

	<b>WORK INSTRUCTION</b>					Effectivity Date:		September 19, 2024	
	Process Name/Title: <b>OFFLINE ASSEMBLY PROCESS</b>					Validity Date:		n/a	
	Model code/Part number: <b>920B / 7R0122-7022</b>		Customer: <b>TRMX</b>	Car Model: <b>TOYOTA-TACOMA</b>		Document No.:		<b>WI-ENG-PDE-720</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO					Revision No.:		2	Page No.: 1 of 7

<b>PARTS:</b>	1. All parts; Connector 6098-3909 (W); AVSSf 0.3 wires B L=572±3mm; AVSSf 0.3 wires Y L=384±2mm; AVSSf 0.3 wires OR L=384±2mm				JIG:	1. Insertion jig with controller 2. Insertion jig with switch cover 3. locking jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
1	OFFLINE	<div style="text-align: center; border: 1px solid red; padding: 5px; margin-bottom: 10px;">Table Lay-out</div>			<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> <b>Safety Instruction</b>            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;"> <b>Housekeeping</b>            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;"> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>	<b>Document reference/s:</b> 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	
09/19/24	2	Inclusion of Measurement, Improved Visual inspection/Quality checkpoint.	D.Castillo	C. Villanueva	A. Arañes	n/a				n/a				
09/06/23	1	Change purpose from pre-launch to mass pro.	M. Manalac	J. Lotere	C. Villanueva	A. Arañes								
09/01/23	0	Initial issue.	M. Manalac	J. Lotere	C. Villanueva	A. Arañes								
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:		September 01, 2023					

