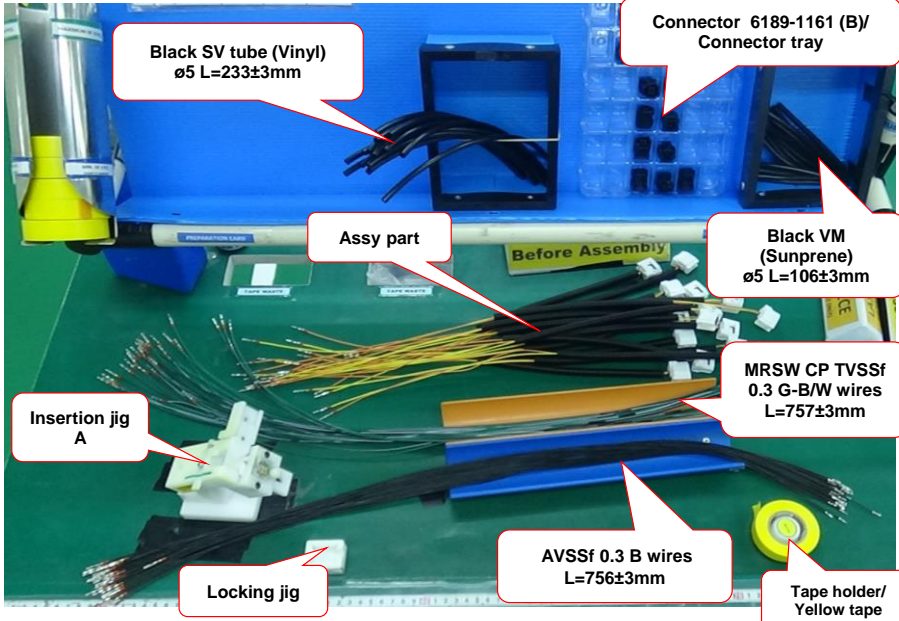
	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>October 1, 2024</b>		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>780B / 7R0104-7023B</b>	Customer: <b>TRMX</b>	Car Model: <b>TOYOTA-TUNDRA</b>	Document No.:	<b>WI-ENG-PDE-1081A</b>		
	Purpose: <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. Assy parts: Connector 6189-1161 (B); Black SV tube (Vinyl) ø5 L=233±3mm; Yellow tape; Black VM tube (Sunprene) ø5 L=106±3mm; MRSW CP TVSSf 0.3 B/W-G L=757±3mm; AVSSf 0.3 B wires L=756±3mm				JIG:		1. Insertion jig 2. Locking jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>				<b>TOOLS/PPE</b>		<b>QUALITY POINTERS</b>	
1	P1	<div>TABLE LAY-OUT</div> 				<p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>		<p><b>Document reference/s:</b> 1. Please refer to <b>WI-PRO-KIT-005</b> for Wire taping without Vinyl tube. 2. Please refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length tolerance 3. Please refer to <b>WI-ENG-PDE-831</b> for Offline assembly process</p> <p>1. No missing parts/tools 2. No excess parts/tools</p>	
Revision History						Prepared by	Reviewed by	Approved by	Noted by
10/01/24	1	Change Purpose from Pre-launch to Masspro.				M. Ariola	C. Villanueva	A. Arañes	n/a
09/30/24	0	Initial Issue. Update the Visual Inspection/Quality checkpoints.				M. Ariola	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted

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## PARTS:

1. Assy parts
2. Black SV tube (Vinyl)  $\phi 5$  L= 233 $\pm$ 3mm

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

P1

Wire insertion to  
Black SV tube (Vinyl)  
 $\phi 5$  L= 233 $\pm$ 3mm



1. Get the SV tube (Vinyl)  $\phi 5$  L= 233 $\pm$ 3mm using right hand then insert the **Y-OR wires** using left hand.

n/a

1. No wrong use of parts
2. No deformed terminal

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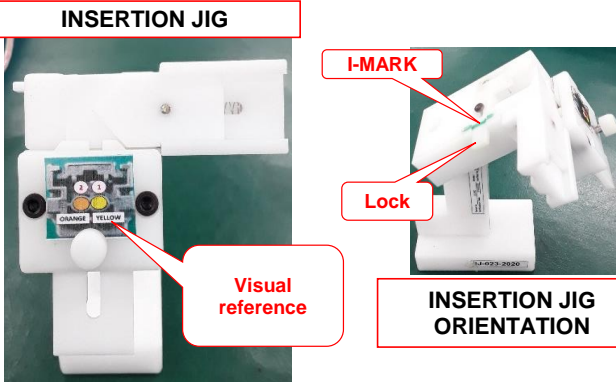
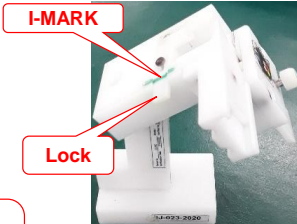

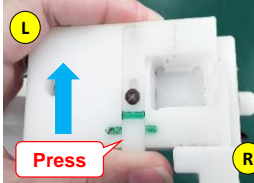
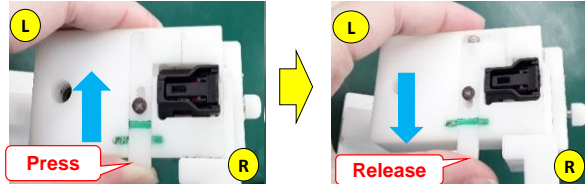
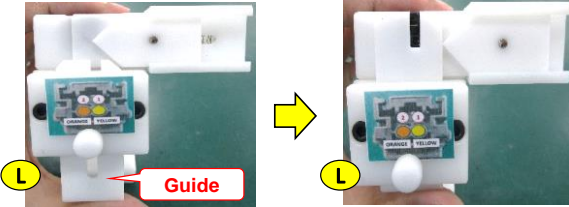


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PARTS:		1. Connector 6189-1161 (B)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1	<p>Connector setting to insertion jig 6189-1161 (B)</p> <div><p><b>INSERTION JIG</b></p><p><b>Visual reference</b></p><p><b>INSERTION JIG ORIENTATION</b></p><p><b>CONNECTOR ORIENTATION</b></p></div> <div><p>1. Press the insertion jig lock using left thumb.</p><p>2. Get the connector <b>6189-1161 (B)</b> using right hand and insert to insertion jig. Release the lock after insertion.</p><p>3. Press the guide using left thumb. The slot for <b>Y wire</b> will be opened.</p></div>		N/A	<div><p><b>CONNECTOR ORIENTATION ILLUSTRATION</b></p><p><b>I-mark is align</b></p><p><b>1 hole is open</b></p><p><b>GOOD</b></p><p><b>I-mark is not align</b></p><p><b>1 hole is open</b></p><p><b>NG</b></p></div> <p>1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p>

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Effectivity Date:

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Customer:

TRMX

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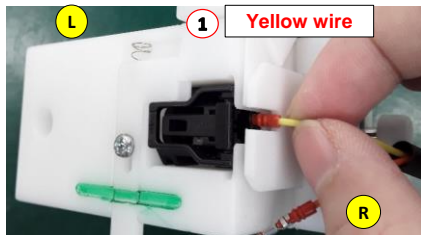
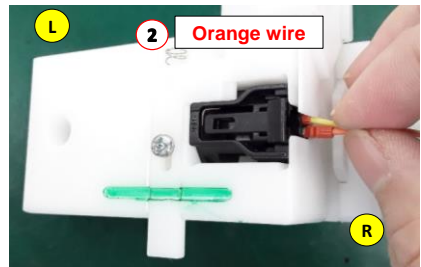
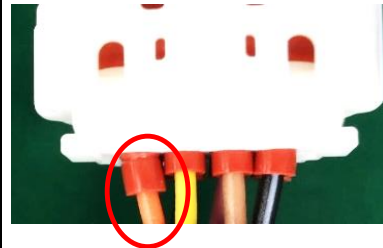
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PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1  Wire insertion to connector 6189-1161 (B)	<div><div>WIRE FACING</div></div> <div><div><div>1 Yellow wire</div></div><div><div>2 Orange wire</div></div></div> <div><div><div>1. Hold the insertion jig using left hand. Get the <b>Y wire</b> and insert to connector using right hand.</div><div>2. Press the button using right thumb. slot for <b>OR wire</b> will be open.</div><div>3. Get the <b>OR wire</b> and insert to connector 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></div></div>	N/A	<div></div> <div><b>Important reminders/Note/s:</b> 1. Make sure wires are properly inserted.  Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.  2. During insertion, hold the wire not rubber seal to prevent sagging.</div> <div><b>Document reference/s:</b> 1. Please refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length tolerance.  2. Please refer to <b>GL-PRO-ASY-029</b> for Pull-Push procedure.</div>

