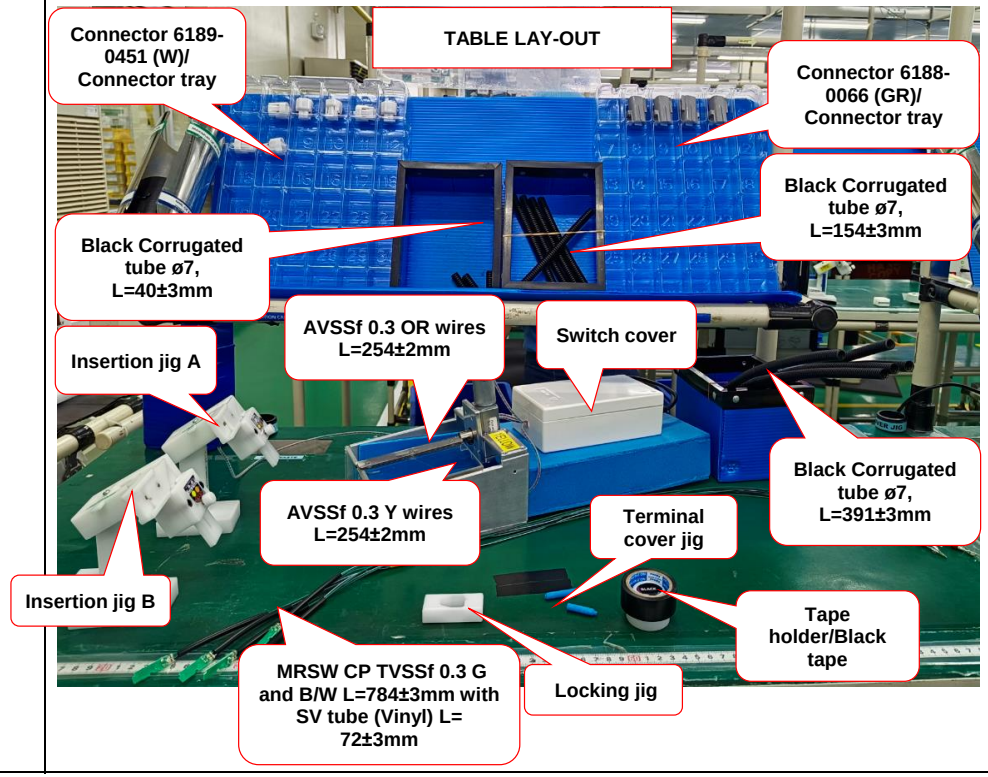
	WORK INSTRUCTION			Effectivity Date:	November 18, 2024	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 930B / 7N0205-7020C	Customer: TRJ	Car Model: TOYOTA-4RUNNER	Document No.:	WI-ENG-PDE-870A	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 1 of 10

PARTS:	1. Connector 6189-0451 (W); AVSSf 0.3 Y-OR Wires L=254±2mm;Connector 6188-0066 (GR); Black Corrugated tube ø7, L=154±3mm; Black Corrugated tube ø7, L=40±3mm; Black Corrugated tube ø7, L=391±3mm; Black tape; MRSW CP TVSSf 0.3 G and B/W L=784±3mm with SV tube (Vinyl) L= 72±3mm	JIG:	1. Insertion jig with switch cover 2. Locking jig 3. Terminal cover jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	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/tols ***Document references:*** ***1. Refer to WI-PRO-CNC-017 for Wire Strip length tolerance.***

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
11/18/24	1	Change Purpose from Pre-launch to Masspro.Update the Visual Inspection/Quality Checkpoints Illustraion.	M. Ariola	C. Villanueva	A. Arañes	n/a
04/16/24	0	Initial issue.	M. Ariola	C. Villanueva	A. Arañes	n/a

Prepared by	Reviewed by	Approved by	Noted by
M. Ariola	C.Villanueva	A. Arañes	n/a
Est. Date:	April 16, 2024		

