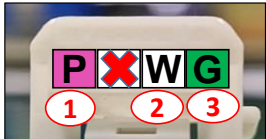
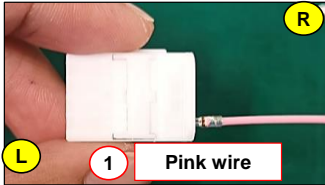
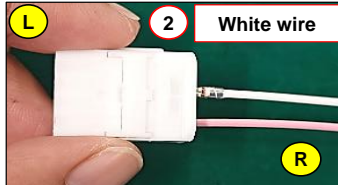
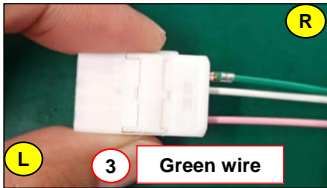







WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	November 22, 2024		
Validity Date:	n/a		
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Process Name/Title:	TAPING ASSEMBLY PROCESS		
Model code/Part number:	559D / 7N0237-7020A	Customer:	TRJ
		Car Model:	TOYOTA HI-ACE
Purpose:	<input type="checkbox"/> PROTOTYPE	<input checked="" type="checkbox"/> PRE-LAUNCH	<input type="checkbox"/> MASSPRO

PARTS:	1. Connector 6098-5677 (W) 2. AVSSf 0.3 P,W,G wires L=830±3mm;			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1 Wire insertion to Connector 6098-5677 (W)	<div><p>VISUAL REFERENCE</p></div> <div><p>1 Pink wire</p></div> <div><p>2 White wire</p></div> <div><p>3 Green wire</p></div> <div><p>1. Hold the connector using left hand. Get the Pink wire then insert to terminal slot 1 using right hand.</p></div> <div><p>2. Hold the connector using left hand. Get the White wire then insert to terminal slot 2 using right hand.</p></div> <div><p>3. Hold the connector using left hand. Get the Green wire then insert to terminal slot 3 using right hand.</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 use of connector 2. No damaged connector 3. No wrong insert 4. One by one insertion 5. No deformed terminal 6. No wrong terminal Orientation</p> <p>Important reminders/Note/s:</p> <p>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 during insertion.</p> <p>Document references:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>

Revision History								Prepared by	Reviewed by	Approved by	Noted by
								 M. Ariola	 C. Villanueva	 A. Arañes	
11/22/24	0	Initial issue.		M. Ariola	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change			Revised	Reviewed	Approved	Noted	Est. Date:	November 22, 2024	

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559D / 7N0237-7020A

Customer: TRJ

Car Model: TOYOTA HI-ACE

Purpose:



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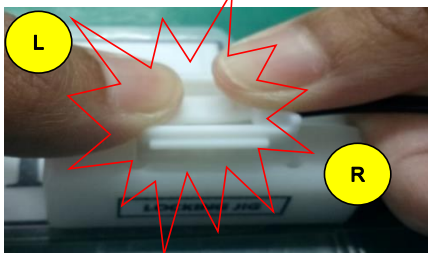
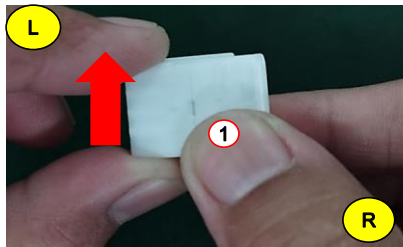
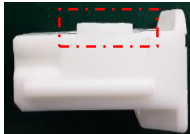


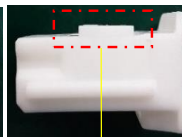


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PARTS:	1. Assy parts			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1 Connector Lock	<div></div> <div><p>1. Put the connector into locking jig using right hand then press 2x to lock. Touch the connector lock to confirm if properly pressed.</p></div> <div></div> <div><p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div> <div></div> <div><p>BEFORE PRESSING</p></div> <div></div> <div><p>AFTER PRESSING</p></div> <div></div> <div><p>GOOD</p></div> <div></div> <div><p>NG</p></div> <div><p>Fully Locked</p></div> <div><p>UnLocked</p></div> <div></div>		<div>LOCKING JIG</div> 	