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

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**780B / 7R0104-7023B**

Customer:

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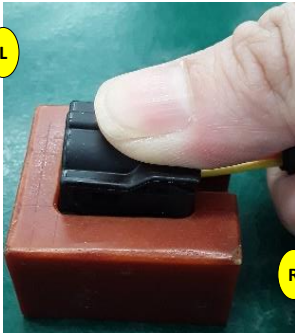






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PARTS:	1. Assy parts			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1  Connector lock	<div><div><div><div><div><div></div><div>L</div></div><div><div></div><div>R</div></div></div><div></div></div></div><div><div>1. Put the connector into locking using right hand and then press <b>2x</b> using both hands.</div></div><div><div><div><div><div><div></div><div>Before Pressing</div></div><div><div></div><div>After Pressing</div></div></div><div></div></div></div><div><div><div><div><div><div></div><div>NG</div></div><div><div></div><div>NG</div></div><div><div></div><div>GOOD</div></div></div><div></div></div></div><div><div><div><div><div></div><div>Unlock Condition</div></div><div><div></div><div>Half lock Condition</div></div><div><div></div><div>Full lock Condition</div></div></div></div></div></div></div></div>		<div><div>LOCKING JIG</div><div></div></div>	<div><div>Important reminders/note/s:</div><div>1. Manual locking may cause damaged connector lock.</div></div> <div><div>1. Use the provided jig tool per model</div><div>2. No unlock/half-locked connector</div><div>3. No damaged lock</div></div>

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PARTS:		1. AVSSf 0.3 B wires L=756±3mm [2pcs] 2. MRSW CP TVSSf 0.3 G-B/W L=757±3mm		3. Yellow tape	JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1	Taping 1 Spot taping	<div></div> <div></div> <div></div>		n/a	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
7		Wire insertion to Black VM tube (Sunprene) ø5 L=106±3mm	<div></div> <div></div>		n/a	<b>Document reference/s:</b> 1. Please refer to <b>WI-PRO-CNC-017</b> for Wire and Strip length tolerance.  1. No wrong use of parts 2. No deformed terminal

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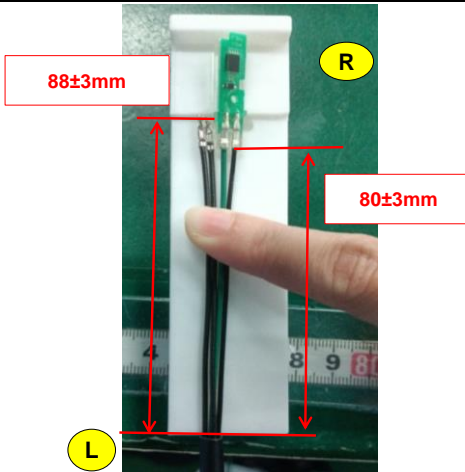
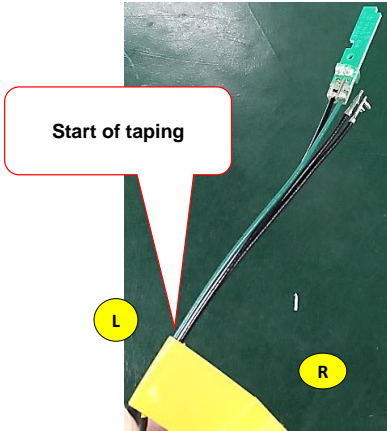
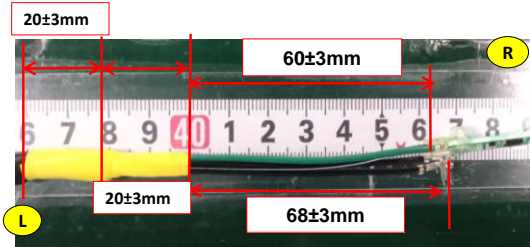


