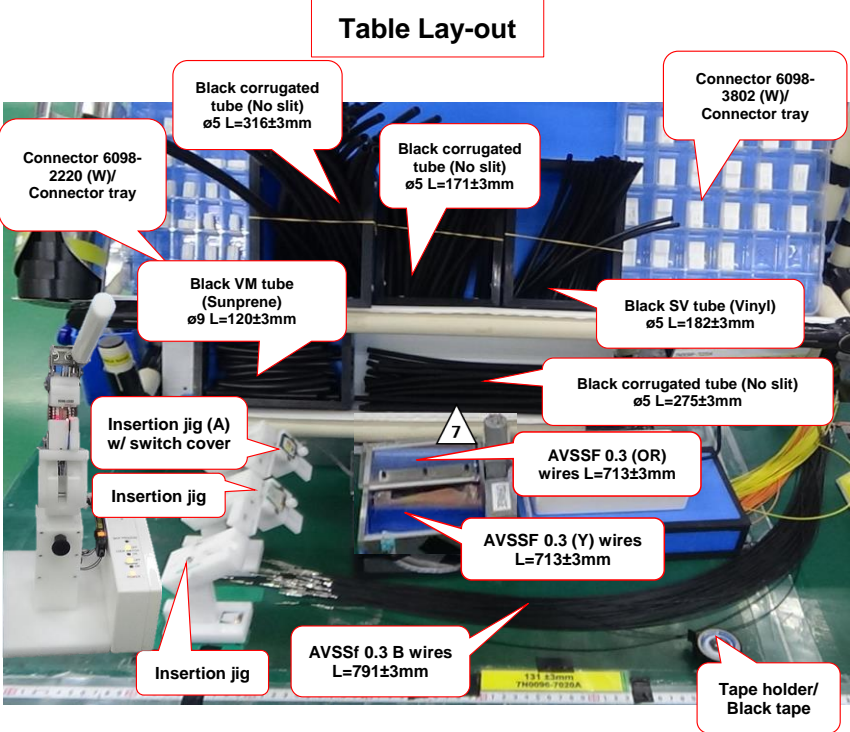
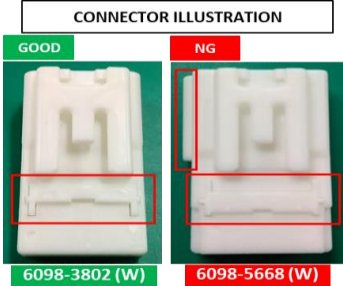


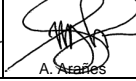
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	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 101D / 7N0097-7020A		Customer: TRJ		Car Model: TOYOTA-RAV4	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.: WI-ENG-PDE-239A		Revision No.: 7		Page No.: 1 of 12	

PARTS:		1. Connector 6098-2220 (W); Connector 6098-3802 (W); AVSSF 0.3 B wires L=791±3mm; AVSSF 0.3 Y-OR wires L=713±3mm; Black corrugated tube (No slit) Ø5 L=316±3mm; Black corrugated tube Ø5 L=171±3mm; Black corrugated tube (No slit) Ø5 L=275±3mm; Black SV tube (Vinyl) Ø5 L=182±3mm;Black VM tube (Sunprene) Ø9 L=120±3mm; Black tape		JIG:		1. Insertion jig with switch cover	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
1	P1	<div>Table Lay-out</div> 		<div>Safety Instruction</div> <p>Be sure to wear required 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>CONNECTOR ILLUSTRATION</div>  <div>1. No missing parts/tools 2. No excess parts/tools</div> <div>Document reference/s:</div> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p>	

Revision History				Prepared by		Reviewed by		Approved by		Noted by	
07/26/24	7	Additional Work procedure/Illustration and notes on page 4-5 as countermeasure for the customer claim (Broken lock of connector 6098-2220 (W)). Aligned switch cover to insertion jig.		D. Castillo	C. Villanueva	C. Villanueva	A. Arañes				
07/26/23	6	Change Table lay-out; Change Quality Checkpoints; Inclusion of Locking process of Connector 6098-2220 (W); Transferred process no.13,14,15,16 and 17 from P1 to P2 due to new process distribution; Improve Quality pointers/Note/s and reference/s (pg.4 and 5-process 4).		M.Ariola	J.Loterte	C. Villanueva	A. Arañes				
04/04/23	5	Correction of Part number from 7N0097-7020 to 7N0097-7020A. Change term from Vinyl tube to SV tube (Vinyl) and Sunprene tube to VM tube (Sunprene).		D. Castillo	C. Villanueva	C. Villanueva	A. Arañes				n/a
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted	Est. Date:	March 9, 2021		

