



## WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

August 20, 2024

Model code/Part number:

920B / 7R0119-7021

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Document No.:

WI-ENG-PDE-959B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

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## PARTS:

1. Assy parts: Clamp 82711-3A640 (B); Clamp 82711-26380 (BR); Black tape 20mm; Red tape 20mm; QR Code label 7V3240-0020

JIG:

1. Clamp assembly jig
2. Bando Gun

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

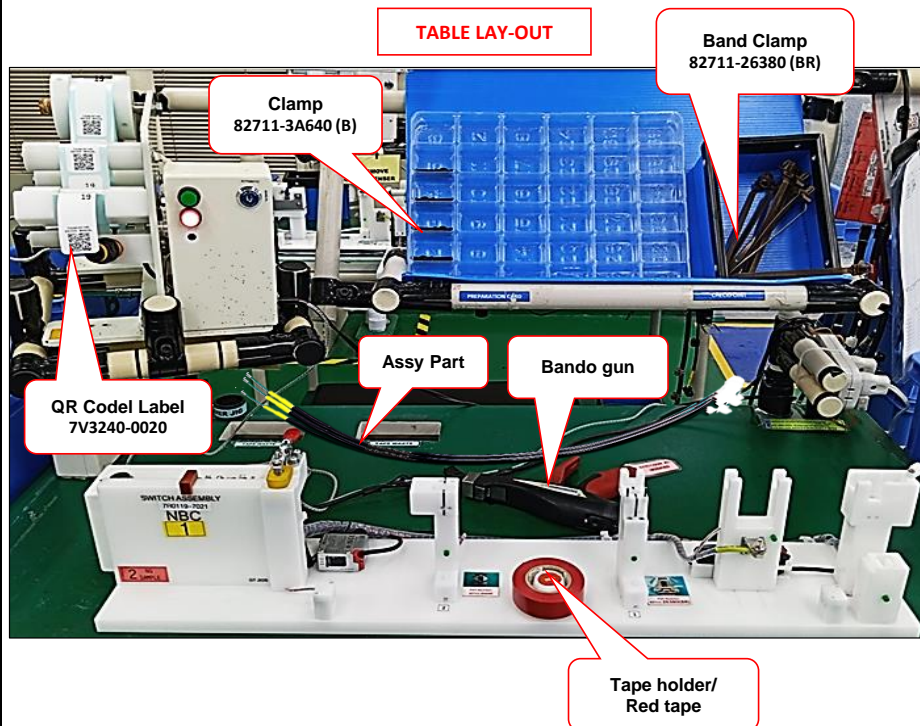
TOOLS/PPE

QUALITY POINTERS

1

P2

Table Lay-out

**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

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
08/20/24	1	Change from Pre-launch to Masspro. Removed and transfer the taping process of Black SV tube (Vinyl) to Black VM tube (Sunprene) near terminal to P1.	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	A.Hernandez	C. Villanueva	A. Arañes	n/a

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PARTS:		1. 82711-3A640 (B) 2. Red tape 20mm		3. 82711-26380 (BR)		JIG:	1. Clamp assembly jig 2. Bando Gun	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE		QUALITY POINTERS
2	P2		Clamp setting			<div><div><p>82711-3A640 (B)</p></div><div><p>82711-26380 (BR)</p></div><div></div><div><div><p>1. Get 1pc. of clamp <b>82711-3A640 (B)</b> using both hands then set to clamp location <b>2</b> using both hands.</p><p>2. Get 1pc. of clamp <b>82711-26380 (BR)</b> using both hands then set to clamp location <b>1</b> using both hands.</p></div><div><p>3. Initially attach <b>Red tape</b> on clamp location <b>2</b> using both hands.</p></div></div></div>		1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector

