



WORK INSTRUCTION

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Model code/Part number:

920B / 7R0116-7022

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

September 10, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-956

Revision No.:

1

Page No.:

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PARTS:

1.Connector 6188-0407 (W); TVSSf 0.3 wires G-B/W L=365±2mm

JIG:

1. Insertion jig with switch cover

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

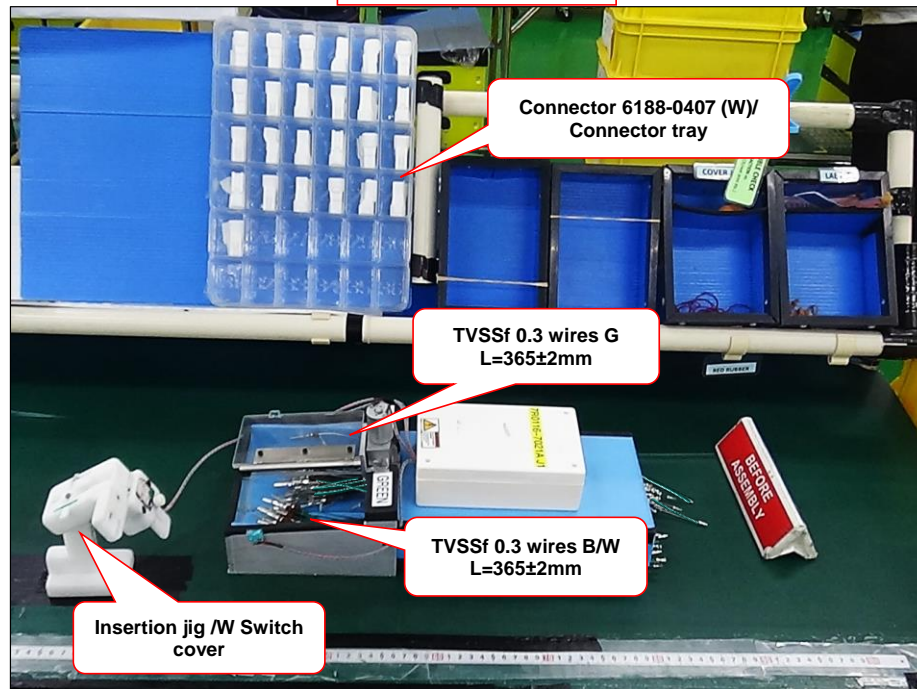
QUALITY POINTERS

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 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 |
|-----------|---------|--|--------------|--------------|----------|-------|-------------|-----------------|-------------|----------|
| 09/10/24 | 1 | Change from Pre-Launch to Masspro. Improvement of Visual inspection/Quality checkpoints. | A. Hernandez | C.Villanueva | A.Arañes | n/a | | | | |
| 08/12/24 | 0 | Initial Issue. | A. Hernandez | C.Villanueva | A.Arañes | n/a | | | | n/a |
| Eff. Date | Rev. No | Details of Change | Revised | Reviewed | Approved | Noted | Est. Date: | August 12, 2024 | | |

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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><div>INSERTION JIG WITH SWITCH COVER</div><div><div><div>G wires</div><div>B/W wires</div><div>Visual reference</div><div>Insertion jig</div><div>Switch cover</div></div><div><div>Lock</div><div>I-mark</div><div>Holes</div></div><div>CONNECTOR ORIENTATION</div></div><div><div><div>L</div><div>Press</div></div><div><div>L</div><div>Press</div><div>R</div></div><div><div>L</div><div>Release</div><div>R</div></div></div><div><div>1. Press the lock of insertion jig using left thumb.</div><div>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></div><div>3. Check the holes/terminal slot for B/W wire.</div></div></div> | | n/a | <div><div>Important reminders and note/s: 1. Refer to above illustration for correct setting.</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</div><div>Connector Orientation Illustration</div><div><div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div></div><div><div>I-mark is not align</div><div>1 hole is open</div><div>NG</div></div></div></div> |

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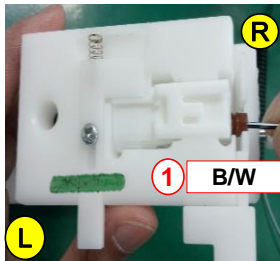

