



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model code/Part number:

736D / 7R0119-7022

Customer: TRMX

Car Model: TOYOTA-TACOMA

Purpose:

☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Effectivity Date:

April 8, 2025

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1238

Revision No.:

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PARTS:

1. All parts: Connector 6188-0407 (W); TVSSf 0.3 wires G-B/W L=562±3mm; Black SV tube (Vinyl) Ø5 L=366±3mm; Black VM tube (Sunprene) Ø5 L=123±3mm; Yellow tape

JIG:

1. Insertion jig with switch cover
2. Measuring jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

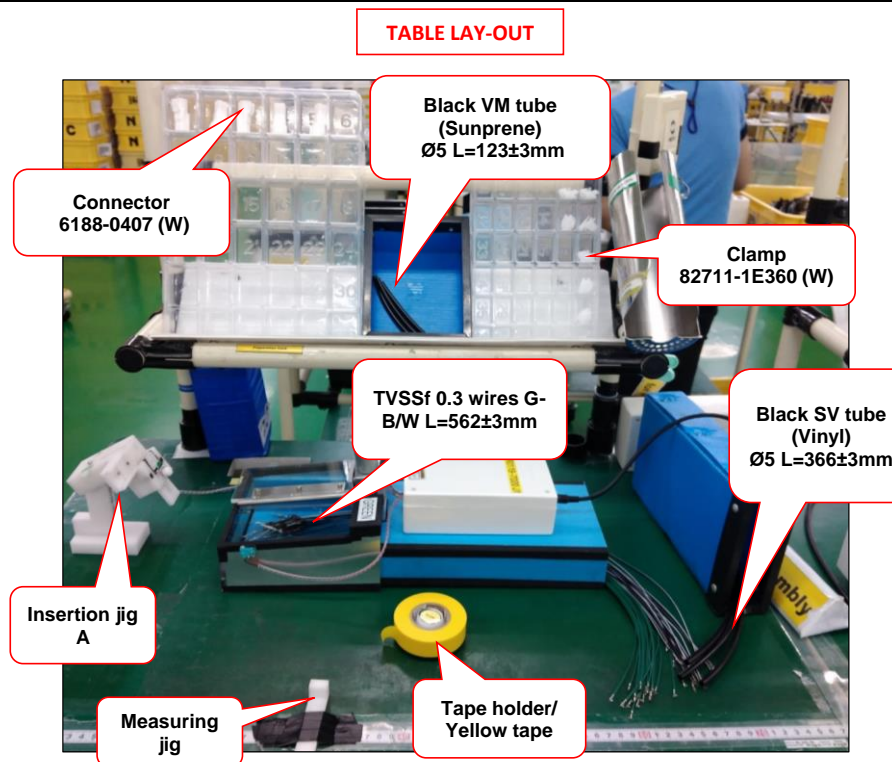
TOOLS/PPE

QUALITY POINTERS

1

P1

Table Lay-out



Safety Instruction

Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

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

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved	Est. Date:	Prepared by	Checked by	Reviewed by	Approved by
04/08/25	0	Initial issue.						A.Hernandez	J.Loterte	C. Villanueva	A. Arañes

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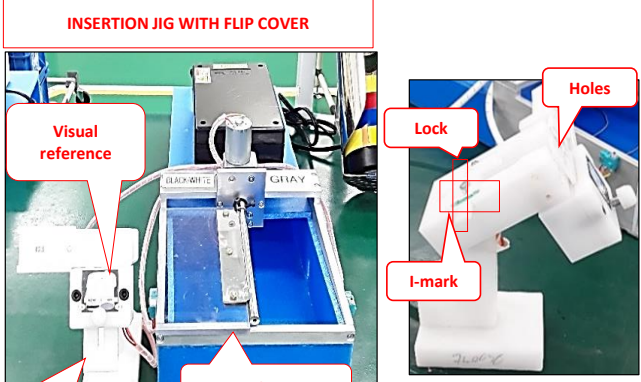