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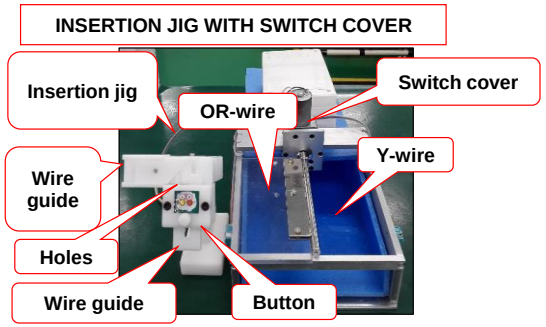
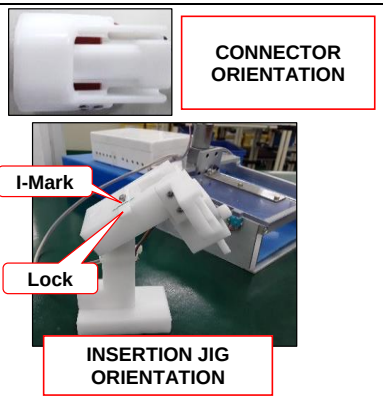
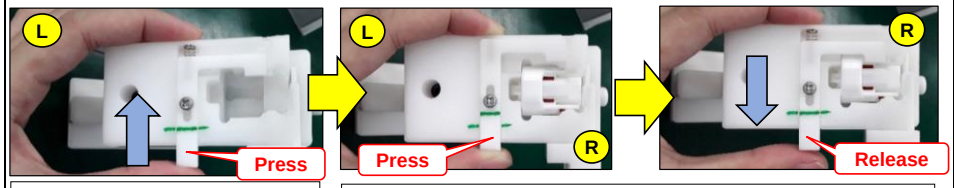
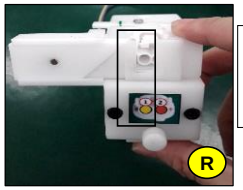
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 930B / 7N0205-7020C	Customer: TRJ	Car Model: TOYOTA-4RUNNER	Document No.:	WI-ENG-PDE-870A	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 2 of 10

PARTS:	1. Connector 6189-0451 (W)	JIG:	1. Insertion jig with switch cover

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1	Connector setting to insertion jig 6189-0451 (W)	   1. Press the lock of insertion jig using left thumb. 2. Insert the connector **6189-0451 (W)** into jig using right hand then release the lock using left thumb. ***Note: Follow the connector orientation.***  3. Push the guide using right hand. The slot for **Yellow wire** will be opened.	n/a	1. Use the provided jog per model 2. No unlocked/half-locked connector ***Important reminders/Note/s:*** ***1. Manual locking may cause damaged connector lock.*** ***Document references:*** ***1. Refer to GL-PRO-ASY-017 for the verification of connector lock.***

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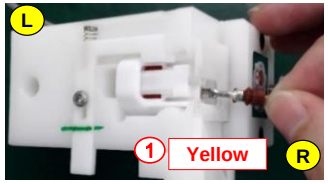
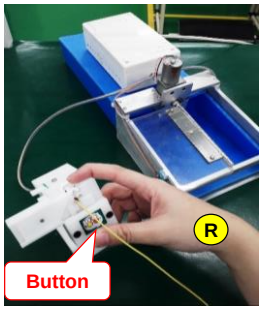
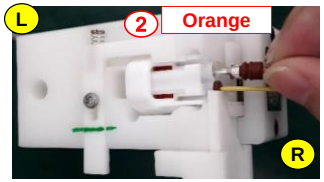
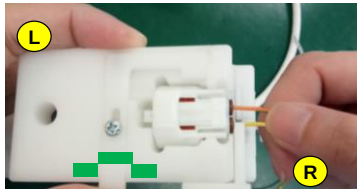
	WORK INSTRUCTION				Effectivity Date:	November 18, 2024		
	Process Name/Title:	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 930B / 7N0205-7020C	Customer: TRJ	Car Model: TOYOTA-4RUNNER		Document No.:	WI-ENG-PDE-870A		
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO		Revision No.:	1	Page No.:	3 of 10

PARTS:	1. Connector 6189-0451 (W) 2. AVSSf 0.3 Y-OR Wires L=254±2mm	JIG:	1. Insertion jig with switch cover

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1	Wire insertion to Connector 6189-0451 (W)	 TERMINAL ORIENTATION  1. Hold the insertion jig using left hand, get **Yellow wire** and insert to connector slot **1** using right hand.  2. Press the button using right thumb, slot for **Orange wire** will be opened.  3. Hold the insertion jig using left hand, get **Orange wire** and insert to connector 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	1. No wrong usage of parts. 2. No deformed terminal

