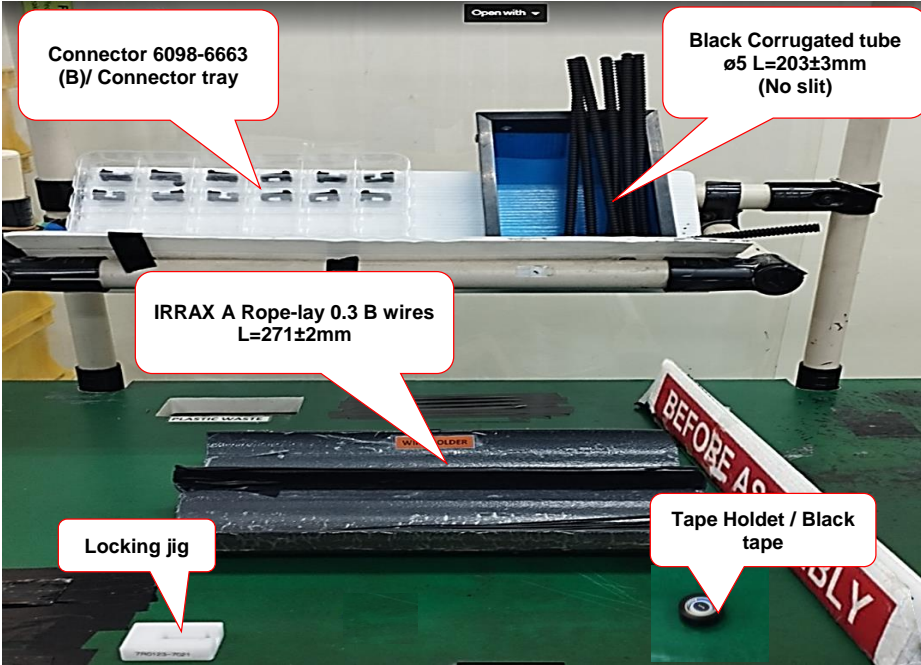






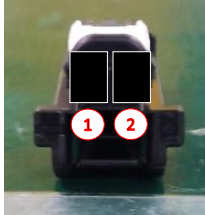

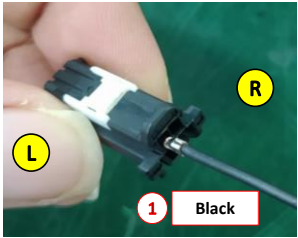
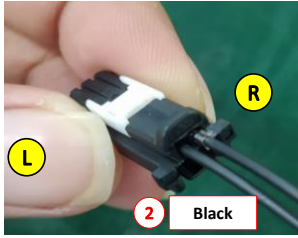
	WORK INSTRUCTION			Effectivity Date:	April 4, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 200D/220D / 7R0123-7023	Customer: TRMX	Car Model: TOYOTA-SEQUOIA	Document No.:	WI-ENG-PDE-862		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	1 of 6

PARTS:	1. All parts: Connector 6098-6663 (B); IRRAX A Rope-lay 0.3 B wires L=271±2mm; Black Corrugated tube ø5 L=203±3mm (No slit)			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1 Table Lay-out	<div> <div>TABLE LAY-OUT</div>  </div>		<div> Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) </div> <div> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div> 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. Important reminders/Note/s: 1. <i>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</i> Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance. 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

Revision History								Prepared by	Reviewed by	Approved by	Noted by				
04/04/24	1	Change from Pre-launch to Masspro. Inclusion of Table lay-out. Change Quality checkpoints to Visual inspection.				D. Castillo	C. Villanueva	A. Arañes	n/a				n/a		
03/19/24	0	Initial issue				D. Castillo	C. Villanueva	A. Arañes	n/a						
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	March 19, 2024				

	WORK INSTRUCTION				Effectivity Date:	April 4, 2024		
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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	2 of 6

PARTS:	1. Connector 6098-6663 (B) 2. IRRAX A Rope-lay 0.3 B wires L=271±2mm 3. Black Corrugated tube ø5 L=203±3mm (No slit)			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to black corrugated tube ø5 L=203±3mm (no slit)	 <div>1. Get the Black corrugated tube ø5 L=203±3mm (no slit) using left hand and get B-B wires using right hand then insert.</div>		n/a	1. No deformed terminal 2. No wrong usage of parts
3	P1 Wire insertion to connector 6098-6663 (B)	<div><div>CONNECTOR ORIENTATION</div></div> <div><div>VISUAL REFERENCE</div></div> <div><div>WIRE FACING</div></div> <div><div>1 Black</div></div> <div><div>2 Black</div></div> <div>1. Hold the connector 6098-6663 (B) then get the first Black wire and insert to terminal slot 1 using right hand. Conduct 2x push pull after wire insertion. Note: Make sure to hold the COT using right hand while insertion to prevent deformed in 7D0349 Terminal.</div> <div>2. Hold the connector 6098-6663 (B) then get the second Black wire and insert to terminal slot 2 using right hand. Conduct 2x push pull after wire insertion.</div>		n/a	1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing Important reminders/Note/s: 1. Insertion of wire must be from left to right. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance. 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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200D/220D / 7R0123-7023

