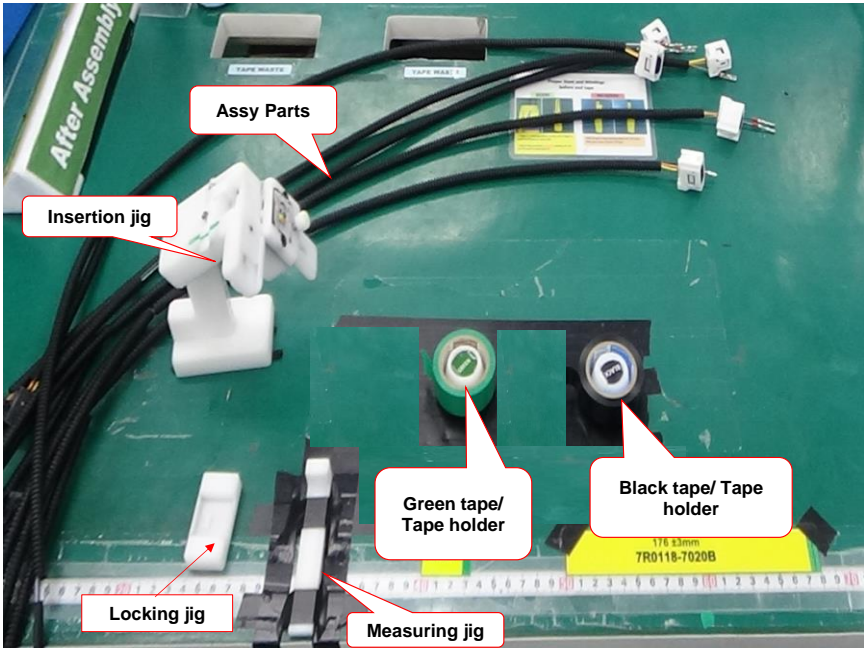







WORK INSTRUCTION				Effectivity Date:	June 24, 2024	
Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a	
Model code/Part number: 920B / 7R0118-7023		Customer: TRMX	Car Model: TOYOTA TACOMA	Document No.:	WI-ENG-PDE-654B	
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.: 1 of 6

PARTS:		1. Assy parts; Black tape [1pc.]; Green tape [1pc.]			JIG:	1. Insertion Jig 2. Measuring Jig 3. Locking Jig	
NO.	PROCESS NAME	2 WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
1	P2	Table Lay-out 			<b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)  <b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.  <b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	1. No missing parts/tools 2. No excess parts/tools	

Revision History							Prepared by	Reviewed by	Approved by	Noted by
06/24/24	2	Transfer Connector setting to Insertion jig 6189-1142 (W), Wire insertion to Connector (Assy parts), Connector lock and Taping 1 Black VM tube (Sunprene) to wire near PCB from P1 (WI-ENG-PDE-654A). Transfer Taping 3 and Y-taping to P3 (WI-ENG-PDE-654B) due to process improvement . Update Table lay-out and Visual inspection/Quality checkpoints. Inclusion of car model "TOYOTA-TACOMA"	D.Castillo	C.Villanueva	A. Arañes	N/A	 D. Castillo	 C. Villanueva	 A. Arañes	N/A
05/24/23	1	Change document from pre-launch to masspro. Additional table lay-out.	D.Castillo	J.Loterte	C.Villanueva	A. Arañes				
03/21/23	0	Initial issue.	D.Castillo	J.Loterte	C.Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	March 21, 2023		

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

June 24, 2024

Validity Date:

n/a

Model code/Part number:

920B / 7R0118-7023

Customer:

TRMX

Car Model:

TOYOTA TACOMA

Document No.:

WI-ENG-PDE-654B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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2

