

	<b>WORK INSTRUCTION</b>					Effectivity Date:		June 3, 2024		
	<b>TAPING ASSEMBLY PROCESS</b>					Validity Date:		-		
	Process Name/Title:		Model code/Part number: <b>011B / 7M0369-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-CAMRY</b>	Document No.:		<b>WI-ENG-PDE-175A</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		10		Page No.:	1 of 12

<b>PARTS:</b>	1. Assy parts; Connector 6098-2220 (W); Connector 6098-3802(W); Black Corrugated tube Ø5 L= 254±3mm (no slit); AVSSf 0.3 wires OR L=353±2mm; AVSSf 0.3 wires Y L=353±2mm; Black SV tube (Viny) Ø5 L= 30±3mm; AVSSf 0.3 wires B-B L=560±3m; Black Corrugated tube tube Ø5 L= 390±3mm (no slit); Black tape					JIG:	1. Insertion jig with& without switch cover 2. Locking jig			
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>					<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
1	P1	<div style="display: flex; justify-content: space-around;"> <div style="border: 1px solid red; padding: 5px; color: red; font-weight: bold;">TABLE LAY-OUT</div> <div style="border: 1px solid red; padding: 5px; color: red; font-weight: bold;">Connector 6098-3802(W)/ Connector tray</div> </div>					<div style="border: 1px dashed red; padding: 5px;"> <b>Safety Instruction</b>            Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> <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 style="border: 1px dashed red; padding: 5px; margin-top: 10px;"> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>	<b>Document reference/s:</b>  <b>1. Please refer to GL-PRO-ASY-029 for Pull-Push procedure.</b>		

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:								
6/03/24	10	Transferred to new format due to Document improvements. Aligned switch cover to insertion jig from (Y-OR) to (OR-Y) to prevent wrong insertion. Improved Work procedure/Illustration on page 1 to 11. Additional process (Connector setting to insertion jig 6098-2220): Improve measurement and Visual inspection/ Quality checkpoints	M. Ariola	C. Villanueva	Arañes	n/a									
6/21/23	9	Changed Table lay-out. Inclusion of Locking jig- Connector 6098-2220 (W). Inclusion of Quality checkpoints on page 11. Improve Quality pointers: Reminders/notes and reference/s on page 1-10; Improve Work procedure /Illustration on process no 12- Connector lock as Document process improvement s. Standardized tube description: SV tube (Vinyl)	M. Ariola	J. Loterte	C. Villanueva	A. Arañes									

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PARTS:		1. Connector 6098-2220(W)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<p>Connector setting to insertion jig 6098-2220(W)</p> <p><b>10</b> <b>INSERTION JIG ILLUSTRATION</b></p> <p>Visual reference</p> <p>OR-wire</p> <p>Y-wire</p> <p>I-mark</p> <p>Lock</p> <p><b>CONNECTOR ORIENTATION</b></p> <p><b>INSERTION JIG ORIENTATION</b></p> <p><b>L</b> <b>Press</b></p> <p>1. Press the lock of insertion jig using left thumb.</p> <p><b>L</b> <b>Release</b></p> <p>2. Insert the connector <b>6098-2220 (W)</b> into jig using right hand and release the lock. <b>Note: Follow the connector orientation.</b></p> <p><b>R</b> <b>Guide</b></p> <p>Hole</p> <p><b>R</b></p> <p>3. Push the guide using left hand. The slot for <b>Y wire</b> will be opened.</p>		n/a	<p><b>Connector Orientation Illustration</b></p> <p>I-mark is align</p> <p>1 hole is open</p> <p><b>GOOD</b></p> <p>I-mark is not align</p> <p>All holes were open</p> <p><b>NG</b></p> <p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p>