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TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

101D / 7N0097-7020A

Customer:

TRJ

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-239A

Purpose:

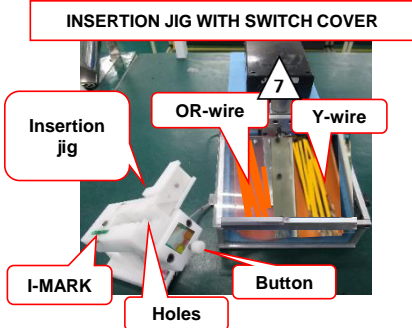
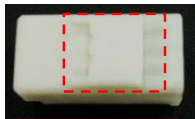
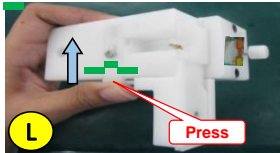
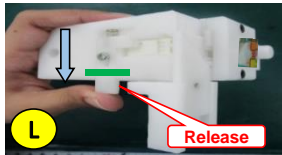
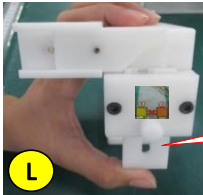
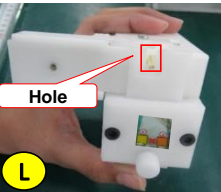
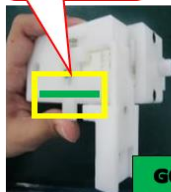
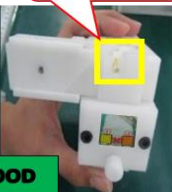
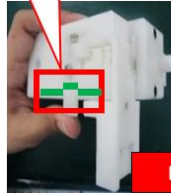

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PARTS:		1. Connector 6098-2220 (W)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<div><div><div><div><div>INSERTION JIG WITH SWITCH COVER</div><div></div></div></div><div><div>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

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

July 26, 2024

Model code/Part number:

101D / 7N0097-7020A

Customer:

TRJ

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-239A

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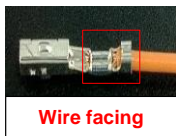
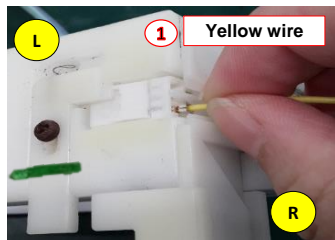
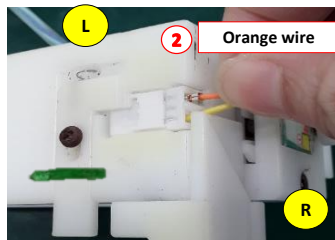
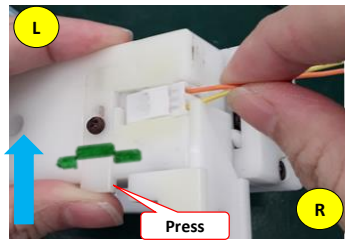
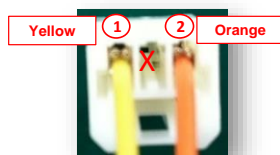
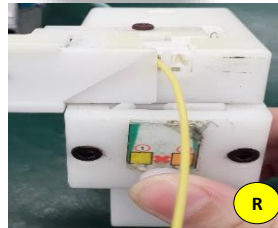
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PARTS:	1. AVSSf 0.3 Y/OR wires L=713±3mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to connector 6098-2220 (W)	<div><div><p>Wire facing</p></div><div><p>1 Yellow wire</p></div><div><p>2 Orange wire</p></div><div><p>Press</p></div><div><p>1. Hold the insertion jig using left hand. Get the Y wire and insert to connector using right hand.</p><p>2. Press the button using right thumb the slot for OR wire will be opened.</p><p>3. Get the OR wire and insert to connector using right hand.</p><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><div><p>Yellow 1 2 Orange</p></div><div></div></div> <div>n/a</div> <div><p>Important reminders/Note/s:</p><p>1. Please hold the wire near terminal during insertion.</p><p>2. Insertion must be from left to right.</p><p>3. Make sure wires are properly inserted.</p><p>conduct Pull-Push-Pull-Push after insertion.</p><p>Do not exert extra force.</p><p>1. No loose insertion</p><p>2. No wrong insertion</p><p>3. One by one insertion</p><p>4. No deform terminal</p><p>5. No wrong wire facing</p><p>Document references/:</p><p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</p><p>2. Refer to GL-PRO-ASY-017 for Pull-Push procedure.</p></div>		

