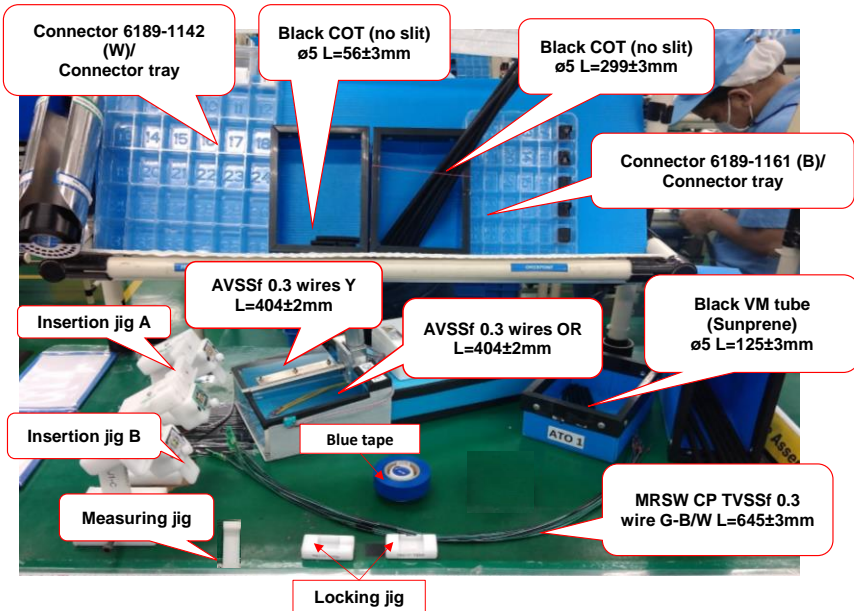

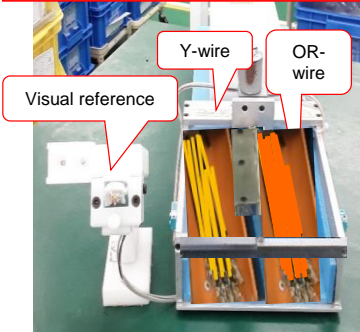
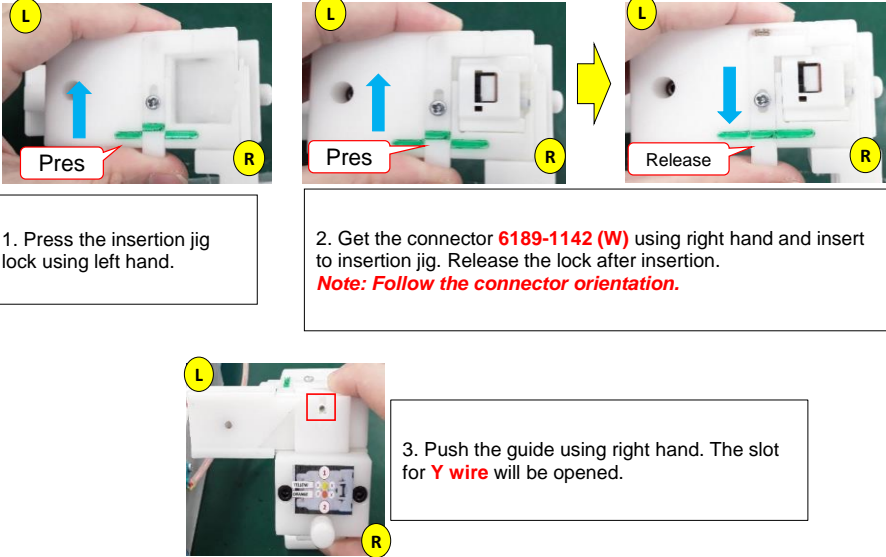
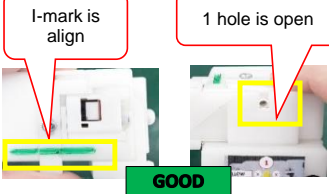
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	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 920B / 7R0117-7023		Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:	WI-ENG-PDE-653A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.:	1 of 8