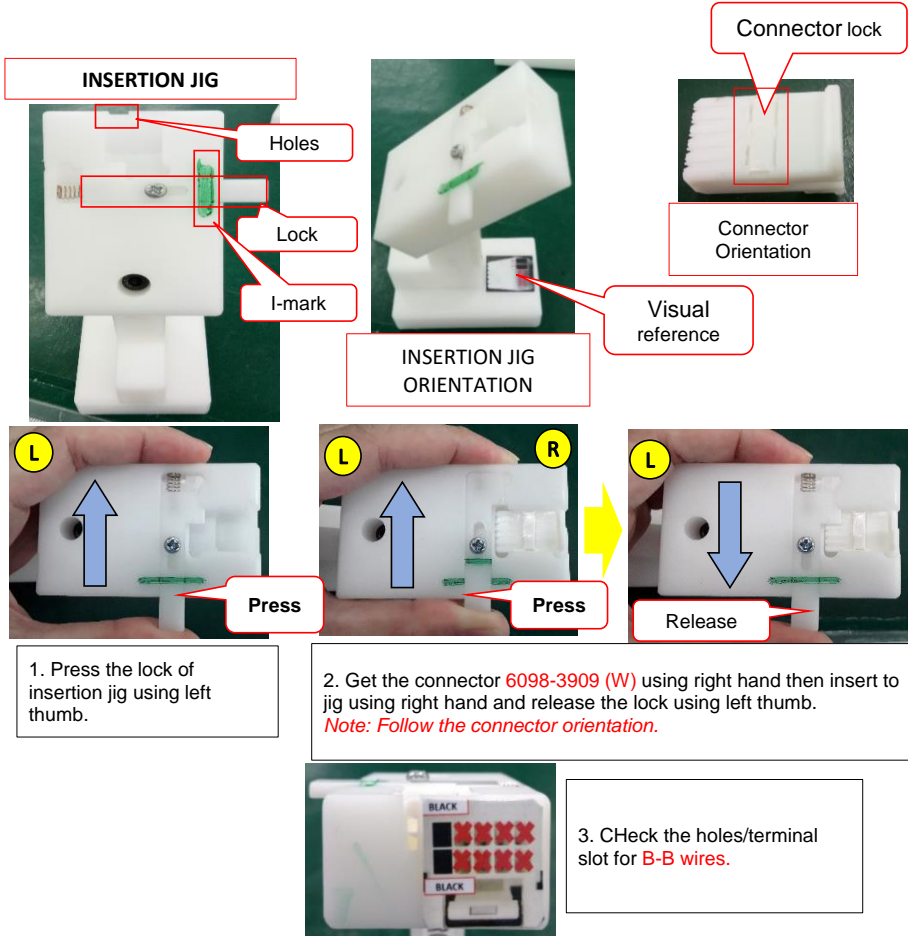
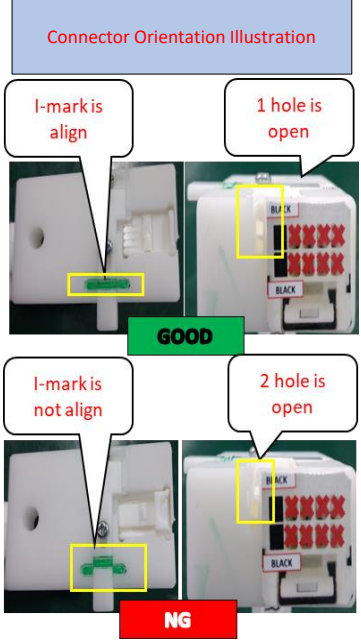
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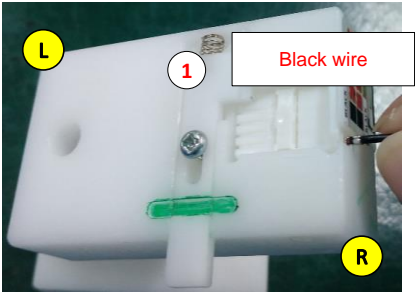
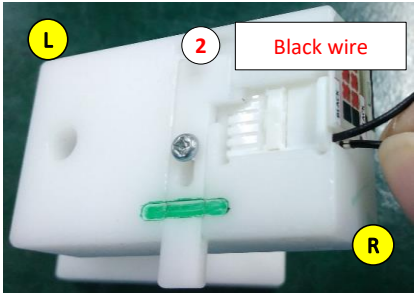
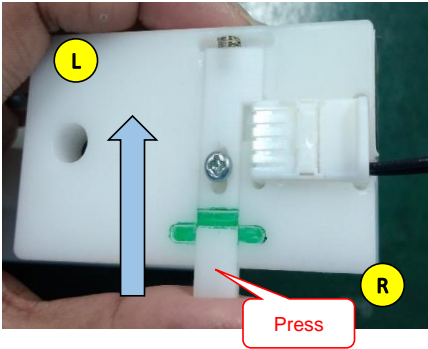
  

PARTS:		1. Connector 6098-3909 (W)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
2	OFFLINE Connector setting to insertion jig 6098-3909 (W)	 <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Get the connector 6098-3909 (W) using right hand then insert to jig using right hand and release the lock using left thumb. <i>Note: Follow the connector orientation.</i></p> <p>3. Check the holes/terminal slot for B-B wires.</p>	n/a	 <p>1. Use provided jig per model</p> <p>2. No wrong usage of parts</p> <p>3. No wrong orientation of connector</p> <p>4. No damaged connector</p> <p><b>Important reminders/Note/s:</b> 1. Follow the connector orientation</p>	

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	Model code/Part number: 920B / 7R0122-7022		Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:	WI-ENG-PDE-720	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	2	Page No.:	3 of 7


PARTS:	1. AVSSf 0.3 wires B L=572±3mm [2pcs]			JIG:	1. Insertion jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
3	OFFLINE	Wire insertion to Connector 6098-3909 (W)	<div><p>Terminal facing</p></div> <div><p>Black wire</p><p>1. Get 1st black wire then insert to terminal slot 1 using right hand. <i>Note: Insertion of wires must be from up to down direction.</i></p></div> <div><p>Black wire</p><p>2. Get 2nd Black wire then insert to terminal slot 2 using right hand.</p></div> <div><p>Press</p><p>3. 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><b>Important reminders/Note/s:</b></p> <p>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><b>Document references:</b></p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p>		