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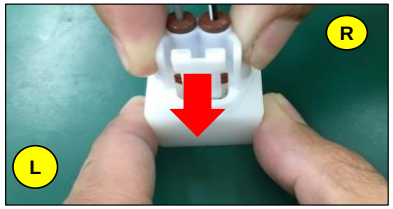
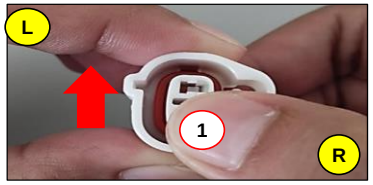
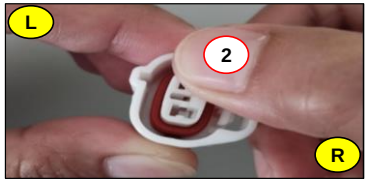
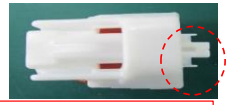
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number: 930B / 7N0205-7020C	Customer: TRJ	Car Model: TOYOTA-4RUNNER	Document No.:	WI-ENG-PDE-870A
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 1	Page No.: 4 of 10

PARTS:	1. Assy Parts	JIG:	1. Locking jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1	Connector lock	 1. Put the connector into locking jig using right hand. Then press to lock 2x using both hands.   2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.  BEFORE PRESSING AFTER PRESSING Check the double lock deformation	LOCKING JIG 	1. Use the provided jog per model 2. No unlocked/half-locked connector ***Important reminders/Note/s:*** ***1. Manual locking jig may caused damaged connector lock*** ***Document references:*** ***1. Refer to GL-PRO-ASY-017 for the verification of connector lock.***

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	Model code/Part number: 930B / 7N0205-7020C	Customer: TRJ	Car Model: TOYOTA-4RUNNER		Document No.:	WI-ENG-PDE-870A		
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO		Revision No.:	1	Page No.:	5 of 10

PARTS:	1. Assy parts 2. Black Corrugated tube ø7, L=40±3mm (no slit) 3. Black tape 4. Black Corrugated tube ø7, L=154±3mm (no slit)	JIG:	1. Terminal cover jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1	Wire Insertion to Black Corrugated tube **ø7, L=40±3mm** **ø7, L=154±3mm** (no slit)	 1. Get the cover jig then insert to **Y-OR wires** using left hand. 2. Get the corrugated tube (no slit) **Ø7, L=40±3mm** using left hand then insert the **Y-OR wires** using right hand. 3. Get the corrugated tube (no slit) **Ø7, L=154±3mm** using left hand then insert the **Y-OR wires** using right hand. 4. After insertion, remove the cover jig using left hand.	TERMINAL COVER JIG 	1. No wrong usage of parts. 2. No deformed terminal

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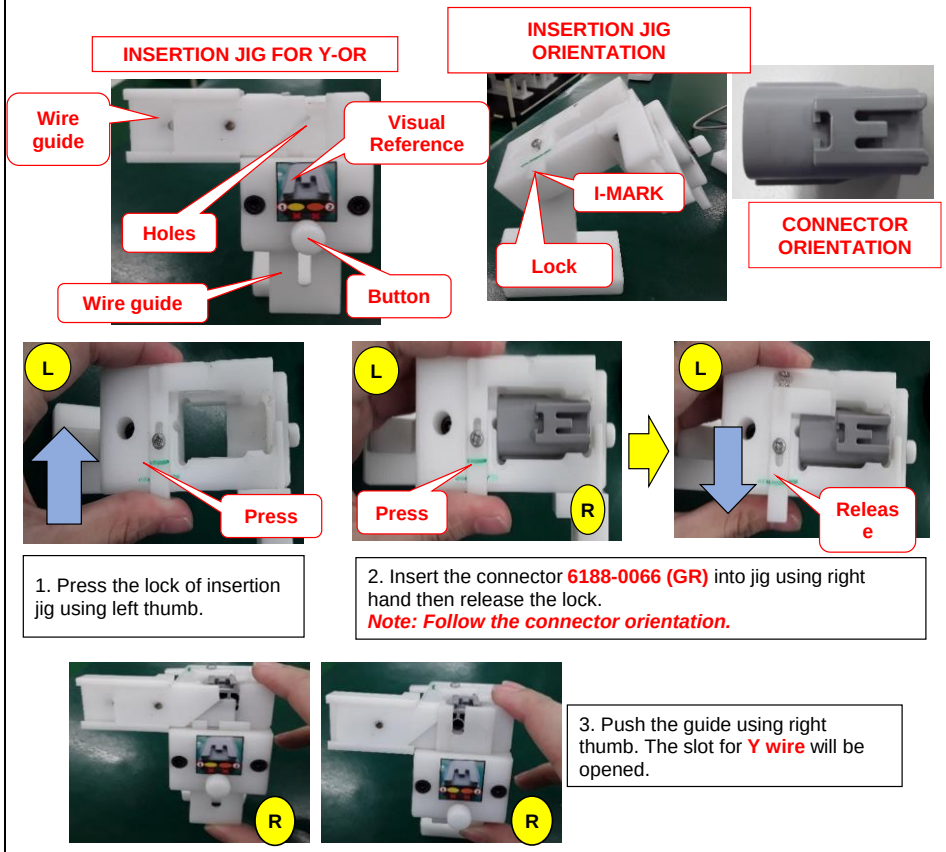
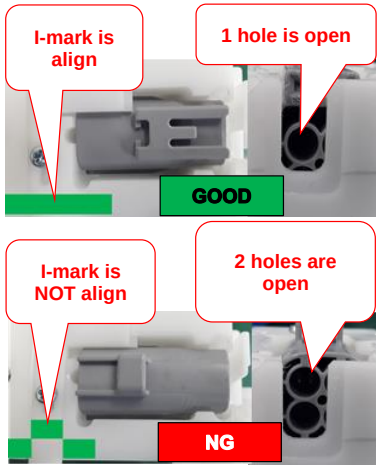
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number: 930B / 7N0205-7020C	Customer: TRJ	Car Model: TOYOTA-4RUNNER	Document No.:	WI-ENG-PDE-870A
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 1	Page No.: 6 of 10

