


	WORK INSTRUCTION				Effectivity Date:		October 01, 2024	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 780B / 7R0103-7023B		Customer: TRMX	Car Model: TOYOTA-TUNDRA	Document No.: WI-ENG-PDE-1078B	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		1	Page No.:


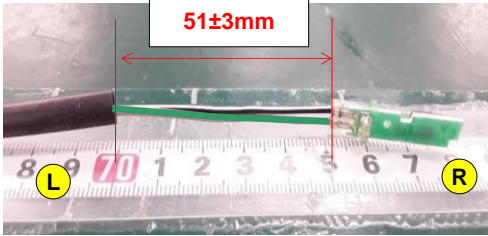
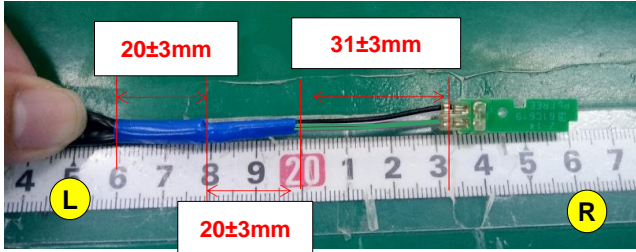

PARTS:	1. Assy part; VM tube (Sunprene) ø5 L=135±3mm ; Black Corrugated tube ø7 L=355±3mm (no slit); MR SW CP (TVSSf 0.3 wires G-B/W L=737±3mm); Blue Tape				JIG:	1. Insertion jig 2. locking jig 3. Measuring jig				
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS			
1	P2	<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;"> <u>Safety Instruction</u> 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;"> <u>Housekeeping</u> 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;"> <u>Alert level</u> 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		
Revision History						Prepared by	Reviewed by			Approved by
10/01/24	1	Change from Pre-launch to Masspro.				D.Castillo	C. Villanueva	A. Arañes	n/a	
09/24/24	0	Initial issue. Transfer some process from P1 and transfer Taping 3 and Y-taping process to P3 due to process improvement.				D.Castillo	C. Villanueva	A. Arañes	n/a	
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date: September 24, 2024

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PARTS:	1. VM tube (Sunprene) ø5 L=135±3mm 2. MR SW CP (TVSSf 0.3 wires G-B/W L=737±3mm) 3. Blue tape			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to VM tube (Sunprene) ø5 L=135±3mm	 <p>1. Get the VM tube (Sunprene) ø5 L=135±3mm using left hand then insert the G-B/W hot melted wires (MR SW CP) by using right hand.</p>		n/a	1. No wrong use of parts 2. No deformed terminal
3	P2 Taping 2 VM tube to wire near PCB	 <p>1. Hold the VM tube (Sunprene) using left hand. Measure the end of VM tube (Sunprene) up to the edge of hot melted wires 51±3mm using right hand.</p>  <p>2. Hold the Sunprene tube using left hand. Get the Blue tape using right hand then start taping process using both hands.</p> <p>3. After taping, check the measurement and taping condition.</p>			Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure. 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

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PARTS:	1. Assy parts 2. Black Corrugated tube (no slit) $\phi 7$ L=355 \pm 3mm			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Wire insertion to Black Corrugated tube (no slit) $\phi 7$ L=355 \pm 3mm	<div></div> <div><p>1. Hold the assy parts using left hand, get the corrugated tube $\phi 7$ L=355\pm3mm using right hand then insert the assy parts (MRSW CP) using left hand.</p></div>	n/a	1. No wrong use of parts 2. No deformed terminal
5		Wire insertion to Assy parts (Combined)	<div></div> <div><p>COT $\phi 7$ L= 208\pm3mm</p></div> <div><p>1. Get the assy parts using left hand. Insert the assy parts G-B/W wire to corrugated tube $\phi 7$ L=208\pm3mm using right hand.</p></div>	n/a	1. No wrong use of parts 2. No deformed terminal

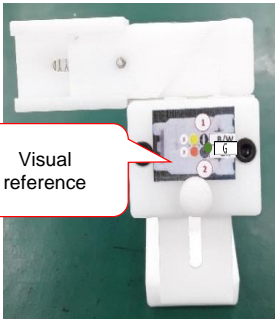


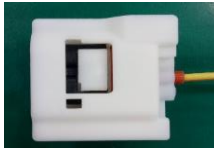
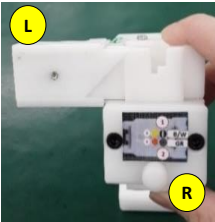
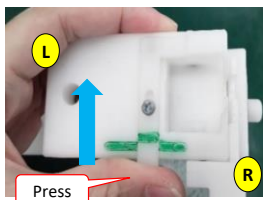
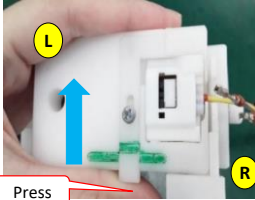
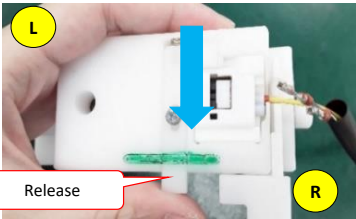




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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	4 of 7


