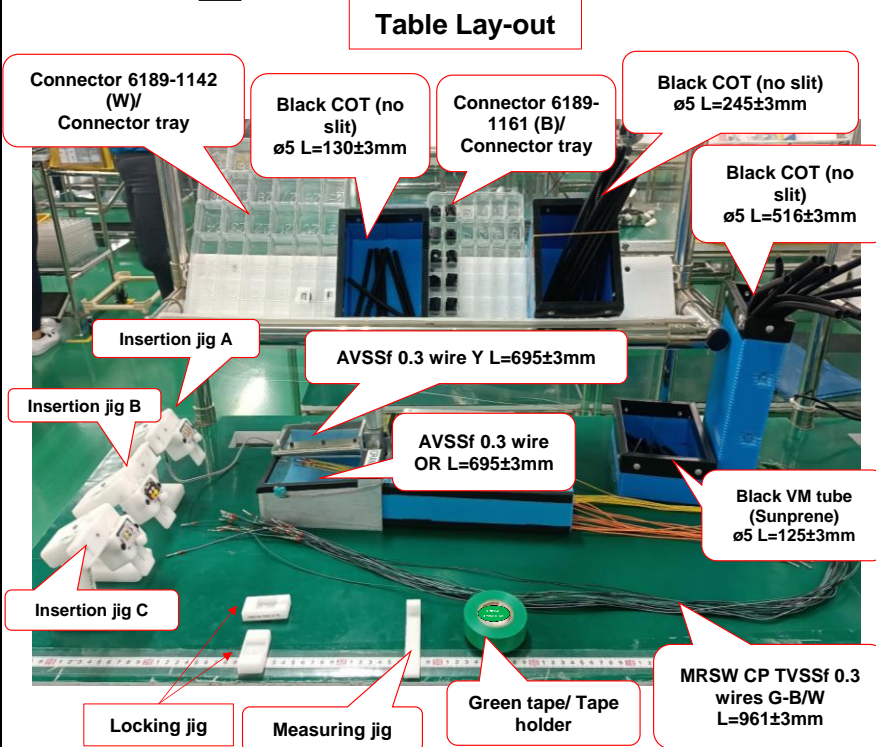

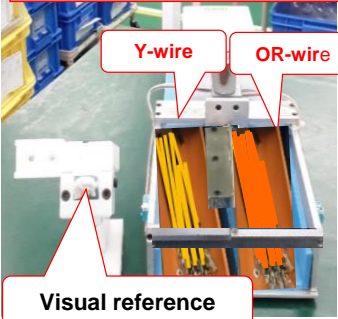
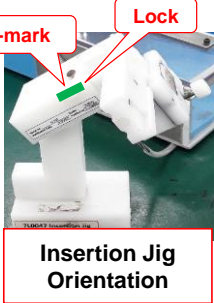
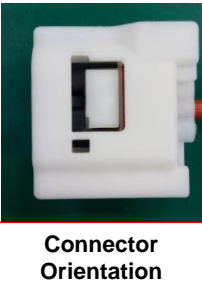
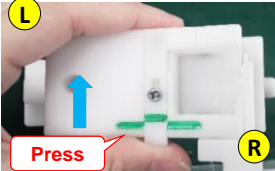
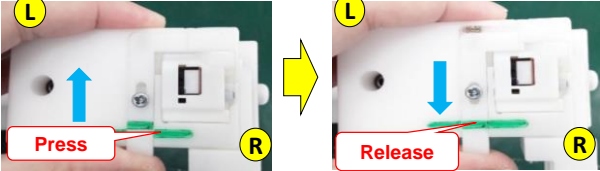
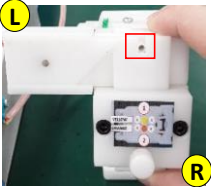


	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date:		June 24, 2024	
	Process Name/Title:				Validity Date:		n/a	
	Model code/Part number: 920B / 7R0118-7023		Customer: TRMX	Car Model: TOYOTA TACOMA	Document No.:		WI-ENG-PDE-654A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		2	Page No.: 1 of 8

