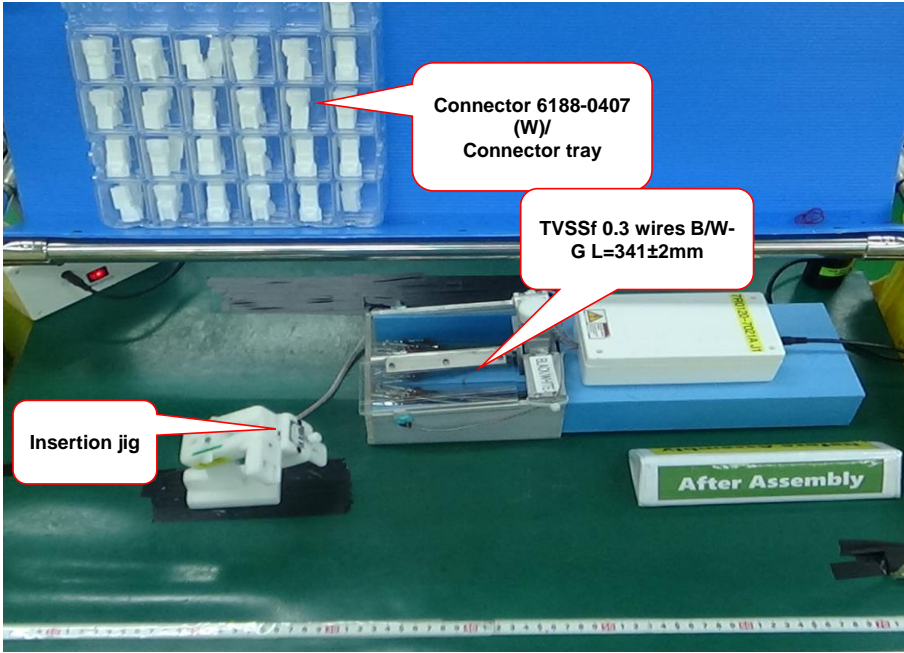




WORK INSTRUCTION
OFFLINE ASSEMBLY PROCESS

Effectivity Date:	June 24, 2024		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-927		
Revision No.:	0	Page No.:	1 of 5

Process Name/Title:	OFFLINE ASSEMBLY PROCESS		
Model code/Part number:	920B / 7R0120-7021A	Customer:	TRMX
		Car Model:	TOYOTA-TACOMA
Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO

PARTS:	1. All parts: Connector 6188-0407 (W); TVSSf 0.3 wires G-B/W L=341±2mm;			JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	n/a	Table Lay-out	<div><p>Table Lay-out</p><p>Connector 6188-0407 (W)/ Connector tray</p><p>TVSSf 0.3 wires B/W- G L=341±2mm</p><p>Insertion jig</p><p>After Assembly</p></div>	<div><p>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p><p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p><p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p></div>	<p>Document reference/s: 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
06/24/24	0	Initial issue. Transfer insertion process and align insertion to crisscross improvement from Taping assembly process.	A.Hernandez C. Villanueva A. Arañes n/a	A.Hernandez C. Villanueva A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised Reviewed Approved Noted	Est. Date:	June 24, 2024

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PARTS:	1. Connector 6188-0407 (W)		JIG:	1.Insertion jig with flip cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	n/a Connector setting to Insertion jig 6188-0407 (W)	<div><div>INSERTION JIG WITH FLIP COVER</div><div><div><div>Visual reference</div><div>Insertion jig</div><div>Switch cover</div><div>GREEN</div><div>BLACK/WHITE</div></div><div><div>Lock</div><div>I-mark</div><div>Holes</div></div><div>CONNECTOR ORIENTATION</div></div><div><div><div>L</div><div>↑</div><div>Press</div></div><div>1. Press the lock of insertion jig using left thumb.</div><div><div><div>L</div><div>↑</div><div>Press</div><div>R</div></div><div>2. Insert the connector 6188-0407 (W) into jig using right hand and release the lock.</div><div>Note: Refer to above illustration for correct setting.</div><div><div><div>L</div><div>↓</div><div>Release</div><div>R</div></div><div>3. Check the holes/terminal slot for B/W wire.</div></div><div></div></div></div></div>	n/a	<div><div>Connector Orientation Illustration</div><div><div><div>I-mark is align</div><div>1 hole is open</div></div><div><div>GOOD</div><div>NG</div></div></div><div><div><div>I-mark is not align</div><div>1 hole is open</div></div><div><div>NG</div></div></div><div>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</div></div>

