Do not exert extra force. 4. Please hold the wire near terminal.</p> <p>Document references:</p> <p>Refer to GL PRO-ASY-029 for pull-push-pull-push procedure5</p>												
4	Connector Lock	<div><p>1. Put the connector into locking jig using right hand then press 2x. Check the connector lock if properly locked.</p></div> <div><div><p>Before Pressing</p></div><div><p>After Pressing</p></div><div><p>Coupler Cross Sectional View</p><table><tr><td>NG</td><td>NG</td><td>GOOD</td></tr><tr><td>Double lock</td><td>Double lock</td><td>Double lock</td></tr><tr><td></td><td></td><td></td></tr><tr><td>Unlock Condition</td><td>Half Lock Condition</td><td>Full Lock Condition</td></tr></table></div></div>		NG	NG	GOOD	Double lock	Double lock	Double lock				Unlock Condition	Half Lock Condition	Full Lock Condition		
NG	NG	GOOD															
Double lock	Double lock	Double lock															
																	
Unlock Condition	Half Lock Condition	Full Lock Condition															

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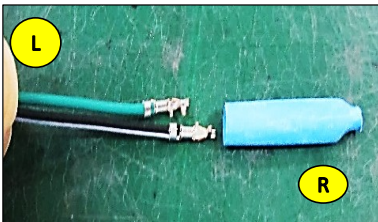


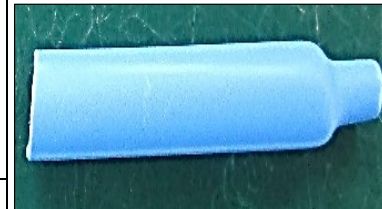


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PARTS:		1. Assy parts 2. Black Corrugated tube (no slit) Ø7 L=50±3mm 3. Black SV tube (Vinyl) Ø10 L=435±3mm		JIG:	1. Terminal Cover Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1	Wire insertion to Black Corrugated tube (no slit) Ø7 L=50±3mm	 1. Get the terminal cover jig using right hand and then insert the B/W-G wires using left hand.  3. After insertion, remove the terminal cover jig using right hand.	 2. Get the Black Corrugated tube (no slit) Ø7 L=50±3mm using right hand and then insert the B/W-G wires using left hand. 	1. No wrong use of parts <div>TERMINAL COVER JIG</div> 
6		Wire insertion Black SV tube (Vinyl) Ø10 L=435±3mm	 1. Get the Black SV tube (Vinyl) Ø10 L=435±3mm using right hand and then insert the B/W-G wires using left hand. 		

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PARTS:

1. Assy parts
2. Black tape (19 mm)

JIG:

1. Measuring Tape

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

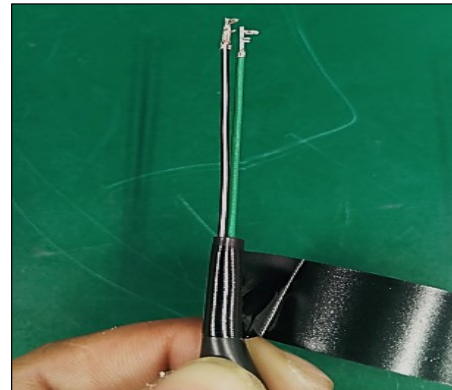
TOOLS/PPE

QUALITY POINTERS

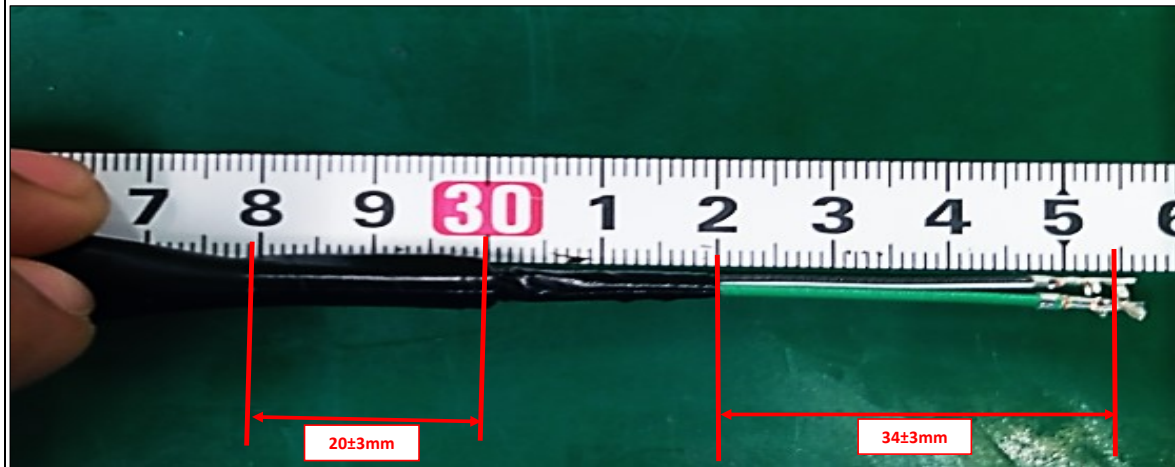
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P1

Taping 1
Black SV tube (Vinyl)
to Wire near terminal



1. Hold the Black SV tube (Vinyl) using left hand then start taping using right hand .
Refer to WI-PRO-ASY-001 for taping procedure.



