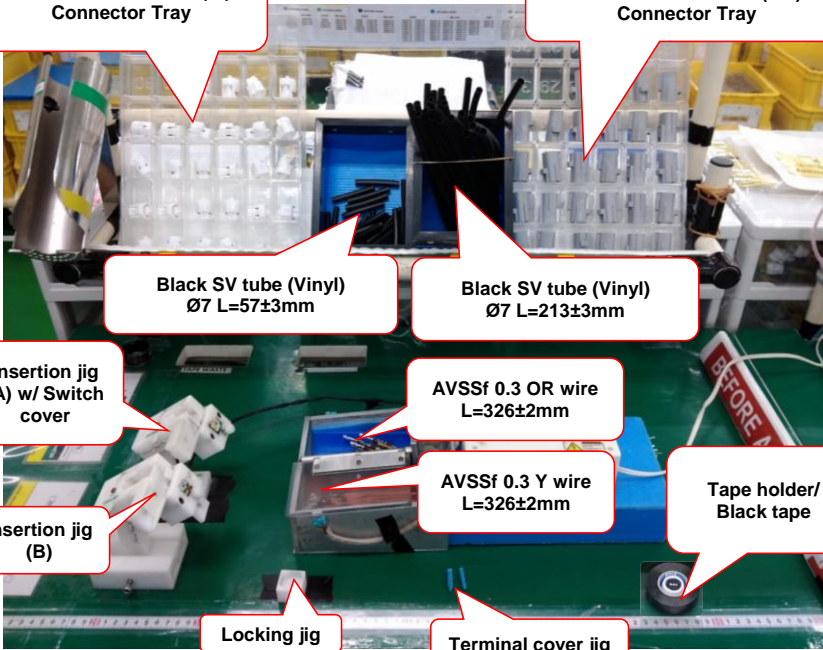



	WORK INSTRUCTION				Effectivity Date:		September 12, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 320B / 7L0053-7025A		Customer: TRQSS	Car Model: TOYOTA-RAV4	Document No.:		WI-ENG-PDE-1035A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		1	Page No.: 1 of 8

PARTS:		1. Connector 6189-0451 (W); Connector 6188-0066 (GR); Black SV tube (Vinyl) Ø7 L=57±3mm; Black SV tube (Vinyl) Ø7 L=213±3mm; AVSSf 0.3 OR wire L=326±2mm; AVSSf 0.3 Y wire L=326±2mm; Black tape		JIG:		1. Insertion jig with switch cover 2. Locking jig 3. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1	P2	<div>TABLE LAY-OUT</div> 		<div>Safety Instruction</div> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>		<div>Document references:</div> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>	

Revision History						Prepared by	Reviewed by	Approved by	Noted by
09/12/24	1	Change from Pre-launch to Masspro.				D. Castillo	C. Villanueva	A. Arañes	n/a
09/11/24	0	Initial issue.				D. Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted

Prepared by: 		Reviewed by: 		Approved by: 		Noted by: n/a	
Est. Date: September 11, 2024							

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TOYOTA-RAV4

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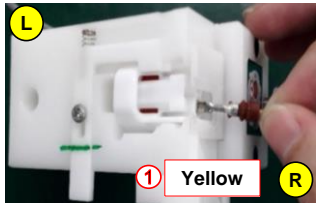
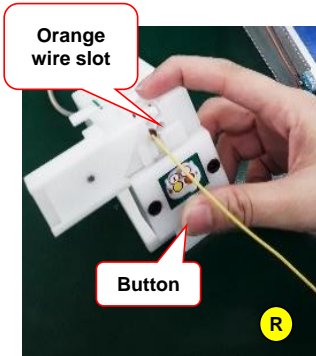
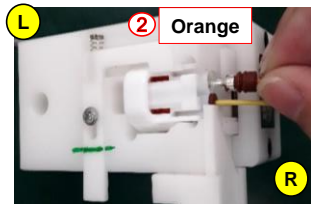
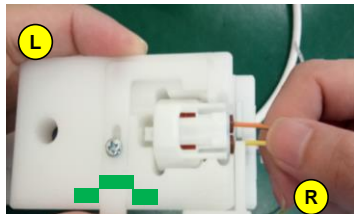
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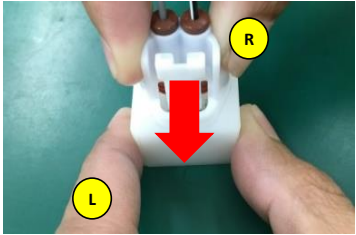
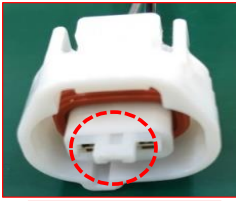
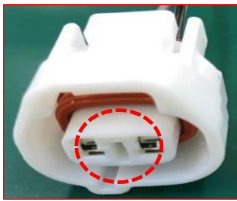






