WORK INSTRUCTION

Process Name/Title:	**TAPING ASSEMBLY PROCESS**	
Model code/Part number: **920B / 7R0119-7021**	Customer: **TRMX**	Car Model: **TOYOTA-TACOMA**
Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		

Effectivity Date:	**August 20, 2024**
Validity Date:	**n/a**
Document No.:	**WI-ENG-PDE-959A**
Revision No.: 1	Page No.: 1 of 8

PARTS: 1. All parts: Connector 6188-0407 (W); TVSSf 0.3 wires G-B/W L=562±3mm; Black SV tube (Vinyl) Ø5 L=366±3mm; Black VM tube (Sunprene) Ø5 L=123±3mm; Yellow tape 20mm

JIG: 1. Insertion jig with switch cover 2. Measuring jig

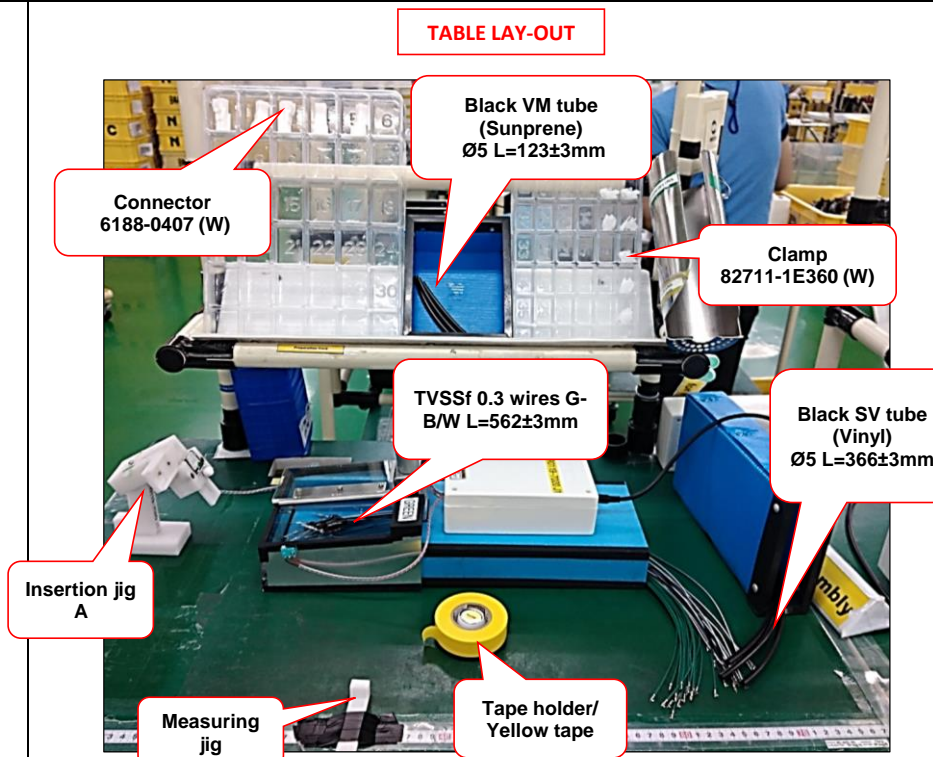| NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1 — Table Lay-out	**TABLE LAY-OUT** Black VM tube (Sunprene) Ø5 L=123±3mm; Connector 6188-0407 (W); Clamp 82711-1E360 (W); TVSSf 0.3 wires G-B/W L=562±3mm; Black SV tube (Vinyl) Ø5 L=366±3mm; Insertion jig A; Measuring jig; Tape holder/ Yellow tape	**Safety Instruction** Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) — **Housekeeping** 1. Maintain and always practice 5's. 2. Personal things on the workplace 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 — *Document reference/s:* *1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance*

		Revision History					Prepared by	Reviewed by	Approved by	Noted by
08/20/24	1	Change from Pre-launch to Masspro and transfer the taping process of Black SV tube (Vinyl) to Black VM tube (Sunprene) near terminal	A.Hernandez	C. Villanueva	A. Arañes	n/a	A.Hernandez	C. Villanueva	A. Arañes	n/a
08/06/24	0	Initial issue.	A.Hernandez	C. Villanueva	A. Arañes	n/a	Est. Date:	August 06, 2024		
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted				