Important reminders/Note/s:

1. Manual Locking may caused damaged connector lock.

Document references:

1. Refer to GL-PRO-ASY-017 for verification of connector lock.

1. Use the provided jog per model
2. No unlocked/half-locked connector

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

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559D / 7N0237-7020ACustomer: **TRJ**Car Model: **TOYOTA HI-ACE**

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PARTS:		1. Black Corrugated tube Ø5, L=349±3mm 2. Assy parts		3. Black Corrugated tube Ø7, L=423±3mm		JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	P1	Wire insertion to Black Corrugated tube Ø5, L=349±3mm	<div></div> <div>1. Get the Black Corrugated tube Ø5, L=349±3mm using right hand and insert P,W and G wires using left hand.</div>			n/a	1. No wrong usage of parts 2. No deformed terminal
4		Wire insertion to Black Corrugated tube Ø7, L=423±3mm	<div></div> <div>1. Get the Black Corrugated tube Ø7, L=423±3mm using right hand and insert P,W and G wires using left hand.</div>			n/a	1. No wrong usage of parts 2. No deformed terminal

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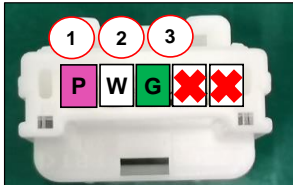


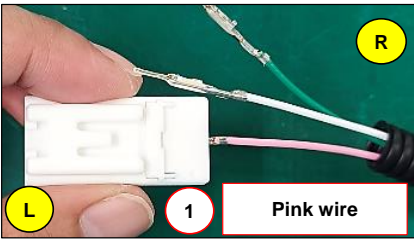
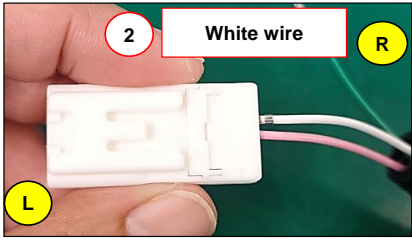
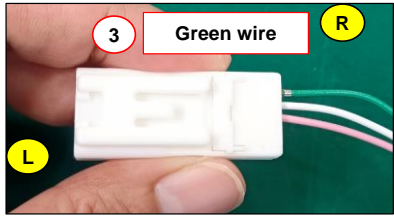

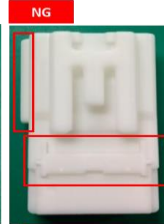
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PARTS:		1. Assy parts 2. Connector 6098-3802 (W)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1 Wire insertion to Connector 6098-3802 (W)	<div><p>VISUAL REFERENCE</p></div> <div><p>CONNECTOR ORIENTATION</p></div> <div><p>TERMINAL ORIENTATION</p></div> <div><p>1 Pink wire</p><p>1. Hold the connector using left hand. Get the Pink wire then insert to terminal slot 1 using right hand.</p></div> <div><p>2 White wire</p><p>2. Hold the connector using left hand. Get the White wire then insert to terminal slot 2 using right hand.</p></div> <div><p>3 Green wire</p><p>3. Hold the connector using left hand. Get the Green wire then insert to terminal slot 3 using right hand.</p></div>		n/a	<p>1. No wrong use of connector 2. No damaged connector 3. No wrong insert 4. One by one insertion 5. No deformed terminal 6. No wrong terminal Orientation</p> <p>Important reminders/Note/s:</p> <p>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>2. Please hold the wire near terminal during insertion.</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <div><p>CONNECTOR ILLUSTRATION</p><div><p>GOOD</p><p>6098-3802 (W)</p></div><div><p>NG</p><p>6098-5668 (W)</p></div></div>

