



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

August 08, 2024

Validity Date:

n/a

Model code/Part number:

920B / 7R0118-7024

Customer:

TRMX

Car Model: TOYOTA TACOMA

Document No.:

WI-ENG-PDE-962B

Purpose:

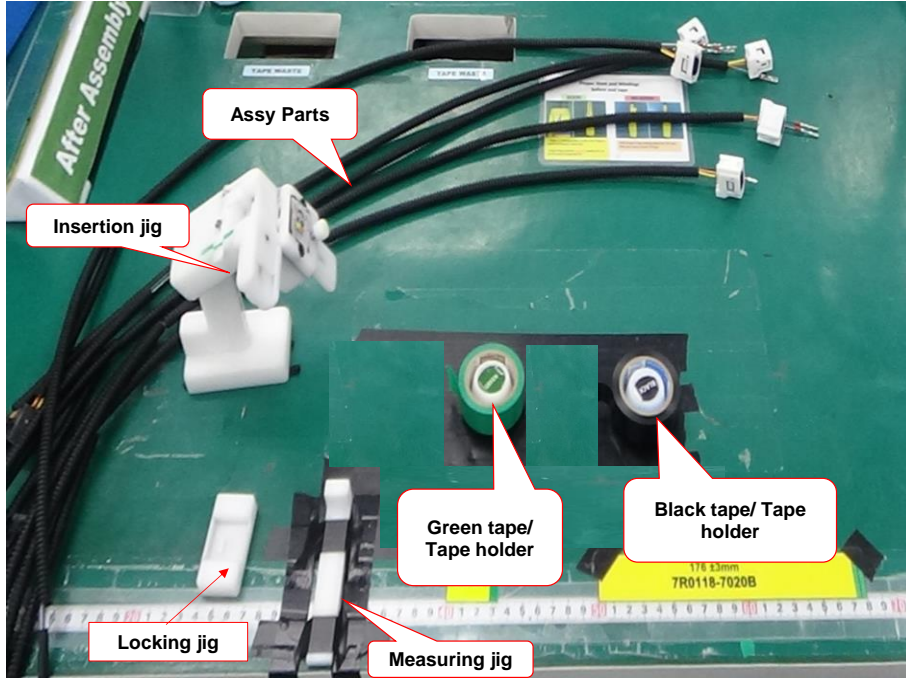
☐ PROTOTYPE☒ PRE-LAUNCH☐ MASSPRO

Revision No.:

0

Page No.:

1 of 6

PARTS:		1. Assy parts; Black tape [1pc.]; Green tape [1pc.]				JIG:		1. Insertion Jig 2. Measuring Jig 3. Locking Jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	P2	<div>Table Lay-out</div> 				<div>Safety Instruction Be sure to wear prescribed 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	
Revision History						Prepared by	Reviewed by	Approved by	Noted by
08/08/24	0	Initial issue.				D.Castillo	C.Villanueva	A. Arañes	N/A
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted
						Est. Date:	August 08, 2024		

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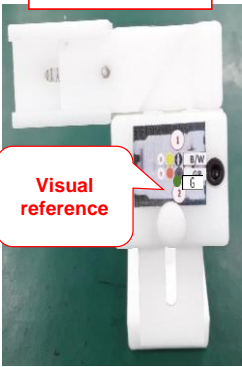




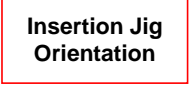
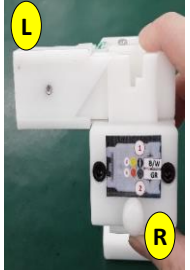
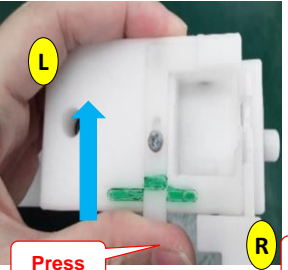
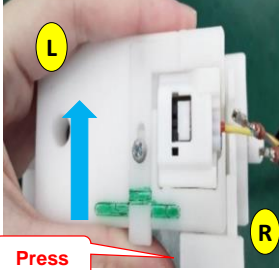
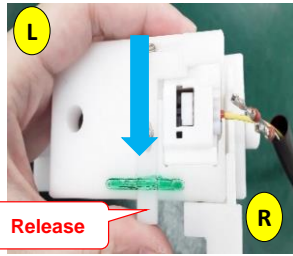




☐ MASSPRO

Revision No.:

0

Page No.:


2 of 6


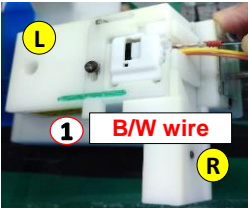

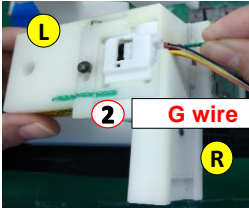
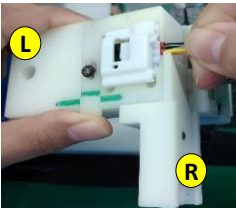
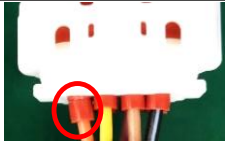