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PARTS:	1. AVSSf 0.3 wires Y L=353mm; OR L=353mm			JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	10 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1  Wire Insertion to Connector 6098-2220 (W)	<div data-bbox="725 336 770 376"></div> <div data-bbox="806 384 940 544"><p>VISUAL REFERENCE</p></div> <div data-bbox="1030 405 1225 515"><p>Wire facing</p></div> <div data-bbox="553 552 873 756"><p>Yellow wire</p></div> <div data-bbox="546 772 911 874"><p>1. Hold the insertion jig using left hand. Get the <b>Yellow wire</b> and insert to connector using right hand. Conduct <b>2x push-pull</b> after wire insertion.</p></div> <div data-bbox="931 552 1158 805"><p>2. Press the button using right thumb. Slot for <b>Orange wire</b> will be open.</p></div> <div data-bbox="582 903 907 1123"><p>Orange wire</p></div> <div data-bbox="557 1147 911 1241"><p>3. Get the <b>Orange wire</b> and insert to connector using right hand. Conduct <b>2x push-pull</b> after wire insertion.</p></div> <div data-bbox="1030 903 1330 1112"><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>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p><b>Important reminders/Note/s:</b></p> <p>1. Please hold the wire near terminal during insertion. 2. Insertion must be from left to right. 3. Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force</p> <p><b>Document reference/s:</b></p> <p>1. Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance. 2. Please refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>

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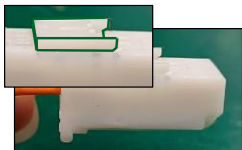

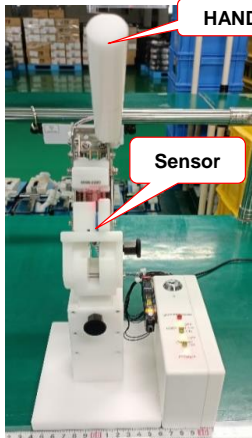
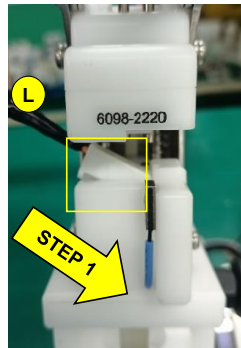
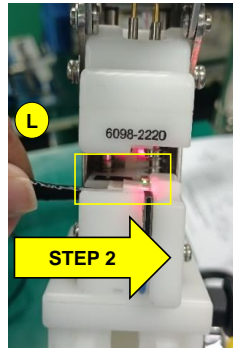
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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	10 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	Connector lock	<div><p><b>CONNECTOR RETAINER ILLUSTRATION</b></p><p><b>SIDE VIEW</b></p><div><p><b>GOOD</b></p></div><div><p><b>NG</b></p></div></div> <div><p><b>HANDLE</b></p><p><b>Sensor</b></p><p><b>RETAINER SENSOR</b></p><p><b>Sensor</b></p><p>6098-2220</p><div><p><b>STEP 1</b></p></div><div><p><b>STEP 2</b></p></div></div> <p>2. 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.</p> <p><b>NOTE: CONNECTOR LOCKING JIG WILL NOT FUNCTION IF CONNECTOR NOT REACH THE SENSOR.</b></p>		<p>1. Please ensure that Connector lock/retainer will not touch or hit by any object prior insertion into locking jig to avoid half-lock connector.</p> <p>2. Maintain 10mm proper holding of wire to connector</p> <p>3. Connector must be fully inserted to connector slot.</p> <p>4. Make sure no offset setting before locking process.</p> <p>5. No wrong setting of connector.</p> <p>6. No damaged connector lock</p> <p>7. No unlocked/ half-locked connector.</p> <p><b>Important reminders/Note/s:</b></p> <p><b>1. Incomplete locking process will alarm the jig.</b></p> <p><b>2. No retainer in connector cannot proceed.</b></p> <p><b>3. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</b></p>