PARTS:		1. Connector 6189-1142 (W); AVSSf 0.3 wires Y-OR L=695±3mm; Black COT (no slit) ø5 L=516±3mm; Black COT (no slit) ø5 L=130±3mm; Connector 6189-1161 (B); Black VM tube (Sunprene) ø5 L=125±3mm; Black COT (no slit) ø5 L=245±3mm; MRSW CP TVSSf 0.3 wires G-B/W L=961±3mm; Green tape		JIG:		1. Insertion jig with switch cover 2. Insertion jig 3. Locking jig 4. Measuring jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
1	P1	<p>Table Lay-out</p> 	<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>Document reference/s:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</p> <p>2. WI-PRO-KIT-005 Wire Taping without Vinyl Tube.</p>			

Revision History				Prepared by	Reviewed by	Approved by	Noted by
06/24/24	2	Transfer Connector setting to Insertion jig 6189-1142 (W), Wire insertion to Connector (Assy parts), Connector lock and Taping 1 Black VM tube (Sunprene) to wire near PCB to P2 (WI-ENG-PDE-654B) due to process improvement . Update Table lay-out and Visual inspection/Quality checkpoints. Inclusion of Car model "TOYOTA-TACOMA".	D.Castillo	C.Villanueva	A. Arañes	N/A	
05/24/23	1	Change document from pre-launch to masspro. Additional table lay-out. Provide measuring jig.	D.Castillo	J.Loterte	C.Villanueva	A. Arañes	
03/21/23	0	Initial issue.	D.Castillo	J.Loterte	C.Villanueva	A. Arañes	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: March 21, 2023

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.:	2 of 8


PARTS:		1. Connector 6189-1142 (W)		JIG:	1. Insertion jig with switch cover	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
2	P1 Connector setting to Insertion jig 6189-1142 (W)	<div><div><p>Insertion Jig with Switch Cover</p><p>Y-wire</p><p>OR-wire</p><p>Visual reference</p></div><div><p>I-mark</p><p>Lock</p><p>Insertion Jig Orientation</p></div><div><p>Connector Orientation</p></div><div><p>Press</p><p>1. Press the insertion jig lock using left hand.</p></div><div><p>Press</p><p>Release</p><p>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.</p></div><div><p>3. Push the guide using right hand. The slot for Y wire will be opened.</p></div></div> <div><p>n/a</p></div> <td><div><p>CONNECTOR ORIENTATION ILLUSTRATION</p><p>I-mark is align</p><p>1 hole is open</p><p>GOOD</p></div><div><p>1. Use the provided jig per model</p><p>2. No wrong orientation of connector</p><p>3. No wrong use of connector</p><p>4. No damaged connector</p></div></td>		<div><p>CONNECTOR ORIENTATION ILLUSTRATION</p><p>I-mark is align</p><p>1 hole is open</p><p>GOOD</p></div> <div><p>1. Use the provided jig per model</p><p>2. No wrong orientation of connector</p><p>3. No wrong use of connector</p><p>4. No damaged connector</p></div>		



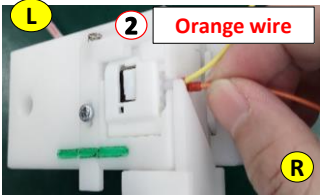
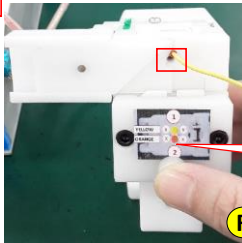

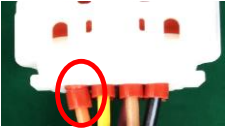


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	Model code/Part number: 920B / 7R0118-7023		Customer: TRMX	Car Model: TOYOTA TACOMA	Document No.: WI-ENG-PDE-654A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	2	Page No.:	3 of 8