PARTS:		1. Connector 6189-1142 (W), 6189-1161 (B); AVSSf 0.3 wires Y-OR L=404±2mm; Black COT (no slit) ø5 L=56±3mm; Black COT (no slit) ø5 L=299±3mm; Blue tape; Black VM tube (Sunprene) ø5 L=125±3mm; MRSW CP TVSSf 0.3 wire G-B/W L=645±3mm		JIG:	1. Insertion jig with switch cover 2. Insertion jig 3. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
1	P1	<div style="text-align: center;"> Table Lay-out  </div>	<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> 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 solid red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 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 some process to P2 (WI-ENG-PDE-653B) due to process improvement. Inclusion of car model "TOYOTA-TACOMA". Update Table lay-out and Visual inspection/Quality checkpoints.	D.Castillo	C.Villanueva	A.Arañes	n/a			
03/31/23	1	Change status from Pre-launch to Masspro.	M.Ariola	J.Lorterte	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.Lorterte	C.Villanueva	A.Arañes			
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	March 17, 2023	

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	Process Name/Title:		Model code/Part number: 920B / 7R0117-7023		Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:	WI-ENG-PDE-653A	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	2	Page No.:	2 of 8	



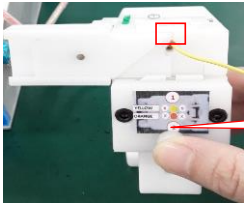
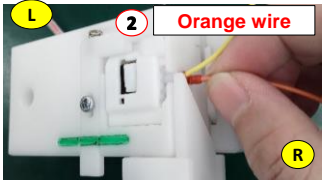
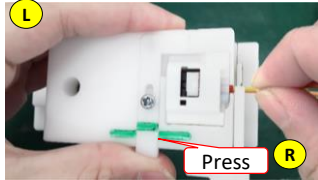
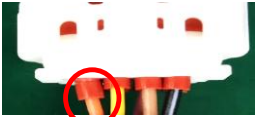


PARTS:	1. Connector 6189-1142 (W) 2. AVSSf 0.3 wires Y-OR L=404±2mm			JIG:	1. Insertion jig with switch cover			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
2	P1 Connector setting to Insertion jig 6189-1142 (W)	<div><div>Insertion Jig with Switch Cover</div><div>Visual reference</div><div>Y-wire</div><div>OR-wire</div><div>Lock</div><div>I-mark</div><div>Insertion Jig Orientation</div><div>Connector Orientation</div><div></div><div>1. Press the insertion jig lock using left hand.</div><div>2. Get the connector 6189-1142 (W) using right hand and insert to insertion jig. Release the lock after insertion. Note: Follow the connector orientation.</div><div>3. Push the guide using right hand. The slot for Y wire will be opened.</div></div> <div><div>CONNECTOR ORIENTATION ILLUSTRATION</div><div></div><div>GOOD</div><div>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</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> <td>n/a</td> <td colspan="3"></td>			n/a			

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	Model code/Part number: 920B / 7R0117-7023		Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.: WI-ENG-PDE-653A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	2	Page No.:	3 of 8

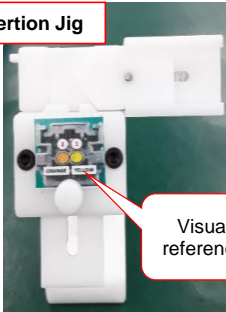
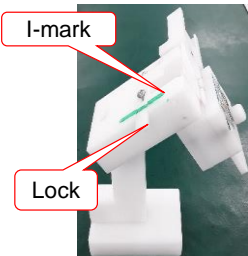

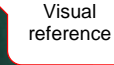


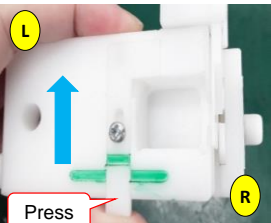
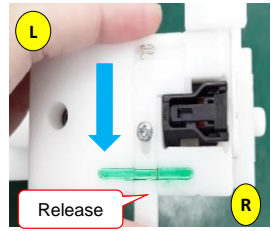
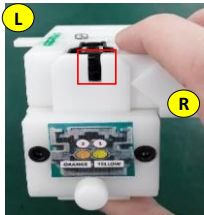

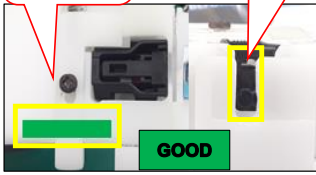
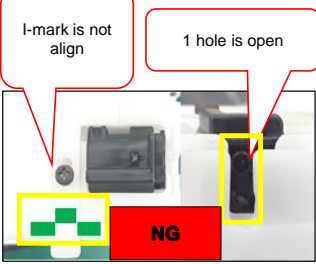