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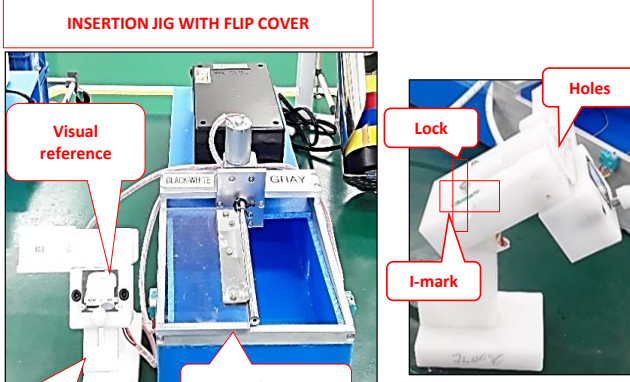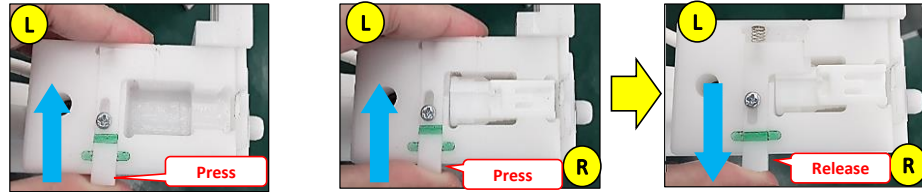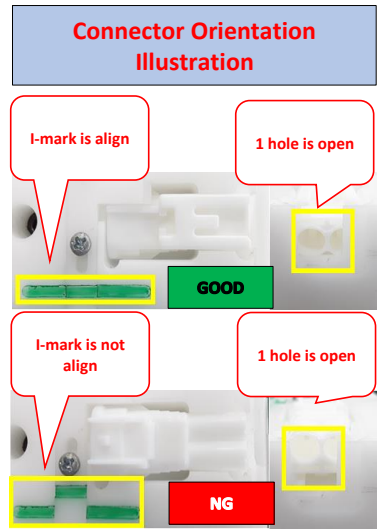
PARTS:	1. Connector 6188-0407 (W)	JIG:	Insertion jig with flip cover

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 — Connector setting to Insertion jig 6188-0407 (W)		n/a	1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector **Connector Orientation Illustration**

INSERTION JIG WITH FLIP COVER

Labels: Visual reference, Insertion jig, Switch cover, Lock, I-mark, Holes, CONNECTOR ORIENTATION

1. Press the lock of insertion jig using left thumb.

2. Insert the connector **6188-0407 (W)** into jig using right hand and release the lock.
Note: Refer to above illustration for correct setting.

3. Check the holes/terminal slot for **B/W wire.**

Connector Orientation Illustration labels: I-mark is align / 1 hole is open — **GOOD**; I-mark is not align / 1 hole is open — **NG**

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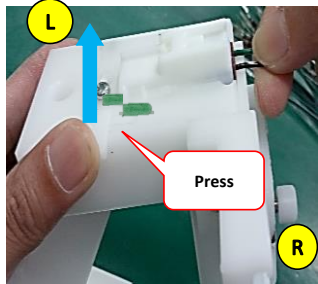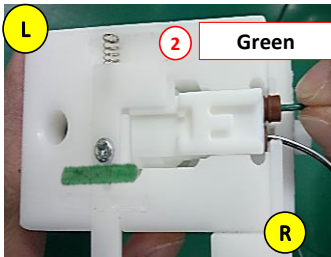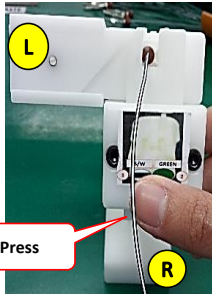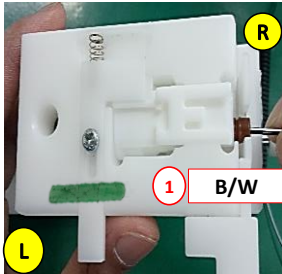
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PARTS:	1. TVSSf 0.3 wires G-B/W L=562±3mm	JIG:	1. Insertion jig with flip cover

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1 — Wire Insetion to Connector 6188-0407 (W)		n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing ***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.* *3. Insertion of wires must be from left to right* ***Document references:*** *1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.* *2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance*

Wire facing

R **L** **L** **1** **B/W** **2** **Green** **R** **Press**

1. Hold the Insertion jig using left hand. Get **Black /White wire** then insert to terminal **slot 1** using right hand.