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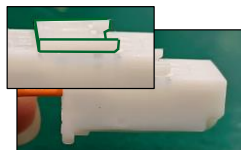
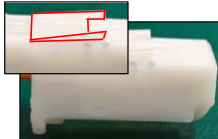
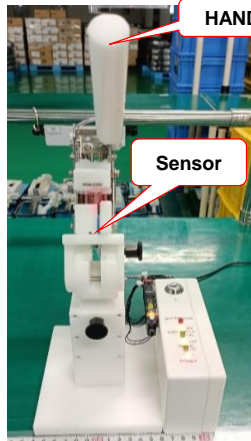
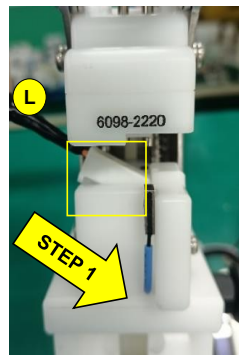
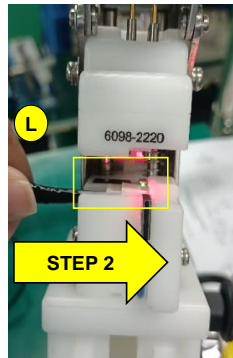
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PARTS:	1. Assy parts	JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1 <div>Connector lock</div>	<div><div><div>CONNECTOR RETAINER ILLUSTRATION</div><div>SIDE VIEW</div><div><div></div><div>GOOD</div></div><div><div></div><div>NG</div></div></div><div><div><div></div><div><div></div><div><div></div></div></div><div>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. NOTE: CONNECTOR LOCKING JIG WILL NOT FUNCTION IF CONNECTOR NOT REACH THE SENSOR.</div></div><div>1. Check the Retainer lock of connector before insertion to locking jig. <i>Note: Must be NO half-locked condition prior connector locking.</i></div></div></div>		<div>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.</div> <div>2. Maintain 10mm proper holding of wire to connector</div> <div>3.Connector must be fully inserted to connector slot.</div> <div>4. Make sure no offset setting before locking process.</div> <div>5.No wrong setting of connector.</div> <div>6. No damaged connector lock</div> <div>7. No unlocked/ half-locked connector.</div> <div>Important reminders/Note/s:</div> <div>1. <i>Incomplete locking process will alarm the jig.</i></div> <div>2. <i>No retainer in connector cannot proceed.</i></div> <div>3. <i>If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</i></div>

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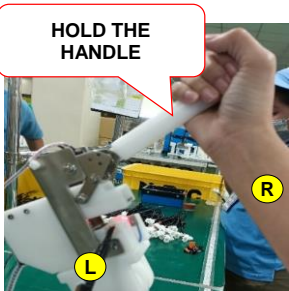

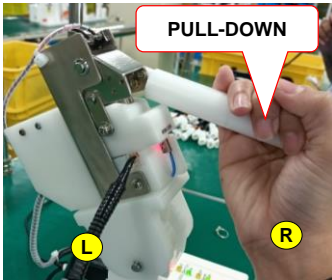

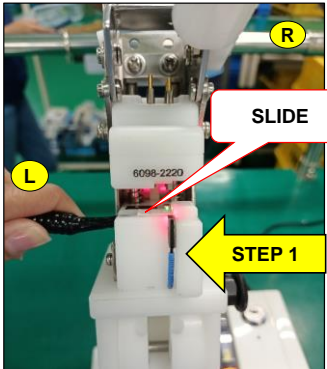

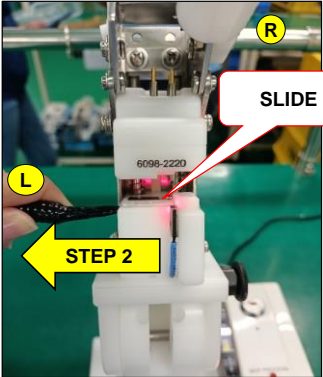

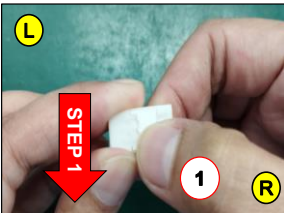
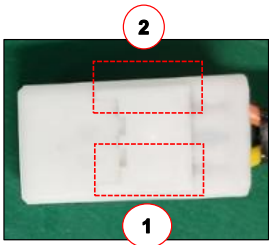
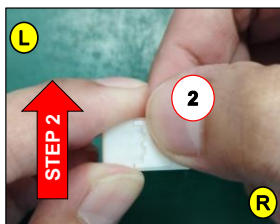
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PARTS:

1. Assy parts

JIG:


n/a




NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	Connector lock (Continuation)	<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>Important reminders/Note/s:</p><p>1. <i>Incomplete locking process will alarm the jig.</i></p><p>2. <i>No retainer in connector cannot proceed.</i></p><p>3. <i>If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction and continue the process.</i></p></div>			

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	Process Name/Title:		Model code/Part number: 101D / 7N0097-7020A		Customer: TRJ	Car Model: TOYOTA-RAV4		Document No.: WI-ENG-PDE-239A
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		7	Page No.: 6 of 12

PARTS:		1. Assy parts 2. Black corrugated tube (no slit) Ø5 L=316±3mm		3. Black corrugated tube (no slit) Ø5 L=171±3mm 4. Black SV tube (Vinyl) Ø5 L=182±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS
5	Wire insertion to Black corrugated tube (no slit) Ø5 L=316±3mm Ø5 L=171±3mm	<div><div>1. Get the corrugated tube Ø5 L=316±3mm using right hand then insert the Y-OR wire using left hand.</div></div> <div><div>2. Get the corrugated tube Ø5 L=171±3mm using right hand then insert the Y-OR wire using left hand.</div></div>				n/a	1. No wrong use of parts 2. No deformed terminal
6	Wire insertion to Black SV tube (Vinyl) Ø5 L=182±3mm	<div><div>1. Get the Black SV tube (Vinyl) Ø5 L=182±3mm using right hand then insert the Y-OR wire using left hand.</div></div>				n/a	1. No wrong use of parts 2. No deformed terminal

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101D / 7N0097-7020A

Customer:

TRJ

Car Model:

TOYOTA-RAV4

Document No.:

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Purpose:

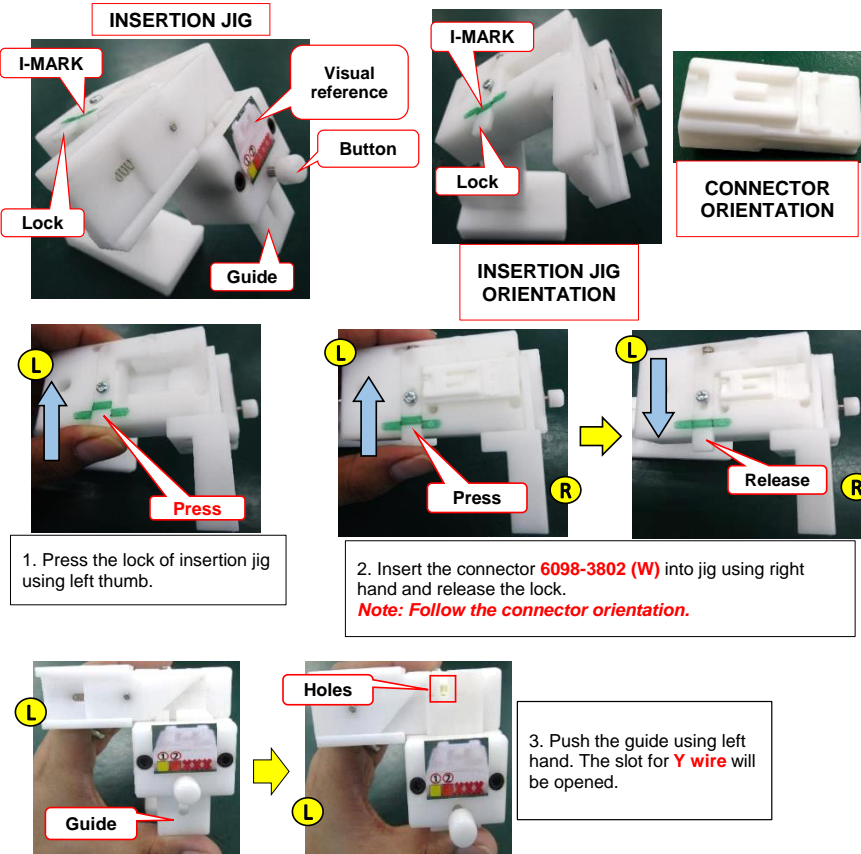
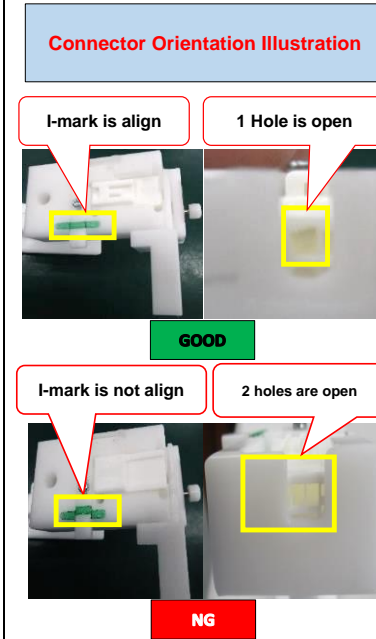
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PARTS:		1. Connector 6098-3802 (W)		JIG:	1.Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1 Connector setting to insertion jig 6098-3802 (W)			n/a	 1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector