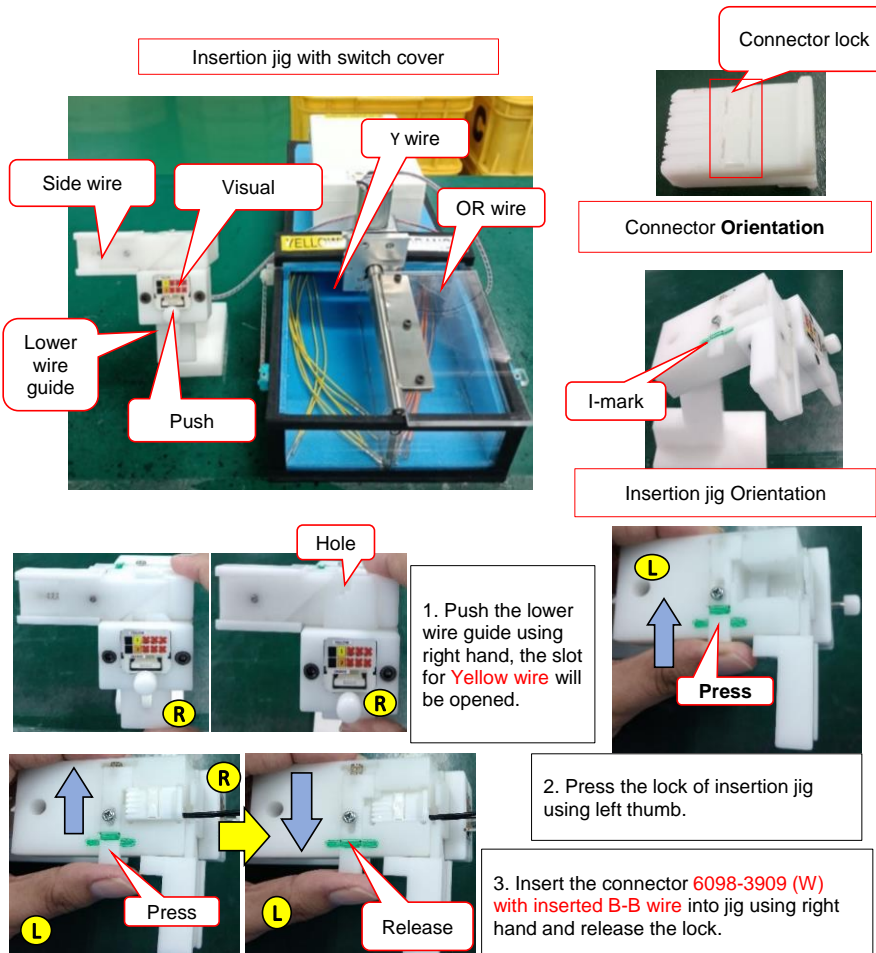
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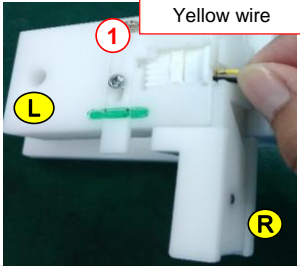
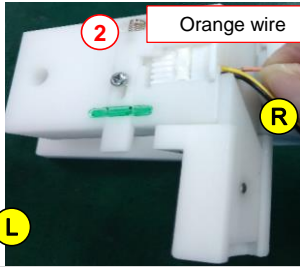
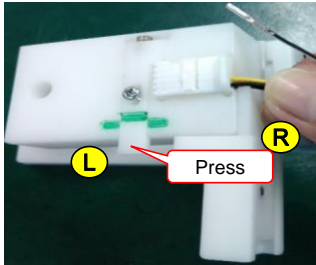
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	Model code/Part number:	<b>920B / 7R0122-7022</b>	Customer:	<b>TRMX</b>	Car Model:	<b>TOYOTA-TACOMA</b>	
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<b>PARTS:</b>	1. Assy parts			JIG:	1. Insertion jig with switch cover		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
4	OFFLINE	<p>Connector setting to insertion jig 6098-3909 (W)</p>  <p>1. Push the lower wire guide using right hand, the slot for <b>Yellow wire</b> will be opened.</p> <p>2. Press the lock of insertion jig using left thumb.</p> <p>3. Insert the connector <b>6098-3909 (W)</b> with inserted <b>B-B wire</b> into jig using right hand and release the lock.</p>			n/a	<p><i>Important reminders/Note/s:</i></p> <p>1. Follow the connector orientation</p> <p>2. Cannot insert the inverted connector.</p> <p>1. Use provided jig per model</p> <p>2. No wrong usage of parts</p> <p>3. No wrong orientation of connector</p> <p>4. No damaged connector</p>	