2. After taping, check the measurement, wire alignment and taping condition.

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

MEASURING TAPE



Wire alignment tolerance



Important reminders/note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.

Document references;

1. Please refer to WI-PRO-ASY-001 for taping procedure.

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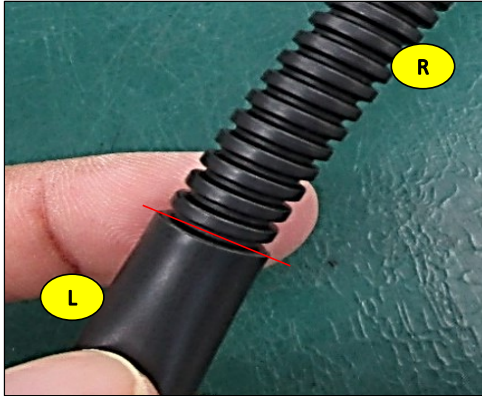
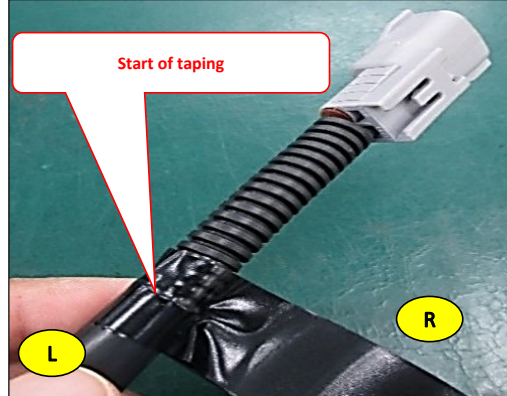
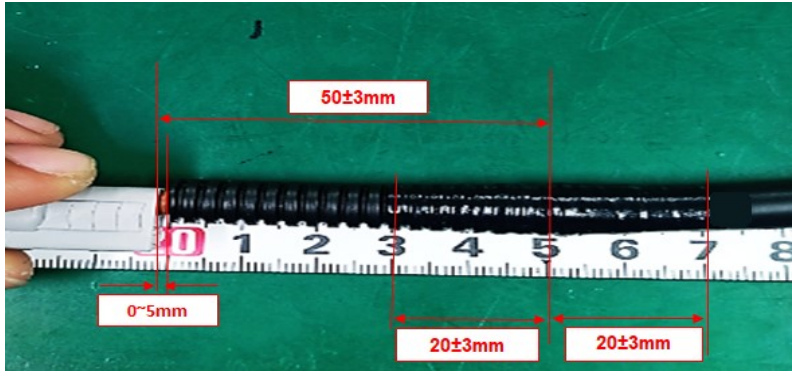


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PARTS:		1. Assy parts 2. Black tape [19mm]		JIG:	1. Measuring tape
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1 Taping 2 Black COT to Black SV tube (Vinyl)	<div></div> <div>1. Fix the Black Corrugated tube (no slit) and Black SV tube (Vinyl) make sure no gap in between.</div> <div></div> <div>2. Hold the Black Corrugated tube and Black SV tube (Vinyl) using left hand then start taping using right hand . Refer to WI-PRO-ASY-001 for taping procedure.</div> <div></div> <div>3. After taping, check the measurement and taping condition.</div>		<div>MEASURING TAPE</div>  <div>Wire alignment tolerance</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 Important reminders/note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. Document references; 1. Please refer to WI-PRO-ASY-001 for taping procedure.

