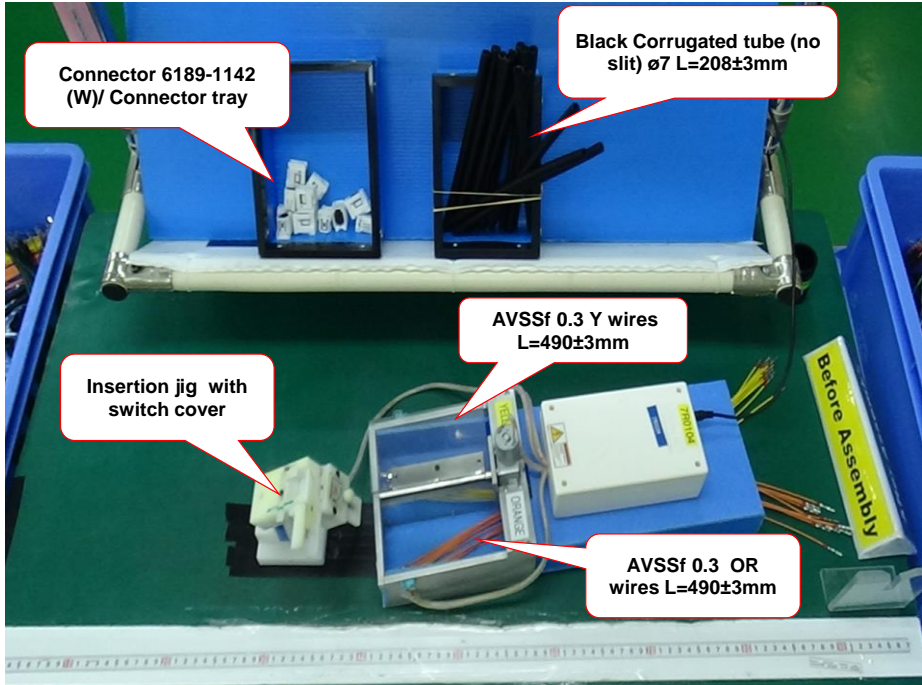
	<b>WORK INSTRUCTION</b>				Effectivity Date:	February 13, 2024			
	<b>OFFLINE ASSEMBLY PROCESS</b>				Validity Date:	n/a			
	Process Name/Title:		Model code/Part number: <b>780B / 7R0104-7023A</b>		Customer: <b>TRMX</b>	Car Model: <b>TOYOTA-TUNDRA</b>	Document No.:	<b>WI-ENG-PDE-831</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO		Revision No.:	0	Page No.:

<b>PARTS:</b>		1. Connector 6189-1142 (W); AVSSf 0.3 Y-OR L=490±3mm; Black corrugated tube (no slit) ø7 L=208±3mm				JIG:	1. Insertion jig with switch cover		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>				<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
1	n/a	<div style="text-align: center;"> <b>TABLE LAY-OUT</b> </div> 				<div> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div> <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> <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> 1. Please refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length tolerance		
		Revision History				Prepared by	Reviewed by	Approved by	Noted by
02/13/24	0	Initial issue.				D.Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted

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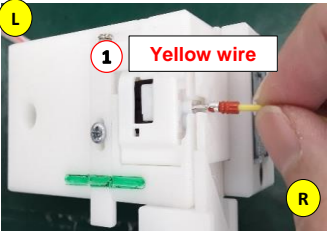
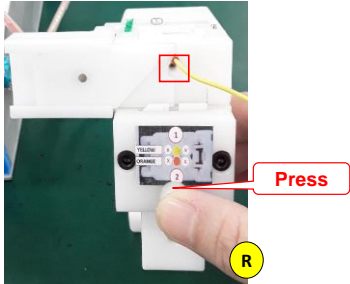
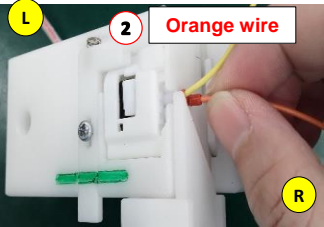
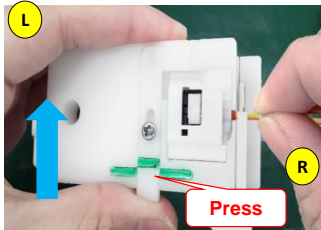
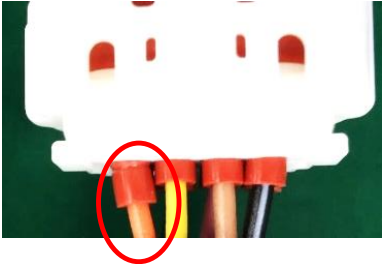
PARTS:	1. Connector 6189-1142 (W)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	n/a  Connector setting to insertion jig 6189-1142 (W)	<div><div>INSERTION JIG WITH SWITCH COVER</div><div><div>Y wire</div><div>OR wire</div><div>I-MARK</div><div>Lock</div><div>Visual reference</div><div>Button</div><div>Guide lock</div></div><div><div>1. Press the lock of insertion jig using left thumb.</div><div><div>Press</div><div>L</div></div></div><div><div>2. Insert the connector 6189-1142 (W) into jig using right hand and release the lock.</div><div><div>Release</div><div>L</div><div>R</div></div></div><div><div>3. Press the guide using left thumb. The slot for Y wire will be opened.</div><div><div>Guide</div><div>L</div></div></div><div><div>INSERTION JIG ORIENTATION</div><div>CONNECTOR ORIENTATION</div></div></div> <div>N/A</div> <td><div>1. Use the provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div><div>CONNECTOR ORIENTATION ILLUSTRATION</div><div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div></div></td>	<div>1. Use the provided jig per model</div> <div>2. No wrong usage of parts</div> <div>3. No wrong orientation of connector</div> <div>4. No damaged connector</div> <div>CONNECTOR ORIENTATION ILLUSTRATION</div> <div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div></div>	