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	2	Page No.:	5 of 7


PARTS:		1. AVSSf 0.3 wires Y L=384±2mm 2. AVSSf 0.3 wires OR L=384±2mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	OFFLINE	<div><p>Terminal facing</p></div> <div><p>Yellow wire</p><p>1. Get the Yellow wire using right hand then insert to terminal slot 1 using right hand.</p></div> <div><p>Orange wire</p><p>3. Get the Orange wire using right hand then insert to terminal slot 2 using right hand.</p></div> <div><p>Press</p><p>4. After insertion, press the lock guide using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p></div>		n/a	<p><b>Important reminders/Note/s:</b></p> <p>1. Cannot insert the inverted connector.</p> <p>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p>


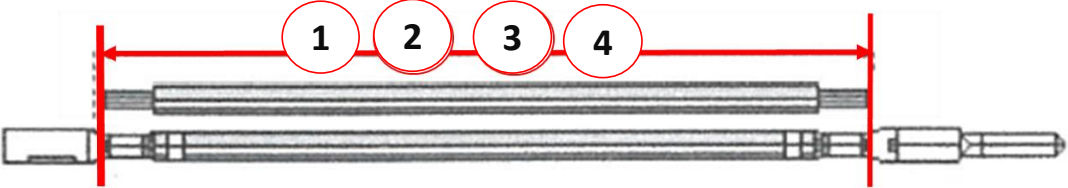
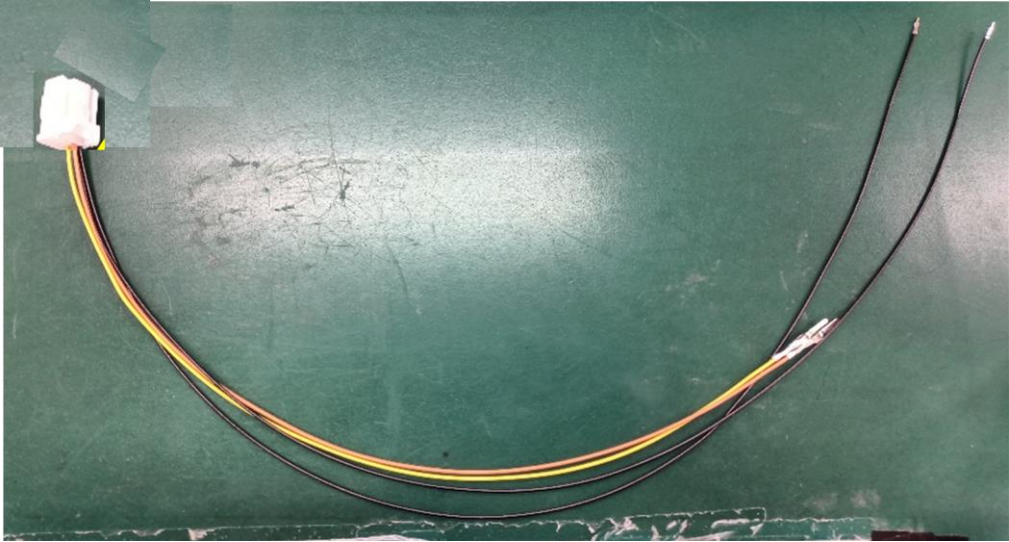
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<b>PARTS:</b>	1. Assy parts			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
6	OFFLINE	Measurement	<div>MEASURING TAPE</div> 	<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>	
		<p>Note:</p> <p>1. Measurement point: End of core wire to the end of core wire</p> <p>2. Terminal is reference only.</p>  			