Customer:

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Document No.:

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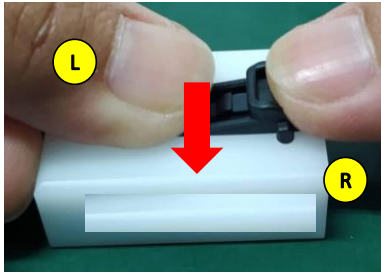
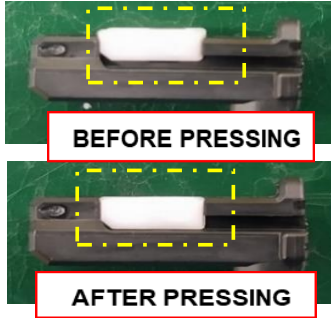
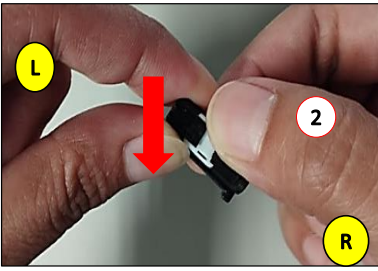
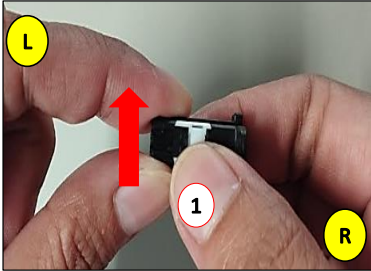

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

3 of 6

PARTS:	1. Assy parts			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	Connector lock	<div><p>1. Put the connector into locking jig using right hand then press to lock 2x using both hands.</p></div> <div></div> <div><p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p></div>	<div>MEASURING TAPE</div> 	<p>Important reminders/Note/s:</p> <p>1. Manual locking may cause damaged connector lock.</p> <p>1. Use provided jig tool per model 2. No unlock/half-locked connector</p>

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☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

April 4, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-862

Revision No.:

1

Page No.:

4 of 6

PARTS:

1. Assy parts
2. Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

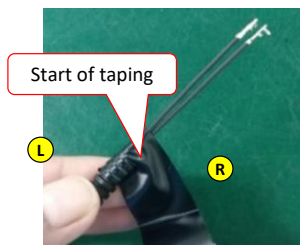
TOOLS/PPE

QUALITY POINTERS

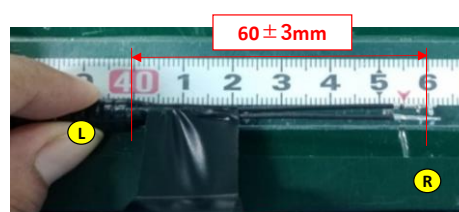
5

P1

Taping 1
COT to wire near terminal



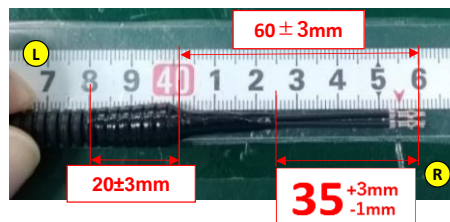
1. Hold the COT using left hand, get the **Black tape** using right hand then start pre-taping using both hands.



2. Measure from end of COT up to terminal pointed tip **60±3mm** then continue the taping process using both hands.



3. Confirm measurement of **35 (+3/-1mm)** from end of tape up to terminal pointed tip then continue the taping process using both hands.



4. After taping, check the measurement, taping condition and terminal appearance.

MEASURING TAPE



Important reminders/Note/s:

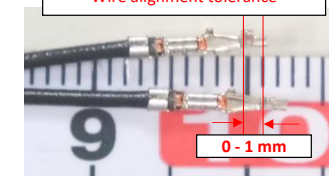
1. **Please use calibrated/verified measuring tape when getting the measurement.**

Document references:

1. **Refer to WI-PRO-ASY-001 for Taping process**

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


Wire alignment tolerance

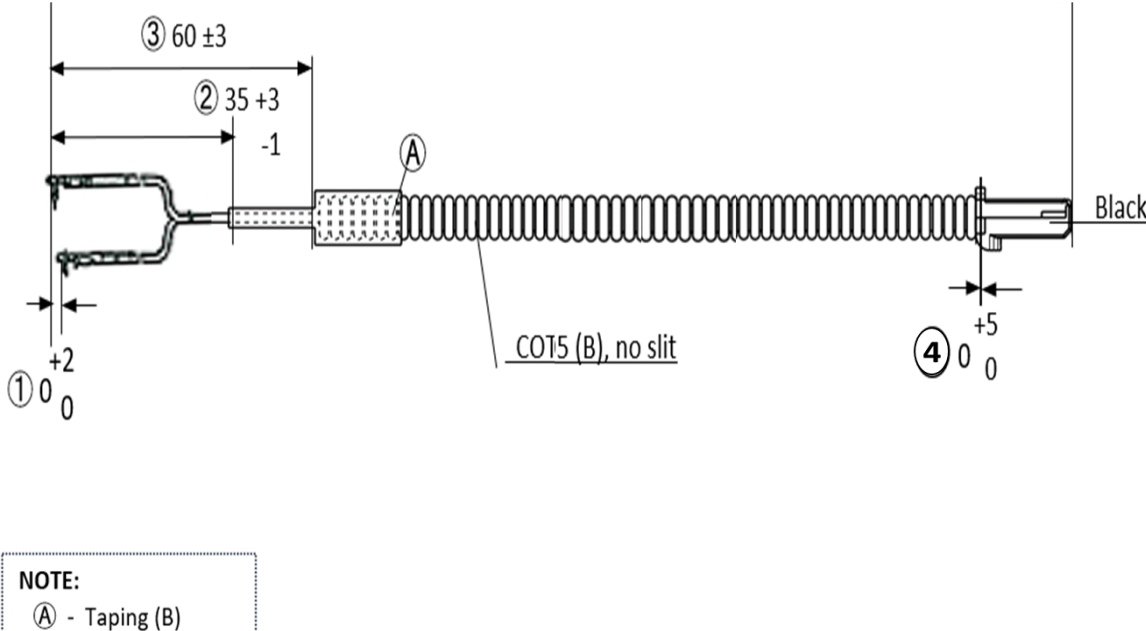



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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		1	Page No.: 5 of 6

PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
6	P1	Measurement 	<div>MEASURING TAPE</div> 	<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension.</p>	

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1

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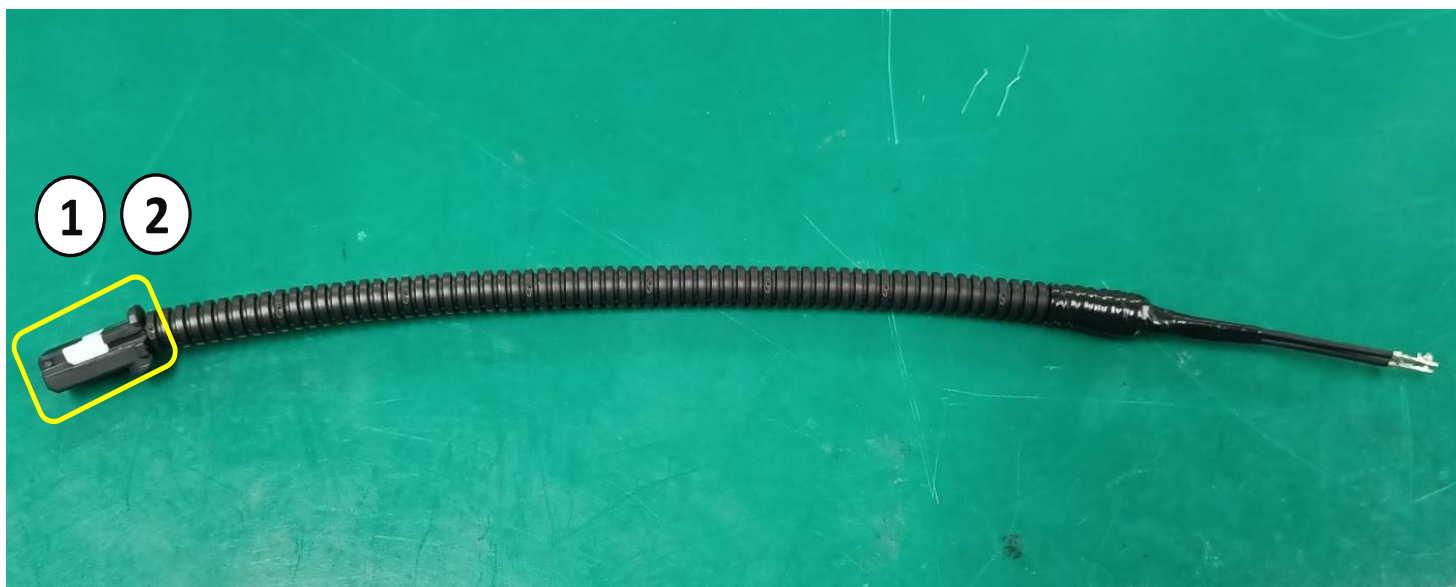
6 of 6

PARTS:

n/a

JIG:

n/a

**VISUAL INSPECTION****TAPING - P1****7R0123-7023****GOOD****NO GOOD****GOOD****NO GOOD****1****No Unlock/Halflock Connector****2****No Terminal Backing Out**

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