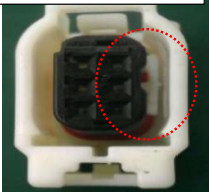
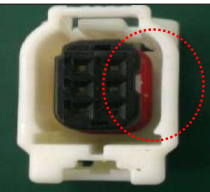

PARTS:	1. Assy parts		JIG:	1. Insertion Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2 Connector setting to Insertion jig 6189-1142 (W)	<div><p>Insertion Jig</p></div> <div><p>I-mark</p></div> <div><p>Lock</p></div> <div><p>Visual reference</p></div> <div><p>Connector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

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	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 920B / 7R0118-7024		Customer: TRMX	Car Model: TOYOTA TACOMA	Document No.:	WI-ENG-PDE-962B		
	Purpose: <input type="checkbox"/> PROTOTYPE <input checked="" type="checkbox"/> PRE-LAUNCH <input type="checkbox"/> MASSPRO				Revision No.:	0	Page No.:	3 of 6

PARTS:	1. Assy parts			JIG:	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2 Wire insertion to Connector (Assy parts)	<div>Wire facing</div> <div>1 B/W wire</div> <div>1. Hold the insertion jig using left hand. Get the B/W wire then insert to terminal slot 1 using right hand.</div> <div>R</div> <div>2. Press the button using right thumb. Slot for Green wire will be opened.</div> <div>2 G wire</div> <div>3. Get the G- wire then insert to terminal slot 2 using right hand.</div> <div>LR</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>		n/a	<div>Note: During insertion, hold the wire not rubber seal to prevent sagging.</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>Important reminders/Note/s: <i>1. Please hold the wire near terminal.</i> <i>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</i></div> <div>Document references: <i>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i></div>
4	Connector lock	<div><div>Put the connector into locking jig using right hand then press 2x. Check the connector lock if properly lock.</div></div> <div>BEFORE PRESSING</div> <div>AFTER PRESSING</div> <div>LOCKING JIG</div>			<div>Important reminders/Note/s: <i>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR.</i></div> <div>1. Use the provided locking jig per model 2. No unlock/half-lock connector 3. No damaged connector</div>

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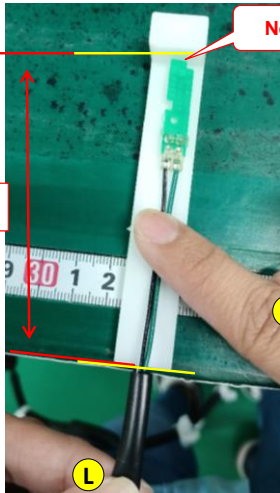
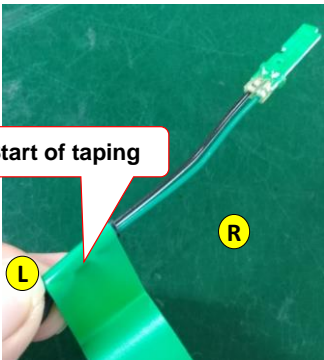
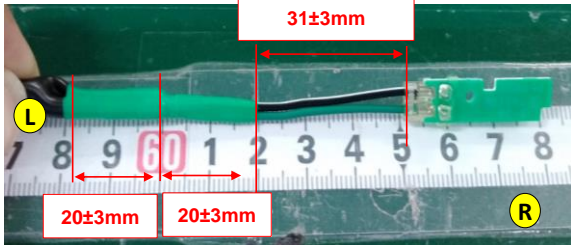


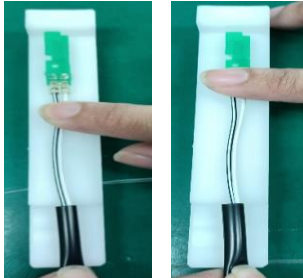
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Revision No.:

0

Page No.:


4 of 6

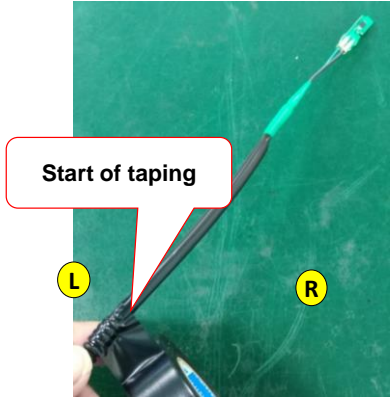
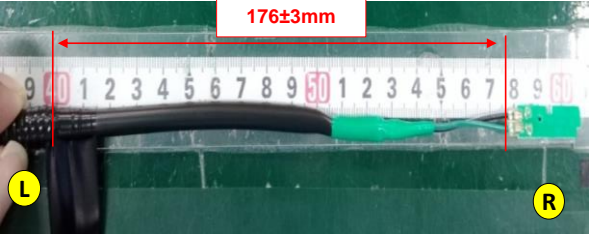