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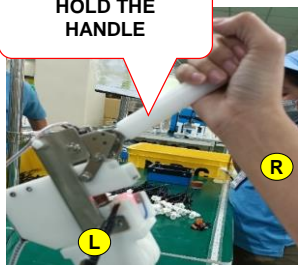
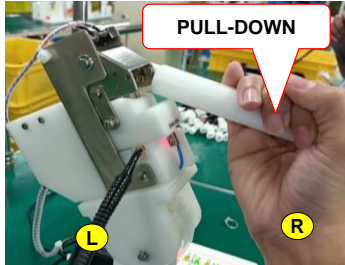
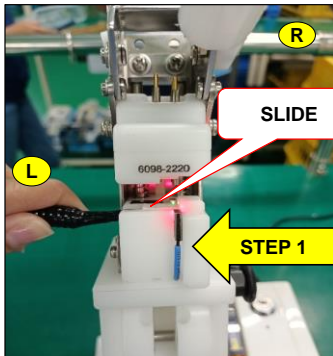
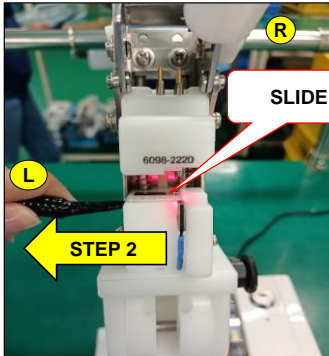
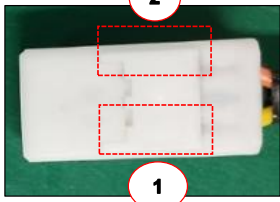


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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	10 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1  Connector lock (Continuation)	<div><div><div></div><div></div><div></div><div></div><div></div><div></div><div></div></div><div><p>3. 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><p>4. Remove the locked connector using left hand based on the illustration, follow the direction of arrow.</p><p>5. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div></div>			<p>1. Please ensure that Connector lock/retainer will not touch or hit by any object prior insertion into locking jig to avoid half-lock connector.</p> <p>2. Maintain 10mm proper holding of wire to connector</p> <p>3.Connector must be fully inserted to connector slot.</p> <p>4. Make sure no offset setting before locking process.</p> <p>5.No wrong setting of connector.</p> <p>6. No damaged connector lock</p> <p>7. No unlocked/ half-locked connector</p> <p><b>Important reminders/Note/s:</b></p> <p><b>1. Incomplete locking process will alarm the jig.</b></p> <p><b>2. No retainer in connector cannot proceed.</b></p> <p><b>3. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</b></p>

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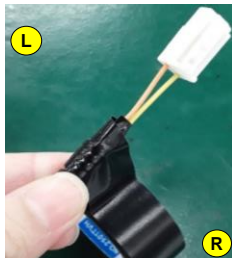
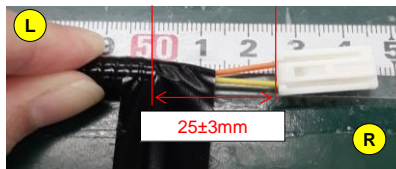
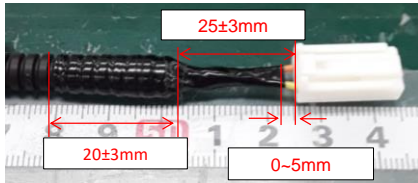

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PARTS:		1. Black Corrugated tube Ø5 L= 254±3mm (no slit) 2. Assy parts		3. Black tape		JIG:	n/a
NO.	PROCESS NAME		10 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS
5	P1	Wire insertion to Corrugated tube Ø5 L= 254±3mm (no slit)	<div><div></div><div>1. Get the corrugated tube Ø5 L=254±3mm (no slit) using right hand then insert the yellow wire and orange wire by using left hand.</div></div>		n/a	1. No wrong use of parts 2. No deformed terminal	
6		Taping 1 COT to wire near Connector	<div><div><div></div><div>1. Hold the assy parts using left hand. Get Black tape using right hand and start pre-taping.</div></div><div><div></div><div>2. Measure from COT to Connector 25±3mm using both hands and continue the taping process.</div></div><div><div></div><div>3. After taping, check the measurement and taping condition.</div></div></div>		<div>MEASURING TAPE</div> <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  <b>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b>	

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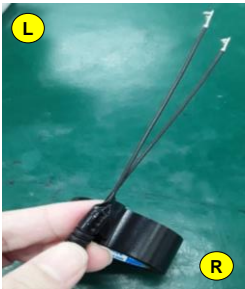
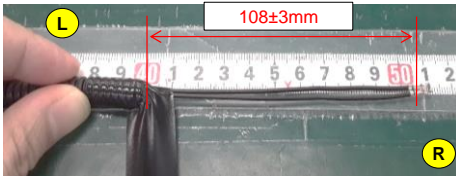
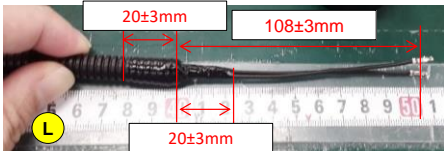