2. Push the button using right hand. The slot for **Green wire** will be opened.

3. Get **Green wire** then insert to terminal **slot 2** using right hand.

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.

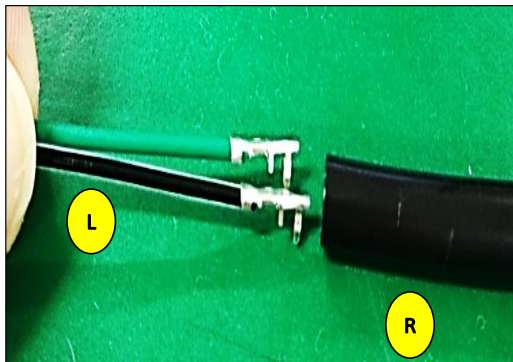| | **WORK INSTRUCTION** | | Effectivity Date: | **August 20, 2024** |
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PARTS:	1. Assy parts 2. Black SV tube (Vinyl) Ø5 L=366±3mm	3. Black VM tube (Sunprene) Ø5 L=123±3mm	JIG:	n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4 (P1)	Wire Insertion to Black SV tube (Vinyl) Ø5 L=366±3mm	1. Get the **Black SV tube (Vinyl) Ø5 L=366±3mm** using right hand then insert the **G-B/W wires** using left hand.	n/a	1. No wrong use of parts
5	Wire Insertion to Black VM tube (Sunprene) Ø5 L=123±3mm	1. Get the **Black VM tube (Sunprene) Ø5 L=123±3mm** using right hand then insert the **G-B/W wires** using left hand.	n/a	1. No wrong use of parts

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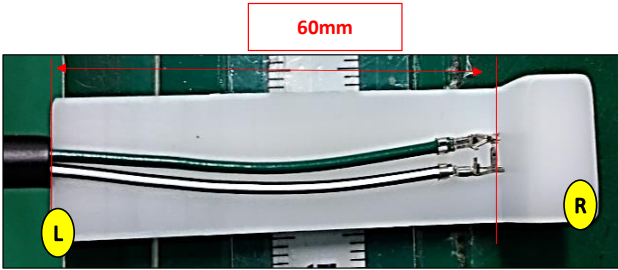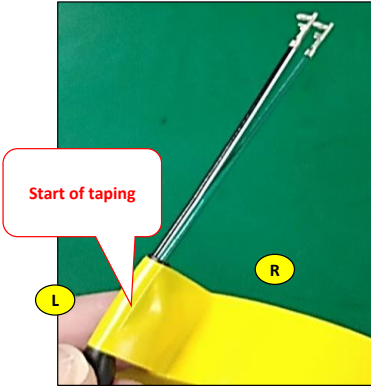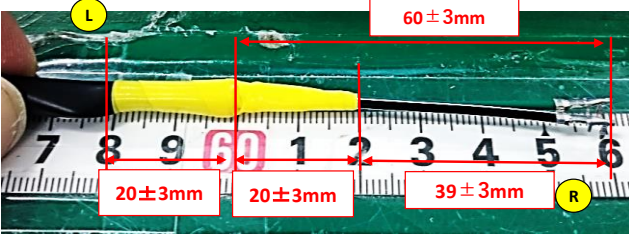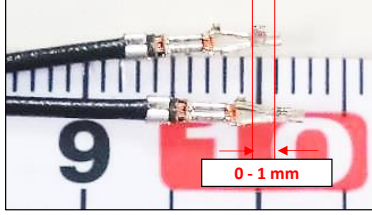
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PARTS:	1. Assy parts 2. Yellow tape 20mm		JIG:	1. Measuring tape 2. Measuring jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1 Taping 1 Black VM tube (Sunprene) to wire near terminal	**60mm** 1. Conduct measurement of **60mm** from end of sunprene tube up to end of the terminal pointed tip using both hands. **Start of taping** 2. Hold the tube using left hand, get the **Yellow tape** using right hand then start taping process using both hands. 60±3mm 20±3mm 20±3mm 39±3mm 3. After taping, check the taping condition, measurement and wire alignment.	**MEASURING TAPE** **MEASURING JIG** 7R0119-7021	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 **Wire alignment tolerance** 0 - 1 mm *Important reminders/Note/s: Please use calibrated/verified measuring tape when getting the measurement.*

