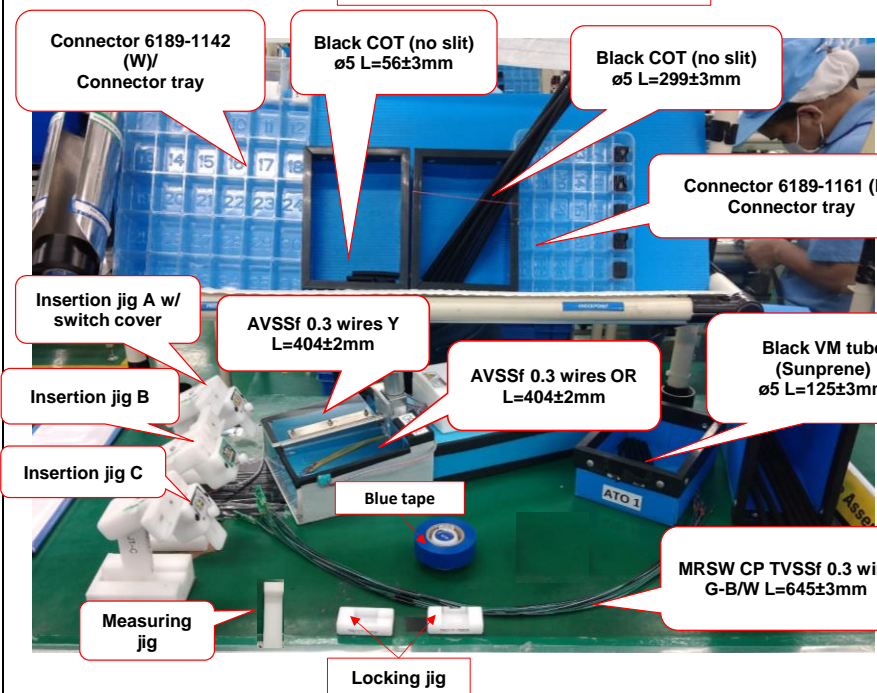
	<b>WORK INSTRUCTION</b>				Effectivity Date:		August 20, 2024	
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: <b>920B / 7R0117-7025</b>		Customer: <b>TRMX</b>	Car Model: <b>TOYOTA-TACOMA</b>	Document No.: <b>WI-ENG-PDE-982A</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		1	Page No.: 1 of 8

<b>PARTS:</b>	1. Connector 6189-1142 (W),6189-1161 (B); AVSSf 0.3 wires Y-OR L=404±2mm; Black COT (no slit) ø5 L=56±3mm; Black COT (no slit) ø5 L=299±3mm; Blue tape; Black VM tube (Sunprene) ø5 L=125±3mm; MRSW CP TVSSf 0.3 wire G-B/W L=645±3mm			JIG:	1. Insertion jig with switch cover 2. Insertion jig 3. Locking jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
1	P1 Table Lay-out	<div><b>TABLE LAY-OUT</b></div> 		<div><b>Safety Instruction</b> Be sure to wear required 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><b>Document reference/s:</b> 1. 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
08/20/24	1	Change purpose from Pre-launch to Masspro.	M.Ariola	C.Villanueva	A.Arañes	n/a	
07/19/24	0	Initial issue.	M.Ariola	C.Villanueva	A.Arañes	n/a	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: July 19, 2024

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# WORK INSTRUCTION

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**PARTS:**  
1. Connector 6189-1142 (W)  
2. AVSSf 0.3 wires Y-OR L=404±2mm

JIG:

1. Insertion jig with switch cover

NO.