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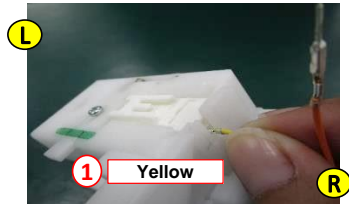
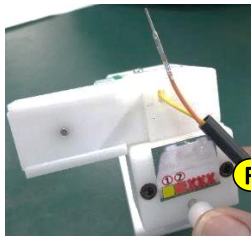
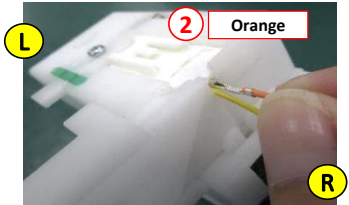
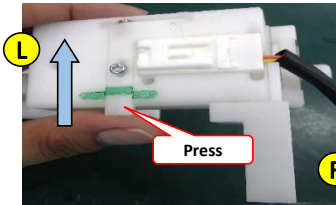
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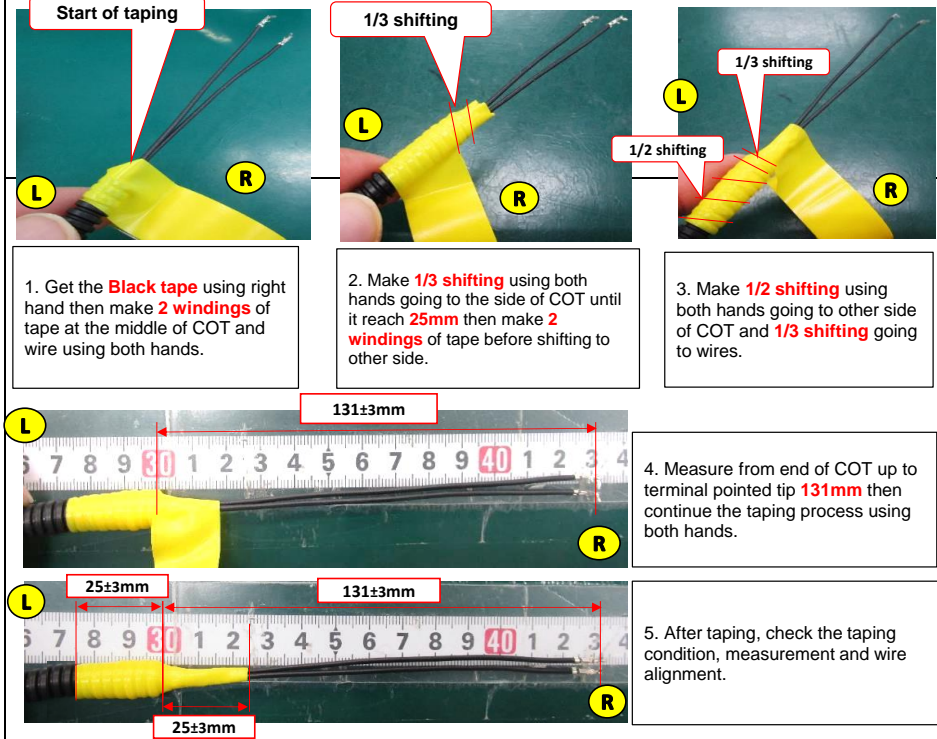
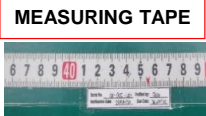
PARTS:		1. Assy parts		JIG:	1.Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1 Wire insertion to connector 6098-3802 (W)	<div><p>WIRE FACING</p></div> <div><p>1. Get the assy part and hold the Y wire then insert to terminal slot 1 using right hand.</p></div> <div><p>2. After insertion of Y wire press the button using right thumb. Slot for OR wire will be opened.</p></div> <div><p>3. Get the OR 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><p>NOTE: Set aside the assy parts.</p></div>		n/a	<p>Important reminders/Note/s:</p> <ul style="list-style-type: none">1. Please hold the wire near terminal during insertion.2. Insertion must be from left to right.3. Make sure wires are properly inserted. <p>conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <ul style="list-style-type: none">1. No loose insertion2. No wrong insertion3. One by one insertion4. No deform terminal5. No wrong wire facing