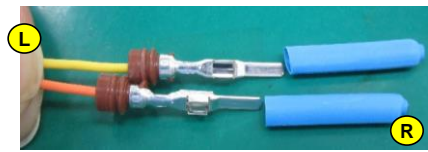

PARTS:		1. AVSSf 0.3 wire Y L=326±2mm 2. AVSSf 0.3 wire OR L=326±2mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2  Wire insertion to connector 6188-0066 (GR)	<div><div>TERMINAL FACING</div></div> <div><div><p>1. Hold the insertion jig using left hand, get <b>Yellow wire</b> and insert to connector slot <b>1</b> using right hand.</p></div><div><p>Orange wire slot</p><p>Button</p><p>2. Press the button using right thumb, slot for <b>Orange wire</b> will be opened.</p></div><div><p>2 Orange</p><p>3. Hold the insertion jig using left hand, get <b>Orange wire</b> and insert to connector slot <b>2</b> 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>		n/a	<b>Important reminders/Note/s:</b>  <b>1. Please hold the wire near terminal during insertion.</b> <b>2. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>do not exert extra force.</b>  <b>Document reference/s:</b>  <b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b>  1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing

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	<b>WORK INSTRUCTION</b>				Effectivity Date:		<b>September 12, 2024</b>	
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:		<b>n/a</b>	
	Model code/Part number: <b>320B / 7L0053-7025A</b>		Customer: <b>TRQSS</b>	Car Model: <b>TOYOTA-RAV4</b>	Document No.:		<b>WI-ENG-PDE-1035A</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		1	Page No.: 4 of 8

<b>PARTS:</b>	1. Assy parts 2. Black SV tube (Vinyl) Ø7 L=57±3mm 3. Black SV tube (Vinyl) Ø7 L=213±3mm			JIG:	1. Locking jig 2. Terminal cover jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
4	Connector lock	<div></div> <div>1. Put the connector into locking jig using right hand then press <b>2x</b>. Touch the connector lock if properly locked.</div> <div><b>Before pressing</b></div> <div><b>After pressing</b></div>		<div><b>LOCKING JIG</b></div> 	<div>1. Use the provided locking jig per model 2. No unlock/half-locked connector 3. No damaged lock</div> <div>Check the double lock deformation</div> <div><b>GOOD</b></div> <div><b>NG</b></div>
5	P2 Wire insertion to Black SV tube (Vinyl) Ø7 L=57±3mm and Black SV tube (Vinyl) Ø7 L=213±3mm	<div><div>1. Get the cover jig then insert to <b>Y-OR wires</b> using right hand.</div></div> <div><div>2. Get the SV tube (Vinyl) <b>Ø7 L=57±3mm</b> using right hand then insert the <b>Y-OR wires</b> using left hand.</div></div> <div><div>3. Get the SV tube (Vinyl) <b>Ø7 L=213±3mm</b> using right hand then insert the <b>Y-OR wires</b> using left hand.</div></div> <div><div>4. After insertion, remove the cover jig using right hand.</div></div>		<div><b>TERMINAL COVER JIG</b></div> 	<div>1. No wrong use of parts. 2. No deformed terminal</div>

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## WORK INSTRUCTION

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## TAPING ASSEMBLY PROCESS

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320B / 7L0053-7025A

Customer:

TRQSS

Car Model:

TOYOTA-RAV4

Document No.:

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Purpose:

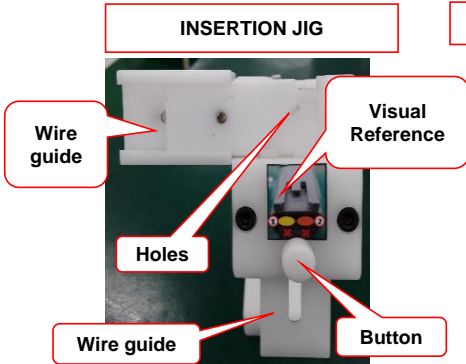
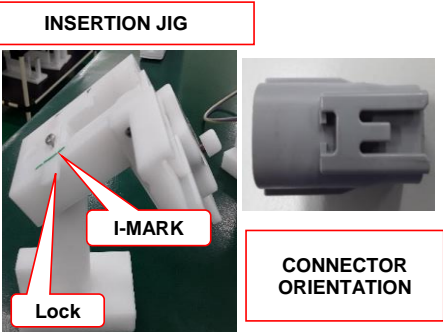

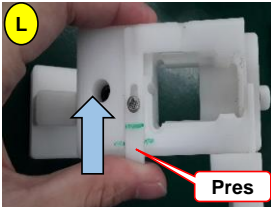
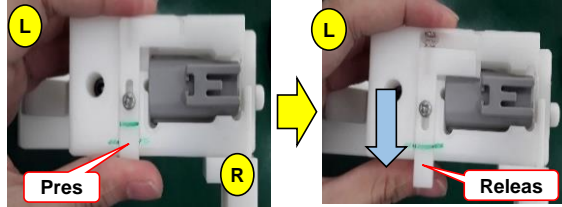
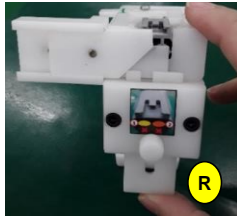
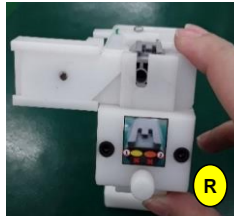


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PARTS:	1. Connector 6188-0066 (GR)			JIG:	1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
6	P2	<div><div><div><div>INSERTION JIG</div><div></div></div><div><div>INSERTION JIG</div><div></div><div></div><div>CONNECTOR ORIENTATION</div></div></div><div><div></div><div></div><div></div><div></div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector <b>6188-0066 (GR)</b> into jig using right hand then release the lock. <i>Note: Follow the connector orientation.</i></div><div>3. Push the guide using right thumb. The slot for <b>Y wire</b> will be opened.</div></div><div>n/a</div><div><div><div>Connector Orientation Illustration</div><div></div><div></div></div><div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</div></div></div>				

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320B / 7L0053-7025A

Customer:

TRQSS

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-1035A

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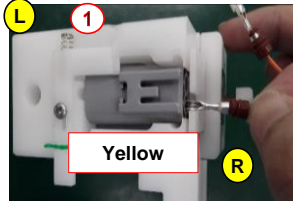
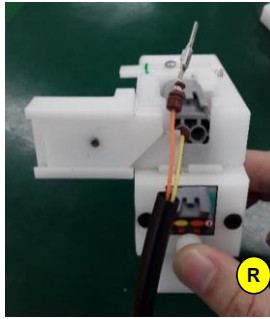
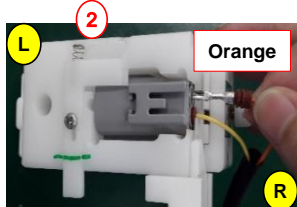
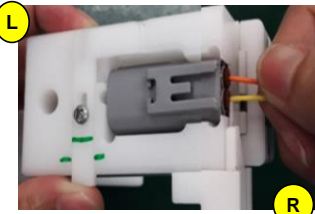

