



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

780B / 7R0105-7023B

Customer:

TRMX

Car Model:

TOYOTA-TUNDRA

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Effectivity Date:

October 15, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1088A

Revision No.:

1

Page No.:

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PARTS:

1. All parts: Connector 6188-0407 (W); TVSSf 0.3 wires G-B/W L=583mm±3mm; Black Corrugated tube Ø5 L=188±3mm (no slit); Black Sunprene tube Ø5 L=325±3mm; Black tape [1pc.]

JIG:

1. Insertion jig with switch cover
2. Locking jig
3. Terminal cover jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

P1

Table Lay-out

Table Lay-out

Connector 6188-0407 (W)/
Connector Tray

Black Corrugated tube
Ø5 L=188±3mm (no slit)

Black Sunprene tube
Ø5 L=325±3mm

TVSSf 0.3 wires G-B/W
L=583mm±3mm

Insertion Jig with
switch cover

Locking

Terminal
cover jig

Black tape/
Tape holder

Safety Instruction

Be sure to wear
prescribed personal
protective equipment
during operation (gloves,
finger cots, etc.)

Housekeeping

1. Maintain and always
practice 5's.
2. Personal things on the
workplace is prohibited.
Keep it in your locker.

Alert level

For any trouble, inform
the Assembly Assistant
Supervisor or Line Leader
for immediate corrective
action.

1. No missing parts/tools
2. No excess parts/tools

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip
Length Tolerance

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
10/15/24	1	Change from Pre-launch to Masspro.	A. Hernandez	C. Villanueva	A. Arañes	n/a	A. Hernandez	C. Villanueva	A. Arañes	n/a
10/14/24	0	Initial Issue.	A. Hernandez	C. Villanueva	A. Arañes	n/a	A. Hernandez	C. Villanueva	A. Arañes	n/a

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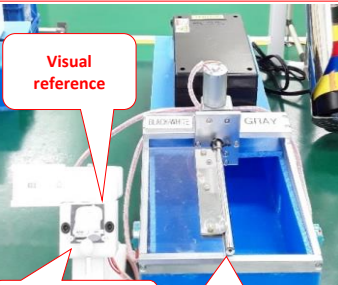
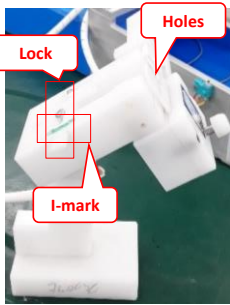

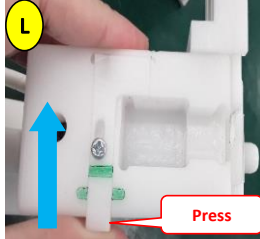
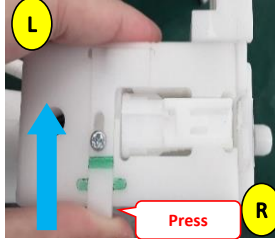
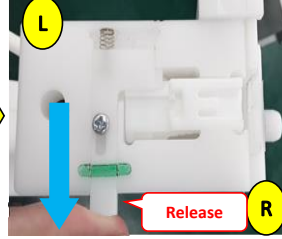
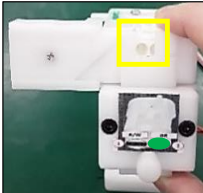
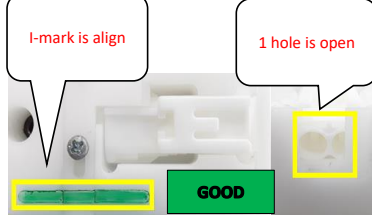
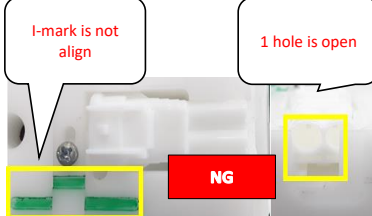
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PARTS:		1. Connector 6188-0407 (W)		JIG:	1. Insertion jig with flip cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1 Connector setting to Insertion jig 6188-0407 (W)	<div><div>INSERTION JIG WITH FLIP COVER</div><div><div><div>Visual reference</div></div><div><div>Lock</div><div>Holes</div><div>I-mark</div></div><div><div>CONNECTOR ORIENTATION</div></div></div><div><div><div>L</div><div>Press</div></div><div><div>L</div><div>Press</div><div>R</div></div><div><div>L</div><div>Release</div><div>R</div></div><div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 6188-0407 (W) into jig using right hand and release the lock. Note: Refer to above illustration for correct setting.</div></div><div><div><div>3. Check the holes/terminal slot for B/W wire.</div></div></div></div></div>		n/a	<div>1. Use the provided jig per model</div> <div>2. No wrong orientation of connector</div> <div>3. No wrong use of connector</div> <div>4. No damaged connector</div> <div><div>Connector Orientation Illustration</div><div><div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div></div><div><div>I-mark is not align</div><div>1 hole is open</div><div>NG</div></div></div></div>