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	WORK INSTRUCTION				Effectivity Date:	July 26, 2024		
	TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Process Name/Title:		Model code/Part number: 101D / 7N0097-7020A		Customer: TRJ	Car Model: TOYOTA-RAV4		Document No.: WI-ENG-PDE-239A
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		7	Page No.:	9 of 12	

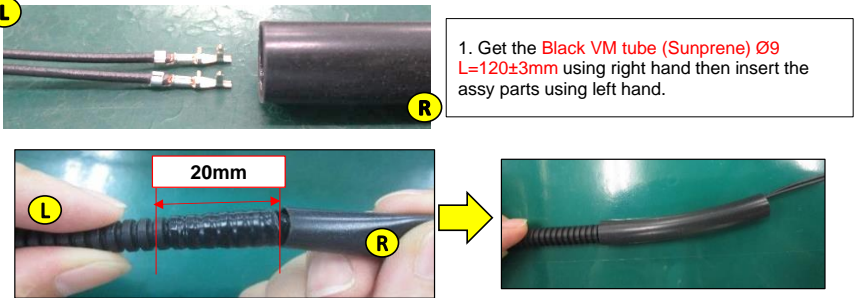
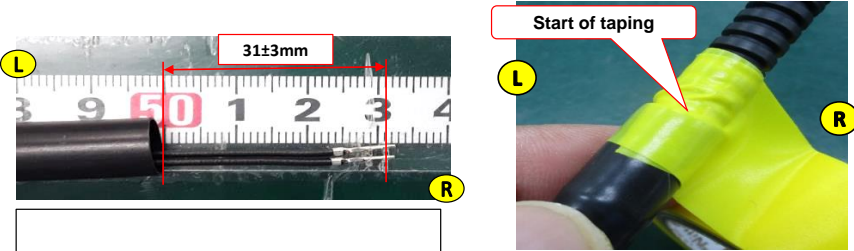

PARTS:	1. Assy parts 2. AVSSf 0.3 B-B wires L=791±3mm [2pcs.] 3. Black corrugated tube (no slit) Ø5 L=275±3mm 4. Black tape			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	Wire insertion to Black Corrugated tube (no slit) Ø5 L=275±3mm			n/a	1. No wrong usage of parts 2. No deformed terminal Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
10	P1 Taping 1 Black corrugated tube to wire near terminal				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. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement. Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.

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	WORK INSTRUCTION			Effectivity Date:	July 26, 2024		
	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Process Name/Title:			Document No.:	WI-ENG-PDE-239A		
	Model code/Part number: 101D / 7N0097-7020A		Customer: TRJ	Car Model: TOYOTA-RAV4	Revision No.: 7 Page No.: 10 of 12		
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO							