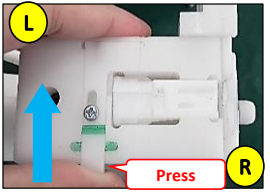
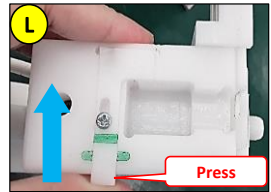
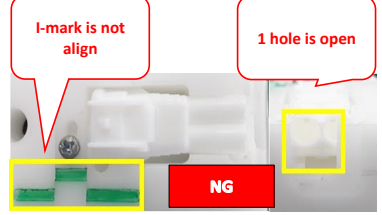
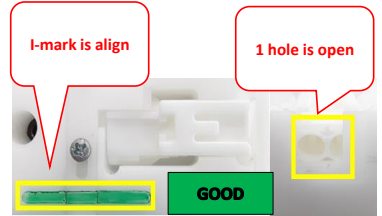
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PARTS:		1. Connector 6188-0407 (W)		JIG:	Insertion jig with flip cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<p>Connector setting to Insertion jig 6188-0407 (W)</p> <div><p>INSERTION JIG WITH FLIP COVER</p><p>CONNECTOR ORIENTATION</p></div> <div></div> <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector 6188-0407 (W) into jig using right hand and release the lock. Note: Refer to above illustration for correct setting.</p> <p>3. Check the holes/terminal slot for B/W wire.</p>		n/a	<p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p> <p>Connector Orientation Illustration</p> <div></div>

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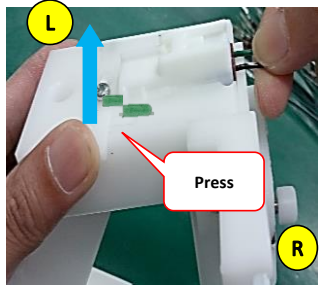
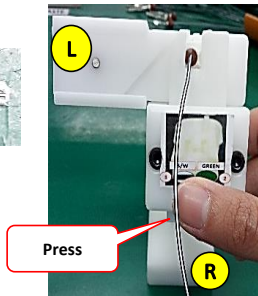

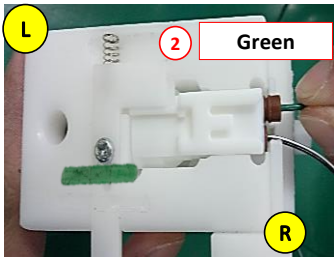
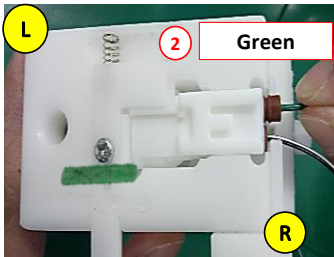
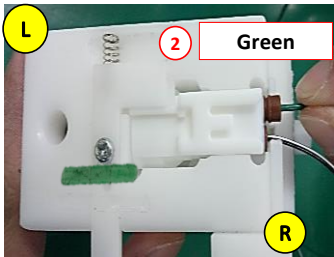
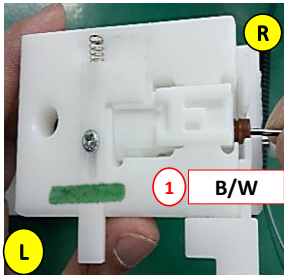
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PARTS:		1. TVSSf 0.3 wires G-B/W L=562±3mm		JIG:	1. Insertion jig with flip cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Wire Insetion to Connector 6188-0407 (W)	<div><p>1. Hold the Insertion jig using left hand. Get Black /White wire then insert to terminal slot 1 using right hand.</p><p>2. Push the button using right hand. The slot for Green wire will be opened.</p><p>3. Get Green wire then insert to terminal slot 2 using right hand.</p><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	<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. 3. Insertion of wires must be from left to right</p> <p>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p>

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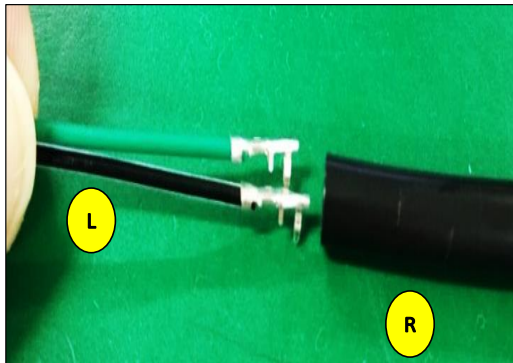

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PARTS:		1. Assy parts	3. Black VM tube (Sunprene) Ø5 L=123±3mm	JIG:	n/a
		2. Black SV tube (Vinyl) Ø5 L=366±3mm			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	Wire Insertion to Black SV tube (Vinyl) Ø5 L=366±3mm	 <div>1. Get the Black SV tube (Vinyl) Ø5 L=366±3mm using right hand then insert the G-B/W wires using left hand.</div>	n/a	1. No wrong use of parts
5		Wire Insertion to Black VM tube (Sunprene) Ø5 L=123±3mm	 <div>1. Get the Black VM tube (Sunprene) Ø5 L=123±3mm using right hand then insert the G-B/W wires using left hand.</div>	n/a	1. No wrong use of parts