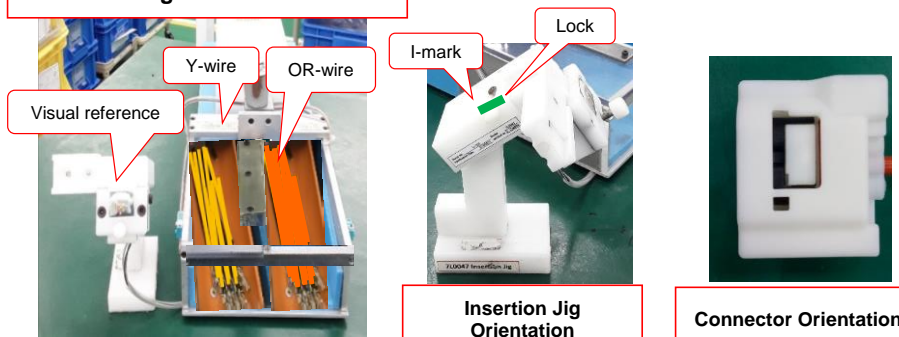
PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

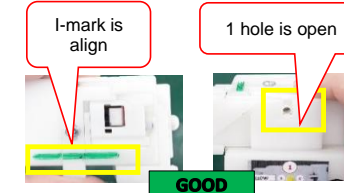
TOOLS/PPE

QUALITY POINTERS

### Insertion Jig with Switch Cover



### CONNECTOR ORIENTATION ILLUSTRATION



### Document reference/s:

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

1. Use the provided jig per model
2. No wrong orientation of connector
3. No wrong use of connector
4. No damaged connector

n/a

2

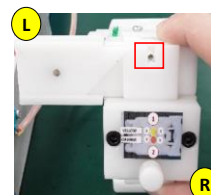
P1

Connector setting to Insertion jig 6189-1142 (W)



1. Press the insertion jig lock using left hand.

2. Get the connector **6189-1142 (W)** using right hand and insert to insertion jig. Release the lock after insertion.  
**Note: Follow the connector orientation.**



3. Push the guide using right hand. The slot for **Y wire** will be opened.

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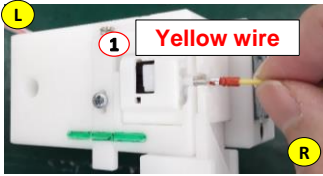
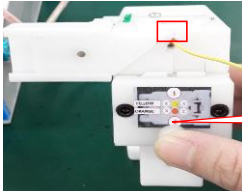
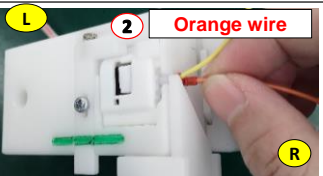

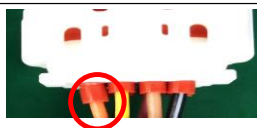
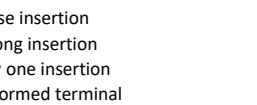


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PARTS:		1. Assy parts 2. Black Corrugated tube (no slit) $\phi 5$ L=56 $\pm$ 3mm 3. Black Corrugated tube (no slit) $\phi 5$ L=299 $\pm$ 3mm		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Wire Insertion to connector 6189-1142 (W)  P1	<div><b>Wire facing</b></div> <div><b>1 Yellow wire</b> 1. Hold the insertion jig using left hand. Get the <b>Yellow wire</b> then insert to terminal slot <b>1</b> using right hand.</div> <div><b>Press</b> 2. Press the button using right thumb. Slot for <b>Orange wire</b> will be opened.</div> <div><b>2 Orange wire</b> 3. Get the <b>Orange wire</b> then insert to terminal slot <b>2</b> using right hand.</div> <div><b>Press</b> 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><b>Note:</b> During insertion, hold the wire not <b>rubber seal</b> to prevent sagging.</div> <div><ol style="list-style-type: none"><li>1. No loose insertion</li><li>2. No wrong insertion</li><li>3. One by one insertion</li><li>4. No deformed terminal</li></ol><b>Important reminders/Note/s:</b><ol style="list-style-type: none"><li>1. Please hold the wire near terminal.</li><li>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</li></ol><b>Document references:</b><ol style="list-style-type: none"><li>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</li></ol></div>
4	Wire insertion to COT (no slit) $\phi 5$ L=56 $\pm$ 3mm $\phi 5$ L=299 $\pm$ 3mm	<div><b>1</b> 1. Get the Corrugated tube <b><math>\phi 5</math> L=56<math>\pm</math>3mm (no slit)</b> using right hand then insert the <b>Y-OR wires</b>.</div> <div><b>2</b> 2. Get the Corrugated tube <b><math>\phi 5</math> L=299<math>\pm</math>3mm (no slit)</b> using right hand then insert the <b>Y-OR wires</b>.</div>		n/a	<ol style="list-style-type: none"><li>1. No wrong use of parts</li><li>2. No deformed terminal</li></ol>

