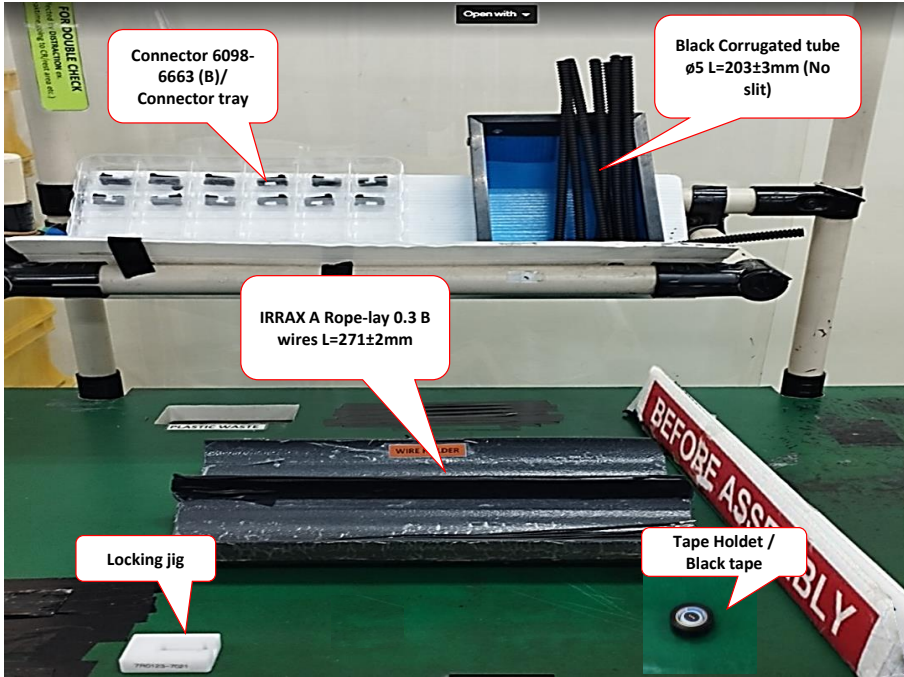





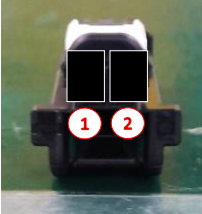

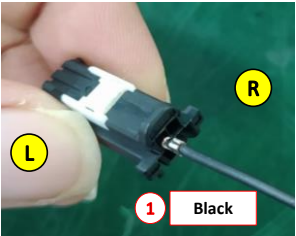
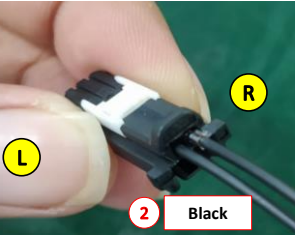
	WORK INSTRUCTION			Effectivity Date:	November 29, 2023		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 200D/220D / 7R0123-7022	Customer: TRMX	Car Model: TOYOTA-SEQUOIA	Document No.:	WI-ENG-PDE-576		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	6	Page No.:	1 of 5

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:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS
1	P1	<div><div>TABLE LAY-OUT</div></div>				<div><div>Safety Instruction</div><div>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div></div> <div><div>Housekeeping</div><div>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div></div> <div><div>Alert level</div><div>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>	<div>1. No missing parts/ tools. 2. No excess parts/tools.</div> <div>Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length tolerance</div>

