



WORK INSTRUCTION

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

October 12, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

780B / 7R0106-7022B

Customer:

TRMX

Car Model:

TOYOTA TUNDR

Document No.:

WI-ENG-PDE-1103

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

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PARTS: 1. . TVSSf 0.3 wire G-B/W L=398±2mm; Connector 6188-0407 (W)

JIG:

1. Insertion jig with switch cover

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

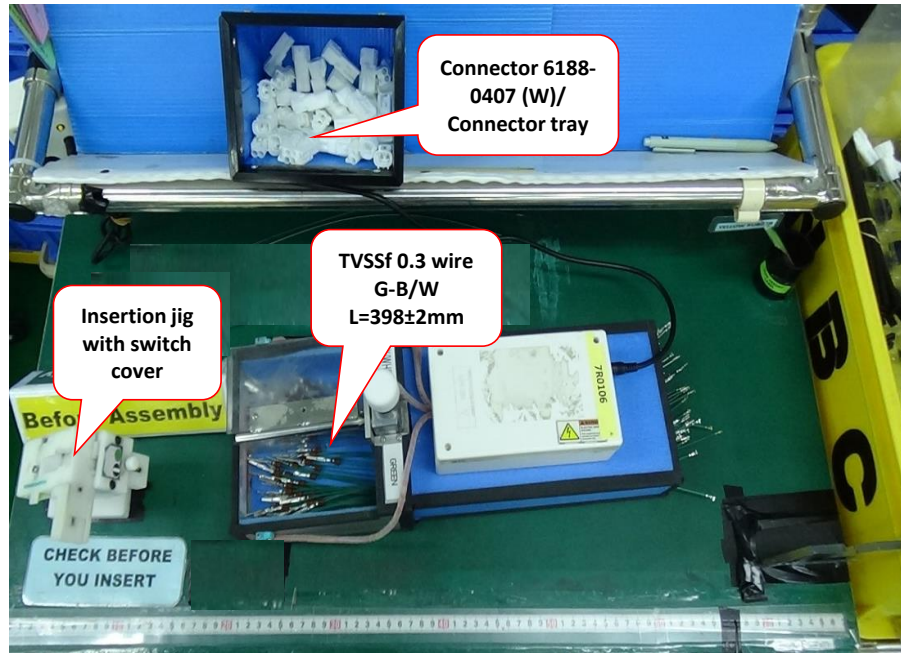
QUALITY POINTERS

1

Offline

Table Lay-out

Table Lay-out



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 work place 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

Revision History

Prepared by

Reviewed by

Approved by

Noted by

10/12/24 1 Change pre-launch to mass pro.

A.Hernandez C. Villanueva A. Arañes n/a

10/11/24 0 Initial issue.

A.Hernandez C. Villanueva A. Arañes n/a

Eff. Date Rev. No Details of Change

Revised Reviewed Approved Noted

Est. Date:

October 11, 2024

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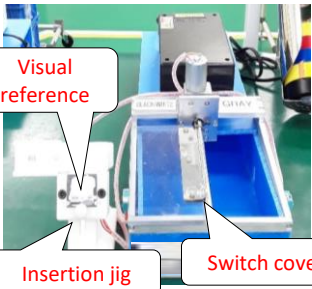
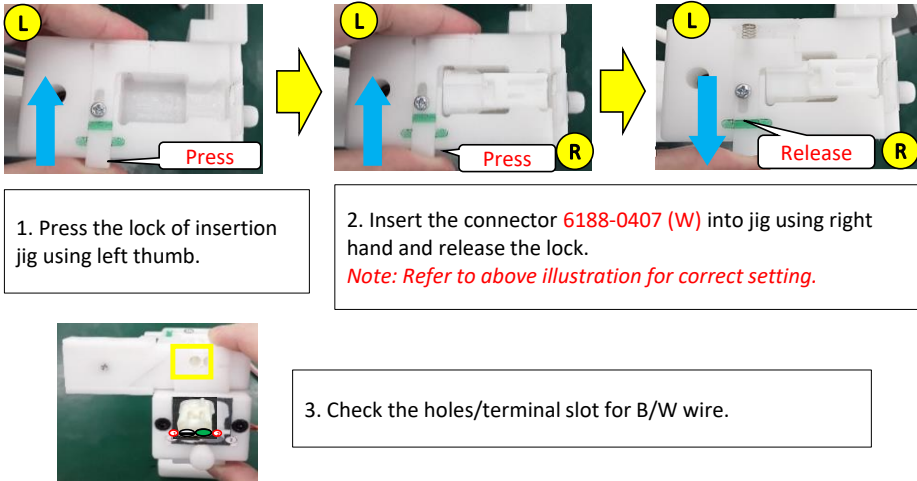
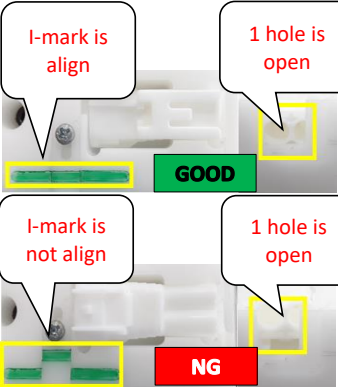
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PARTS:		1. Connector 6188-0407 (W)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Offline Connector setting to Insertion jig 6188-0407 (W)	<div><p>Insertion jig with switch cover</p><p>Lock</p><p>Holes</p><p>I-mark</p><p>Connector orientation</p></div> <div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the connector 6188-0407 (W) into jig using right hand and release the lock. <i>Note: Refer to above illustration for correct setting.</i></p><p>3. Check the holes/terminal slot for B/W wire.</p></div>		n/a	<div><p>Connector Orientation Illustration</p><p>1. Use the provided jig per model 2. No wrong orientation of connector</p></div>