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# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

August 20, 2024

Process Name/Title:

Model code/Part number:

920B / 7R0117-7025

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Validity Date:

n/a

Document No.:

WI-ENG-PDE-982A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

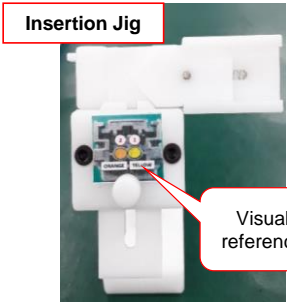
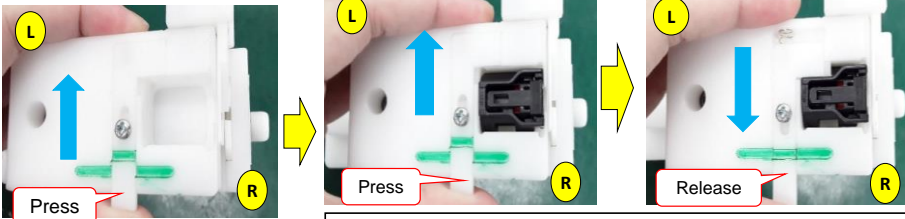
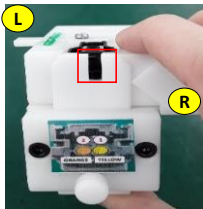
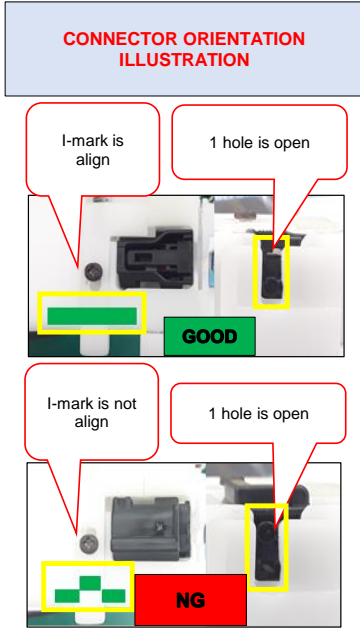
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PARTS:		1. Connector 6189-1161 (B)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1	<p>Connector setting to Insertion jig 6189-1161 (B)</p>  <p>Insertion Jig</p> <p>I-mark</p> <p>Lock</p> <p>Visual reference</p> <p>Insertion Jig Orientation</p> <p>Connector Orientation</p>  <p>1. Press the insertion jig lock using left hand.</p> <p>2. Get the connector <b>6189-1161 (B)</b> using right hand and insert to insertion jig. Release the lock after insertion. <b>Note: Follow the connector orientation.</b></p>  <p>3. Push the guide using right hand. The slot for <b>Y wire</b> will be opened.</p>		n/a	<p><b>CONNECTOR ORIENTATION ILLUSTRATION</b></p>  <p>I-mark is align</p> <p>1 hole is open</p> <p>I-mark is not align</p> <p>1 hole is open</p> <p><b>GOOD</b></p> <p><b>NG</b></p> <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>

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920B / 7R0117-7025

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TRMX

Car Model:

TOYOTA-TACOMA

Purpose:

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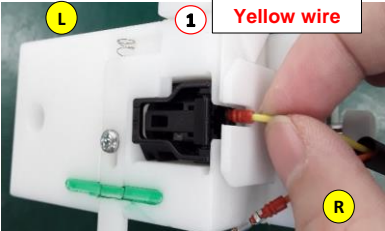