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PARTS:		1. Assy parts 2. Yellow tape		JIG:	1.Measuring jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1  Taping 2 Black VM tube (Sunprene) to wire near terminal and hotmelted wires	<div><p>88±3mm</p><p>80±3mm</p><p>R</p><p>L</p></div> <div><p>Start of taping</p><p>L</p><p>R</p></div> <div><p>1. Hold the VM tube (Sunprene) using left hand. Measure from end of VM tube (Sunprene) up to the edge of hotmelted wires <b>80±3mm</b> and from end of VM tube (Sunprene) up to the terminal pointed tip <b>88±3mm</b> using the provided measuring jig.</p></div> <div><p>2. Hold the VM tube (Sunprene) using left hand. Get the <b>Yellow tape</b> using right hand then start taping process using both hands.</p></div> <div><p>20±3mm</p><p>60±3mm</p><p>20±3mm</p><p>68±3mm</p><p>R</p><p>L</p></div> <div><p>3. After taping, check the measurement, wire alignment and taping condition.</p></div>		<div><p>MEASURING JIG</p></div> <div><p>MEASURING TAPE</p></div>	<p><b>Important reminders/note/s:</b></p> <p>1. Use <b>YELLOW TAPE</b> only.</p> <p>2. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension</p>

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# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number: **780B / 7R0104-7023B**

Customer: **TRMX**

Car Model: **TOYOTA-TUNDRA**

Purpose:

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PARTS:

N/A

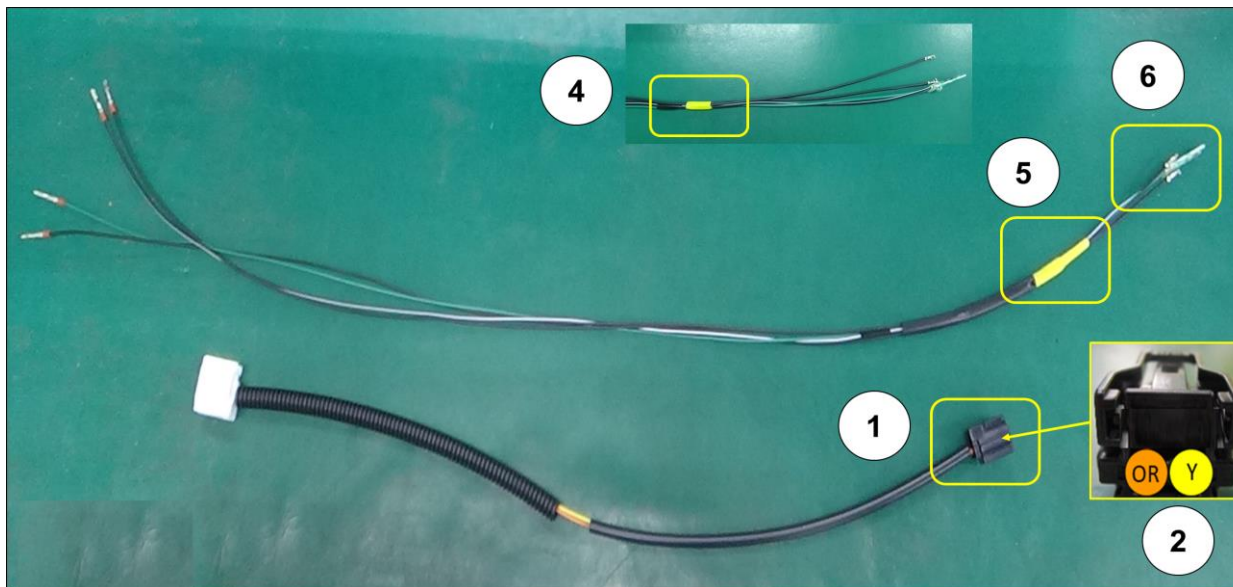
JIG:

N/A

### QUALITY CHECKPOINTS

# TAPING - P1

# 7R0104-7023B



- 1 No UNLOCKED/ HALF-LOCKED CONNECTOR
- 2 No WRONG INSERT
- 3 No TERMINAL BACKING OUT
- 4 No MISSING SPOT TAPE (YELLOW)
- 5 No WRONG COLOR OF TAPE (YELLOW)
- 6 No DEFORMED TERMINAL

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