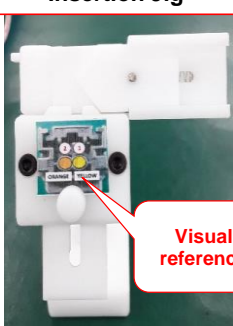
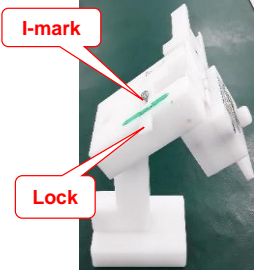
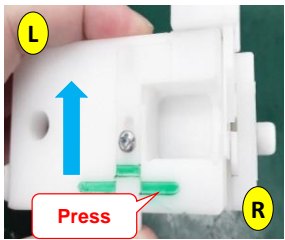

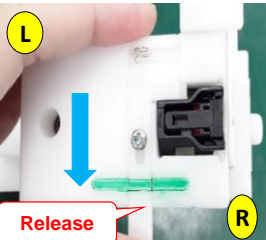
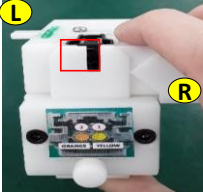
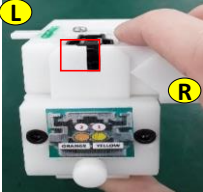


PARTS:	1. AVSSf 0.3 wire Y-OR L=695±3mm 2. Black Corrugated tube ø5 L=516±3mm (no slit) 3. Black Corrugated tube ø5 L=130±3mm (no slit)			JIG:	1. Insertion Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Wire Insertion to connector 6189-1142 (W)	<div> Wire facing</div> <div> 1 Yellow wire</div> <div> 2 Orange wire</div> <div> Press</div> <div> Press</div> <div>1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot 1 using right hand.</div> <div>2. Press the button using right thumb. Slot for Orange wire will be opened.</div> <div>3. Get the Orange wire then insert to terminal slot 2 using right hand.</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>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>Note: During insertion, hold the wire not rubber seal to prevent sagging.</div> <div></div> <div>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.</div> <div>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>
4	Wire insertion to COT (no slit) ø5 L=516±3mm ø5 L=130±3mm	<div> 1</div> <div> 2</div> <div>1. Get the Corrugated tube ø5 L=516±3mm (no slit) using right hand then insert the Y-OR wires.</div> <div>2. Get the Corrugated tube ø5 L=130±3mm (no slit) using right hand then insert the Y-OR wires.</div>			<div>1. No wrong use of parts 2. No deformed terminal</div>

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.:	4 of 8

PARTS:	1. Connector 6189-1161 (B)			JIG:	1. Insertion jig			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
5	P1	<div><div><div>Insertion Jig</div><div>Visual reference</div></div><div><div>I-mark</div><div>Lock</div></div><div><div>Insertion Jig Orientation</div><div>Press</div></div><div><div>Connector Orientation</div><div>Press</div></div><div><div>Release</div><div>Release</div></div><div><div>1. Press the insertion jig lock using left hand.</div><div>2. Get the connector 6189-1161 (B) using right hand and insert to insertion jig. Release the lock after insertion. Note: Follow the connector orientation.</div><div><div>3. Push the guide using right hand. The slot for Y wire will be opened.</div></div></div></div>			n/a	<div><div>CONNECTOR ORIENTATION ILLUSTRATION</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>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>		

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Document No.:

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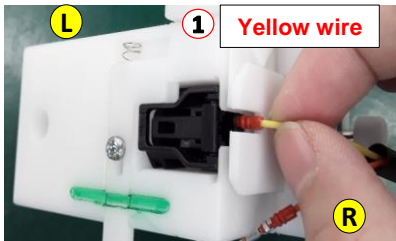
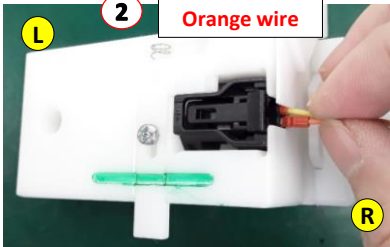