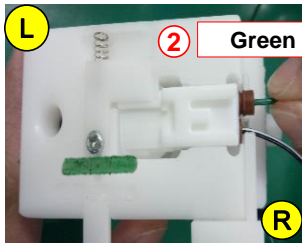
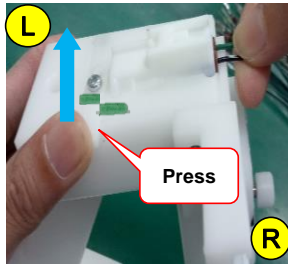
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|--------|--|---|--|-----------|---|
| PARTS: | | 1. TVSSf 0.3 wires G-B/W L=365±2mm | | JIG: | 1. Insertion jig with switch cover |
| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 3 | Offline Wire Insetion to Connector 6188-0407 (W) | <div><div><p>1. Hold the Insertion jig using left hand. Get Black /White wire then insert to terminal slot 1 using right hand.</p></div><div><p>2. Push the button using right hand. The slot for Green wire will be opened.</p></div></div> <div><div><p>3. Get Green wire then insert to terminal slot 2 using right hand.</p></div><div><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></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. 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</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> |

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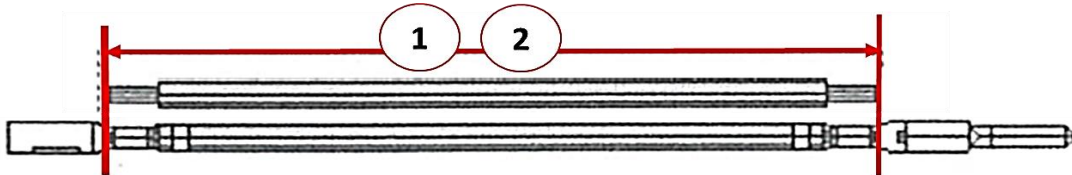


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|--------|------------------------|---|--|--|--|
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| NO. | PROCESS NAME | WORK PROCEDURE/ ILLUSTRATION | | TOOLS/PPE | QUALITY POINTERS |
| 4 | Offline Measurement | <div>Note: 1. Measurement point: 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>1. No wrong dimension</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> |

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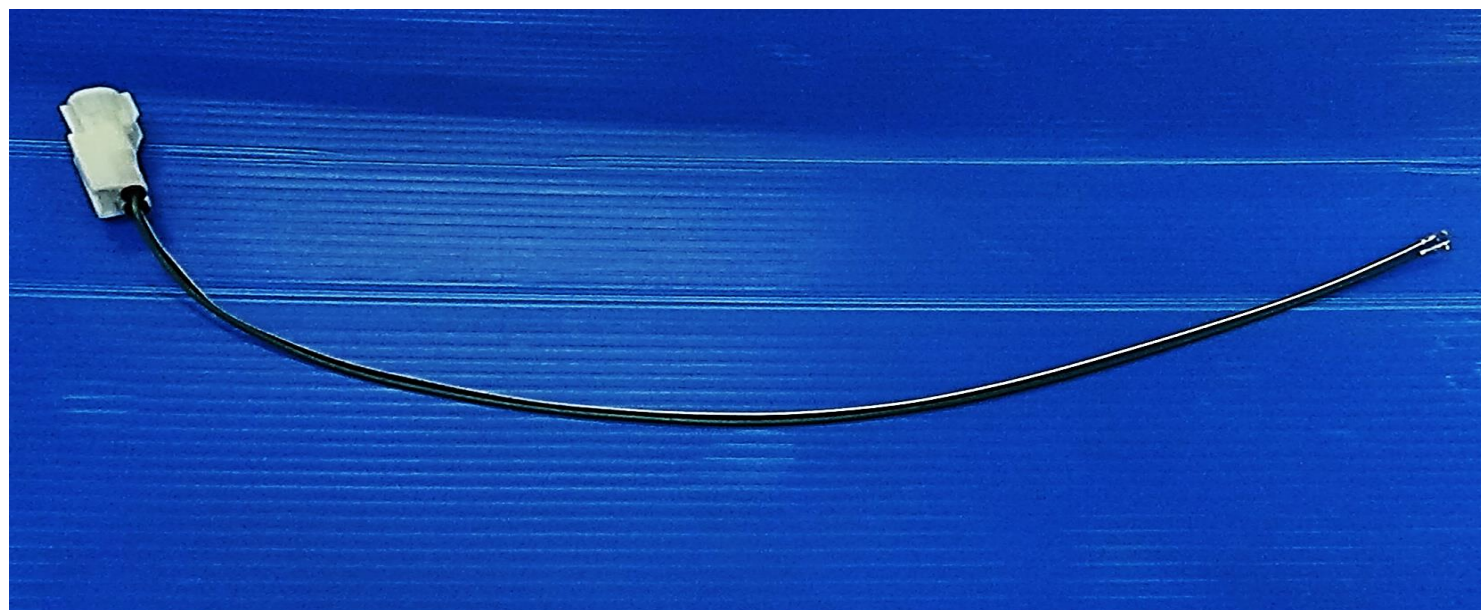
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ VISUAL INSPECTION****OFFLINE****7R0116-7022****1 No Wrong insert****2 No Terminal Backing out****3 No Deformed Terminal**

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