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PARTS:	1. Assy parts		JIG:	1. Insertion Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2  Connector setting to Insertion jig 6189-1142 (W)	<div><div><div>Insertion Jig</div><div>Visual reference</div><div>I-mark</div><div>Lock</div><div>Connector Orientation</div><div>Insertion Jig Orientation</div><div><div>1. Press the lower wire guide using right thumb to make sure connector with inserted wires will be inserted.</div></div><div><div>2. Press the Insertion jig lock using left thumb. Get the assy parts and insert the connector using right hand.</div></div><div><div>3. After insertion, release the insertion jig lock using left thumb.</div></div></div><div><div><div><div>L</div><div>R</div><div>Press</div></div><div><div>L</div><div>R</div><div>Press</div></div><div><div>L</div><div>R</div><div>Release</div></div></div></div></div>	n/a	<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>CONNECTOR ORIENTATION ILLUSTRATION</div> <div><div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div></div></div>


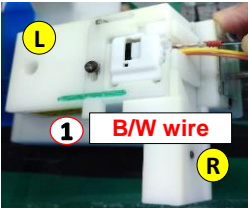
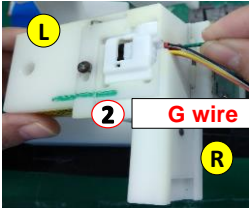
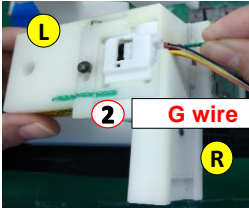
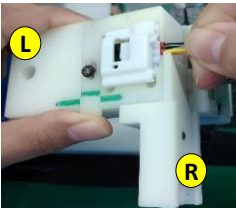
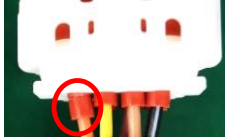

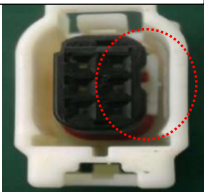


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	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>June 24, 2024</b>		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	<b>n/a</b>		
	Model code/Part number: <b>920B / 7R0118-7023</b>		Customer: <b>TRMX</b>	Car Model: <b>TOYOTA TACOMA</b>	Document No.:	<b>WI-ENG-PDE-654B</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	<b>2</b>	Page No.:	<b>3 of 6</b>

<b>PARTS:</b>	1. Assy parts			JIG:	1. Insertion jig 2. Locking jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
3	Wire insertion to Connector (Assy parts)	<div>  <div>Wire facing</div> </div> <div>  <div>1. Hold the insertion jig using left hand. Get the <b>B/W wire</b> then insert to terminal slot <b>1</b> using right hand.</div> </div> <div>  <div>2. Press the button using right thumb. Slot for <b>Green wire</b> will be opened.</div> </div> <div>  <div>3. Get the <b>G- wire</b> then insert to terminal 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>	n/a	<div>  <div>Note: During insertion, hold the wire not rubber seal to prevent sagging.</div> </div> <div> <ol style="list-style-type: none"> <li>No loose insertion</li> <li>No wrong insertion</li> <li>One by one insertion</li> <li>No deformed terminal</li> <li>No wrong wire facing</li> </ol> </div> <div> <b>Important reminders/Note/s:</b> <ol style="list-style-type: none"> <li>Please hold the wire near terminal.</li> <li>Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</li> </ol> </div> <div> <b>Document references:</b> <ol style="list-style-type: none"> <li>Refer to <b>GL-PRO-ASY-029</b> for Pull-Push procedure.</li> </ol> </div>	
4	Connector lock	<div>  <div>Put the connector into locking jig using right hand then press <b>2x</b>. Check the connector lock if properly lock.</div> </div> <div> <div>BEFORE PRESSING</div>  </div> <div> <div>AFTER PRESSING</div>  </div>	<div> <div>LOCKING JIG</div>  </div>	<div> <b>Important reminders/Note/s:</b> <ol style="list-style-type: none"> <li><b>MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR.</b></li> </ol> </div> <div> <ol style="list-style-type: none"> <li>Use the provided locking jig per model</li> <li>No unlock/half-lock connector</li> <li>No damaged connector</li> </ol> </div>	

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

June 24, 2024

Validity Date:

n/a

Model code/Part number:

920B / 7R0118-7023

Customer:

TRMX

Car Model:

TOYOTA TACOMA

Document No.:

WI-ENG-PDE-654B

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

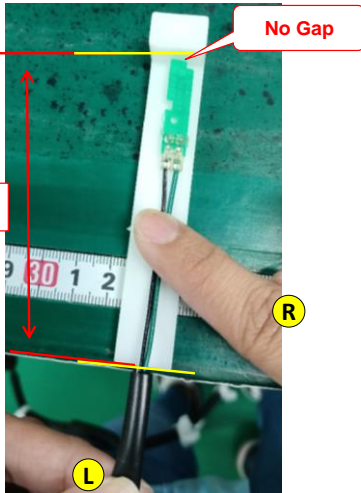
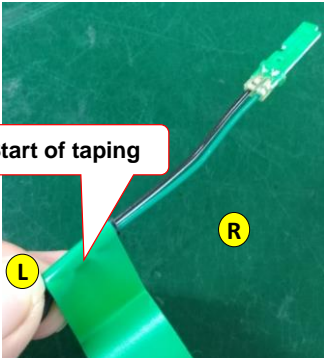
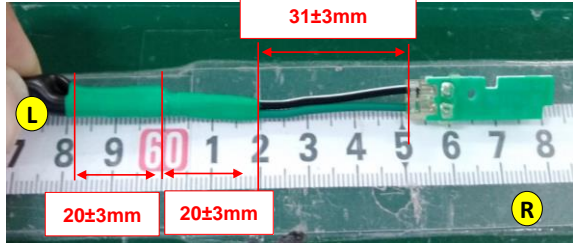




☒ MASSPRO

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PARTS:		1. Assy parts 2. Green tape		JIG:	1. Measuring jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2  Taping 1 Black VM tube (Sunprene) to wire near PCB	<div><div><p>No Gap</p><p>82mm</p><p>L R</p></div><div><p>Start of taping</p><p>L R</p></div><div><p>2. Get the <b>Green tape</b> using right hand then start taping process using both hands.</p></div><div><p>31±3mm</p><p>20±3mm 20±3mm</p><p>L R</p></div><div><p>1. Get the assy parts and set to measuring jig. First, set the holmeted wire (No Gap) using right hand. Last, set the VM tube (Sunprene) (No Gap) using left hand.</p></div><div><p>3. After taping, check the measurement and taping condition.</p></div></div> <div><div><p><b>MEASURING TAPE</b></p></div><div><p><b>MEASURING JIG</b></p></div></div> <div><div><p>GOOD</p><p>NG</p></div><div><p><b>Important reminders/Note/s:</b></p><p>1. Use <b>GREEN TAPE</b> only.</p><p>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><b>Position the finger in wire to avoid deformed hotmelt</b></p></div></div>			

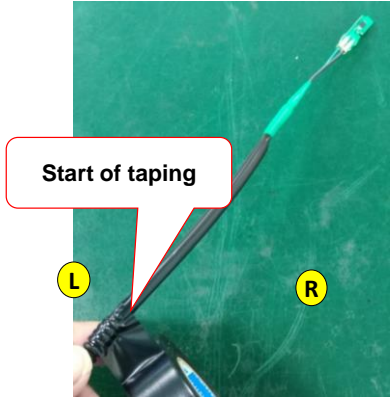
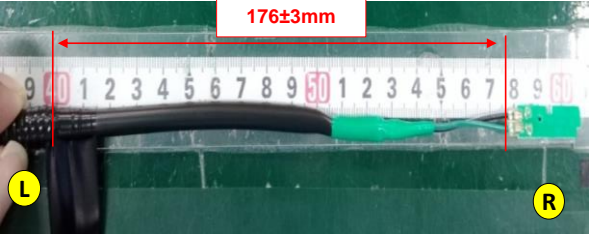


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	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>June 24, 2024</b>		
	<b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Process Name/Title:			Document No.:	WI-ENG-PDE-654B		
	Model code/Part number: <b>920B / 7R0118-7023</b>		Customer: <b>TRMX</b>	Car Model: <b>TOYOTA TACOMA</b>	Revision No.: 2      Page No.:      5 of 6		
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO							

