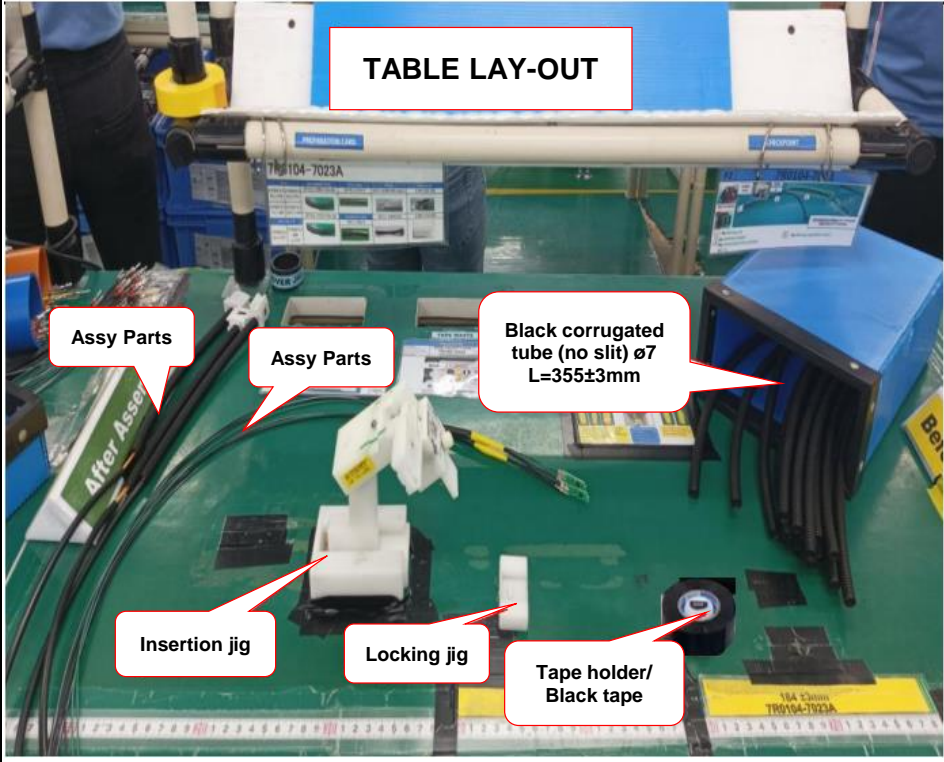
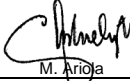

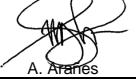
	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>October 1, 2024</b>		
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>780B / 7R0104-7023B</b>		Customer: <b>TRMX</b>	Car Model: <b>TOYOTA-TUNDRA</b>	Document No.:	<b>WI-ENG-PDE-1081B</b>		
	Purpose: <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; Black tape; Black corrugated tube (no slit) ø7 L=355±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	P2	Table Lay-out		<div><b>Safety Instruction</b> Be sure to wear prescribed 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>	<b>Document reference/s:</b> <i>1. Please refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length tolerance.</i> <i>2. Please refer to <b>WI-PRO-KIT-005</b> for Wire taping without tube.</i>  1. No missing parts/tools 2. No excess parts/tools

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	 M. Ariola	 C. Villanueva	 A. Arañes	n/a
09/30/24	0	Initial issue. Update Visual Inspection/ Quality checkpoints.	M. Ariola	C. Villanueva	A. Arañes	n/a				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 30, 2024		

