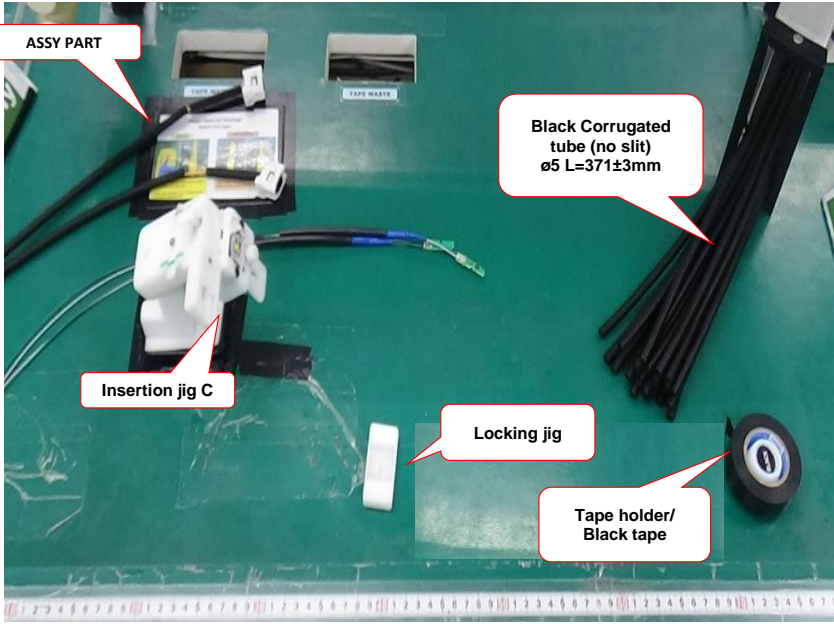



	WORK INSTRUCTION				Effectivity Date:		June 24, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 920B / 7R0117-7023		Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:		WI-ENG-PDE-653B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		2	Page No.: 1 of 6

PARTS:		1. Assy parts: Black tape; Black Corrugated tube (no slit) ø5 L=371±3mm		JIG:		1.Insertion jig 2.Locking jig	
NO.	PROCESS NAME	2	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS		
1	P2	Table Lay-out	<div style="text-align: center;"> Table Lay-out </div> 	<div style="border: 1px dashed red; padding: 5px;"> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px;"> Housekeeping 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;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	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 COT to VM tube taping and Y-taping to P3 (WI-ENG-PDE-653C) and transfer process 2-6 from P1 (WI-ENG-PDE-653A) due to process improvement. Inclusio of car model "TOYOTA-TACOMA". Update Table lay-out and Visual inspection/Quality checkpoints.	D.Castillo	C.Villanueva	A.Arañes	n/a	 M.Ariola	 C.Villanueva	 A.Arañes	n/a	
03/31/23	1	Change purpose from Pre-launch to Masspro.	M.Ariola	J.Loterte	C.Villanueva	A.Arañes					
03/17/23	0	Initial issue. From ATO to SAKI. AVSSF 0.3 Y-OR wires; Connector 6189-1161 (B); two (2) Black COT (no slit) ø5 L=56±3mm; Black COT (no slit) ø5 L=299±3mm; Clamp 82711-12A60 (W); Reduced dummy seal from [4pcs] to [2pcs].	M.Ariola	J.Loterte	C.Villanueva	A.Arañes					
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	March 17, 2023			

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920B / 7R0117-7023

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TRMX

Car Model:

TOYOTA-TACOMA

Document No.:

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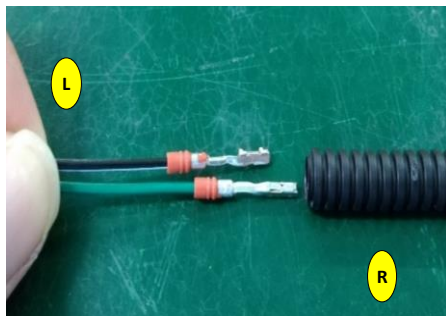
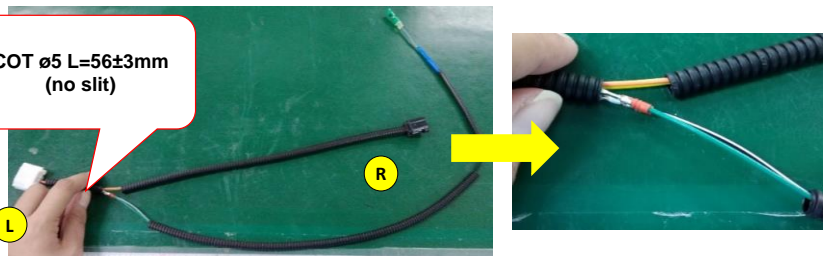
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		JIG:		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	<div><div>2</div><div>Wire insertion to COT (no slit) ø5 L=371±3mm</div><div>P2</div></div>	<div><div>1. Get the corrugated tube (no slit) ø5 L=371±3mm using right hand then insert the G-B/W wires using left hand.</div></div>	n/a	1. No wrong use of parts 2. No deformed terminal
3	<div><div>2</div><div>Wire insertion to assy parts</div></div>	<div><div>COT ø5 L=56±3mm (no slit)</div><div>1. Get the assy parts using left hand then insert the G-B/W wires to COT (no slit) ø5 L=56±3mm using right hand.</div></div>	n/a	1. No wrong insertion 2. No deformed terminal

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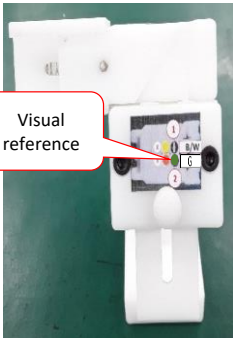

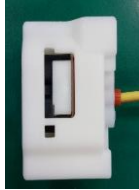
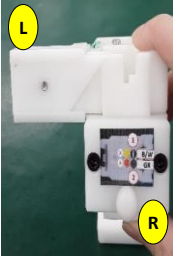
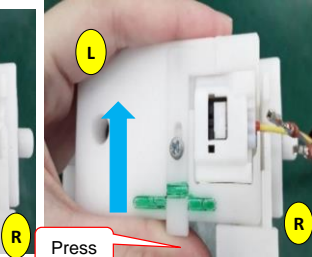
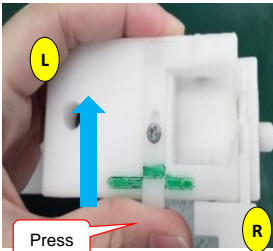
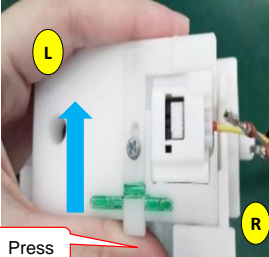
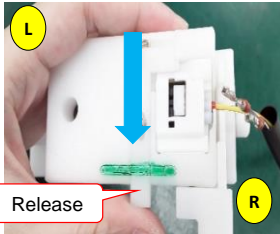
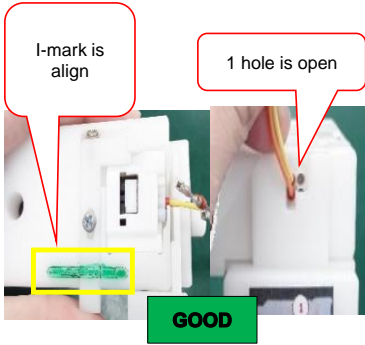
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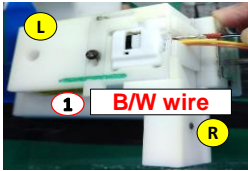

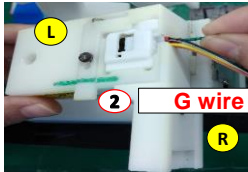
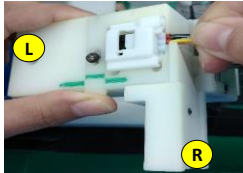

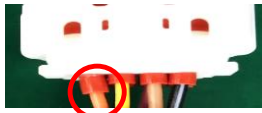
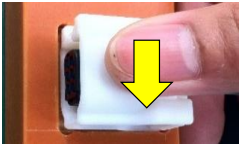
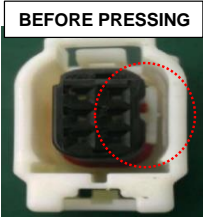
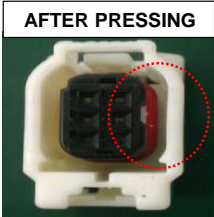