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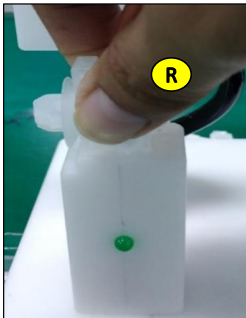
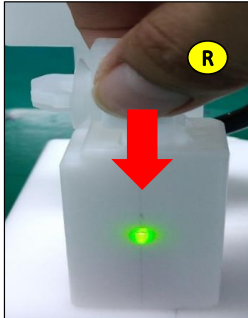
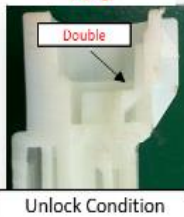
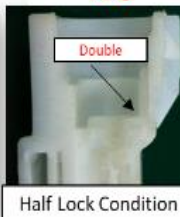
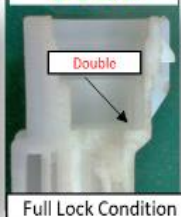



☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts		JIG:	1. Clamp assembly jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2	Connector lock		
		<div><div></div><div><p>1. Put the connector into locking jig using right hand then press <b>2x</b> to lock using both hands. Check the lock if properly locked.</p></div></div> <div><p>Coupler Cross Sectional View</p><div><div><p>NG</p><p>Unlock Condition</p></div><div><p>NG</p><p>Half Lock Condition</p></div><div><p>GOOD</p><p>Full Lock Condition</p></div></div><div><div><p>Before lock</p></div><div><p>After lock</p></div></div></div> <div><div><p>LOCKING JIG</p></div></div> <div><p>1. Use the provided locking jig per model 2. No unlock/half-locked connector 3. No skip of locking process</p><p><b>Important reminders/Note/s:</b> <b>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b></p></div>		

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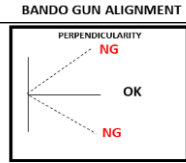
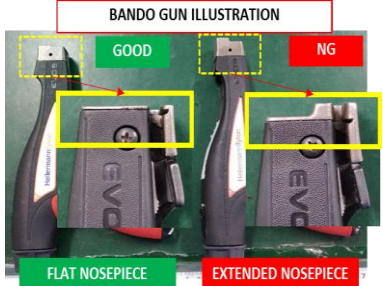
☒ MASSPRO

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PARTS:		1. Assy parts 2. Red tape 20mm		JIG:	1. Clamp assembly jig 2. Bando Gun
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Clamp assembly	<div><p>1. Get the assy parts and set into jig. (See above picture for correct setting of harness). First, set the connector 6098-0407 (W) to Receiver base 1 then lock. Continue to set the harness in jig. Color sensor light will beep/buzz if sensor detects Yellow tape. Last, set the terminal end together within the stopper then press by Toggle clamp.</p><p>2. Check if all LED light for Power On, Clamp ON, Sensor ON was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.</p><p>3. Initially tighten the band clamp on location 1 using both hands.</p><p>4. Get the bando gun using right hand then cut the band clamp on location 1 using both hands. Press the SW button after cut. Continue if the sequence light on clamp location 2 was ON.</p><p>Note: Setting of band clamp cutter depends on the size of the COT/Vinyl tube. For: ø5 - 1~2, ø7 - 3~4</p></div> <div><p>BANDO GUN POSITION ON CLAMP LOCATION 1</p><p>GOOD NG</p></div> <div><p>BANDO GUN ALIGNMENT</p><p>PERPENDICULARITY NG OK NG</p></div> <div><p>BANDO GUN ILLUSTRATION</p><p>GOOD NG</p><p>FLAT NOSEPIECE EXTENDED NOSEPIECE</p></div>		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

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PARTS:		1. Assy Parts 2. Red tape 20mm		JIG:	1. Clamp assembly jig 2. Bando Gun
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2 Clamp assembly (Continuation)	 <p>5. Hold the tape on clamp location <b>2</b>. Make <b>3 windings</b> of tape then cut the tape using both hands. Press the <b>SW button</b> after taping. <b>Go</b> sound will be heard</p>			1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position  <b>Important reminders/Note/s:</b> <b>1. Make sure no gap in stopper and terminals</b>