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PARTS:		1. Assy parts ; Connector 6189-1161 (B)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1	<div><div><p>Wire facing</p></div><div><p>1 Yellow wire</p></div><div><p>2 Orange wire</p></div></div>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

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PARTS:	1. Assy parts 2. Black VM tube (Sunprene) ø5 L=125±3mm 3. MRSW CP TVSSf 0.3 wires G-B/W L=961±3mm 4. Black COT (no slit) ø5 L=245±3mm			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	Connector lock	<div></div> <div>Put the connector into locking jig using right hand then press 2x using both hands. Check the connector lock if properly lock.</div> <div><div><div>Before Pressing</div><div>After Pressing</div></div><div><div><div>NG</div><div>NG</div><div>GOOD</div></div><div><div>Unlock Condition</div><div>Half lock Condition</div><div>Full lock Condition</div></div></div></div>		<div><div>Locking jig</div></div>	<div>1. Use the provided jig per connector 2. No unlock/half-locked connector</div> <div>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR. 2. SET ASIDE THE ASSY PARTS.</div>
8	P1 Wire insertion to Black VM tube (Sunprene) ø5 L=125±3mm	<div></div> <div>1. Get the Black VM tube (Sunprene) ø5 L=125±3mm using right hand then insert the MRSW CP TVSSf 0.3 wires G-B/W L=961±3mm using left hand.</div>		n/a	1. No wrong usage of parts Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.
9	Wire insertion to COT (no slit) ø5 L=245±3mm	<div></div> <div>1. Get the corrugated tube (no slit) ø5 L=245±3mm using right hand then insert the G-B/W wires using left hand.</div>			1. No wrong use of parts 2. No deformed terminal

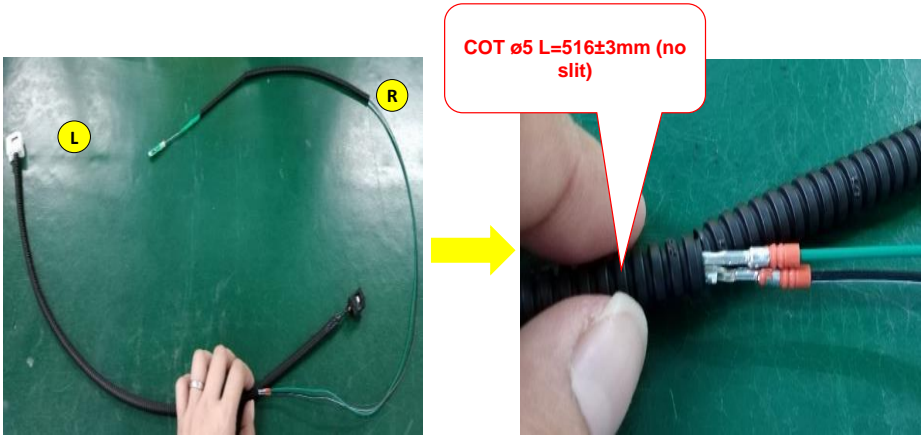
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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		2	Page No.: 7 of 8

PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
10	P1	Wire insertion to assy parts (Combined)  <div>1. Get the assy parts using left hand then insert the G-B/W wires to COT (no slit) ø5 L=516±3mm using right hand.</div>	n/a	1. No wrong insertion 2. No deformed terminal	

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PARTS:

1. Assy parts

JIG:

n/a



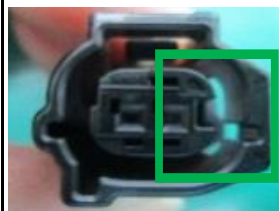
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P1