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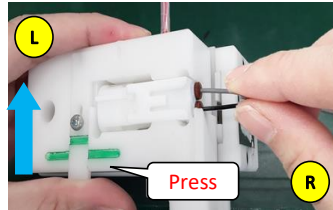
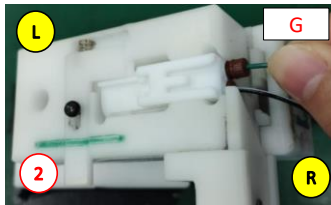
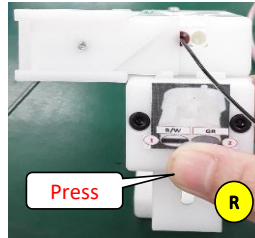
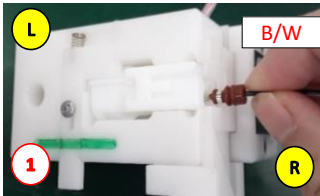

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PARTS:		1. TVSSf 0.3 wire G-B/W L=398±2mm 2. Connector 6188-0407 (W)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Offline Wire insertion to connector (6188-0407) (W)	<div></div> <div><p>1. Hold the insertion jig using left hand. Get the Black/White wire and insert to terminal slot ① using right hand. Note : Conduct Pull-Push-Pull-Push after insertion.</p><p>2. Press the button using right hand. Slot for Green wire will be open.</p><p>3. Get the Green wire then insert to terminal slot ② using right hand. Note : Conduct Pull-Push-Pull-Push after insertion.</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:</p> <p>1. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force. 2. Please hold the wire near terminal during insertion. 3. Insertion of wire must be from left to right.</p> <p>Document reference/s:</p> <p>1. Refer to GL-PRO-ASY-029 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p>