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Model code/Part number:

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Customer: TRJ

Car Model: TOYOTA HI-ACE

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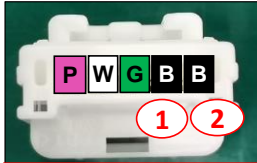


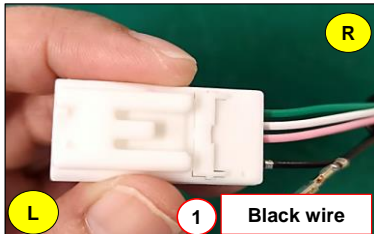
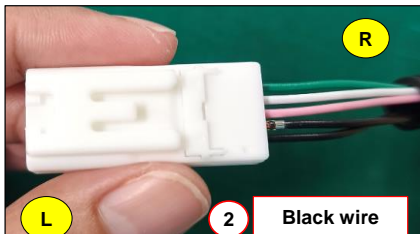
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PARTS:		1. Assy parts 2. AVSSf 0.3 B-B wires L=977±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	Wire insertion to Black Corrugated tube (Assy parts)	<div></div> <div>1. Get the assy parts using left hand and insert AVSSf 0.3 B-B wires L=977±3mm using right hand.</div>		n/a	<div>1. No wrong usage of parts 2. No deformed terminal</div> <div>Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.</div>
7	P1 Wire insertion to Connector 6098-3802 (W)	<div><div><div>VISUAL REFERENCE</div></div><div><div>CONNECTOR ORIENTATION</div></div><div><div>TERMINAL ORIENTATION</div></div><div><div><div>Black wire</div></div><div>1. Hold the connector using left hand. Get the 1st Black wire then insert to terminal slot 1 using right hand.</div></div><div><div><div>Black wire</div></div><div>2. Get the 2nd Blackwire then insert to terminal slot 2 using right hand.</div></div></div>		n/a	<div>1. No wrong use of connector 2. No damaged connector 3. No wrong insert 4. One by one insertion 5. No deformed terminal 6. No wrong terminal Orientation</div> <div>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 during insertion.</div> <div>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

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Car Model: TOYOTA HI-ACE

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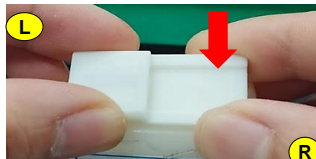










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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1 Connector Lock	<div><p>1. Load the connector into the jig holding both side of the connector, tip first.</p></div> <div><p>2. Press the lower part of connector to fully insert into the locking jig.</p></div> <div><p>Right thumb-Lower Left thumb-middle</p><p>3. Press the lower parts of connector using right hand while left hand holding the middle.</p></div> <div><p>Right thumb-upper Left thumb-middle</p><p>4. Press the upper part of connector using right hand while left hand holding the middle.</p></div> <div><p>Right thumb-middle Left thumb-middle</p><p>5. Lift then press the connector in the middle using left and right hand.</p></div> <div><p>1</p><p>2</p><p>6. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div>		<div>LOCKING JIG</div> 	<div>1. Use provided jig per model</div> <div>2. No unlock/half-locked connector</div> <div>Important reminders/Note/s:</div> <div>1. Manual locking jig may caused damaged connector lock.</div> <div>Document references:</div> <div>1. Refer to GL-PRO-ASY-017 for the verification of connector lock.</div> <div><p>Before pressing</p><p>After pressing</p></div> <div><p>GOOD Full Lock</p><p>NG Half Lock</p></div>

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

Process Name/Title:

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559D / 7N0237-7020ACustomer: **TRJ**Car Model: **TOYOTA HI-ACE**

Purpose:



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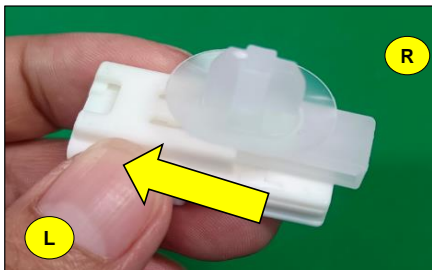
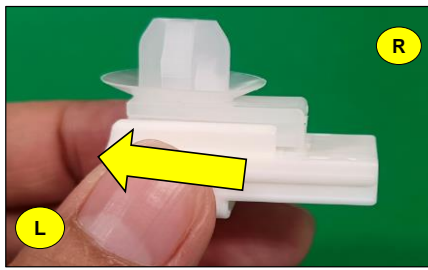
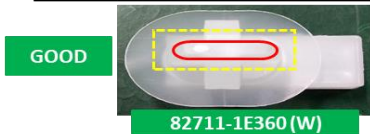

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PARTS:		1. Assy parts 2. Clip type clamp 82711-1E360 (W)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1 Clip attachment (Clip type clamp)	<div></div> <div>CLAMP ORIENTATION</div> <div></div> <div></div> <div>1. Hold the Connector using left hand, get the clip type clamp 82711-1E360 (W) then insert the clamp using right hand. Note: Sound will be heard if properly inserted.</div>		n/a	<div>CLIP CLAMP ILLUSTRATION</div> <div></div> <div></div> <div>1. No wrong used of clamp 2. No damaged clamp 3. No missing clamp</div>

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PARTS:		1. Assy parts 2. Brown tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	Spot taping 1	<p>1. Fix the excess wire and initially attach the Brown tape in the middle and start taping using both hands. Make 2 windings of tape then cut the tape.</p>		<p>MEASURING TAPE</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> <p>Important reminders/ Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p>
11	Spot taping 2	<p>1. Hold the wires using left hand and measure from wire up to terminal pointed tip 120±3mm</p> <p>2. Get the Brown tape and start taping on the black wires. Conduct 2 windings of tape before cut the tape using both hands.</p> <p>3. After taping, check the measurement and taping condition.</p>		<p>MEASURING TAPE</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> <p>Important reminders/ Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p>

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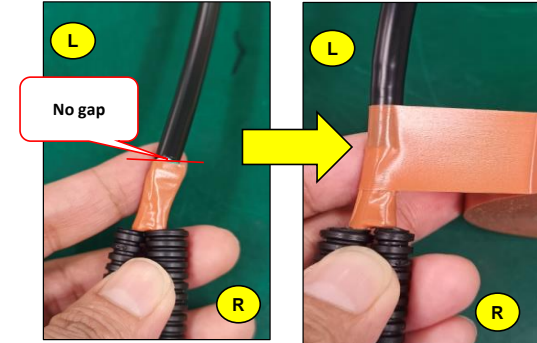


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PARTS:	1. Assy parts 2. Black SV tube (vinyl) ø5 L=490±3mm			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
12	Wire insertion to Black SV tube (vinyl) ø5 L=490±3mm	 <div>1. Get the B-B wires using right hand then insert the Black SV tube (vinyl) ø5 L=490±3mm using left hand.</div>		n/a	1. No wrong usage of parts 2. No deformed terminal
13	P1 Spot taping 3	 <div>1. Combine the assy parts and the Black SV tube (Vinyl). initially attach the Brown tape in the middle and start taping using both hands. Make 2 windings of tape then cut the tape.</div>  <div>2. After taping, check the taping condition.</div>		<div>MEASURING TAPE</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 use calibrated/verified measuring tape when getting the measurement.</div>

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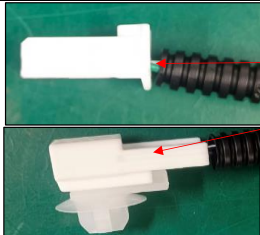
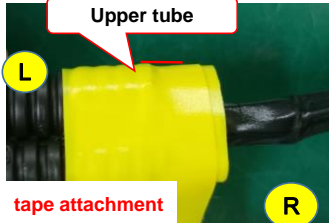