PARTS:	1. Connector 6188-0066 (GR)	JIG:	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1	Connector setting to insertion jig 6188-0066 (GR)	 1. Press the lock of insertion jig using left thumb. 2. Insert the connector **6188-0066 (GR)** into jig using right hand then release the lock. ***Note: Follow the connector orientation.*** 3. Push the guide using right thumb. The slot for **Y wire** will be opened.		1. No wrong usage of parts. 2. No deformed terminal **Connector Orientation Illustration** 

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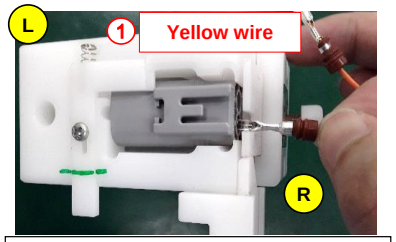
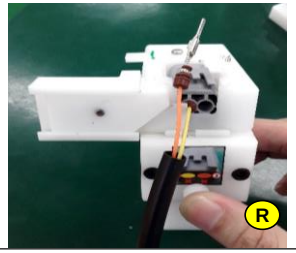
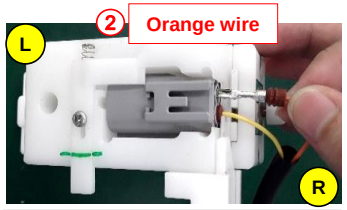
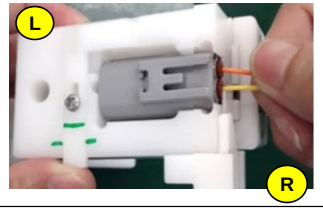
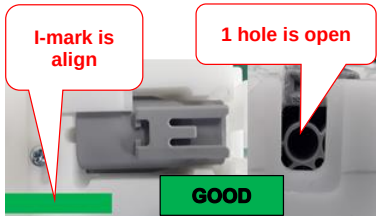
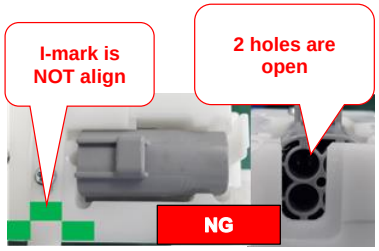
	Model code/Part number: 930B / 7N0205-7020C	Customer: TRJ	Car Model: TOYOTA-4RUNNER	Document No.:	WI-ENG-PDE-870A
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 1	Page No.: 7 of 10

PARTS:	1. Assy parts 2. Connector 6188-0066 (GR)	JIG:	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1	Wire insertion to Connector 6188-0066 (GR)	 WIRE FACING  1. Hold the insertion jig using left hand. Get the assy parts, insert the **Yellow wire** to connector slot **1** using right hand.  2. Press the button using right thumb, slot for **Orange wire** will be opened.  3. Get **Orange wire** then insert to connector 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.		1. No wrong usage of parts. 2. No deformed terminal **Connector Orientation Illustration**  