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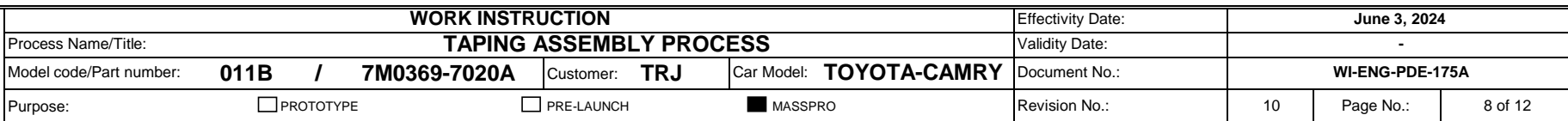
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PARTS:		1. Black tape 2. Black Corrugated tube tube Ø5 L= 390±3mm (no slit)		3. AVSSf 0.3 wires B-B L=560±3m [2pcs] 4. Assy parts		JIG:	n/a
NO.	PROCESS NAME	10 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
7	Wire insertion to Corrugated tube tube Ø5 L= 390±3mm (no slit)			1. Get the corrugated tube Ø5 L= 390±3mm (no slit) using left hand then insert the 2 Black wires by using right hand.		n/a	
8	Taping 2 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 terminal pointed tip 108±3mm using both hands and continue the taping process</p>  <p>3. Check the measurement, wire alignment and taping condition after taping.</p>		 <p>MEASURING TAPE</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  <b>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b>	

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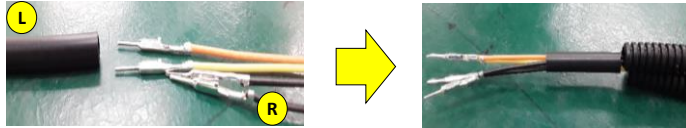



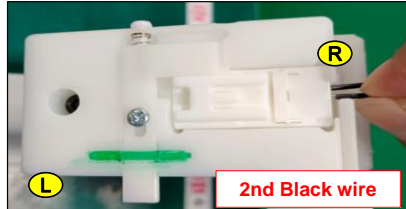
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PARTS:		1.Black SV tube (Viny) Ø5 L= 30±3mm 2. Assy parts		JIG:	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	Wire insertion to Black SV tube (Viny) Ø5 L= 30±3mm	 1. Combine the assy parts (Y-OR wires with COT Ø5 L= 254±3mm and 2 Black wires with COT Ø5 L= 390±3mm) then get the SV tube (Viny) Ø5 L= 30±3mm using left hand and insert the wires using right hand.		n/a	1. No wrong use of parts
11	Wire insertion to Connector 6098-3802 (W)	    1. Hold the insertion jig using left hand. Insert the 1st Black wire to connector using right hand. Conduct 2x push-pull after insertion. 2. Get the 2nd Black wire then insert to connector using right hand. Conduct 2x push-pull after insertion. 3. Press the lower guide using right hand. Slot for Yellow wire will be open.		n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing  <b>Important reminders/Note/s:</b> 1. Please hold the wire near terminal. 2. Insertion must be from left to right. 3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.  <b>Document references:</b> 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
11	P1	<p>Wire insertion to connector 6098-3802 (W) (Continuation)</p> <p>4. Hold the insertion jig using left hand. Get the <b>Yellow wire</b> to connector using right hand. Conduct <b>2x push-pull</b> after insertion.</p> <p>5. Press the button of insertion jig using right hand and slot for <b>Orange wire</b> will be open.</p> <p>6. Hold the insertion jig using left hand. Get the <b>Orange wire</b> to connector using right hand. Conduct <b>2x push-pull</b> after insertion.</p> <p>7. 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>	n/a	<p>1. Use the provided jig per model</p> <p>2. No wrong orientation of connector</p> <p>3. No wrong use of connector</p> <p>4. No damaged connector</p> <p><b>Important reminders/Note/s:</b></p> <p><b>1. Please hold the wire near terminal.</b></p> <p><b>2. Make sure wires are properly inserted.</b></p> <p><b>Conduct Pull-Push-Pull-Push after insertion.</b></p> <p><b>Do not exert extra force.</b></p> <p><b>3. Insertion of wires must be from left to right</b></p> <p><b>Document references:</b></p> <p><b>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b></p>	