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PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P2	<div><div>TERMINAL FACING</div></div> <div><div>1. Hold the insertion jig using left hand. Get the assy parts, insert the <b>Yellow wire</b> to connector slot <b>1</b> using right hand.</div></div> <div><div>2. Press the button using right thumb, slot for <b>Orange wire</b> will be opened.</div></div> <div><div>3. Get <b>Orange wire</b> then insert to connector slot <b>2</b> using right hand.</div></div> <div><div>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.</div></div> <div></div>		n/a	<p><b>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"><li>1. Please hold the wire near terminal during insertion.</li><li>2. Make sure wires are properly inserted.</li></ol> <p>Conduct Pull-Push-Pull-Push after insertion. do not exert extra force.</p> <p><b>Document reference/s:</b></p> <ol style="list-style-type: none"><li>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</li></ol> <ol style="list-style-type: none"><li>1. No loose insertion</li><li>2. No wrong insertion</li><li>3. One by one insertion</li><li>4. No deformed terminal</li><li>5. No wrong wire facing</li></ol>

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### PARTS:

1. Assy parts

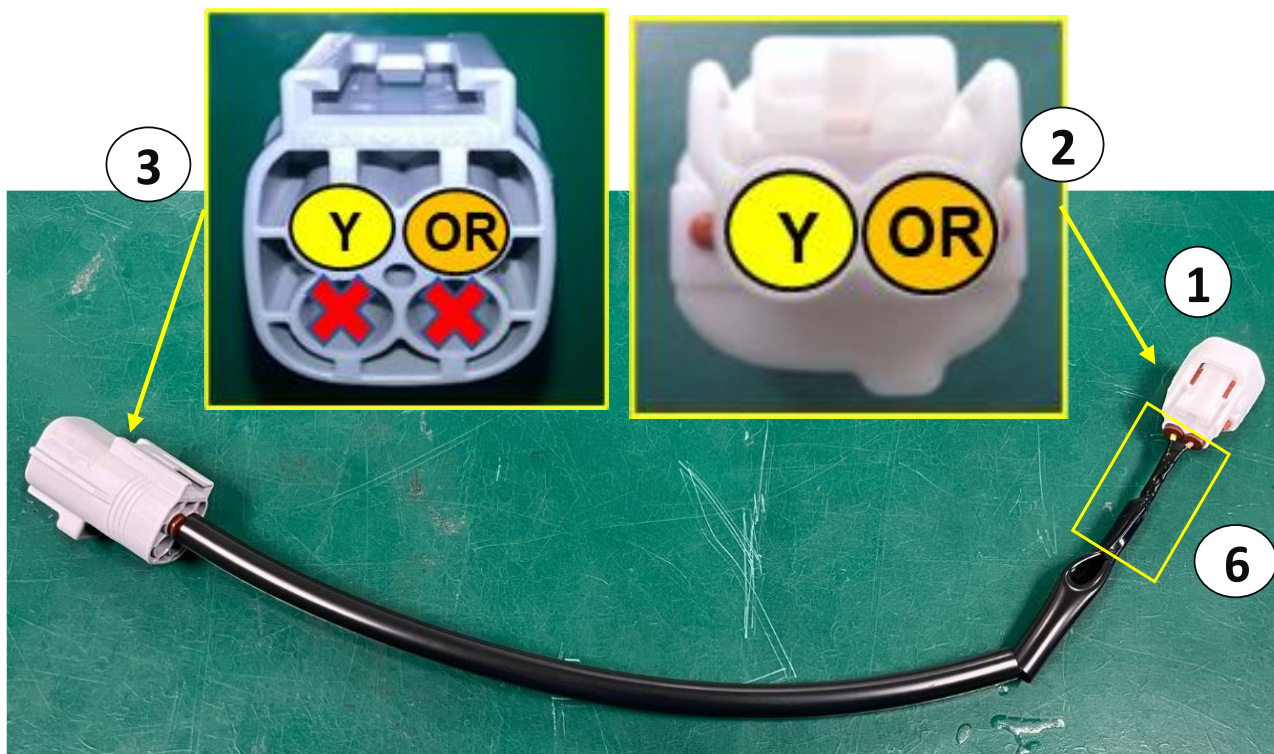
JIG:

n/a

### VISUAL INSPECTION/ QUALITY CHECKPOINTS

## TAPING - P1

## 7L0053-7025A



- ① No Unlocked/  
Half-locked connector
- ② ③ No Wrong Insert
- ④ No Deformed terminal
- ⑤ No Terminal backing  
out
- ⑥ No Missing Tape

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