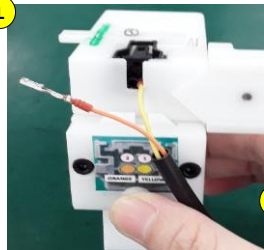
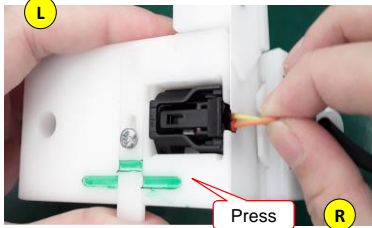

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PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1 Wire insertion to connector 6189-1161 (B)	<div><p>Wire facing</p></div> <div><p>1. Hold the insertion jig using left hand. Get the <b>Yellow wire</b> then insert to terminal slot <b>1</b> using right hand.</p></div> <div><p>3. Get the <b>Orange wire</b> then insert to terminal slot <b>2</b> using right hand.</p></div> <div><p>2. Press the button using right thumb. Slot for <b>Orange wire</b> will be opened.</p></div> <div><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	<div><p>Note: During insertion, hold the wire not <u>rubber seal</u> to prevent sagging.</p></div>  <div><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><b>Important reminders/Note/s:</b> 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><b>Document references:</b> 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p></div>

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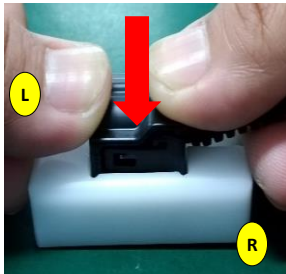
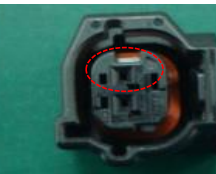






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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) $\phi 5$ L=125 $\pm$ 3mm		3. MRSW CP TVSSf 0.3 wire G-B/W L=645 $\pm$ 3mm		JIG:	1. Locking jig 2. Measuring jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
7	P1	Connector lock	<div></div> <div>Put the connector into locking jig using right hand then press <b>2x</b> using both hands. Check the connector lock if properly lock.</div> <div><div></div><div></div></div>			<div>LOCKING JIG</div> 	<b>Important reminders/Note/s:</b> <b>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b>  1. Use the provided jig per connector 2. No unlock/half-locked connector
8		Wire insertion to Black VM tube (Sunprene) $\phi 5$ L=125 $\pm$ 3mm	<div></div> <div>1. Get the VM tube (Sunprene) <b><math>\phi 5</math> L=125<math>\pm</math>3mm</b> using right hand then insert the <b>MRSW CP TVSSf 0.3 wire G-B/W L=645<math>\pm</math>3mm</b> using left hand.</div>			n/a	<b>Document reference/s:</b> <b>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b>  1. No wrong usage of parts

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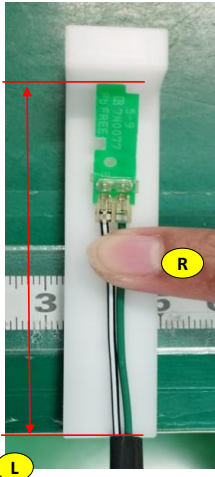
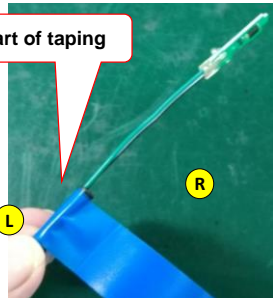
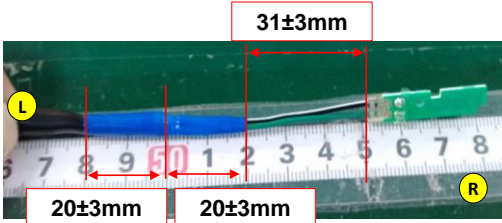


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PARTS:		1. Assy parts 2. Blue tape		JIG:	1. Measuring jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1 Taping 1 Black VM tube (Sunprene) to wire near PCB	<div></div> <div></div> <div><p>1. Conduct measurement on measuring jig by placing the assy parts on guide dimension. (See illustration)</p></div> <div></div> <div><p>2. Get the <b>Blue tape</b> using right hand then start taping process using both hands.</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>		<div><p><b>MEASURING TAPE</b></p></div> <div><p><b>MEASURING JIG</b></p></div>	<p><b>Important reminders/Note/s:</b></p> <p>1. Use <b>BLUE TAPE</b> only</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <p>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</p>