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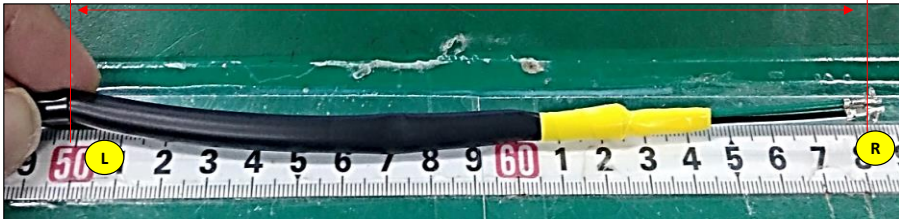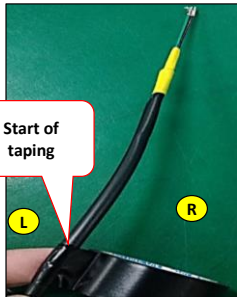
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PARTS:	1. Assy part 2. Black tape 20mm		JIG:	n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1 Taping 1 Black SV tube (Vinyl) to Black VM tube (Sunprene) near terminal	**184±3mm** 1. Measure from end of SV tube (Vinyl) up to terminal pointed tip **184±3mm** using both hands. Start of taping 2. Hold the corrugated tube and sunprene tube using left hand, get the **Black tape** then start taping process using both hands. **184±3mm** **20±3mm** **20±3mm** 3. After taping, check the taping condition, measurement and wire alignment.	n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing

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PARTS:	1. Assy Parts		JIG:	n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P1 — Clip attachment 82711-1E360 (W)	**CLAMP ORIENTATION** 1. Hold the connector using left hand, get the Clamp **82711-1E360 (W)** then insert using right hand.	n/a	1. No wrong use of parts 2. No loose attachment **CLIP CLAMP ILLUSTRATION** GOOD 82711-1E360 (W) NG 82711-12B10 (W)

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| PARTS: | n/a | JIG: | n/a |

VISUAL INSPECTION/QUALITY CHECKPOINTS

P1 — 7R0119-7021

Black tape
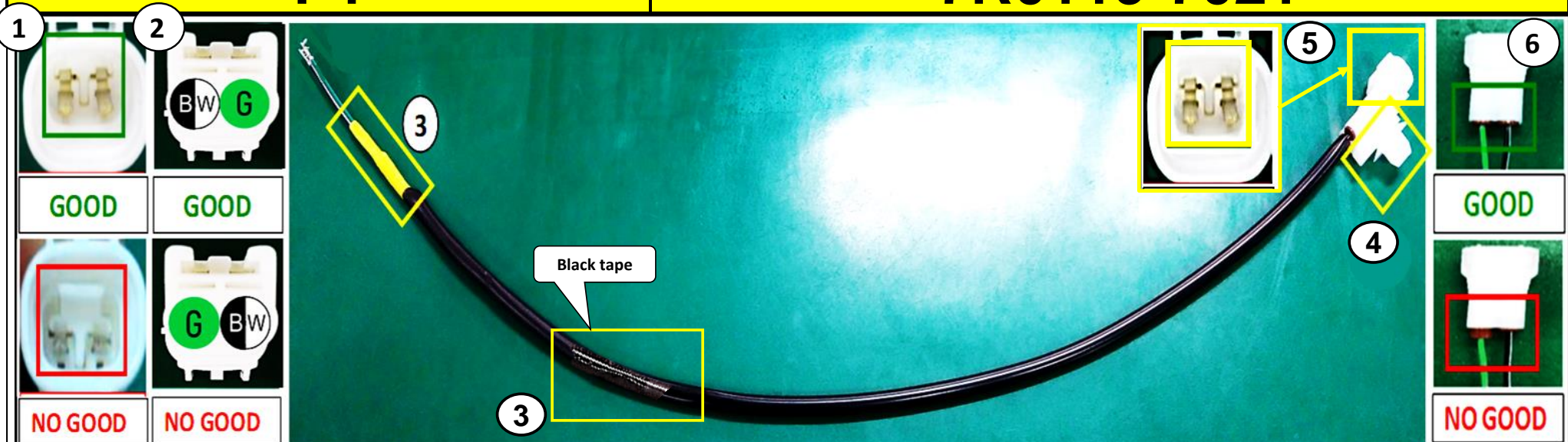
① **No Halflocked/Unlock Connector**

② **No Wrong Insertion**

③ **No Missing/Wrong use of tape**

④ **No Missing Clip Attachment**

⑤ **No Deformed Terminal**

⑥ **No Terminal Backing Out**

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