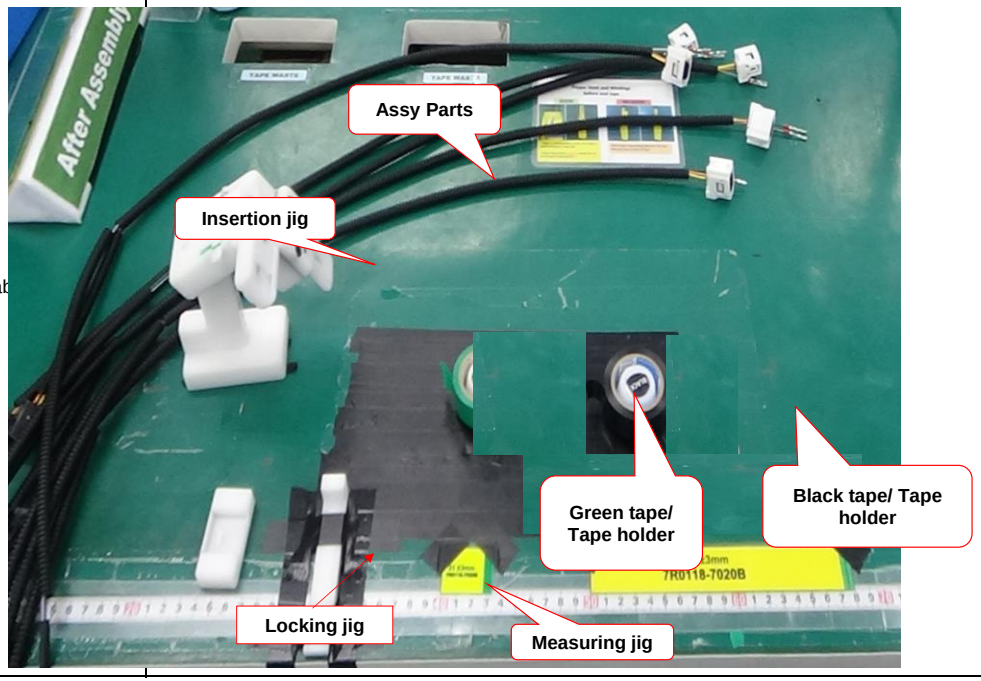
	WORK INSTRUCTION			Effectivity Date:	September 10, 2024		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number:	920B / 7R0118-7025	Customer: TRMX	Car Model: TOYOTA TACOMA	Document No.:	WI-ENG-PDE-996B	
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 1 of 6

PARTS:	1. Assy parts; Black tape [1pc.]; Green tape [1pc.]	JIG:	1. Insertion Jig 2. Measuring Jig 3. Locking Jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	Tab	**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

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
09/10/24	1	Change from Pre-launch to Masspro. Update Visual inspection/Quality checkpoints.	D.Castillo	C.Villanueva	A. Arañes	N/A
08/12/24	0	Initial issue.	D.Castillo	C.Villanueva	A. Arañes	N/A

Prepared by	Reviewed by	Approved by	Noted by
D. Castillo	C.Villanueva	A. Arañes	N/A
Est. Date:	August 12, 2024		

