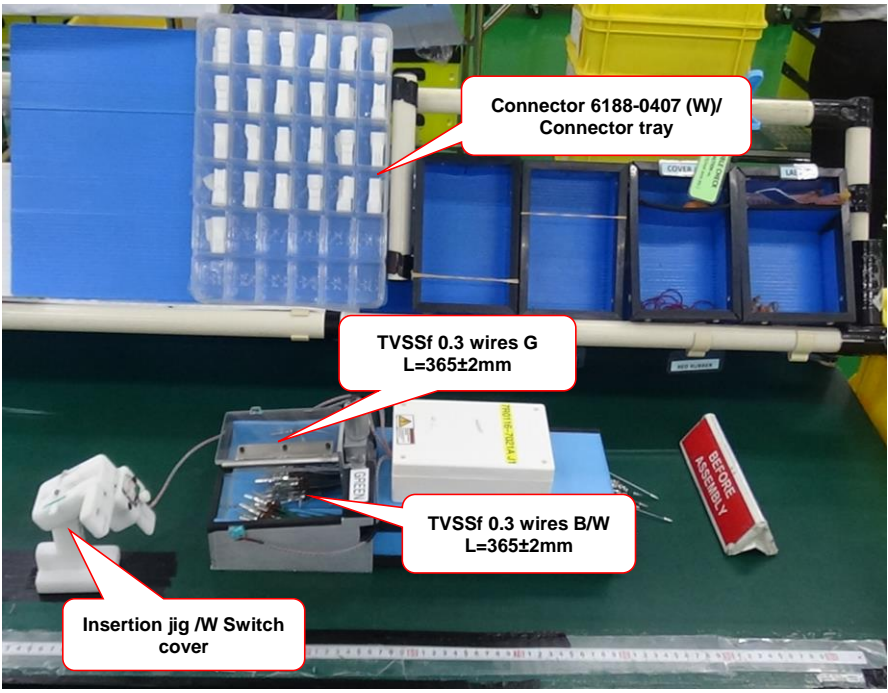
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	OFFLINE ASSEMBLY PROCESS				Validity Date:		n/a		
	Process Name/Title:		Model code/Part number: 920B / 7R0116-7021A		Customer: TRMX		Car Model: TOYOTA-TACOMA		
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.:		WI-ENG-PDE-920		
				Revision No.:		0		Page No.:	1 of 5


PARTS:	1.Connector 6188-0407 (W); TVSSf 0.3 wires G-B/W L=365±2mm			JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	Offline	<div style="text-align: center;"> TABLE LAY-OUT </div>  <div style="position: absolute; top: 320px; left: 470px; border: 1px solid black; padding: 2px;">Connector 6188-0407 (W)/ Connector tray</div> <div style="position: absolute; top: 475px; left: 420px; border: 1px solid black; padding: 2px;">TVSSf 0.3 wires G L=365±2mm</div> <div style="position: absolute; top: 590px; left: 440px; border: 1px solid black; padding: 2px;">TVSSf 0.3 wires B/W L=365±2mm</div> <div style="position: absolute; top: 655px; left: 290px; border: 1px solid black; padding: 2px;">Insertion jig /W Switch cover</div>		<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed 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.

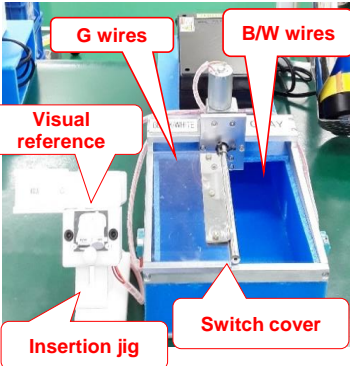
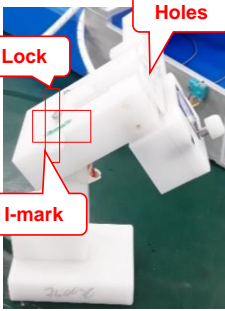

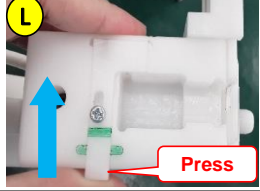
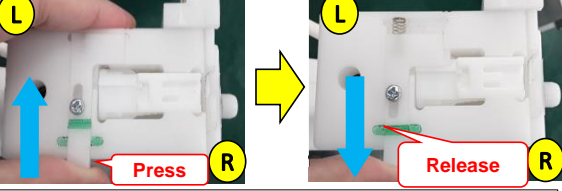
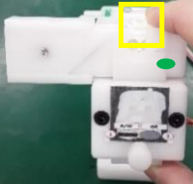

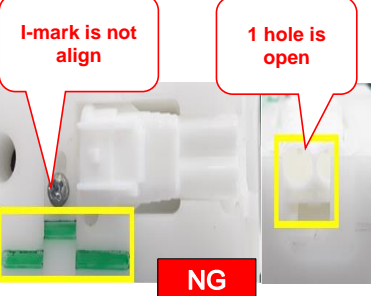
Revision History				Prepared by	Reviewed by	Approved by	Noted by
06/24/24	0	Initial issue. Seprate Connector setting and wire insertion process from P1 (WI-ENG-PDE-650A). Aligned switch cover to insertion jig.	D.Castillo	C.Villanueva	A.Arañes	n/a	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:
							June 24, 2024

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	OFFLINE ASSEMBLY PROCESS				Validity Date:	n/a			
	Process Name/Title:		Model code/Part number: 920B / 7R0116-7021A		Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:	WI-ENG-PDE-920	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	0	Page No.:	2 of 5	