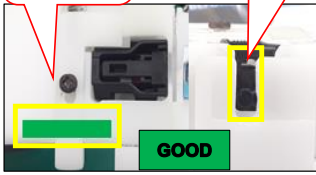
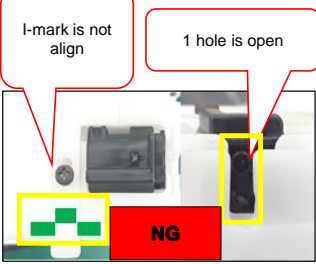
PARTS:	1. Assy parts 2. Black Corrugated tube (no slit) ø5 3. Black Corrugated tube (no slit) ø5 L=299±3mmL=56±3mm			JIG:	1. Insertion jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
3	P1 Wire Insertion to connector 6189-1142 (W)	<div><p>Wire facing</p></div> <div><p>1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot 1 using right hand.</p></div> <div><p>2. Press the button using right thumb. Slot for Orange wire will be opened.</p></div> <div><p>3. Get the Orange 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>			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</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>		
4	Wire insertion to COT (no slit) ø5 L=56±3mm ø5 L=299±3mm	<div><p>1. Get the Corrugated tube ø5 L=56±3mm (no slit) using right hand then insert the Y-OR wires.</p></div> <div><p>2. Get the Corrugated tube ø5 L=299±3mm (no slit) using right hand then insert the Y-OR wires.</p></div>			n/a	<p>1. No wrong use of parts 2. No deformed terminal</p>		

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PARTS:	1. Connector 6189-1161 (B)			JIG:	1. Insertion jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
5	P1	<div><div><p>Insertion Jig</p></div><div><p>I-mark</p></div><div><p>Lock</p></div><div><p>Visual reference</p></div><div><p>Insertion Jig Orientation</p></div><div><p>Connector</p></div><div><p>Press</p></div><div><p>Release</p></div><div><p>Push the guide using right hand. The slot for Y wire will be opened.</p></div><div><p>1. Press the insertion jig lock using left hand.</p><p>2. Get the connector 6189-1161 (B) using right hand and insert to insertion jig. Release the lock after insertion. Note: Follow the connector orientation.</p></div></div> <td>n/a</td> <td colspan="3"><div><p>CONNECTOR ORIENTATION ILLUSTRATION</p></div><div><p>I-mark is align</p><p>1 hole is open</p><p>GOOD</p></div><div><p>I-mark is not align</p><p>1 hole is open</p><p>NG</p></div><div><p>1. Use the provided jig per model</p><p>2. No wrong orientation of connector</p><p>3. No wrong use of connector</p><p>4. No damaged connector</p></div></td>			n/a	<div><p>CONNECTOR ORIENTATION ILLUSTRATION</p></div> <div><p>I-mark is align</p><p>1 hole is open</p><p>GOOD</p></div> <div><p>I-mark is not align</p><p>1 hole is open</p><p>NG</p></div> <div><p>1. Use the provided jig per model</p><p>2. No wrong orientation of connector</p><p>3. No wrong use of connector</p><p>4. No damaged connector</p></div>		

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920B / 7R0117-7023

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Document No.:

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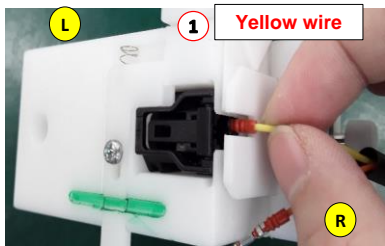
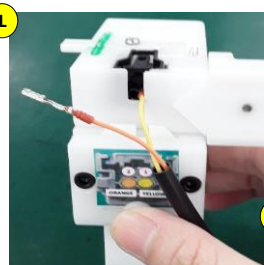
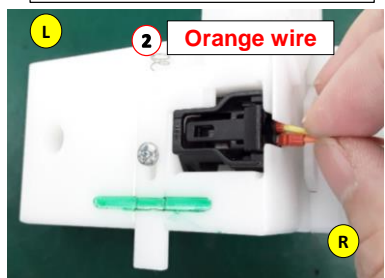
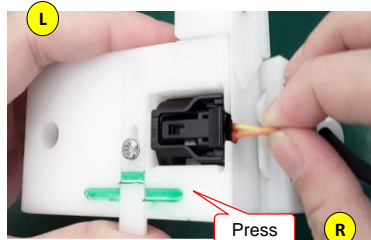
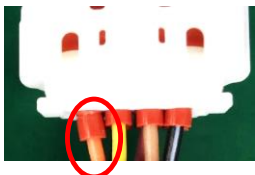
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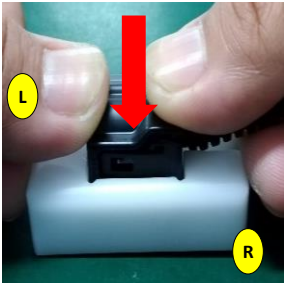