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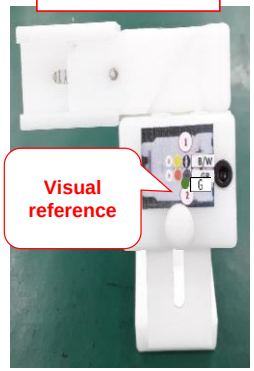
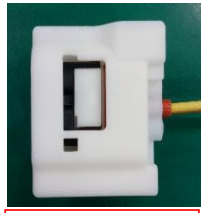
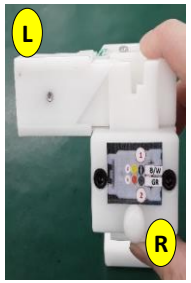
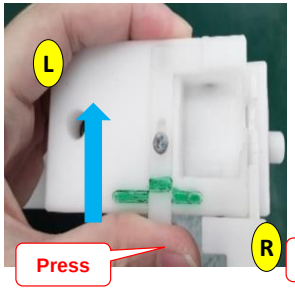
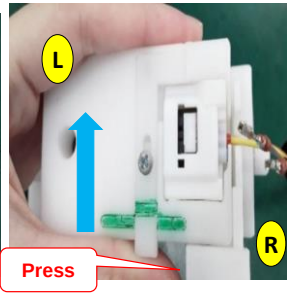
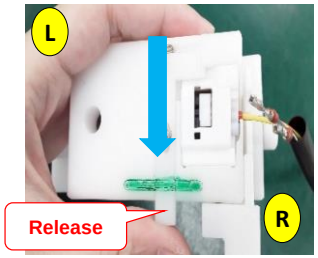
	Model code/Part number: 920B / 7R0118-7025	Customer: TRMX	Car Model: TOYOTA TACOMA	Document No.:	WI-ENG-PDE-996B		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.:	2 of 6

PARTS:	1. Assy parts	JIG:	1. Insertion Jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2	Connector setting to Insertion jig 6189-1142 (W)	 Insertion Jig Orientation  Connector Orientation  1. Press the lower wire guide using right thumb to make sure connector with inserted wires will be inserted.   2. Press the Insertion jig lock using left thumb. Get the assy parts and insert the connector using right hand.  3. After insertion, release the insertion jig lock using left thumb.	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**

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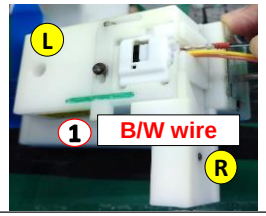
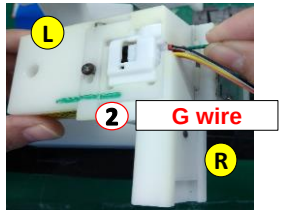
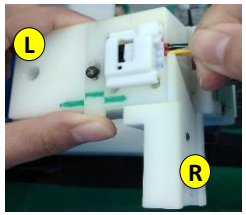
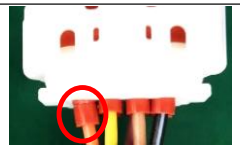
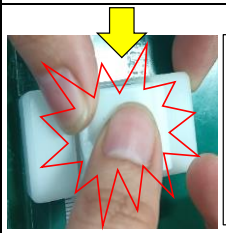
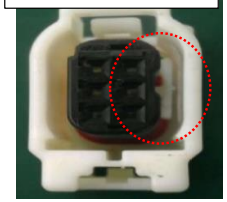
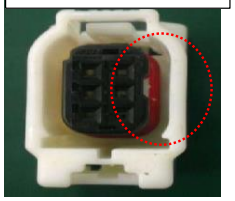
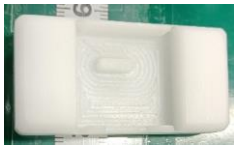
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.:	3 of 6

PARTS:	1. Assy parts	JIG:	1. Insertion jig 2. Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2	Wire insertion to Connector (Assy parts)	 Wire facing  1. Hold the insertion jig using left hand. Get the **B/W wire** then insert to terminal slot **1** using right hand. 2. Press the button using right thumb. Slot for **Green wire** will be opened.  3. Get the **G- 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.	n/a	Note: During insertion, hold the wire not rubber seal to prevent sagging.  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.* ***Document references:*** *1. Refer to **GL-PRO-ASY-029** for Pull-Push procedure.*
4		Connector lock	 Put the connector into locking jig using right hand then press **2x.** Check the connector lock if properly lock. BEFORE PRESSING  AFTER PRESSING 	LOCKING JIG 	***Important reminders/Note/s:*** *1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR.* 1. Use the provided locking jig per model 2. No unlock/half-lock connector 3. No damged connector