PARTS:	1. Assy parts 2. Black VM tube (Sunprene) Ø9 L=120±3mm 3. Black tape			JIG:	n/a			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
11	Wire insertion to Black VM tube (Sunprene) Ø9 L=120±3mm	<div><p>1. Get the Black VM tube (Sunprene) Ø9 L=120±3mm using right hand then insert the assy parts using left hand.</p><p>2. Insert the VM tube (Sunprene) to COT 20mm (Tape width)</p></div>			n/a	1. No wrong use of parts 2. No deformed terminal		
12	P1 Taping 2 Black VM tube (Sunprene) to Black corrugated tube (no slit) near terminal	<div><p>1. Measure from end of VM tube (Sunprene) up to terminal pointed tip 31±3mm using both hands.</p><p>2. Get the Black tape using right hand then make 2 windings of tape at the middle of VM tube (Sunprene) and COT using both hands.</p></div>			<div></div>	<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</div> <div>Important reminders/Note/s: 1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</div>		

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Document No.:

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Purpose:

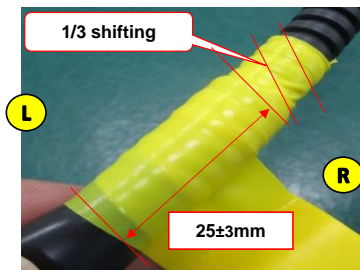



☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
12	P1 Taping 2 Black VM tube (Sunprene) to Black corrugated tube (no slit) near terminal (Continuation)	 <p>3. Make 1/3 shifting using both hands going to the side of sunprene until it reach 25±3mm then make 2 windings of tape before shifting to other side.</p>  <p>4. Make 1/2 shifting using both hands going to other side of COT then make 3 windings of tape and cut the tape.</p>  <p>5. After taping, check the taping condition and measurement.</p>			<p>Important reminders/Note/s:</p> <p>1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>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</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p>

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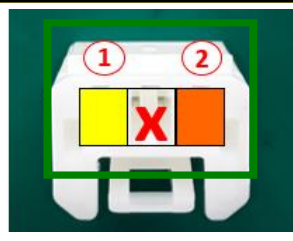
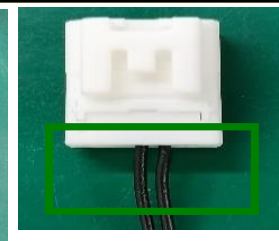
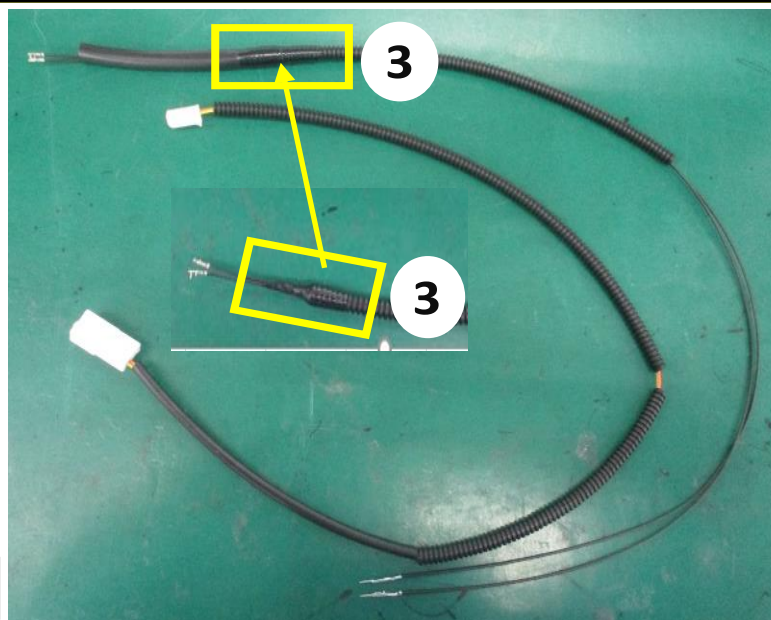
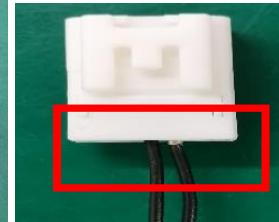
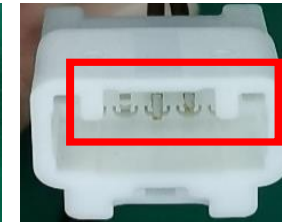
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**P1****7N0097-7020A****GOOD****GOOD****GOOD****GOOD****NO GOOD****NO GOOD****NO****NO****1****No Unlock/
Halflocked Connector****2****No Wrong Insert
(on 2 connector)****3****No Missing Tape**
(taping on COT-wire and
taping on VM tube
(Sunprene))**4****No Terminal Backing
Out**

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