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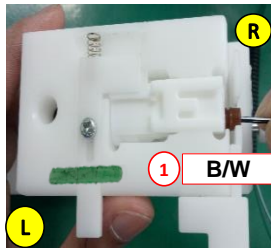
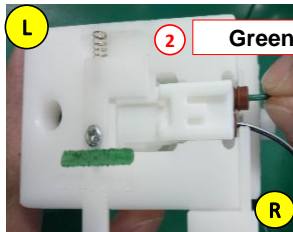
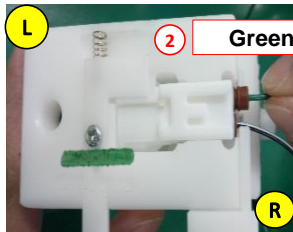
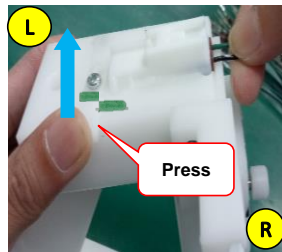
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. TVSSf 0.3 wires G-B/W L=341±2mm		JIG:	1. Insertion jig with flip cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	n/a	<div><div><div></div><div></div></div><div><div></div><div></div></div><div>1. Hold the Insertion jig using left hand. Get Black /White wire then insert to terminal slot 1 using right hand.</div><div>2. Push the button using right hand. The slot for Green wire will be opened.</div><div>3. Get Green wire then insert to terminal slot 2 using right hand.</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>	n/a	<p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal.</p> <p>2. Make sure wires are properly inserted.</p> <p>Conduct <u>Pull-Push-Pull-Push</u> after insertion.</p> <p>Do not exert extra force.</p> <p>3. Insertion of wires must be from left to right</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No loose insertion</p> <p>2. No wrong insertion</p> <p>3. One by one insertion</p> <p>4. No deformed terminal</p> <p>5. No wrong wire facing</p>

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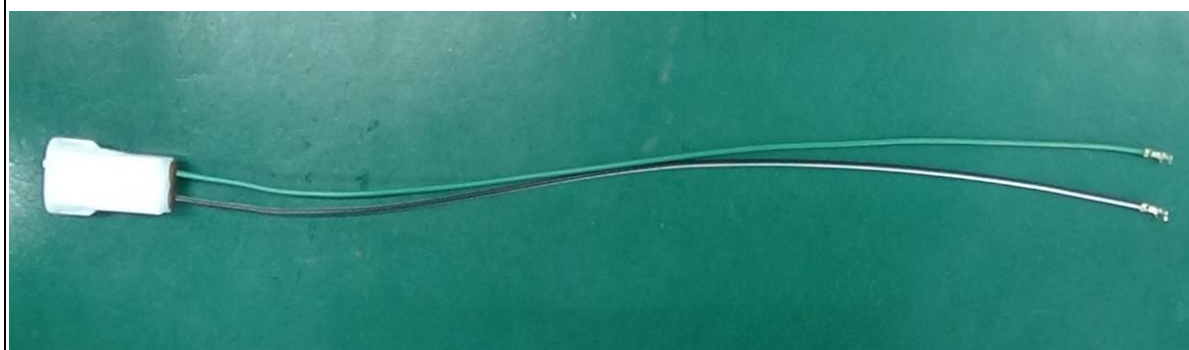
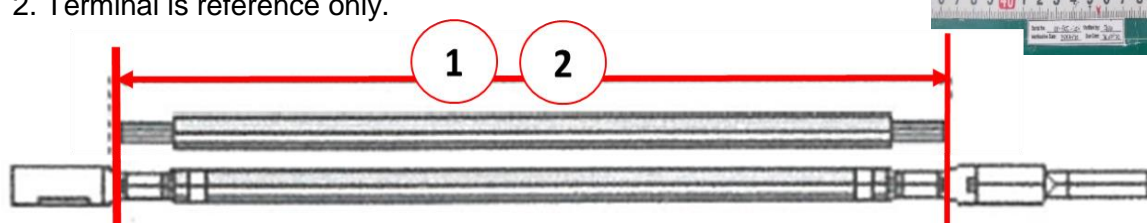
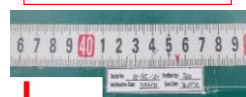
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		n/a		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	n/a	Measurement	<div><p>Note:</p><p>1. Measurement point: End of core wire to the end of core wire</p><p>2. Terminal is reference only.</p></div>	<div>Measuring tape</div> 	<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection.</p> <p>1. No wrong dimension</p>