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PARTS:

1. Assy parts

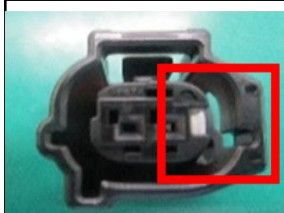
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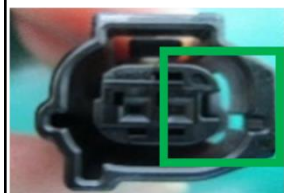
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P1

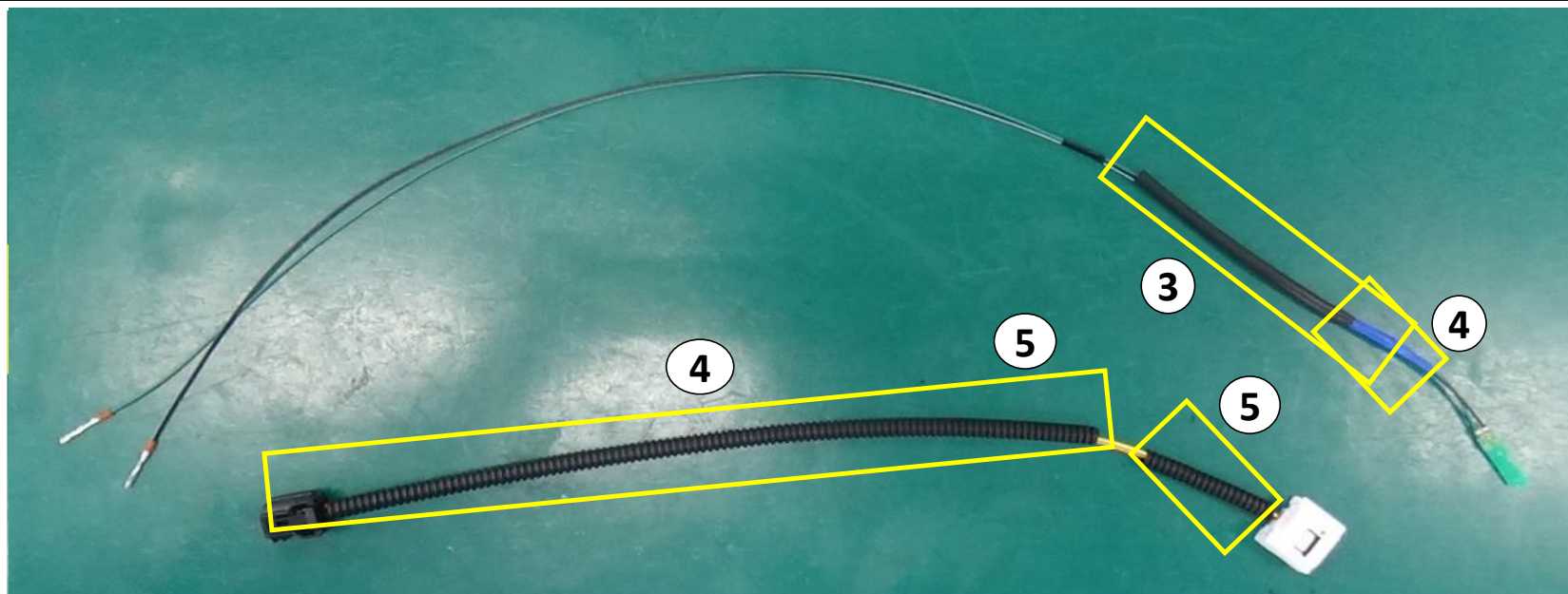
7R0117-7025



NO GOOD



GOOD



① ②

No **WRONG INSERT**

No **TERMINAL BACKING OUT**

③

No **MISSING VM TUBE (SUNPRENE)**

④

No **WRONG USED OF TAPE (BLUE)**

⑤

No **WRONG USED OF TAPE**

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