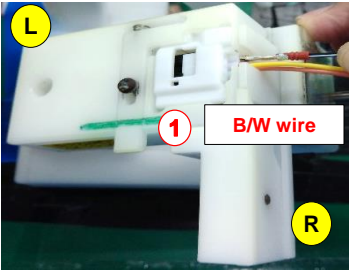

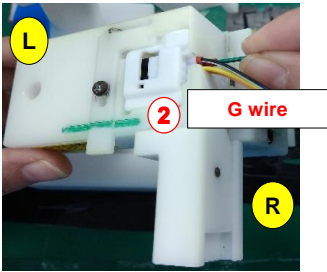
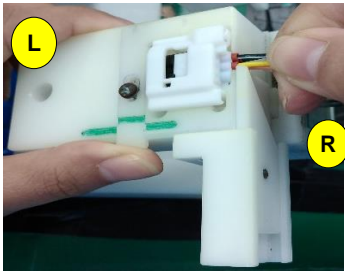
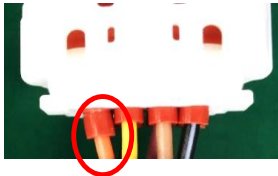
PARTS:	1. Assy parts			JIG:	1. Insertion jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
6	P2 Connector setting to Insertion jig 6189-1142 (W)	<div><div>Insertion Jig</div><div></div><div>Visual reference</div><div></div><div>Lock</div><div></div><div>I-mark</div><div></div><div>Connector Orientation</div><div>Insertion Jig Orientation</div><div></div><div>L</div><div>R</div><div>1. Press the lower wire guide using right thumb to make sure connector with inserted wires will be inserted.</div><div></div><div>L</div><div>R</div><div>Press</div><div>2. Press the Insertion jig lock using left thumb. Get the assy parts and insert the connector using right hand.</div><div></div><div>L</div><div>R</div><div>Press</div><div></div><div>L</div><div>R</div><div>Release</div><div>3. After insertion, release the insertion jig lock using left thumb.</div></div> <td>n/a</td> <td colspan="3"><div>CONNECTOR ORIENTATION ILLUSTRATION</div><div></div><div>I-mark is align</div><div></div><div>1 hole is open</div><div>GOOD</div><div>Important reminders/Note/s: 1. Follow the connector orientation</div><div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</div></td>		n/a	<div>CONNECTOR ORIENTATION ILLUSTRATION</div> <div></div> <div>I-mark is align</div> <div></div> <div>1 hole is open</div> <div>GOOD</div> <div>Important reminders/Note/s: 1. Follow the connector orientation</div> <div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</div>		

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PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P2 Wire Insertion to connector 6189-1142 (W)	<div><p>Terminal facing</p></div> <div><p>1 B/W wire</p></div> <div><p>2</p></div> <div><p>3 G wire</p></div> <div><p>4</p></div>		n/a	<p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal.</p> <p>2. Make sure wires are properly inserted.</p> <p>Conduct Pull-Push-Pull-Push after insertion.</p> <p>Do not exert extra force.</p> <p>Document references:</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> <p>Note: During insertion, hold the wire not rubber seal to prevent sagging.</p> 


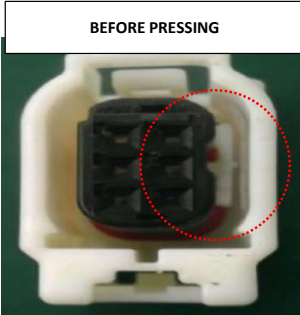
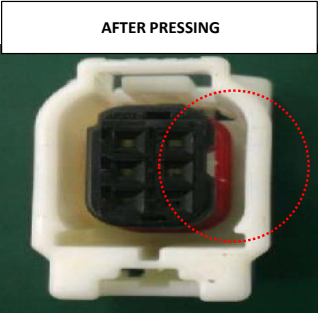

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PARTS:	1. Assy parts			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P2	Connector lock		<div>LOCKING JIG</div> 	<p>Important reminders/Note/s:</p> <p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <p>1. Use the provided locking jig per model 2. No unlock/half-lock connector 3. No damaged connector</p>
		<div><div>BEFORE PRESSING</div><div>AFTER PRESSING</div></div> <div><div>1. Put the connector into locking jig using right hand then press 2x. Check the connector lock if properly lock.</div></div>			

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PROTOTYPE



PRE-LAUNCH



MASSPRO

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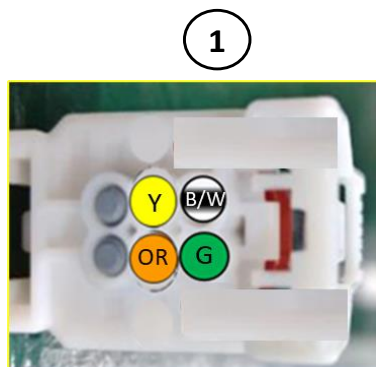
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P2****7R0103-7023B**

①

No WRONG INSERT

③

No TERMINAL BACKING OUT

②

**No UNLOCKED/ HALF-LOCKED
CONNECTOR**

④

**No MISSING TAPE/ NO WRONG USE
OF TAPE (BLUE TAPE)**

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