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PARTS:

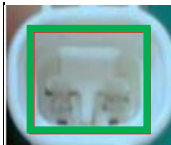
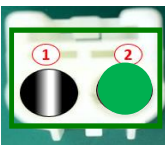
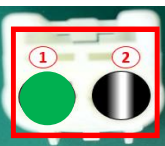
n/a

JIG:

n/a

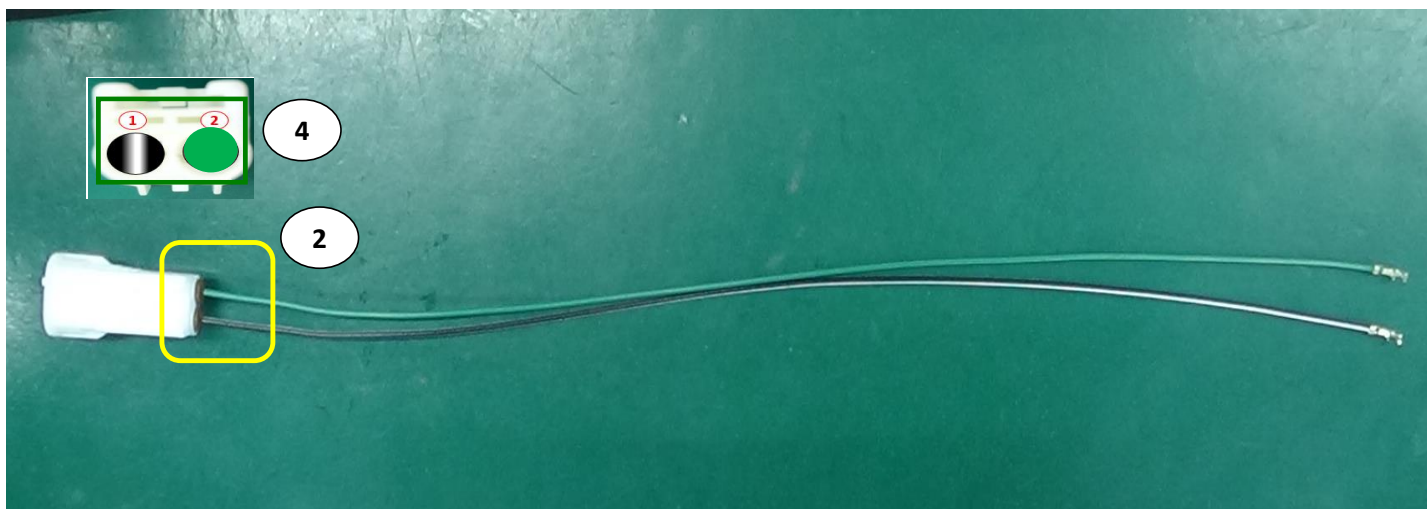
VISUAL INSPECTION/QUALITY CHECKPOINTS**OFFLINE INSERTION****7R0120-7021A**

1

**GOOD****NO GOOD****GOOD****NO GOOD**

4

2



3

**GOOD****NO GOOD**

1

No Locked Connector

3

No Terminal Backing Out

2

No Wrong Insert

4

No Deformed Terminal

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