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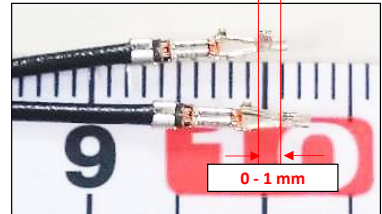
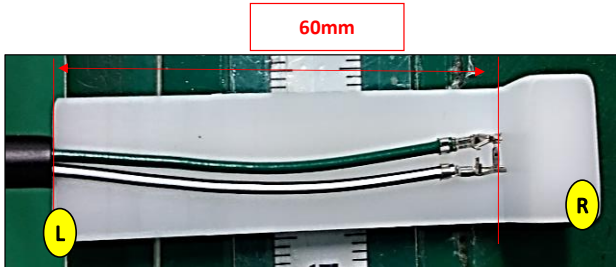
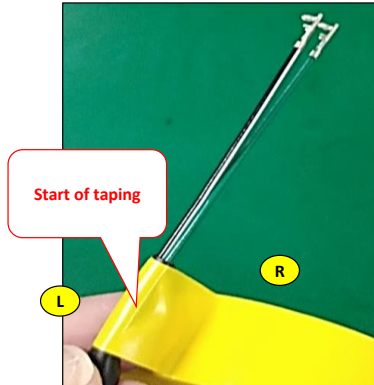
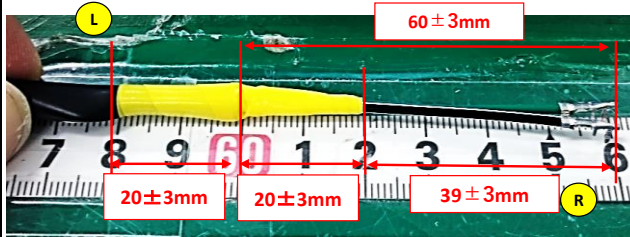
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PARTS:		1. Assy parts 2. Yellow tape		JIG:	1. Measuring jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1	Taping 1 Black VM tube (Sunprene) to wire near terminal		<div>MEASURING TAPE</div>  <div>MEASURING JIG</div> 	<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>Wire alignment tolerance</div>  <div>Important reminders/Note/s: Please use calibrated/verified measuring tape when getting the measurement.</div>
		<div>1. Conduct measurement of 60mm from end of sunprene tube up to end of the terminal pointed tip using both hands.</div>  <div>2. Hold the tube using left hand, get the Yellow tape using right hand then start taping process using both hands.</div>  <div>3. After taping, check the taping condition, measurement and wire alignment.</div> 			

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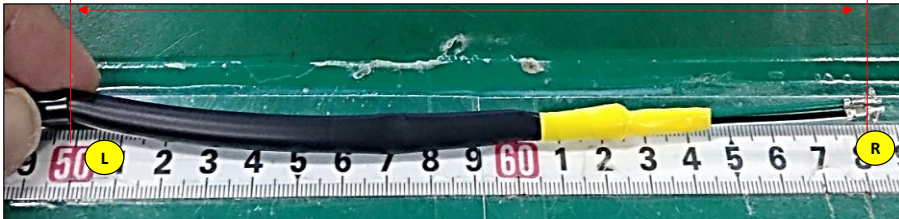
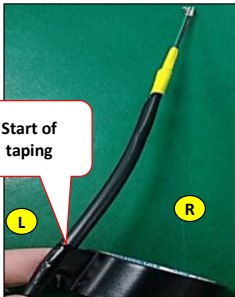

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PARTS:		1. Assy part 2. Black tape	JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1 Taping 1 Black SV tube (Vinyl) to Black VM tube (Sunprene) near terminal	<div>184 ± 3mm</div>  <div>1. Measure from end of SV tube (Vinyl) up to terminal pointed tip 184±3mm using both hands.</div> <div>Start of taping</div>  <div>2. Hold the corrugated tube and sunprene tube using left hand, get the Black tape then start taping process using both hands.</div> <div>184 ± 3mm</div>  <div>20 ± 3mm 20 ± 3mm</div> <div>3. After taping, check the taping condition, measurement and wire alignment.</div>	n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing