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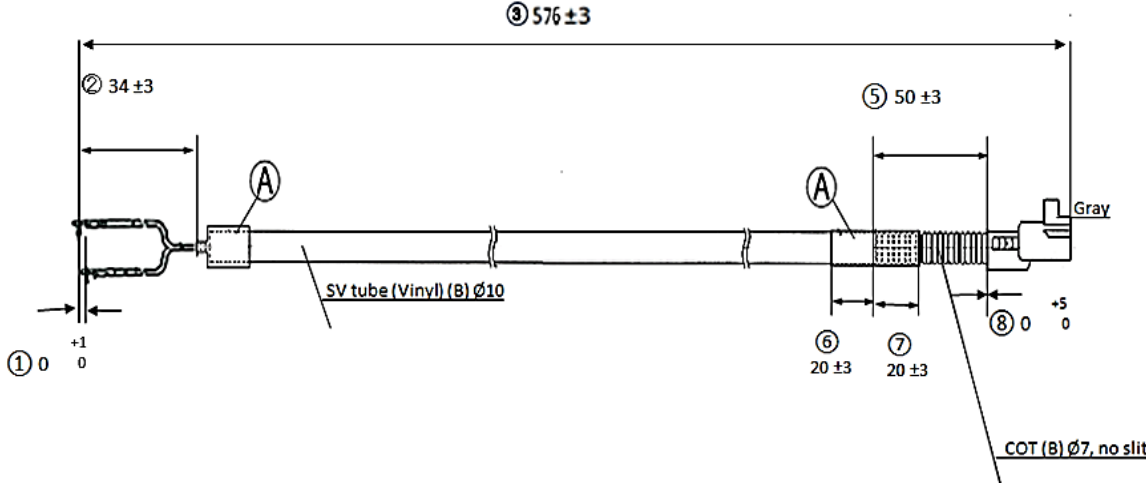
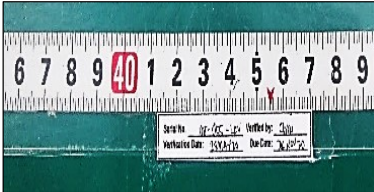
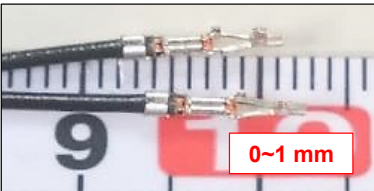
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PARTS:	1. Assy parts		JIG:	1. Measuring tape
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P1 Measurement			<div>1. No wrong dimension</div> <div><div>MEASURING TAPE</div></div> <div><div>Wire alignment tolerance</div></div> <div>Important reminders/note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div>

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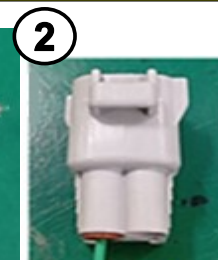
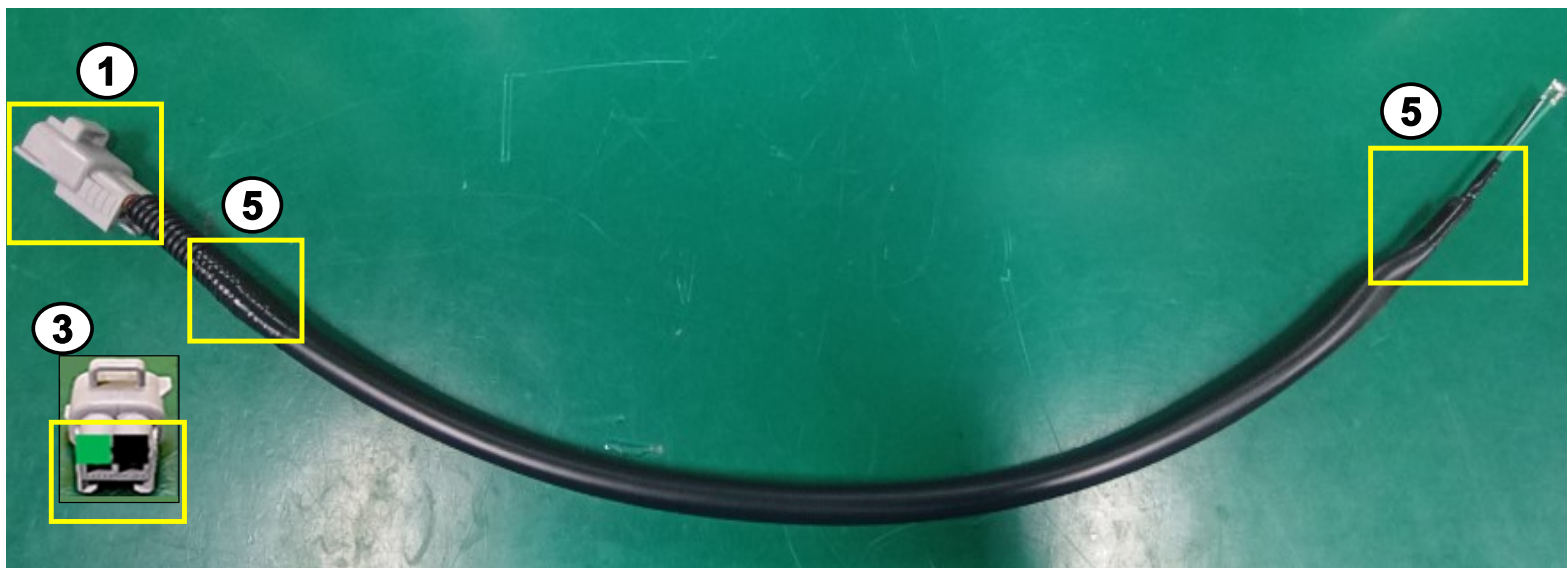
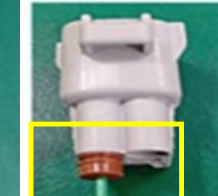
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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION**P1****7L0036-7021****GOOD****NO GOOD****GOOD****NO GOOD****① No Halflocked/Unlock Connector****② No Terminal Backing Out****③ No Deformed Terminal****④ No Wrong Insertion****⑤ No Missing Tape**

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