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	WORK INSTRUCTION			Effectivity Date:	February 13, 2024		
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	Model code/Part number: 780B / 7R0104-7023A		Customer: TRMX	Car Model: TOYOTA-TUNDRA	Document No.:	WI-ENG-PDE-831	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	0	Page No.:	3 of 5

PARTS:	1. Connector 6189-1142 (W) 2. AVSSf 0.3 Y L=490±3mm; OR wire L=490±3mm			JIG:	1. Insertion jig with switch cover		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
3	n/a	<div><div>WIRE FACING</div></div> <div><div>1 Yellow wire</div></div> <div><div>Press</div></div> <div><div>2 Orange wire</div></div> <div><div>Press</div></div> <div>1. Hold the insertion jig using left hand. Get the <b>Y wire</b> and insert to connector using right hand.</div> <div>2. Press the button using right thumb. The slot for <b>OR wire</b> will be opened.</div> <div>3. Get the <b>OR wire</b> and insert to connector 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>		N/A	<div></div> <div><b>Important reminders/Note/s:</b> 1. Make sure wires are properly inserted.  Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.  2. During insertion, hold the wire not rubber seal to prevent sagging.</div> <div><b>Document reference/s:</b> 1. Please refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length tolerance.  2. Please refer to <b>GL-PRO-ASY-029</b> for Pull-Push procedure.</div>		

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<b>PARTS:</b>		1. Assy parts 2. Black corrugated tube(no slit) $\varnothing 7$ L=208 $\pm$ 3mm		JIG:	N/A
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
4	n/a	<div>Wire insertion to Black corrugated tube (no slit) <math>\varnothing 7</math> L= 208<math>\pm</math>3mm</div> <div></div> <div>1. Get the corrugated tube (no slit) <b><math>\varnothing 7</math> L= 208<math>\pm</math>3mm</b> using right hand then insert the <b>Y-OR wires</b> using left hand.</div>		N/A	1. No wrong use of parts 2. No deformed terminal

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**PARTS:**

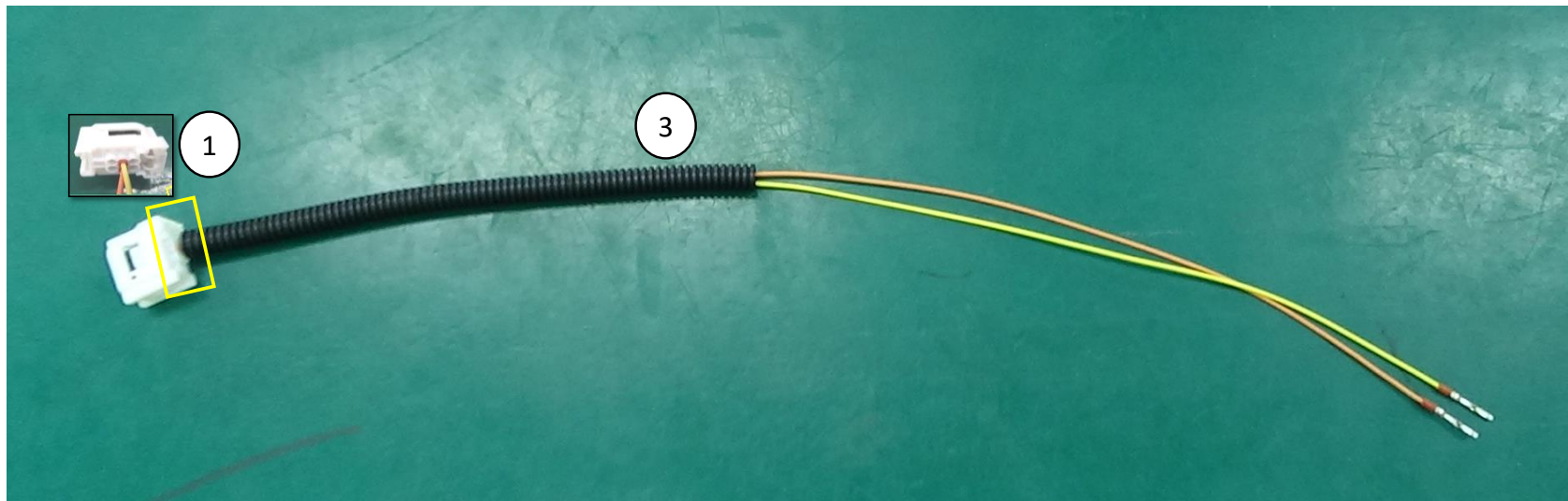
N/A

JIG:

N/A

**QUALITY CHECKPOINTS**

n/a

**OFFLINE INSERTION****7R0104-7023A****GOOD****NO GOOD**

1

**No Wrong Insert**

2

**No Terminal  
Backing Out**

3

**No Missing COT**

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