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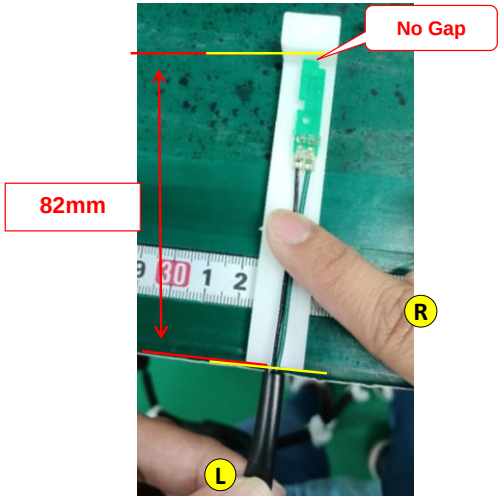
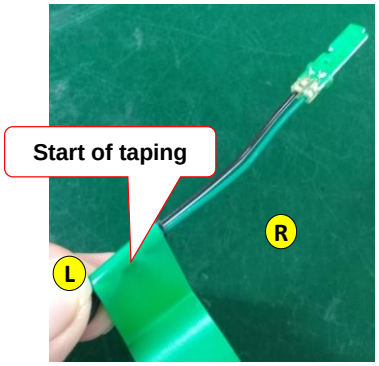
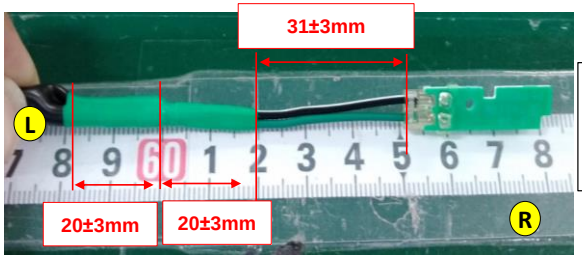
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.:	4 of 6

PARTS:	1. Assy parts 2. Green tape	JIG:	1. Measuring jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2	Taping 1 Black VM tube (Sunprene) to wire near PCB	 1. Get the assy parts and set to measuring jig. First, set the holmeted wire (No Gap) using right hand. Last, set the VM tube (Sunprene) (No Gap) using left hand.  2. Get the **Green tape** using right hand then start taping process using both hands.  3. After taping, check the measurement and taping condition.	MEASURING TAPE MEASURING JIG 	***Important reminders/Note/s:*** *1. Use GREEN TAPE only.* *2. Please use calibrated/verified measuring tape when getting the measurement.* 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 GOOD NG ***Position the finger in wire to avoid deformed hotmelt***

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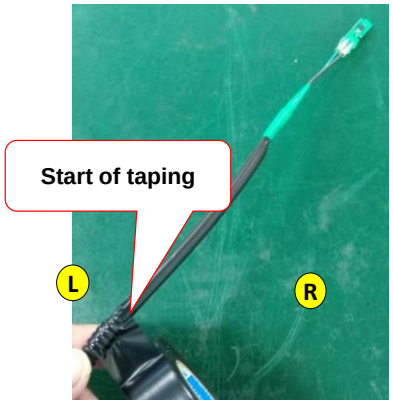
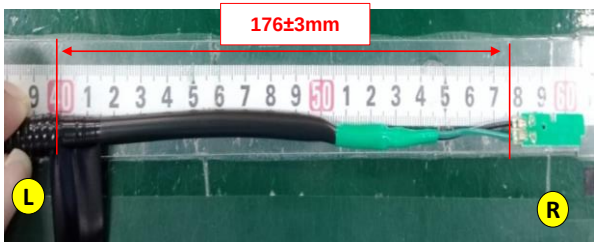
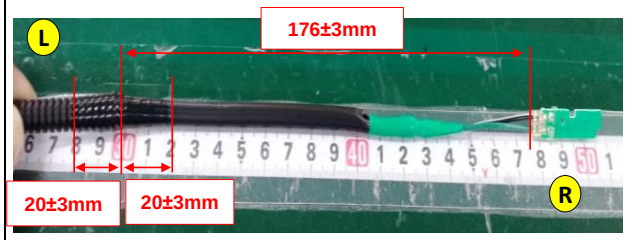
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.:	5 of 6

