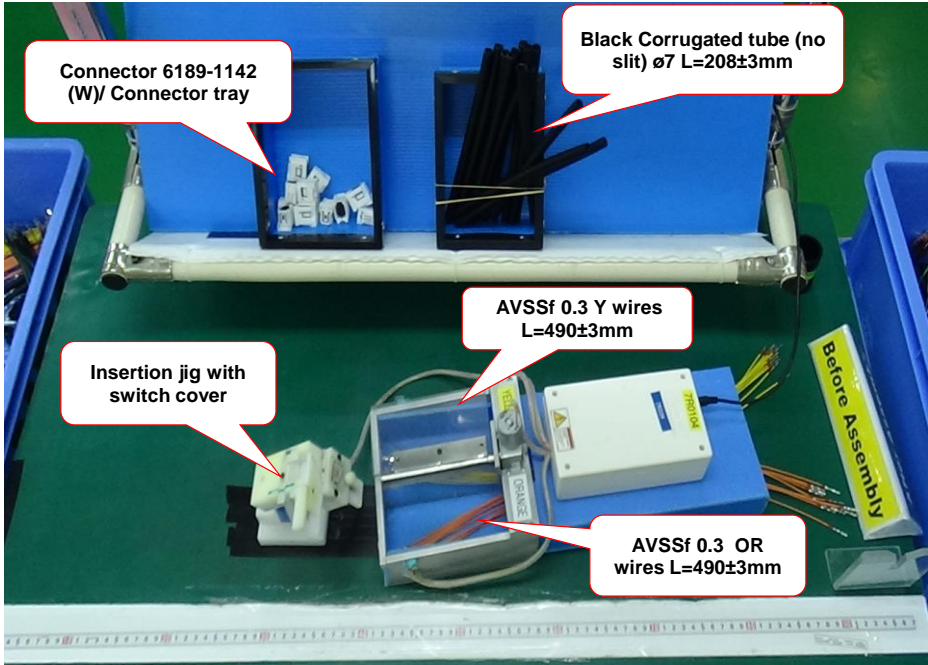



	<b>WORK INSTRUCTION</b>				Effectivity Date:		<b>October 1, 2024</b>	
	<b>OFFLINE ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: <b>780B / 7R0104-7023B</b>		Customer: <b>TRMX</b>	Car Model: <b>TOYOTA-TUNDRA</b>	Document No.: <b>WI-ENG-PDE-1080</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		1	Page No.: 1 of 6

PARTS:	1. Connector 6189-1142 (W); AVSSf 0.3 Y-OR L=490±3mm; Black corrugated tube (no slit) ø7 L=208±3mm		JIG:	1. Insertion jig with switch cover	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
1	n/a	Table Lay-out	<div><div>TABLE LAY-OUT</div></div>	<div><div><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div><div><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><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>	<div><b>Document reference/s:</b> 1. Please refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length tolerance</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>

Revision History							Prepared by	Reviewed by	Approved by	Noted by
										
10/01/24	1	Change Purpose from Pre-launch to Masspro.	M. Ariola	C. Villanueva	A. Arañes	n/a				
09/30/24	0	Initial issue. Inclusion of Measurement and update the quality checkpoints.	M. Ariola	C. Villanueva	A. Arañes	n/a				n/a
Eff. Date	Rev. No	Details of Change			Revised	Reviewed	Approved	Noted	Est. Date	September 30, 2024

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PARTS:		1. Connector 6189-1142 (W)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	n/a	<div><div>INSERTION JIG WITH SWITCH COVER</div><div><div><div>Y wire</div><div>OR wire</div><div>I-MARK</div><div>Lock</div><div>Visual reference</div><div>Button</div><div>Guide lock</div><div>Press</div><div>L</div></div><div><div>1. Press the lock of insertion jig using left thumb.</div></div><div><div>2. Insert the connector <b>6189-1142 (W)</b> into jig using right hand and release the lock.</div></div><div><div>3. Press the guide using left thumb. The slot for <b>Y wire</b> will be opened.</div></div></div><div><div>INSERTION JIG ORIENTATION</div><div>CONNECTOR ORIENTATION</div><div><div>L</div><div>R</div><div>L</div><div>Release</div></div><div><div>L</div><div>Guide</div></div></div></div> <div>N/A</div> <td><div>CONNECTOR ORIENTATION ILLUSTRATION</div><div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div></div></td>		<div>CONNECTOR ORIENTATION ILLUSTRATION</div> <div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div></div>	