PARTS:	1. Connector 6188-0407 (W)			JIG:	1. Insertion jig with switch cover			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
2	Offline Connector setting to Insertion jig 6188-0407 (W)	<div><div>INSERTION JIG WITH SWITCH COVER</div><div></div><div></div><div></div></div> <div><div></div><div></div></div> <div><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. <i>Note: Refer to above illustration for correct setting.</i></p><p>3. Check the holes/terminal slot for B/W wire.</p></div></div>			n/a	<div><p>Important reminders and note/s:</p><p>1. Refer to above illustration for correct setting.</p><p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector</p></div> <div><div>Connector Orientation Illustration</div><div></div><div></div></div>		

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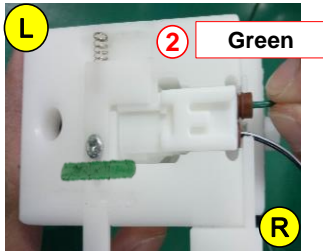
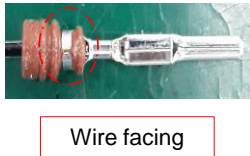
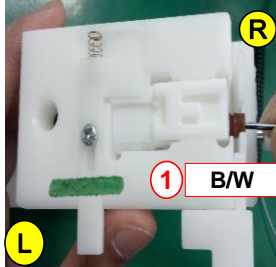
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PARTS:	1. TVSSf 0.3 wires G-B/W L=365±2mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Offline	<div><div></div><div><p>1. Hold the Insertion jig using left hand. Get Black /White 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></div>	n/a	<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. 3. Insertion of wires must be from left to right</div> <div>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</div>

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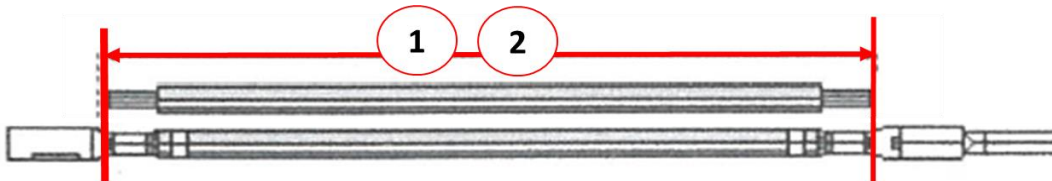


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Offline	Measurement	<p>Note:</p> <ol style="list-style-type: none">1. Measurement point: End of core wire to the end of core wire2. Terminal is reference only.   <p>Measuring tape</p>  <p>Important reminders and note/s:</p> <ol style="list-style-type: none">1. Please use calibrated/verified measuring tape when getting the measurement.2. For Hatsumono, Nakamono and Owarimono. <p>Document reference/s:</p> <ol style="list-style-type: none">1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection <p>1. No wrong dimension</p>		

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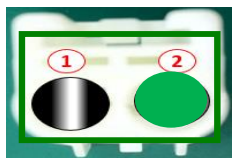
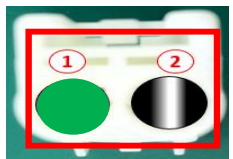
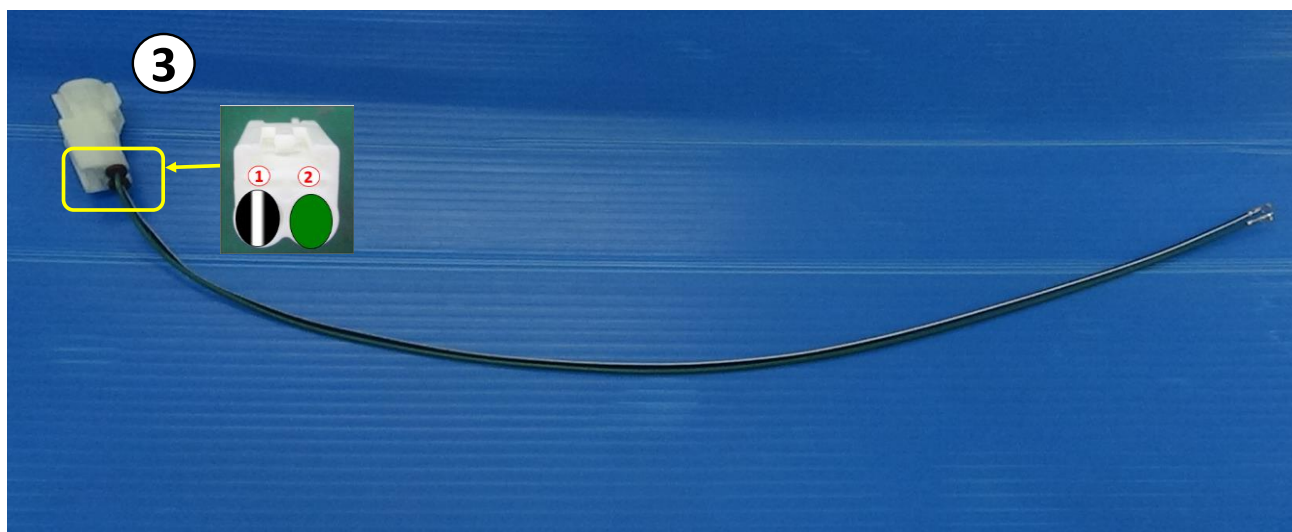
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ VISUAL INSPECTION**OFFLINE****7R0116-7021A****①****GOOD****NO GOOD****③****②****GOOD****NO GOOD****①****No Wrong insert****②****No Terminal Backing out****③****No Deformed Terminal**

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