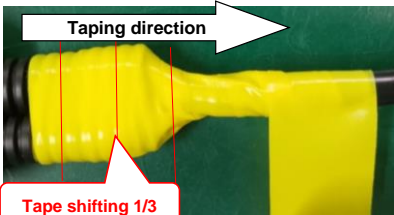

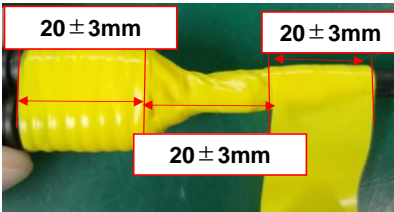
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PARTS:		1. Assy parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
14	P1 Y-Taping	<div></div> <div><p>With Gap</p><p>L R</p><p>1. Fix the 3 corrugated tube. Note: Follow the correct facing. (If need to standard)</p></div> <div></div> <div><p>Upper tube</p><p>pre-tape</p><p>tape attachment</p><p>L R</p><p>taping direction</p></div> <div></div> <div><p>Tape shifting 1/2</p><p>3. Winding the tape 1/2 shifting going to the left side.</p></div> <div></div> <div><p>Taping direction</p><p>Tape shifting 1/3</p><p>5. Winding the tape 1/3 shifting going to the right side until reach the other side of tube.</p></div> <div></div> <div><p>20 ± 3mm</p></div> <div></div> <div><p>20 ± 3mm 20 ± 3mm 20 ± 3mm</p></div> <div><p>4. Make 2 windings, width must be - 20±3mm.</p></div> <div><p>6. Make 2 windings, width must be 20±3mm.</p></div>			<p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>Important reminders/Note/s:</p> <p>1. Use <u>yellow tape</u> for easy visualization of tape shifting, but actual should be <u>BROWN TAPE</u></p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No loose tape 2. No flip-out tape 3. No peel-off tape 4. No wrong use of tape 5. No wrong dimension-out tape 6. No exposed wire 7. No gap between tubes</p>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

November 22, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

559D / 7N0237-7020A

Customer: TRJ

Car Model: TOYOTA HI-ACE

Document No.:

WI-ENG-PDE-1157

Purpose:



PROTOTYPE



PRE-LAUNCH



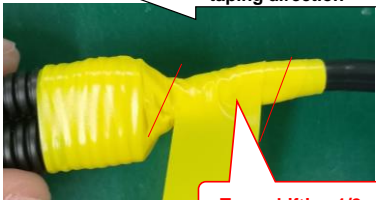
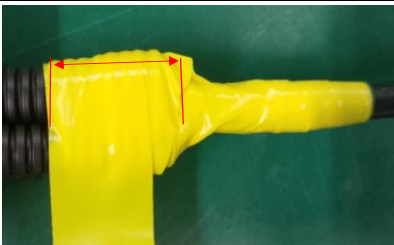
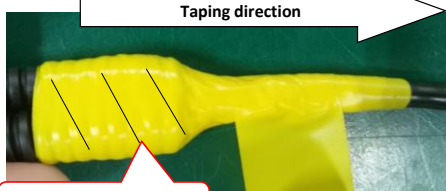
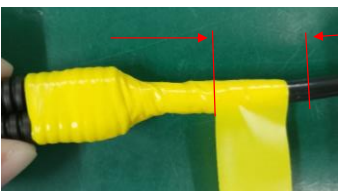
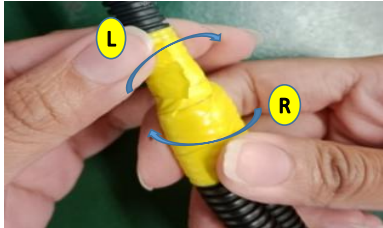
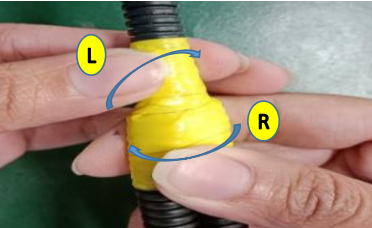
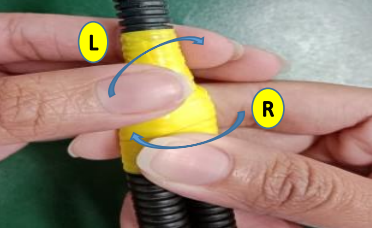
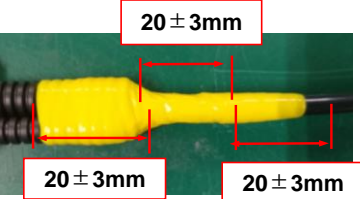
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Revision No.:

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PARTS:	1. Assy parts 2. Black Tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
15	P1 Y-Taping (continuation)	<div><p>7. Winding the tape 1/2 shifting going to the left side.</p></div> <div><p>8. Make 2 windings, width must be 20±3mm.</p></div> <div><p>9. Winding the tape 1/2 shifting going to the right side until it reaches the other side of the tube</p></div> <div><p>10. Make 3 winds, width must be 20±3mm. Then cut the tape.</p></div> <div><p>11. conduct proper pressing of end tape using left hand (top part). <i>Note: Reference only.</i></p></div> <div><p>12. conduct proper pressing of end tape using left hand (Middle part).</p></div> <div><p>13. conduct proper pressing of end tape using left hand (bottom part).</p></div> <div><p>14. Check the Measurement and condition of tape.</p></div>	<p>8. Make 2 windings, width must be 20±3mm.</p> <p>tape cutting</p>	<p>Document reference/s: 1. Refer to WI-PRO-ASY-001C for taping procedure (special).</p> <p>Important reminders/Note/s: 1. Use yellow tape for easy visualization of tape shifting, but actual should be BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement.</p> <ol style="list-style-type: none">1. No loose tape2. No flip-out tape3. No peel-off tape4. No wrong use of tape5. No wrong dimension-out tape6. No exposed wire7. No gap between tubes

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

Process Name/Title:

Model code/Part number:

559D / 7N0237-7020ACustomer: **TRJ**Car Model: **TOYOTA HI-ACE**

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Effectivity Date:

November 22, 2024

Validity Date:

n/a

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PARTS:		1. Clamp 82711-16830 (B) 2. Clamp 82711-16820 (BR)		3. Assy parts		JIG:	1. Temporary clamp assembly jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
16	P1	Clamp setting	<div><div> 82711-16830 (B)</div><div> 82711-16820 (BR)</div><div></div><div>1. Get 1pc. of clamp 82711-16830 (B) using right hand and set to clamp location 1 using both hands.</div><div>2. Get 1pc. of clamp 82711-16820 (BR) using right hand and set to clamp location 1 using both hands.</div></div>			n/a	<div>1. No loose attachment of clamp 2. No damaged clamp 3. No missing parts</div> <div>Important reminders/Notes: 1. Please check the clamp first before start of assembly to avoid wrong use of clamp.</div> <div><div><div>BAND CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>NG</div></div><div> 82711-16820 (BR)</div><div> 82711-26380 (BR)</div></div><div><div>BAND CLAMP ILLUSTRATION</div><div><div>GOOD</div><div>NG</div></div><div> 82711-16830 (B)</div><div> 82711-34490 (B)</div></div></div>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