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## OFFLINE ASSEMBLY PROCESS

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Model code/Part number:

920B / 7R0122-7022

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Document No.:

WI-ENG-PDE-720

Purpose:



PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Assy parts

JIG:

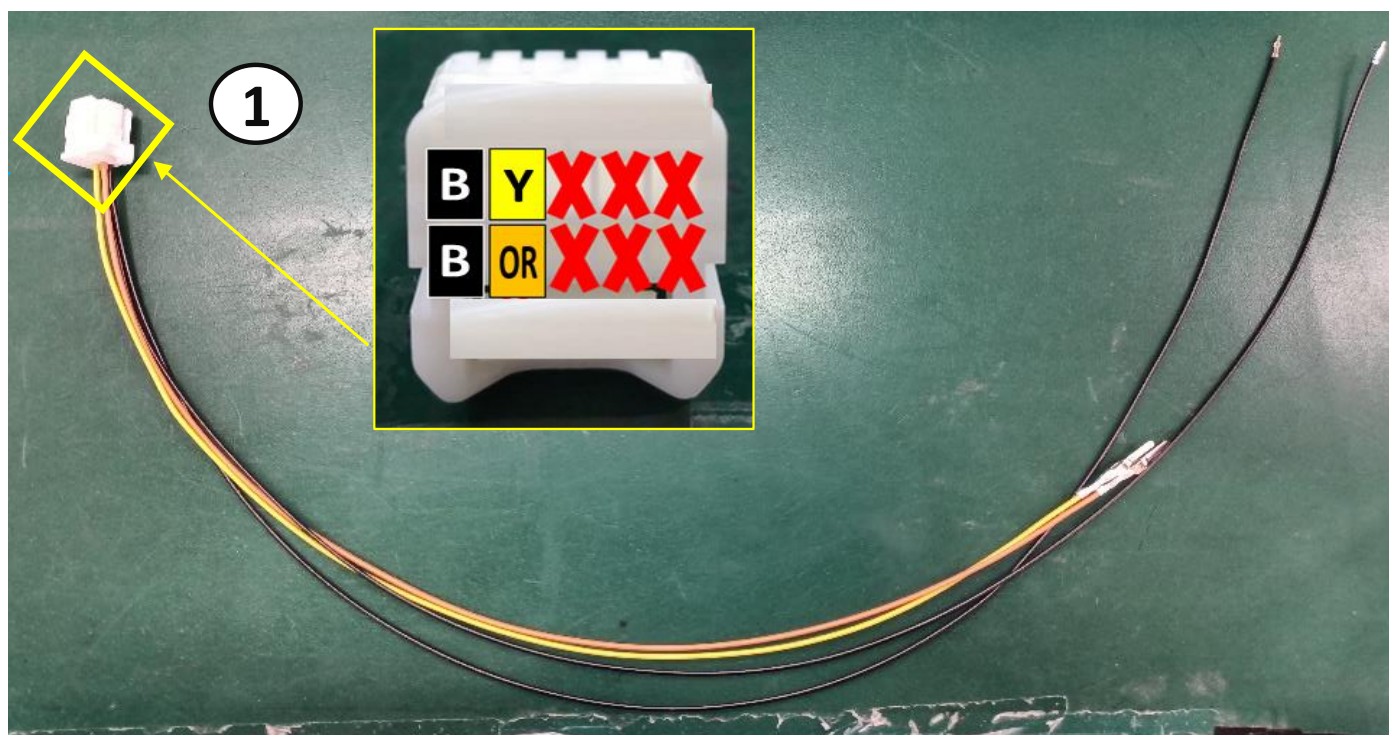
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## VISUAL INSPECTION/ QUALITY CHECKPOINTS

# OFFLINE INSERTION

# 7R0122-7022



① No Wrong Insert

② No Terminal Backing Out

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