PARTS:	1. Assy parts 2. Black tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P2	Taping 2 COT to VM tube (Sunprene) near PCB	 1. Hold the COT using left hand, get the **Black tape** using right hand then start pre-taping using both hands.  2. Measure from end of COT up to PCB **176±3mm** then continue the taping process using both hands.  3. After taping, check the measurement and taping condition.	**MEASURING TAPE** 	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 ***Important reminders/Note/s:*** *1. Please use calibrated/verified measuring tape when getting the measurement.* ***Document reference/s:*** *1. Refer to **WI-PRO-ASY-001** for taping procedure.*

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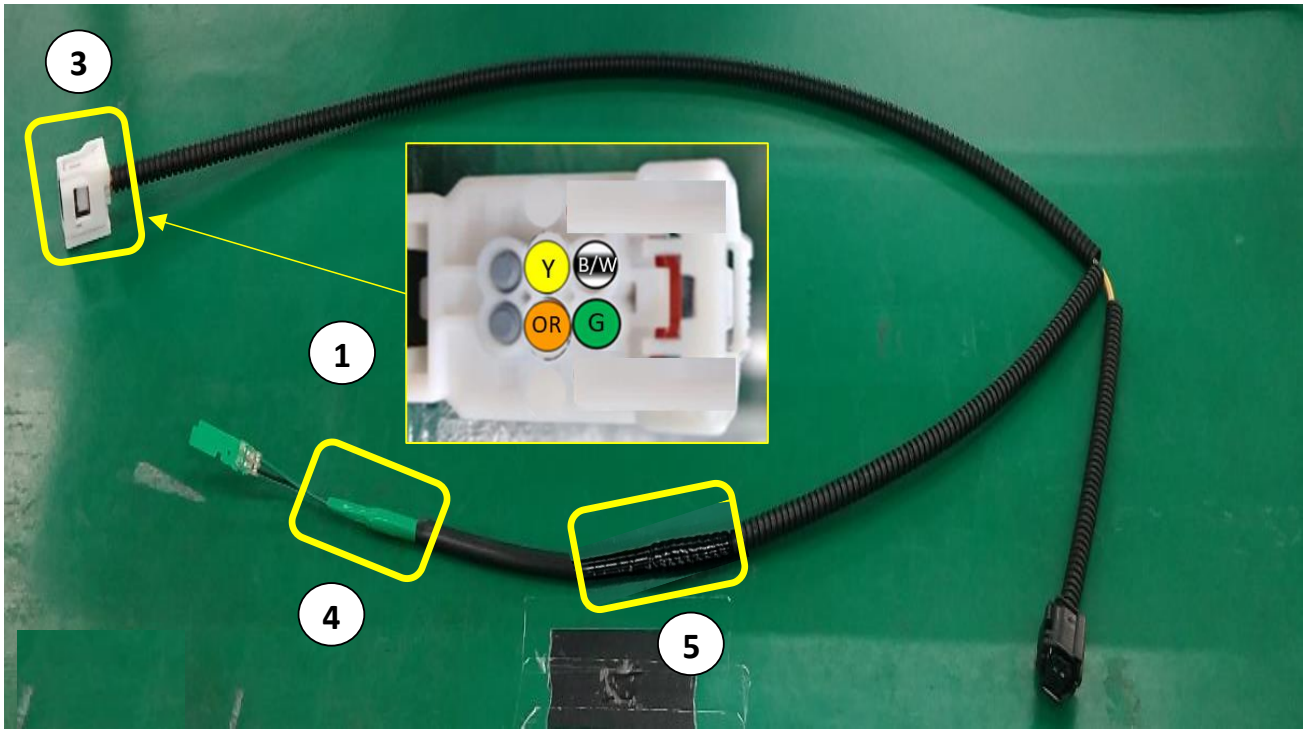
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.:	6 of 6

PARTS:	1. Assy parts	JIG:	n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING - P2 7R0118-7025



1. No WRONG INSERT
2. No TERMINAL BACKING OUT
3. No UNLOCKED/ HALF-LOCKED CONNECTOR
4. No MISSING TAPE/ NO WRONG USE OF TAPE (GREEN TAPE)
5. No MISSING TAPE/ No WRONG USE OF TAPE

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