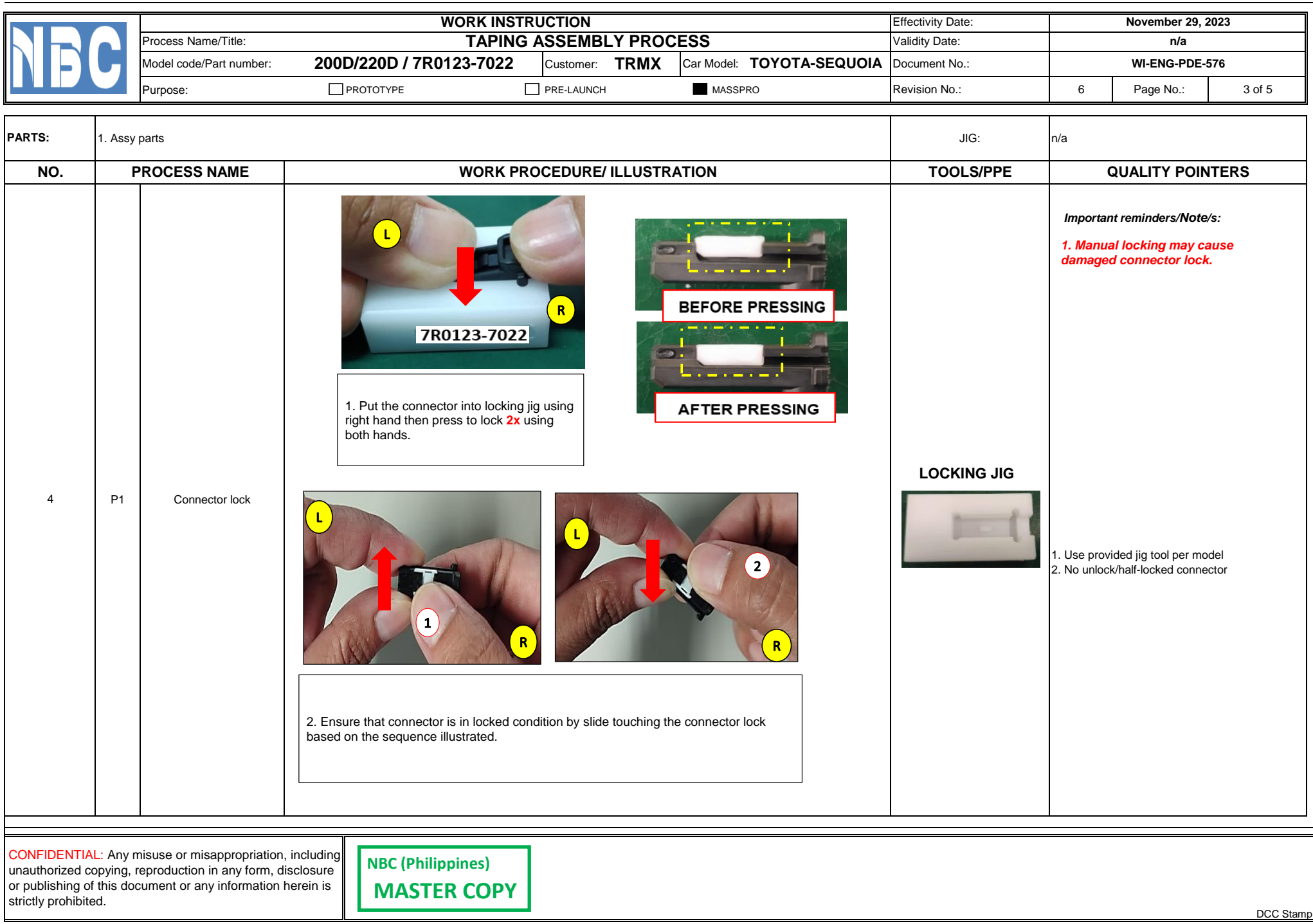
Revision History								Prepared by	Reviewed by	Approved by	Noted by
11/29/2023	6	Remove terminal cover jig and update process sequence due to process improvement. Update table lay-out.				D. Castillo	C. Villanueva	A. Arañes	n/a		
11/03/2023	5	Separate the Clamp assembly process due to process improvement (WI-ENG-PDE-743)				D. Castillo	J. Loterte	C. Villanueva	A. Arañes		
03/15/2023	4	Work instruction improvement: Remove offline process. Inclusion of batching. Update table lay-out. Inclusion of Quality Checkpoints (Page 10).				D. Castillo	J. Loterte	C. Villanueva	A. Arañes		
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:	August 12, 2022

	WORK INSTRUCTION				Effectivity Date:	November 29, 2023		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 200D/220D / 7R0123-7022		Customer: TRMX	Car Model: TOYOTA-SEQUOIA	Document No.:	WI-ENG-PDE-576		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO				Revision No.:	6	Page No.:	2 of 5

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 style="border: 1px solid black; padding: 5px; margin-top: 10px;"> 1. Get the Black corrugated tube ø5 L=203±3mm (no slit) using left had 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 style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  <div style="border: 1px solid red; padding: 2px; background-color: white;">CONNECTOR ORIENTATION</div> </div> <div style="text-align: center;">  <div style="border: 1px solid red; padding: 2px; background-color: white;">VISUAL REFERENCE</div> </div> <div style="text-align: center;">  <div style="border: 1px solid red; padding: 2px; background-color: white;">WIRE FACING</div> </div> </div> <div style="display: flex; justify-content: space-around; margin-top: 10px;"> <div style="text-align: center;">  </div> <div style="text-align: center;">  </div> </div> <div style="display: flex; justify-content: space-between; margin-top: 10px;"> <div style="width: 45%;"> 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: Insertion of wire must be from left to right. </div> <div style="width: 45%;"> 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> </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. 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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DCC Stamp





WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model code/Part number:

200D/220D / 7R0123-7022

Customer:

TRMX

Car Model:

TOYOTA-SEQUOIA

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

November 29, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-576

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6

Page No.:

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PARTS:

1. Assy parts
2. Black tape

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

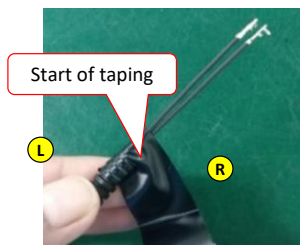
TOOLS/PPE

QUALITY POINTERS

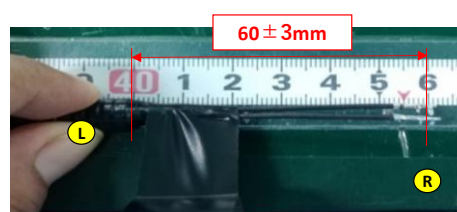
5

P1

Taping 1
COT to wire near termina



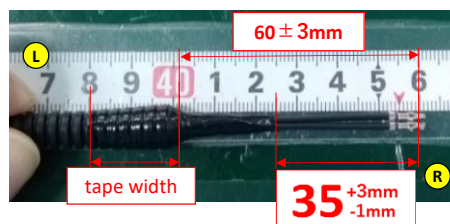
1. Hold the COT using left hand, get the **Black tape** using right hand then start pre-taping using both hands.



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

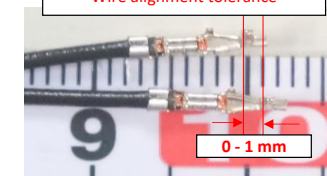


Important reminders/Note/s:

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

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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**WORK INSTRUCTION**

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TAPING ASSEMBLY PROCESS

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Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

6

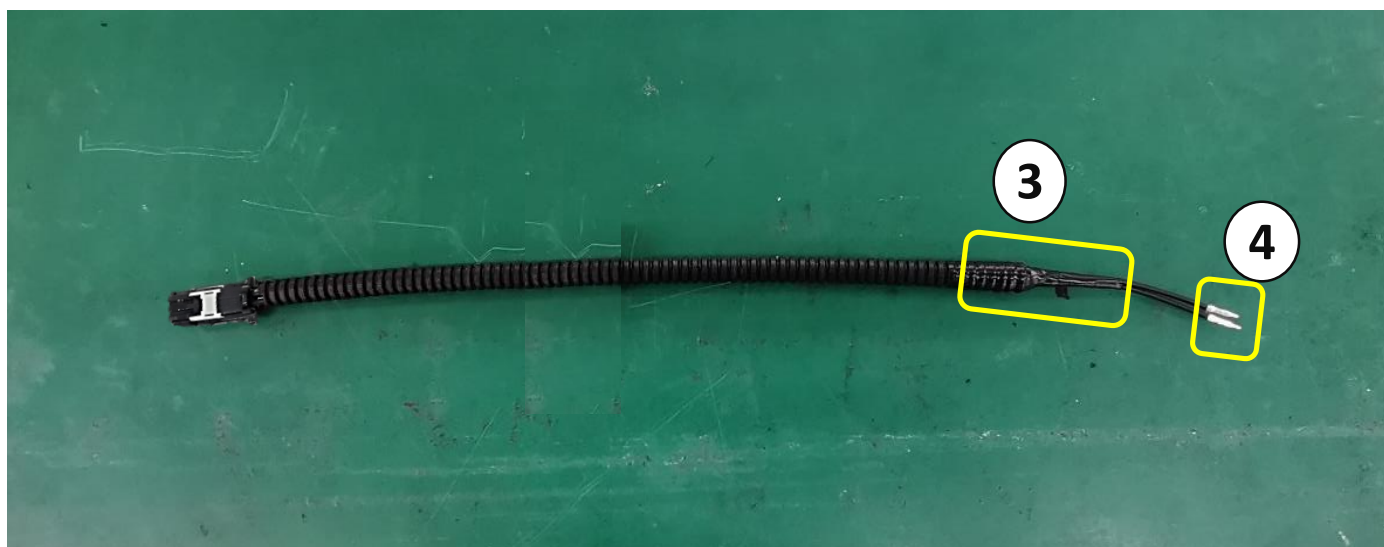
Page No.:

5 of 5**PARTS:**

n/a

JIG:

n/a

QUALITY CHECKPOINTS**P1****7R0123-7022****GOOD****NO GOOD****GOOD****NO GOOD**

- ① No Unlock/
Halflock Connector
- ② No Terminal Backing Out

- ③ No Missing Tape
- ④ No Deformed Terminal

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