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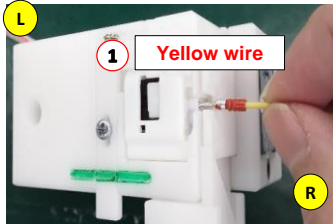
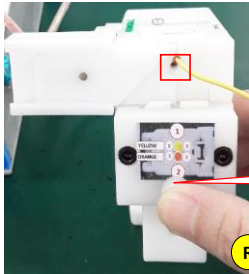
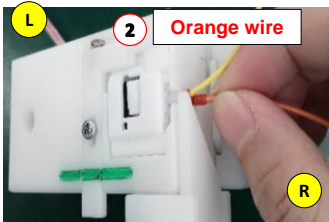
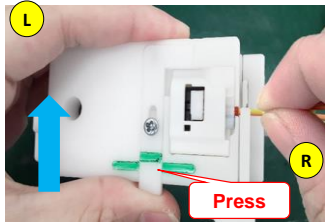
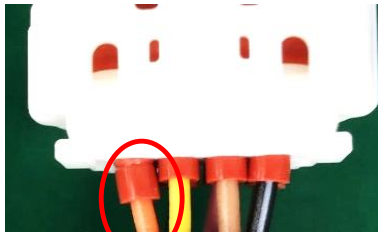
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PARTS:		1. Connector 6189-1142 (W) 2. AVSSf 0.3 Y L=490±3mm; OR wire L=490±3mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	n/a	Wire insertion to connector 6189-1142 (W)		N/A	<div><div><div>WIRE FACING</div></div><div><div>1. Hold the insertion jig using left hand. Get the <b>Y wire</b> and insert to connector using right hand.</div></div><div><div>2. Press the button using right thumb. The slot for <b>OR wire</b> will be opened.</div></div><div><div>3. Get the <b>OR wire</b> and insert to connector using right hand.</div></div><div><div>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.</div></div></div> <div><div></div><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><div>Important reminders/Note/s:</div><div>1. Make sure wires are properly inserted.</div><div>Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</div><div>2. During insertion, hold the wire not rubber seal to prevent sagging.</div><div>Document reference/s:</div><div>1. Please refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length tolerance.</div><div>2. Please refer to <b>GL-PRO-ASY-029</b> for Pull-Push procedure.</div></div></div>

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<b>PARTS:</b>		1. Assy parts 2. Black corrugated tube(no slit) $\varnothing 7$ L=208 $\pm$ 3mm		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
4	n/a	<div>Wire insertion to Black corrugated tube (no slit) <math>\varnothing 7</math> L= 208<math>\pm</math>3mm</div> <div></div> <div>1. Get the corrugated tube (no slit) <math>\varnothing 7</math> L= 208<math>\pm</math>3mm using right hand then insert the <b>Y-OR wires</b> using left hand.</div>		N/A	1. No wrong use of parts 2. No deformed terminal