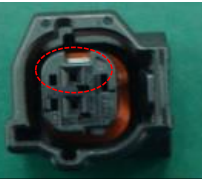





PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1 Wire insertion to connector 6189-1161 (B)	<div> Wire facing</div> <div> 1 Yellow wire</div> <div> 2 Press the button using right thumb. Slot for Orange wire will be opened.</div> <div> 3 Orange wire</div> <div> Press</div> <div>1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot 1 using right hand.</div> <div>2. 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>3. Get the Orange wire then insert to terminal slot 2 using right hand.</div>	n/a	<div>Note: During insertion, hold the wire not <u>rubber seal</u> to prevent sagging.</div> <div></div> <div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>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.</div> <div>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>


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	Model code/Part number: 920B / 7R0117-7023		Customer: TRMX		Car Model: TOYOTA-TACOMA		Document No.: WI-ENG-PDE-653A	
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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) ø5 L=125±3mm 3. MRSW CP TVSSf 0.3 wire G-B/W L=645±3mm		JIG:		1. Locking jig 2. Measuring jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS	
7	Connector lock P1	<div>  </div> <div>   </div> <div>    </div> <div> Put the connector into locking jig using right hand then press 2x using both hands. Check the connector lock if properly lock. </div>		<div>  </div>		Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR 1. Use the provided jig per connector 2. No unlock/half-locked connector	
8	Wire insertion to Black VM tube (Sunprene) ø5 L=125±3mm	<div>  </div> <div> 1. Get the VM tube (Sunprene) ø5 L=125±3mm using right hand then insert the MRSW CP TVSSf 0.3 wire G-B/W L=645±3mm using left hand. </div>		n/a		Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 1. No wrong usage of parts	

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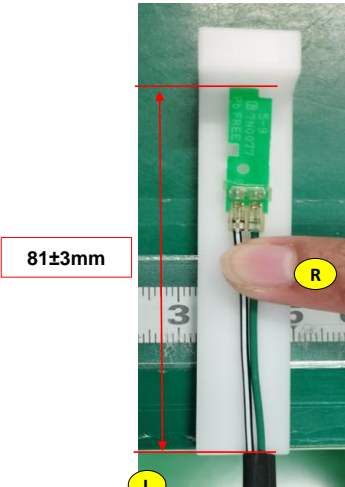
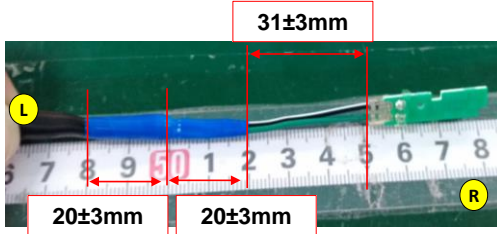
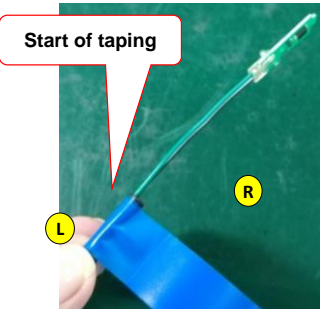


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PARTS:		1. Assy parts 2. Blue tape		JIG:	1. Measuring jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	P1 Taping 1 Black VM tube (Sunprene) to wire near PCB	<div><p>81±3mm</p><p>L R</p></div> <div><p>1. Conduct measurement on measuring jig by placing the assy parts on guide dimension. (See illustration)</p></div> <div><p>20±3mm 20±3mm 31±3mm</p><p>L R</p></div> <div><p>2. Get the Blue tape using right hand then start taping process using both hands.</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>		<div><p>Start of taping</p><p>L R</p></div> <div><p>MEASURING TAPE</p></div> <div><p>MEASURING JIG</p></div>	<p>Important reminders/Note/s:</p> <p>1. Use <u>BLUE TAPE</u> only</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s:</p> <p>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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PARTS:

1. Assy parts

JIG:

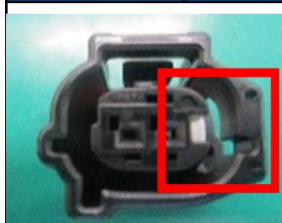
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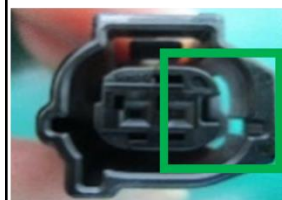
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P1

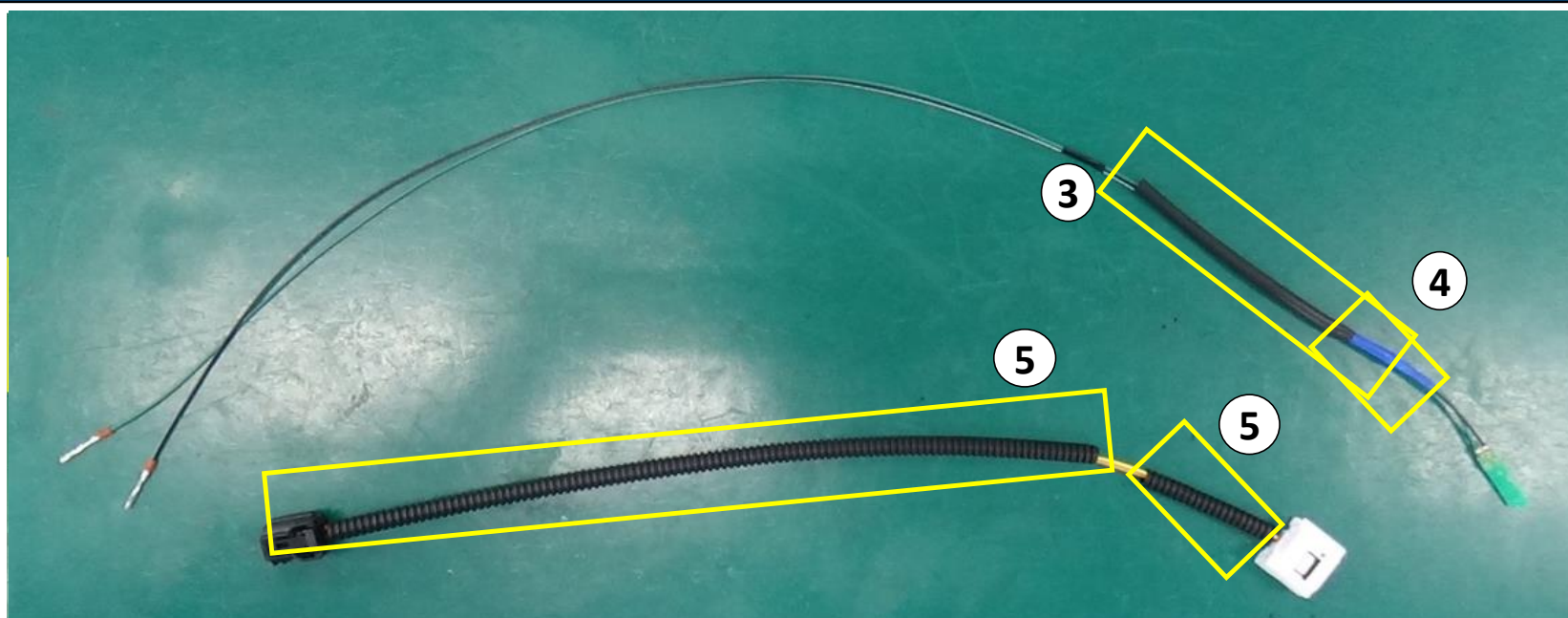
7R0117-7023



NO GOOD



GOOD



① ②

No **WRONG INSERT**

No **TERMINAL BACKING OUT**

③

No **MISSING VINYL**

④

No **MISSING TAPE**

⑤

No **MISSING COT**

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