PARTS:	1. Assy parts		JIG:	1.Insertion Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	<div><div><div>2</div></div><div>P2</div><div>Connector setting to Insertion jig 6189-1142 (W) (Assy parts)</div></div>	<div><div><div><div>Insertion Jig</div></div><div><div>I-mark</div></div><div><div>Lock</div></div><div><div>Connector Orientation</div></div><div><div>Insertion Jig Orientation</div></div><div><div>Press</div></div><div><div>Press</div></div><div><div>Release</div></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>CONNECTOR ORIENTATION ILLUSTRATION</div></div></div></div>	n/a	<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>

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	Model code/Part number: 920B / 7R0117-7023		Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:	WI-ENG-PDE-653B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	2	Page No.:	4 of 6

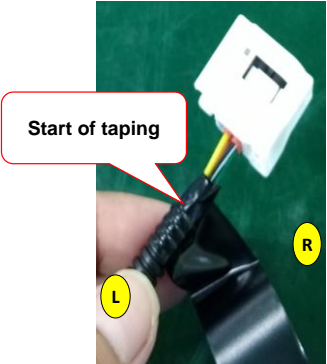
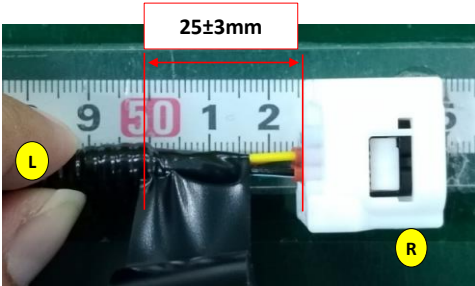
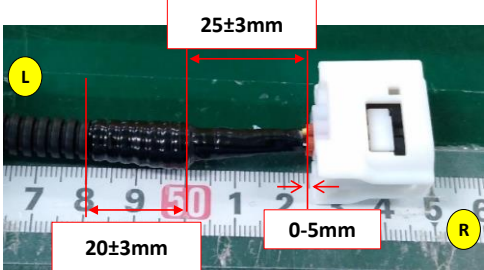

PARTS:	1. Assy parts			JIG:	1.Insertion jig 2.Locking jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
5	Wire insertion to Connector (Assy parts) P2	<div><p>1 B/W wire</p></div> <div><p>2. Press the button using right thumb. Slot for G- wire will be opened.</p></div> <div><p>3. Get the G 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>Wire facing</p></div>		n/a	<div><p>Note: During insertion, hold the wire not rubber seal to prevent sagging.</p></div> <div><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>Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p><p>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p></div>		
6	Connector lock	<div><p>Put the connector into locking jig using right hand then press 2x. Check the connector lock if properly lock.</p></div> <div><p>BEFORE PRESSING</p></div> <div><p>AFTER PRESSING</p></div>		<div><p>LOCKING JIG</p></div>	<p>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <div><p>1. Use the provided locking jig per model 2. No unlock/half-lock connector 3. No damaged connector</p></div>		

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	Model code/Part number: 920B / 7R0117-7023		Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.: WI-ENG-PDE-653B		
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PARTS:	1. Assy parts 2. Black tape			JIG:	n/a			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
7	P2 Taping 2 COT to wire near connector	<div><p>Start of taping</p></div> <div><p>25±3mm</p></div> <div><p>25±3mm 20±3mm 0-5mm</p></div> <div><p>1. Hold the COT then get Black tape using right hand then start taping process using both hands.</p><p>2. Measure from end of COT up to edge of connector 25±3mm then continue the taping process using both hands.</p><p>3. After taping, check the measurement and taping condition.</p></div>			<div>MEASURING TAPE</div> 	<p>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</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>		

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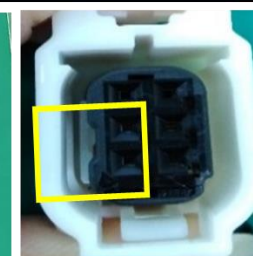
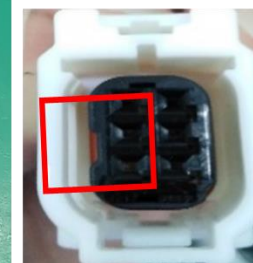
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P2****7R0117-7021****GOOD****NO GOOD****①****②****No WRONG INSERT****No TERMINAL BACKING OUT****③****NO UNLOCK/HALFLOCK CONNECTOR****④****NO MISSING TAPE**

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