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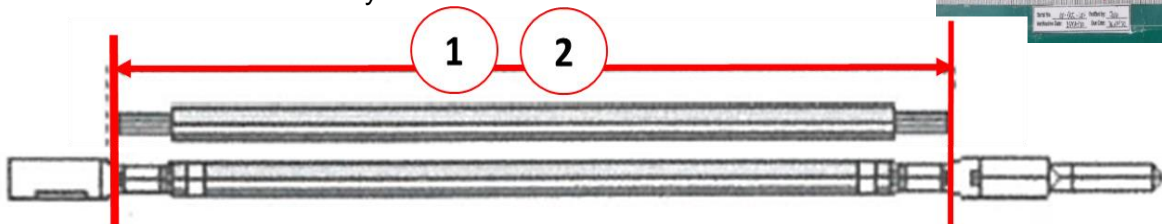
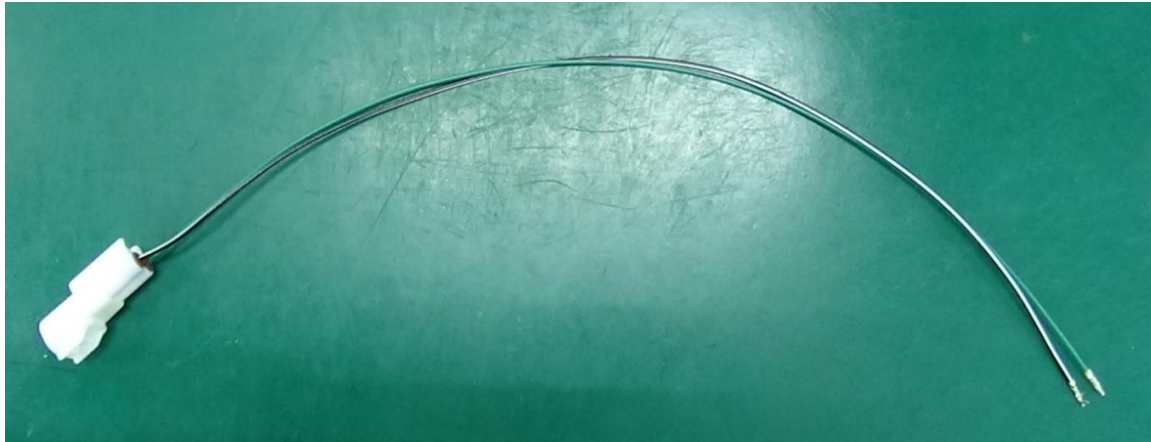

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Offline Measurement	<div>Note: 1. Measurement point: End of core wire to the end of core wire 2. Terminal is reference only.</div> <div></div> <div></div>	<div>Measuring tape</div> <div></div>	<div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection.</div> <div>1. No wrong dimension</div>

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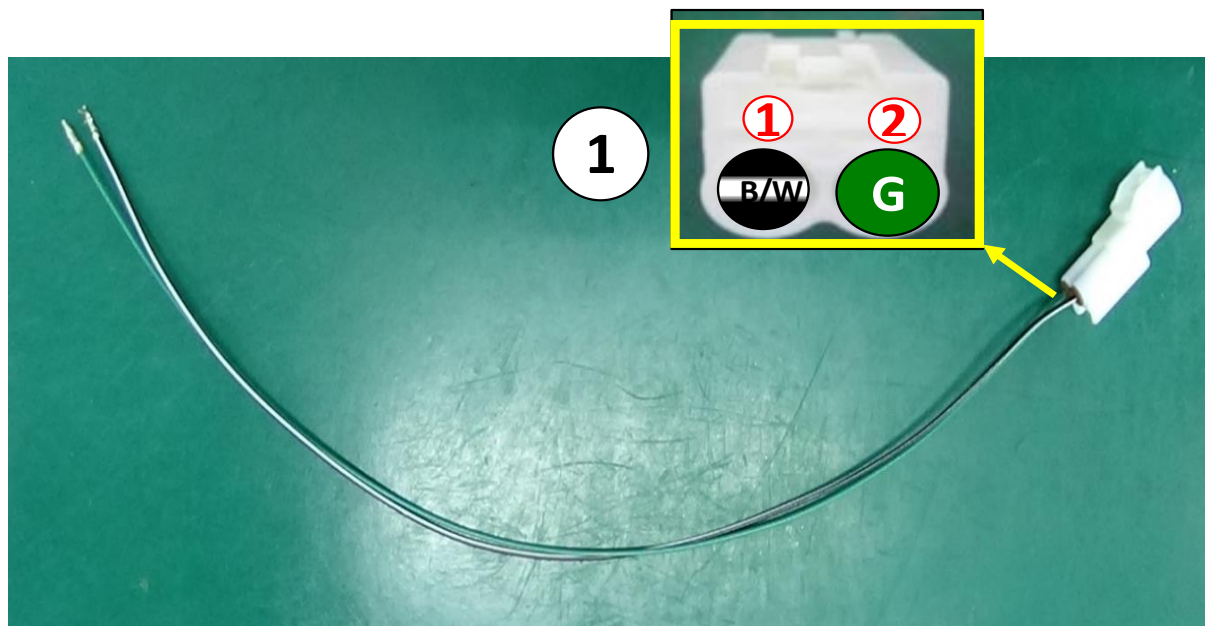
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PARTS:

n/a

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**OFFLINE INSERTION****7R0106-7022B****1 No Wrong insert****2 No Terminal
Backing out****3 No Deformed
Terminal**

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