<b>PARTS:</b>		1. Assy parts 2. Black tape		JIG:	n/a	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
6	P2 Taping 2 COT to VM tube (Sunprene) near PCB	<div></div> <div></div> <div></div> <div>1. Hold the COT using left hand, get the <b>Black tape</b> using right hand then start pre-taping using both hands.</div> <div>2. Measure from end of COT up to PCB <b>176±3mm</b> then continue the taping process using both hands.</div> <div>3. After taping, check the measurement and taping condition.</div>		<div><b>MEASURING TAPE</b></div> 	<div><b>Important reminders/Note/s:</b></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><b>Document reference/s:</b></div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>1. Refer to <b>WI-PRO-ASY-001</b> for taping procedure.</div>	

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

June 24, 2024

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Model code/Part number:

920B / 7R0118-7023

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☐ PRE-LAUNCH

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PARTS:

1. Assy parts

JIG:

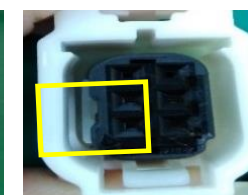
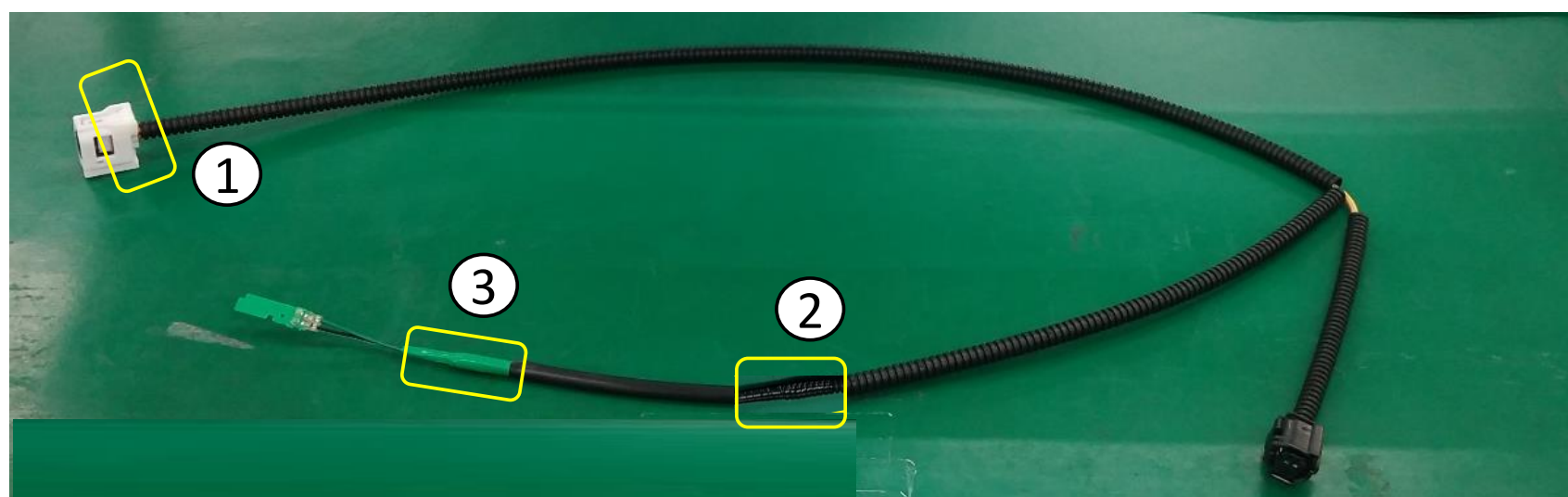
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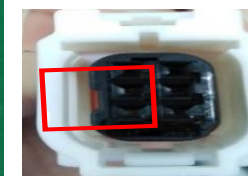
### VISUAL INSPECTION/ QUALITY CHECKPOINTS

P2

7R0118-7023



GOOD



NO GOOD

1

No Wrong Insert

No Terminal Backing Out

2

No Missing Tape

3

No Wrong use of Tape

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