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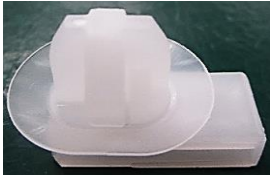
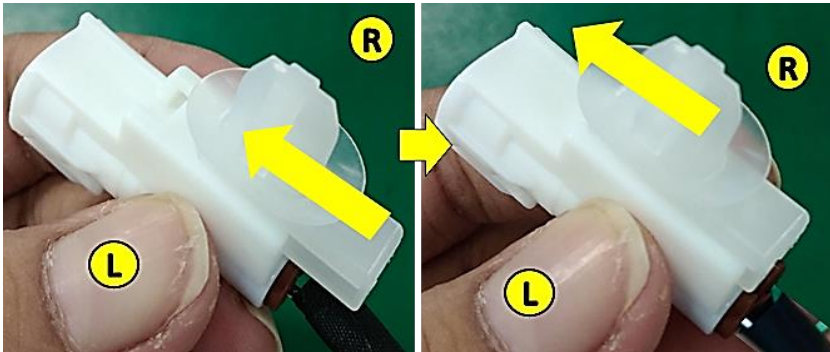
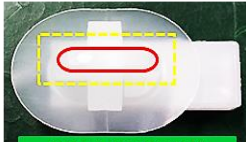
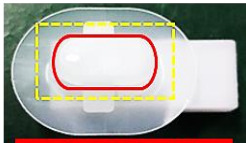
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PARTS:	1. Assy Parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P1	<div><div></div><div>CLAMP ORIENTATION</div><div></div><div>1. Hold the connector using left hand, get the Clamp 82711-1E360 (W) then insert using right hand.</div></div>	n/a	<div>1. No wrong use of parts 2. No loose attachment</div> <div><div>CLIP CLAMP ILLUSTRATION</div><div><div>GOOD</div><div></div><div>82711-1E360 (W)</div></div><div><div>NG</div><div></div><div>82711-12B10 (W)</div></div></div>

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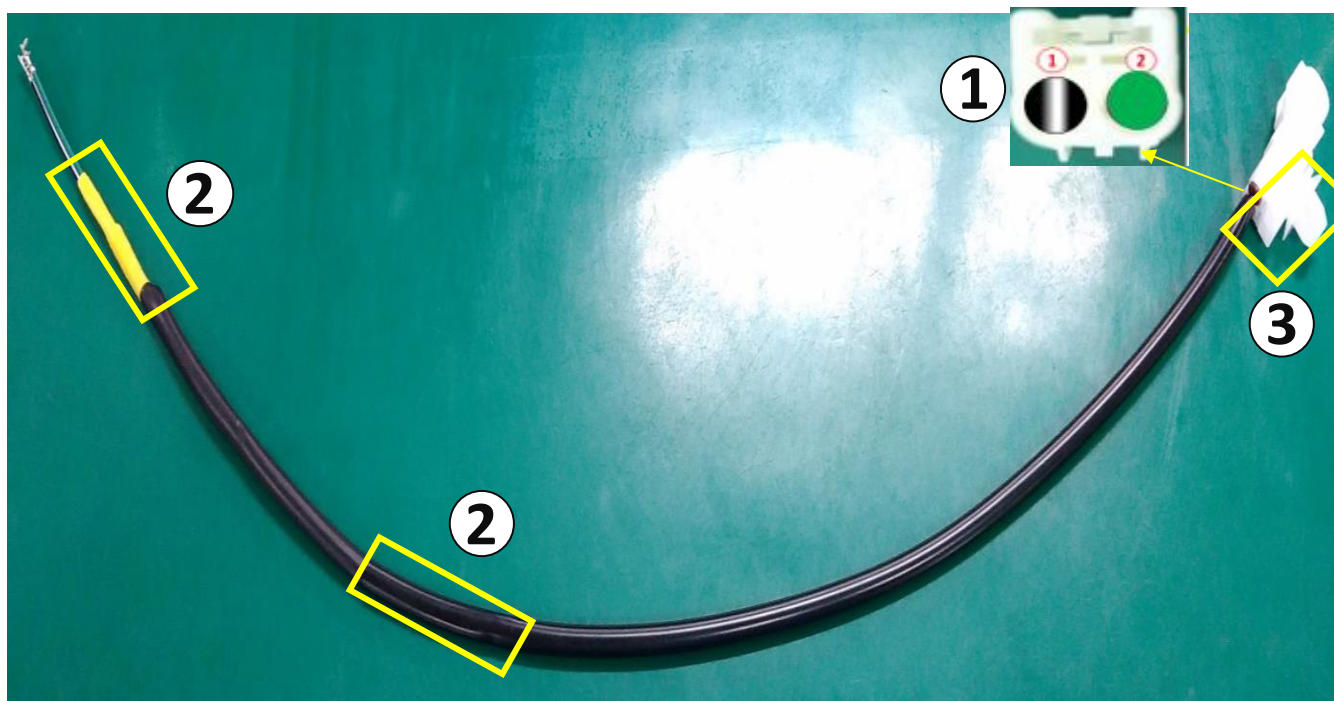
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PARTS:

1. Assy Parts

JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS**P1****7R0119-7022**

- ① No Wrong Insert
- ② No Wrong use of tape (Yellow/Black tape)
- ③ No Missing Clip Clamp
- ④ No Terminal Backing Out
- ⑤ No Deformed Terminal

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