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Model code/Part number:

011B

/ 7M0369-7020A

Customer: TRJ

Car Model: TOYOTA-CAMRY

Validity Date:

-

Document No.:

WI-ENG-PDE-175A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


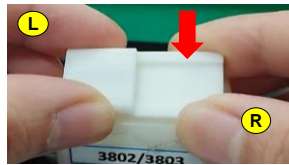



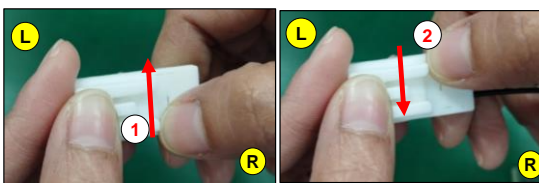





☒ MASSPRO

Revision No.:

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Page No.:

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PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	10 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
12	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>6. 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><p>After pressing</p></div> <div><div><p>GOOD Full Lock</p></div><div><p>NG Half Lock</p></div></div> <p><b>Important reminders/Note/s:</b> 1. Manual locking may cause damaged connector lock.</p>

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

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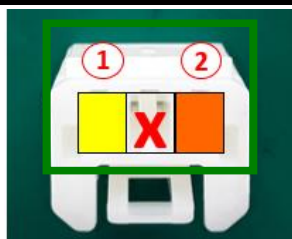
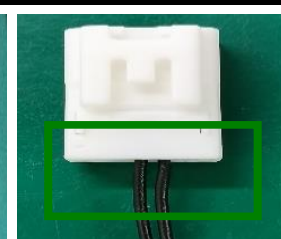
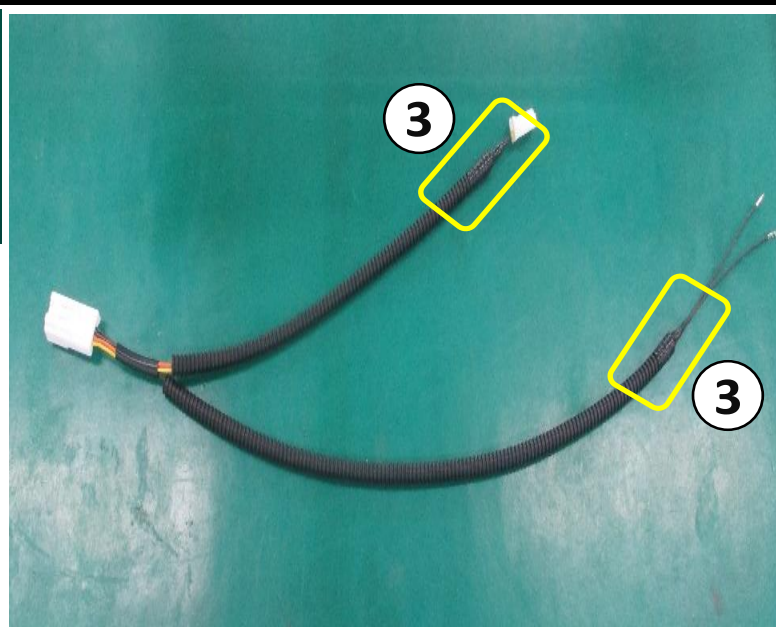
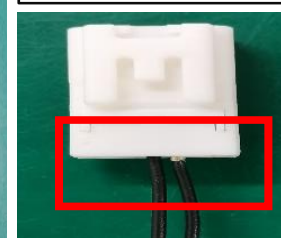
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PARTS:

JIG:

**VISUAL INSPECTION / QUALITY CHECKPOINTS****P1****7M0369-7020A****GOOD****GOOD****GOOD****GOOD****NO GOOD****NO GOOD****NO GOOD****NO GOOD**

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

**2** No **Wrong Insert**  
(on 2 connector)

**3** No **Missing Tape**

**4** No **Terminal**  
**Backing Out**

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