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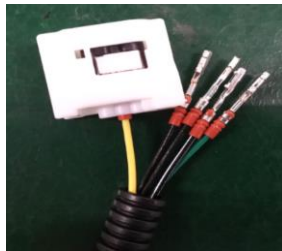
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<b>PARTS:</b>		1. Assy parts 2. Black corrugated tube (no slit) $\varnothing 7$ L=355 $\pm$ 3mm		JIG:	N/A
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	P2 Wire insertion to Black corrugated tube (no slit) $\varnothing 7$ L= 355 $\pm$ 3mm	 <p>1. Hold the wires using left hand, get the corrugated tube (no slit) <math>\varnothing 7</math> L=355<math>\pm</math>3mm using right hand then insert the <b>G-B/W hotmelted wires and B-B wires</b> using left hand.</p>		n/a	1. No wrong use of parts 2. No deformed terminal   <b>Important reminders/note/s:</b> 1. Wire must not be inserted at the same time
3	Wire insertion to assy parts	 <p>1. Get the assy parts, hold the <b>COT <math>\varnothing 5</math> L= 208<math>\pm</math>3mm</b> then insert the <b>G-B/W hotmelted wires and B-B wires</b> using right hand.</p>  <p>2. After insertion, check the inserted wires.. <b>Note: No wires left inside COT.</b></p>		n/a	1. No wrong use of parts 2. No deformed terminal

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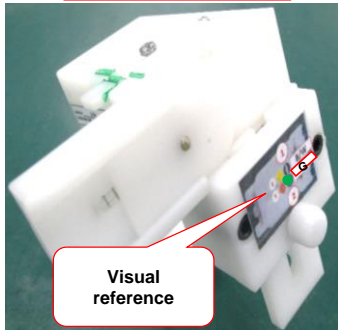
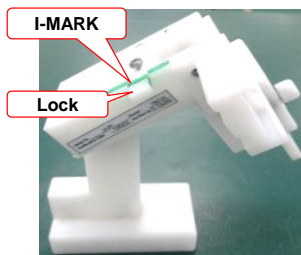

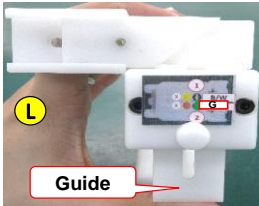
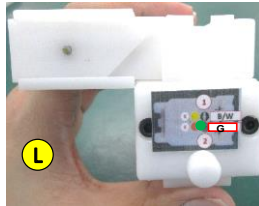
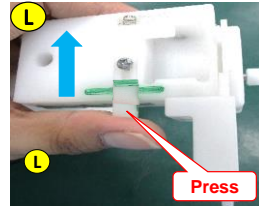
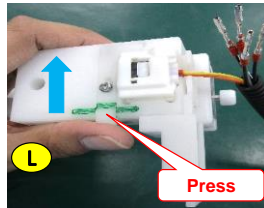
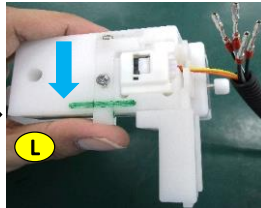
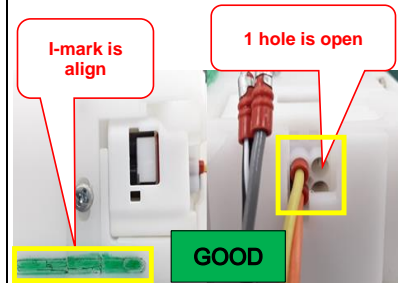
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PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	<div><div><b>INSERTION JIG</b></div><div><div>Visual reference</div></div><div><div>I-MARK Lock</div><div><b>INSERTION JIG ORIENTATION</b></div></div><div><div><b>CONNECTOR ORIENTATION</b></div></div><div><div>Guide</div></div><div><div>L</div></div><div><div>L Press</div></div><div><div>L Press</div></div><div><div>L</div></div><div><div>1. Press the lower wire guide using left thumb to make sure connector with inserted wires will be inserted.</div><div>2. Press the insertion jig lock using left hand.</div><div>3. Get the assy parts and insert the connector using right hand. Release the lock after insertion.</div></div></div>		N/A	<div><b>CONNECTOR ORIENTATION ILLUSTRATION</b></div> <div><div>I-mark is align 1 hole is open <b>GOOD</b></div></div> <div><div>1. Use the provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div></div>

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780B / 7R0104-7023B

Customer:

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Car Model:

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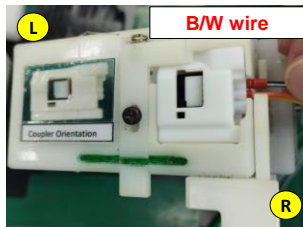
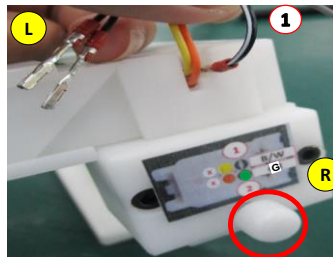
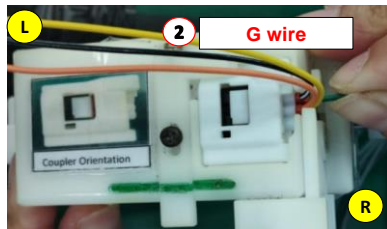
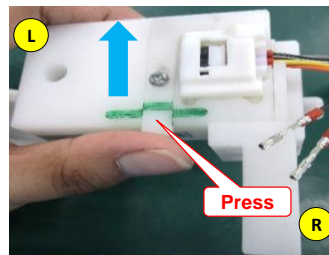
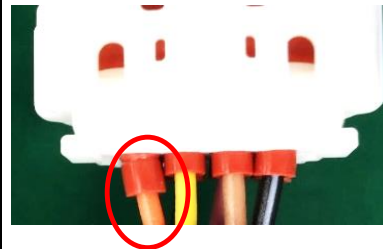
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PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2  Wire insertion to connector 6189-1142 (W) (Assy parts)	<div><div>WIRE FACING</div></div> <div><div>1. Hold the insertion jig using left hand. Get the <b>B/W wire</b> and insert to connector using right hand.</div></div> <div><div>2. Press the button using right thumb. The slot for <b>G wire</b> will be opened.</div></div> <div><div>3. Hold the <b>G wire</b> and insert to connector using right hand.</div></div> <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>	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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TRMX

Car Model:

TOYOTA-TUNDRA

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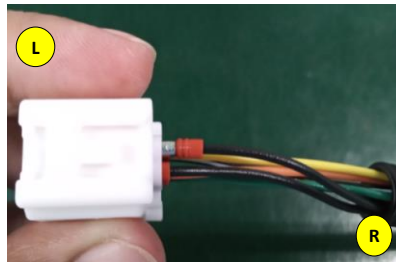
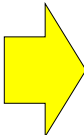
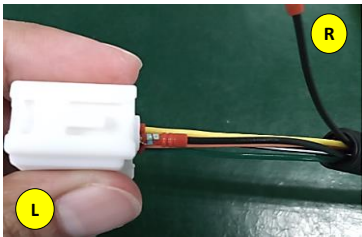
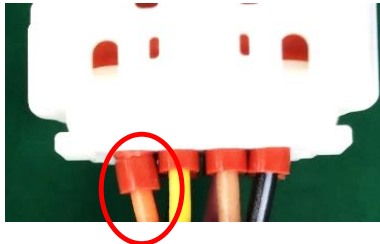
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PARTS:	1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P2  Wire insertion to connector 6189-1142 (W) (Assy parts)	<div><div>WIRE FACING</div></div> <div><div>CONNECTOR ORIENTATION</div><div></div><div>1. Hold the connector using left hand and insert first <b>B wire</b> to connector using right hand.</div><div>2. Hold the connector using left hand and insert second <b>B wire</b> to connector using right hand.</div></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><b>Important reminders/Note/s:</b>  1. Make sure wires are properly inserted.  Conduct <b><u>Pull-Push-Pull-Push</u></b> after insertion. Do not exert extra force.  3. During insertion, hold the wire not <u>rubber seal</u> to prevent sagging.  4. Insertion of wire must be from left to right.</div> <div><b>Important reminders/Note/s:</b>  1. Please refer to <b>GL-PRO-ASY-029</b> for Pull-Push procedure.</div> <div></div>

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Car Model:

**TOYOTA-TUNDRA**

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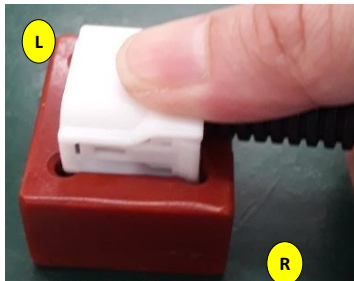


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PARTS:	1. Assy parts			JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	Connector lock	<div><div><div><div><div>L</div><div></div><div>R</div></div></div><div><div>BEFORE PRESSING</div><div>AFTER PRESSING</div></div><div><div><div><div><div><div></div><div></div><div></div></div><div></div></div><div><div><div></div><div></div><div></div></div><div></div></div></div></div></div><div>1. Put the connector into locking jig using right hand and then press <b>2x</b> using both hands. Check the connector lock if properly locked.</div></div></div> <div><div>LOCKING JIG</div><div></div></div>		<b>Important reminders/note/s:</b> <i>1. Manual locking may cause damaged connector lock.</i>  1. Use the provided jig tool per model 2. No unlock/half-locked connector 3. No damaged lock	
8	Taping 1 Black corrugated tube to Black VM tube (Sunprene)	<div><div><div><div><div><div></div><div></div><div></div></div><div></div></div><div><div><div></div><div></div><div></div></div><div></div></div></div></div></div> <div>184± 3mm</div> <div>176± 3mm</div> <div>1. Measure the end of the corrugated tube up to the edge of hotmelt <b>176mm</b> and terminal pointed tip <b>184mm</b>.</div>		<div><div>MEASURING TAPE</div><div></div></div>	<b>Important reminders/note/s:</b> <i>1. Please use calibrated/verified measuring tape when getting the measurement.</i>  1. No peel-off tape 2. No flip out tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension

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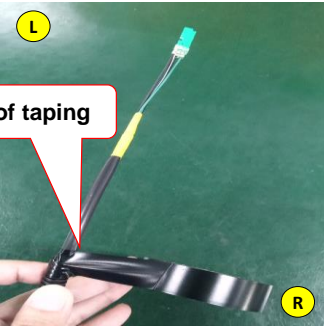
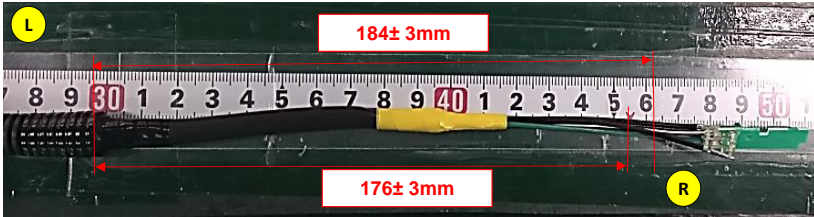
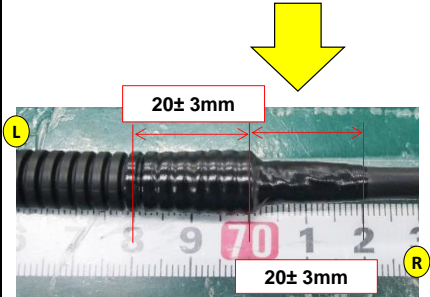

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PARTS:		1. Assy parts 2. Black tape		JIG:	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P2 Taping 1 Black corrugated tube to Black VM tube (Sunprene) (Continuation)	 <p>2. Hold the corrugated tube using left hand. Get the Black tape using right hand and start taping process using both hands.</p>   <p>3. After taping, check the measurement and taping condition.</p>		 <p>MEASURING TAPE</p>	<p><b>Important reminders/note/s:</b></p> <p>1. 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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PARTS:

n/a

JIG:

n/a

### QUALITY CHECKPOINTS

## TAPING - P2

# 7R0104-7023B



1 No **WRONG INSERT**

3 No **TERMINAL BACKING OUT**

2 No **UNLOCKED/ HALF-LOCKED CONNECTOR**

4 No **MISSING TAPE**

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