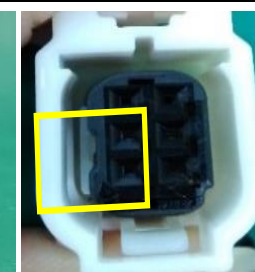
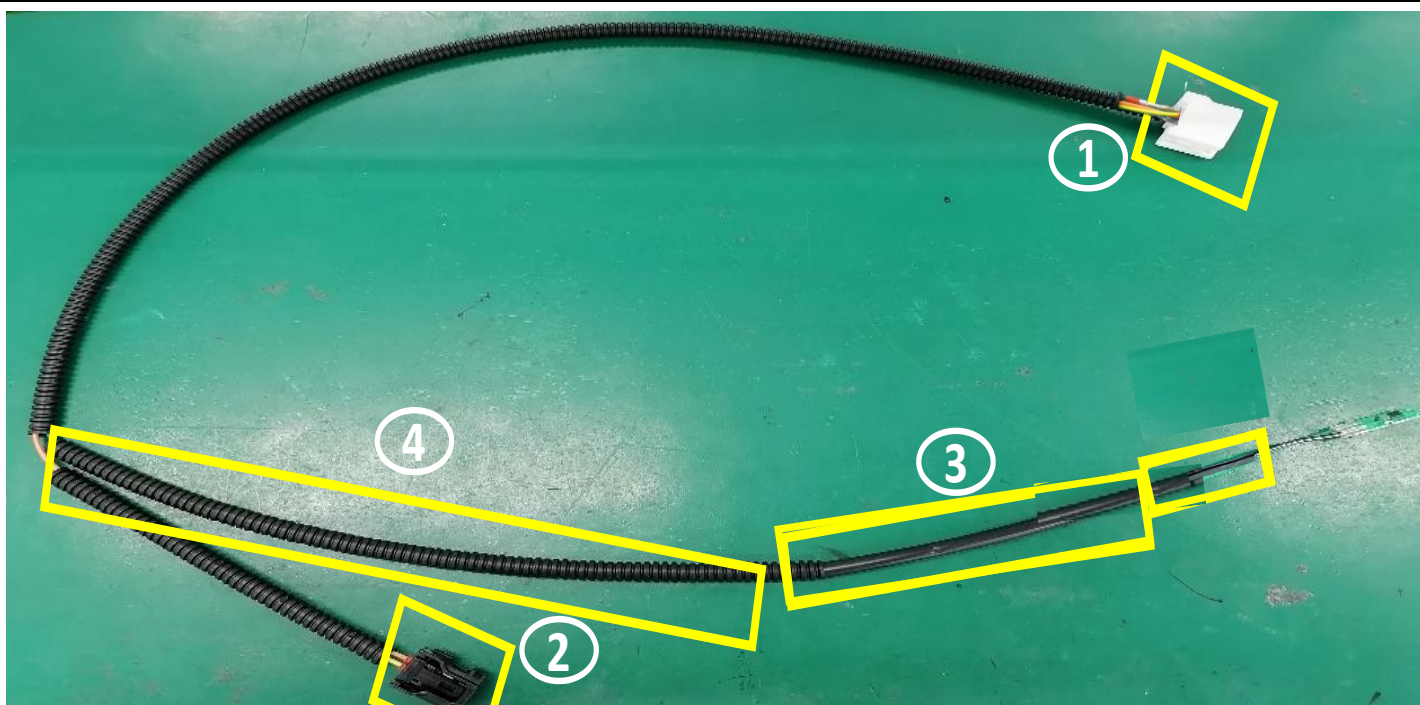
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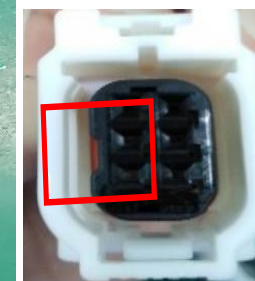
NO GOOD



GOOD



GOOD



NO GOOD

① ②

No **WRONG INSERT**
No **TERMINAL BACKING OUT**

③ ⑤

No **MISSING VINYL**
No **MISSING TAPE**

④

No **MISSING COT**

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