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**WORK INSTRUCTION****OFFLINE ASSEMBLY PROCESS**

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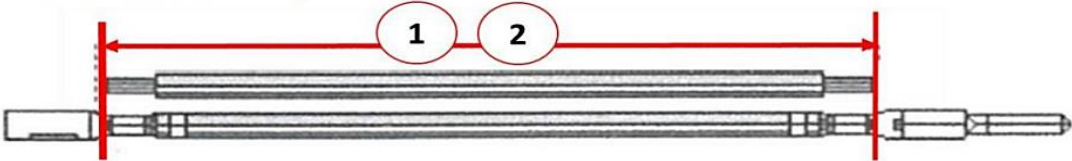
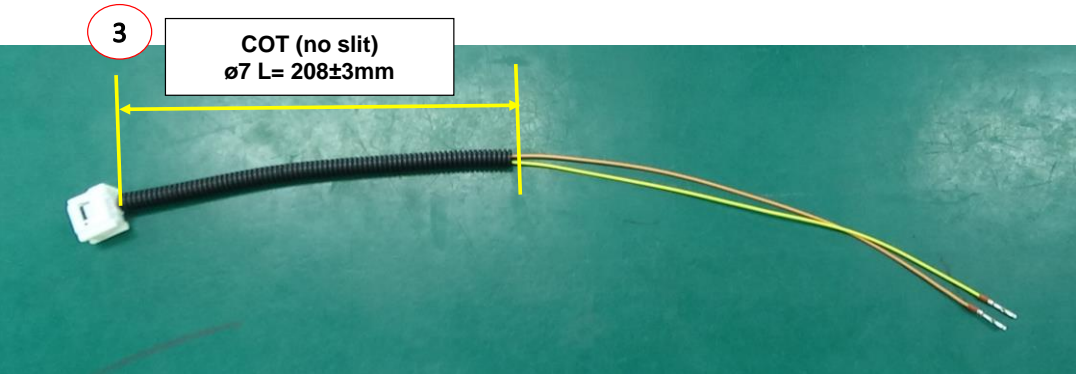

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PARTS:		1. Assy parts 2. Black corrugated tube(no slit) $\phi 7$ L=208 $\pm$ 3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	n/a  Measurement	<div>Note: 1. Measurement point: End of core wire to the end of core wire 2. Terminal is reference only.</div> <div></div> <div></div> <div>COT (no slit) <math>\phi 7</math> L= 208<math>\pm</math>3mm</div>		<div>MEASURING TAPE</div> <div></div>	<div>Important reminders/Note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>2. For Hatsumono, Nakamono and Owarimono inspection.</div> <div>Document reference/s:</div> <div>1. Please refer to GL-PRO-ASY-029 for Pull-Push procedure.</div> <div>2.Refer to WI-PRO-CNC-017 for Wire and Strip lenght tolerance.</div> <div>1. No wrong dimension</div>

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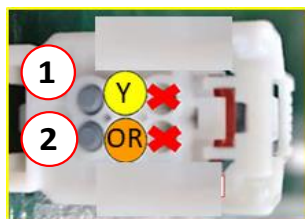
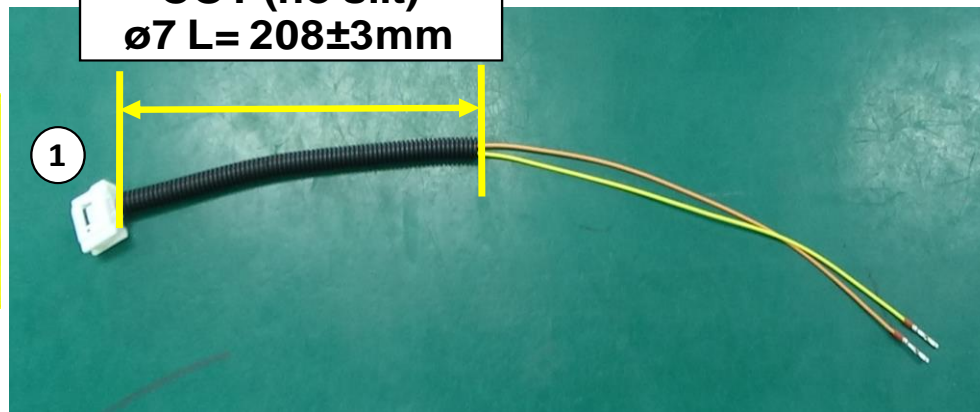
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PARTS:

N/A

JIG:

N/A

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE ASSEMBLY****7R0104-7023B****COT (no slit)**  
**ø7 L= 208±3mm****1 No WRONG INSERT****2 No TERMINAL BACKING OUT****3 No MISSING PARTS**

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