PARTS:		1. Assy parts 2. Green tape		JIG:	1. Measuring jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2 Taping 1 Black VM tube (Sunprene) to wire near PCB	<div><div><p>No Gap</p><p>82mm</p><p>(R)</p><p>(L)</p></div><div><p>Start of taping</p><p>(R)</p><p>(L)</p></div><div><p>2. Get the Green tape using right hand then start taping process using both hands.</p></div><div><p>31±3mm</p><p>20±3mm</p><p>20±3mm</p><p>(L)</p><p>(R)</p></div><div><p>1. Get the assy parts and set to measuring jig. First, set the holmeted wire (No Gap) using right hand. Last, set the VM tube (Sunprene) (No Gap) using left hand.</p></div><div><p>3. After taping, check the measurement and taping condition.</p></div></div> <div><div>MEASURING TAPE</div><div></div><div>MEASURING JIG</div><div></div></div> <div><p>Important reminders/Note/s:</p><p>1. Use GREEN TAPE only.</p><p>2. Please use calibrated/verified measuring tape when getting the measurement.</p><ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension<div><p>GOOD NG</p></div><p>Position the finger in wire to avoid deformed hotmelt</p></div>			

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
6	P2 Taping 2 COT to VM tube (Sunprene) near PCB	<div><div>1. Hold the COT using left hand, get the Black tape using right hand then start pre-taping using both hands.</div></div> <div><div>2. Measure from end of COT up to PCB 176±3mm then continue the taping process using both hands.</div></div> <div><div>3. After taping, check the measurement and taping condition.</div></div>		<div>MEASURING TAPE</div> 	<div>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</div> <div>Important reminders/Note/s:</div> <div>1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-ASY-001 for taping procedure.</div>	

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Page No.:

6 of 6

PARTS:

1. Assy parts

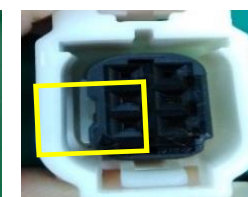
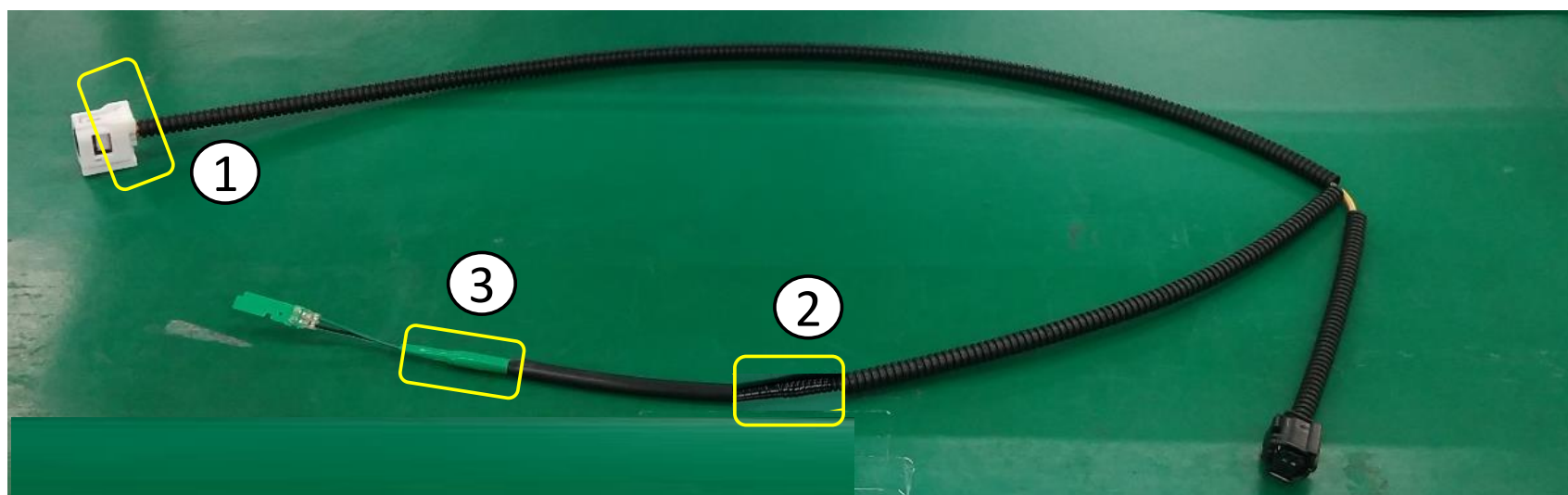
JIG:

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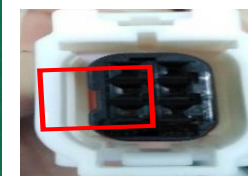
VISUAL INSPECTION/ QUALITY CHECKPOINTS

P2

7R0118-7024



GOOD



NO GOOD

1

No Wrong Insert

No Terminal Backing Out

2

No Missing Tape

3

No Wrong use of Tape

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