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**PARTS:**

1. Assy Parts
2. QR Code label 7V3240-0020

JIG:

n/a

**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

5

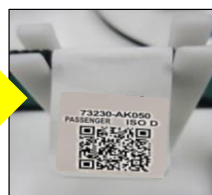
P2

Label Attachment

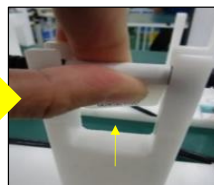
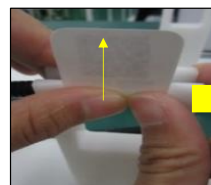
Model Code	Item No.	Item Name
7R0116-7022	73240-AK020	DRIVER PWR/ISO D
7R0117-7025	73240-AK010	DRIVER MANUAL
7R0118-7025	73240-AK020	DRIVER PWR/ISO D
7R0119-7021	73240-AK050	PASSENGER ISO D
7R0120-7022	73230-AK030	PASSENGER FOLD-FLAT



2. Align the end part of label in the jig.

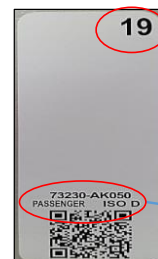


4. Align both end part of label .



6. Press the label upside down using finger.

7. After taping, conduct **POINT CHECKING** before removing the harness from the jig.



19

Model code

1. Get the label.

**Note:** Check the model code, item no. & name

Item no. &amp; name



3. Fold the center part of the label



5. After alignment , Press the label with both fingers .



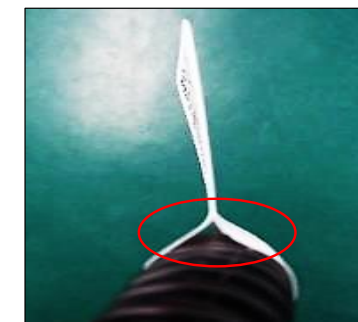
Acceptable overlap 0-1mm

GOOD



NG

1. No bubbles
2. No damage
3. No peel off
4. No wrong use of label
5. No missing parts
6. No loose attachment
7. No wrong usage of label



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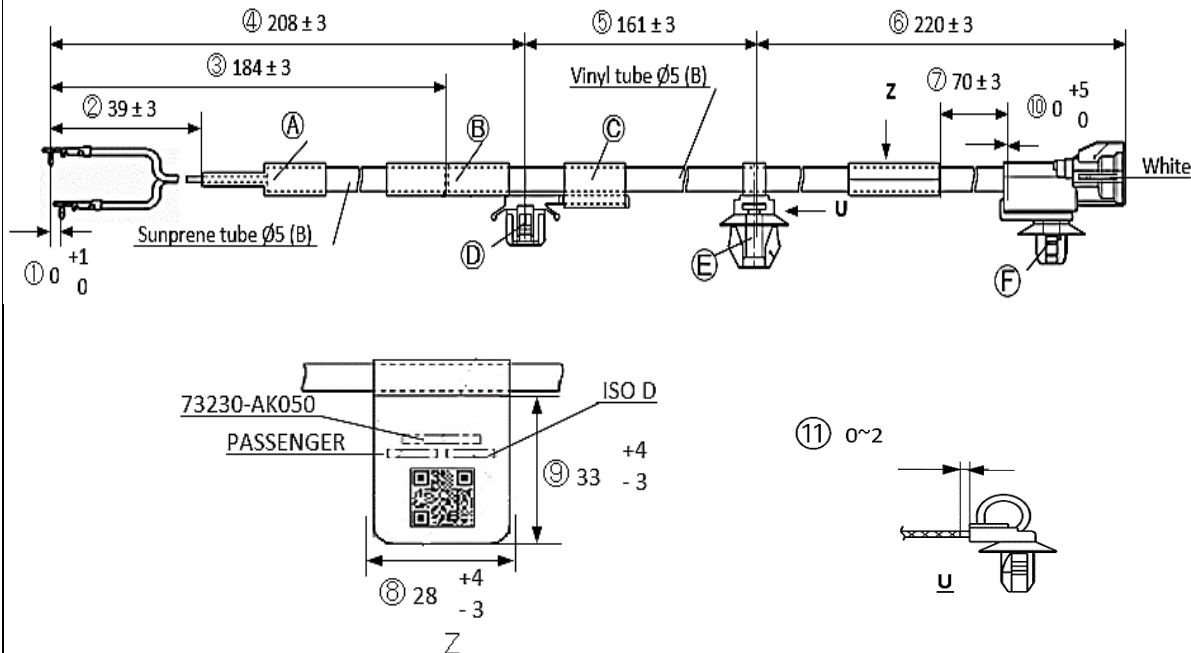