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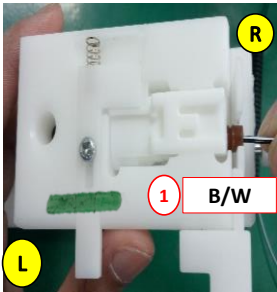
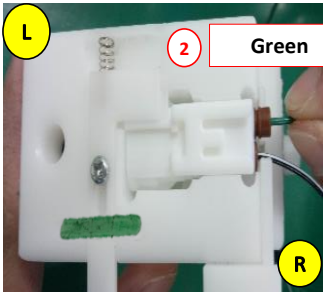
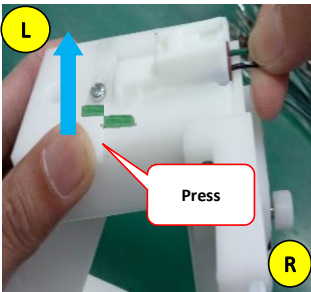
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PARTS:		1. TVSSf 0.3 G-B/W wires L=583mm±3mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1	Wire Insertion to connector 6188-0407 (W)	<div><p>Wire facing</p><p>1 B/W</p><p>2 Green</p><p>Press</p><p>1. Hold the Insertion jig using left hand. Get Black/White wire then insert to terminal slot 1 using right hand.</p><p>2. Push the button using right hand. The slot for Green wire will be opened.</p><p>3. Get the Green wire then insert to terminal slot 2 using right hand.</p><p>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.</p></div>	n/a	<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>Important reminders/Note/s: 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p>

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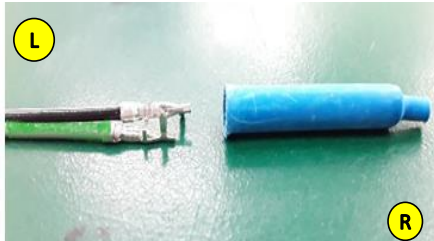

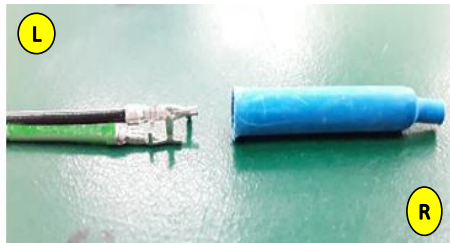

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PARTS:		1. Assy parts 2. Black Corrugated tube Ø5 L=188±3mm (No slit)		JIG:	1. Locking jig 2. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1 Wire insertion to Corrugated tube Ø5 L=188±3mm (No slit)	<div><div></div><div>1. Get the terminal cover jig using right hand then insert the G-B/W wires using left hand.</div><div></div><div>2. Get the Corrugated Ø5 L=188±3mm (no slit) using right hand and insert the G-B/W wires using left hand.</div><div></div><div>3. After insertion, remove the terminal cover jig using right hand.</div></div>		<div>Terminal Cover Jig</div> <div></div>	1. No wrong use of parts 2. No deformed terminal

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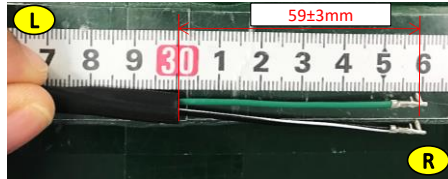
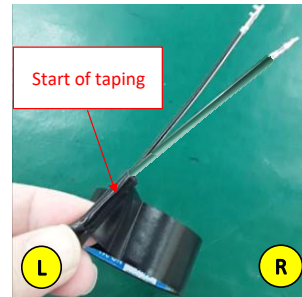
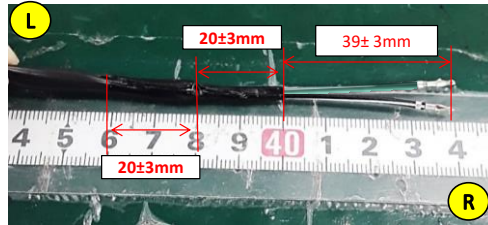

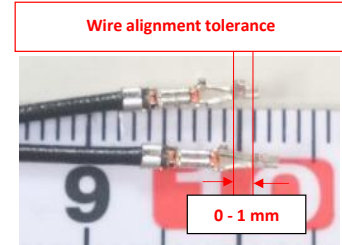
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PARTS:				JIG:	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	Wire insertion to Sunprene tube Ø5 L=325±3mm	<div></div> <div>1. Get the Black Sunprene tube Ø5 L=325±3mm using right hand and insert the G-B/W wires using left hand</div>		n/a	1. No wrong use of parts 2. No deformed terminal
6	P1 Taping 1 Black sunprene tube to wirre near terminal	<div></div> <div>1. Hold the sunprene tube using left hand and measure from end of sunprene tube up to terminal pointed tip 59±3mm using both hands.</div> <div></div> <div>2. Hold the Sunprene tube using left hand. Get the Black tape using right hand and begin taping process using both hands</div> <div></div> <div>3. After taping, check the measurement, terminal alignment and taping condition.</div>		<div></div> <div>Measuring tape</div>	<div></div> <div>Wire alignment tolerance</div> <div>0 - 1 mm</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: 1. Please use calibrated/verified measuring tape when getting the measurement.</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
7	P1 Taping 2 Black COT and Black sunprene tube near terminal	<div><p>1. Measure the end of the corrugated tube up to the end of the terminal pointed tip 384±3mm using both hands.</p></div> <div><p>2. Get the Black tape using right hand. Hold corrugated tube using left hand then start taping using both hands.</p></div> <div><p>3. After taping, check the measurement, alignment and tape condition.</p></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: 1. Please use calibrated/verified measuring tape when getting the measurement.</div>

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PARTS:

n/z

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**TAPING - P1****7R0105-7023B**

- ① No Wrong Insert
- ② No Missing Tape (BLACK)
- ③ No Missing Clip Attachment
- ④ No Deformed Terminal
- ⑤ No Terminal Backing out
- ⑥ No Missing COT and VM tube (SUNPRENE)

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