559D / 7N0237-7020A

Customer: TRJ

Car Model: TOYOTA HI-ACE

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PROTOTYPE



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PARTS:		1. Clamp 82711-16830 (B) 2. Clamp 82711-16820 (BR)		3. Assy parts		JIG:	1. Temporary clamp assembly jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
17	P1	Clamp Assembly	<div><div><p>Receiver base 1</p><p>Receiver base 2</p><p>Connector setting</p><p>82711-16830 (B)</p><p>82711-16820 (BR)</p></div><div><p>1. Initially tighten the band clamp on Clamp location 1 and 2 using both hands.</p><p>2. Get the bando gun using right hand then cut the band clamp on location 1 using both hands. Press the SW button after cut. Continue the process if sequence light on clamp location 2 was ON.</p></div><div><div><p>BANDO GUN ILLUSTRATION</p><p>GOOD</p><p>NG</p><p>FLAT NOSEPIECE</p><p>EXTENDED NOSEPIECE</p></div><div><p>BANDO GUN ALIGNMENT</p><p>PERPENDICULARITY</p><p>OK</p><p>NG</p></div><div><p>PROPER CUTTING POSITION OF BANDO GUN</p><p>GOOD</p></div><div><p>IMPROPER CUTTING POSITION OF BANDO GUN</p><p>NG</p></div><div><p>Fixed setting of band clamp cutter: 1~2</p></div></div></div>			n/a	<div><p>1. Make sure no gap between stopper and terminal.</p><p>2. No wrong use of clamp</p><p>3. No damaged clamp</p></div> <div><p>Important reminders/Notes:</p><p>1. Must be no gap between the terminal and stopper jig.</p><p>2. Using steel rule , Check if the band cut measurement is within the required dimension and should not exceed the allowable range (0~2mm).</p><p>3. Setting of band clamp cutter depends on the size of the COT/SV tube (Vinyl) Ø5- 1~2, Ø7- 3~4</p></div> <div><p>0 ~ 2mm</p></div>

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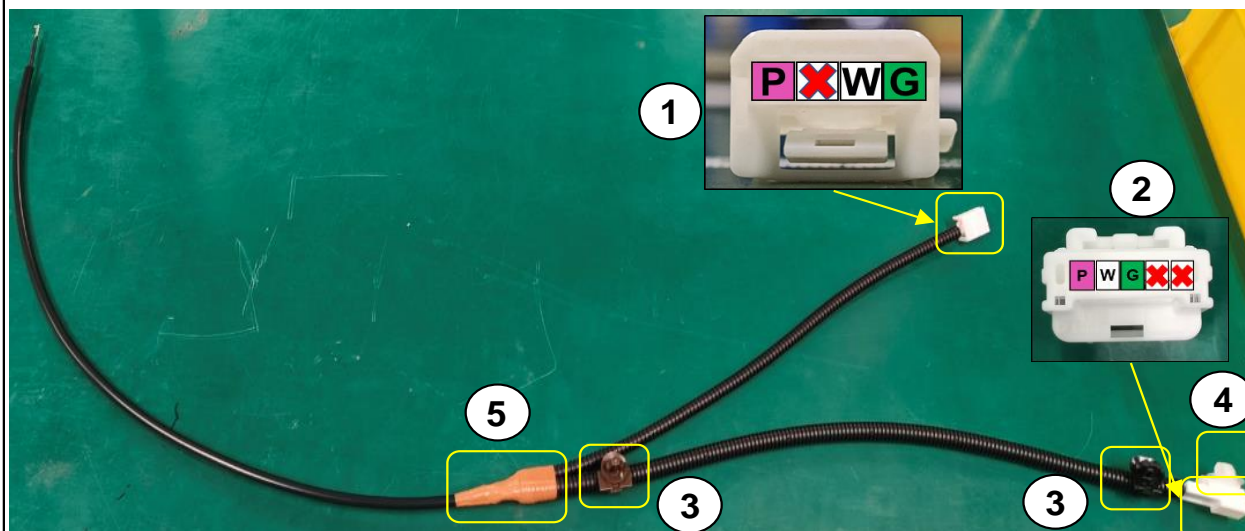
PARTS:

JIG:

VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING - P1

7N0237-7020A



- 1 No unlocked/halflocked connector
- 2 No Wrong insertion
- 3 Check the alignment of clamp
- 4 No missing clip type clamp
- 5 No wrong used of tape (Brown tape)

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