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PARTS:		1. Assy Parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P2	Measurement			<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p>

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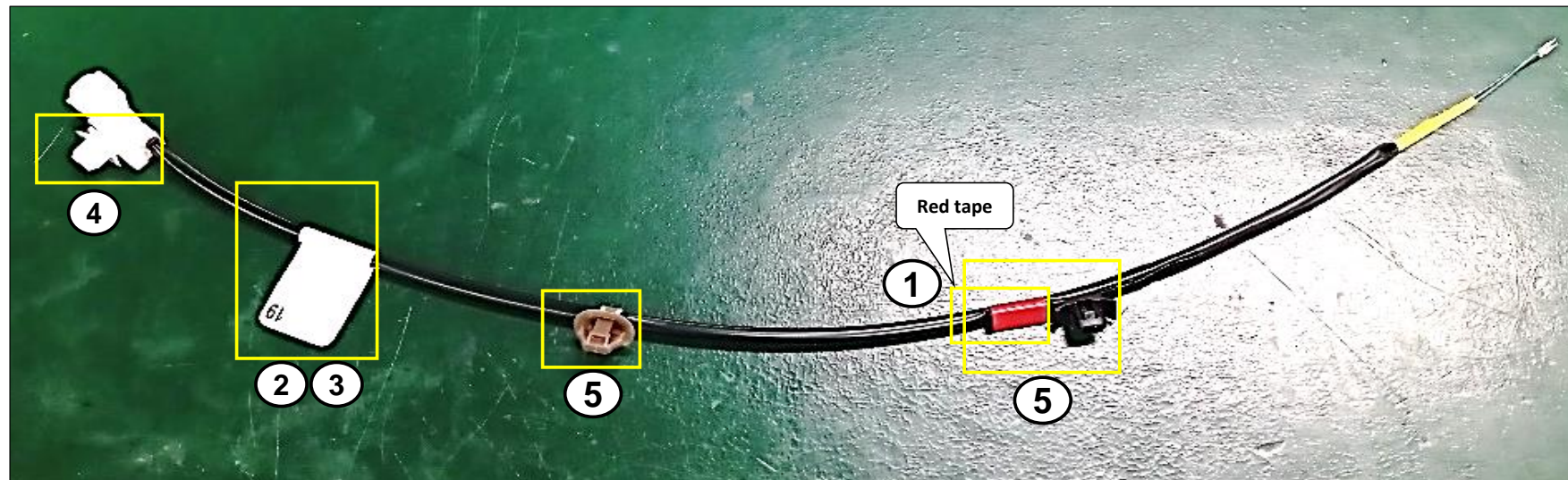
JIG:

n/a

### VISUAL INSPECTION/QUALITY CHECKPOINTS

**P2**

**7R0119-7021**



- ① No Missing/Wrong use of tape
- ② No Wrong use QR Code label
- ③ No Wrong Orientation of QR Code label
- ④ No Missing Clip Attachment
- ⑤ No Missing Clamp

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