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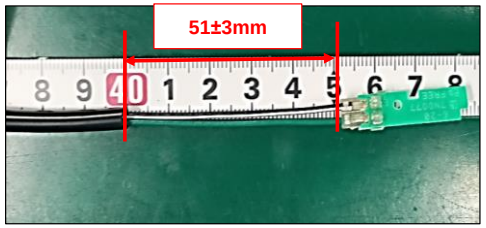
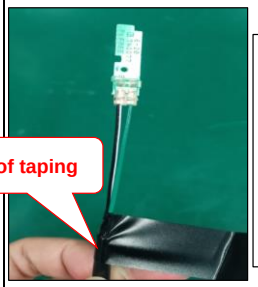
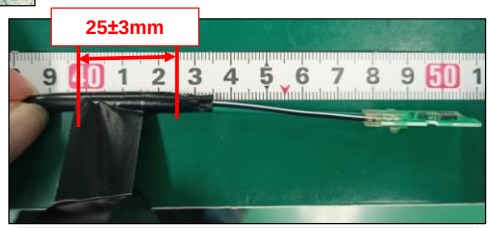
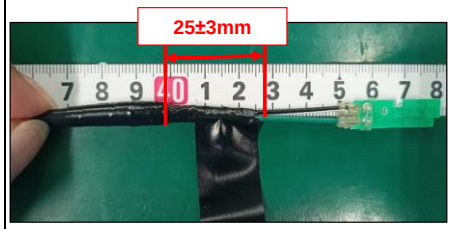
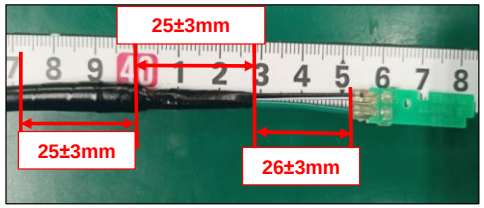
	Model code/Part number: 930B / 7N0205-7020C	Customer: TRJ	Car Model: TOYOTA-4RUNNER	Document No.:	WI-ENG-PDE-870A	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 8 of 10

PARTS:	1. MRSW CP TVSSf 0.3 G and B/W L=784±3mm with SV tube (Vinyl) L= 72±3mm 2. Black tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P1	Taping 1 Black SV tube (Vinyl) to Wire near Hotmelted wire	 1. Get the **MRSW CP TVSSf 0.3 G and B/W L=784±3mm with SV tube (Vinyl) L= 72±3mm.** Hold the Black SV tube (Vinyl) using left hand. Measure from end of SV tube (Vinyl) up to edge of hotmelted wires **51±3mm** using right hand.  2. Hold the Black SV tube (Vinyl) using left hand. Get the black tape using right hand and start taping process.  3. Confirm the measurement from end of tape up to end of SV tube (Vinyl) **25±3mm** then start taping using both hands.  4. Confirm the measurement from SV tube (Vinyl) up to end of tape **25±3mm then** start taping using both hands.  5. After taping, check the measurement and taping condition.	**MEASURING TAPE** 	***Important reminders/Note/s:*** ***1. 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 dimension 6. No wrong use of tape

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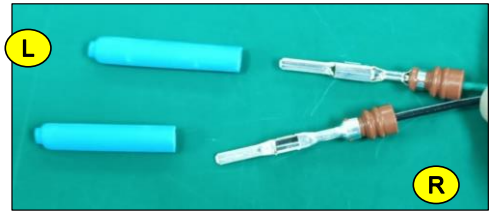
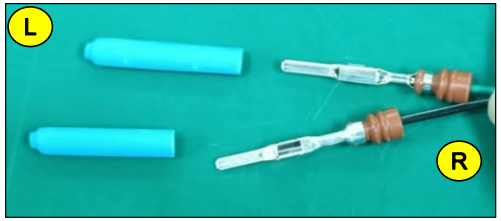
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 930B / 7N0205-7020C	Customer: TRJ	Car Model: TOYOTA-4RUNNER	Document No.:	WI-ENG-PDE-870A	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 9 of 10

PARTS:	1. Assy parts 2. Black corrugated tube ø7, L=391±4mm (No slit),	JIG:	1. Terminal cover jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P1	Wire insertion to Black corrugated tube ø7, L=391±4mm (No slit)	 1. Get the **MRSW CP (TVSSf 0.3 G-B/W wires L=784±3mm)** using both hands then insert the terminal cover jig using left hand. 2. Get the **Black corrugated tube ø7, L=391±4mm (No slit),** using left hand then insert the wires using right hand.  3. After insertion, remove the terminal cover jig using left hand.	**TERMINAL COVER JIG** 	1. No wrong usage of parts. 2. No deformed terminal

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NBC	WORK INSTRUCTION			Effectivity Date:	November 18, 2024
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number: 930B / 7N0205-7020C	Customer: TRJ	Car Model: TOYOTA-4RUNNER	Document No.:	WI-ENG-PDE-870A
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 1	Page No.: 10 of 10

PARTS:	n/a	JIG:	n/a

VISUAL INSPECTIONS/QUALITY CHECKPOINTS

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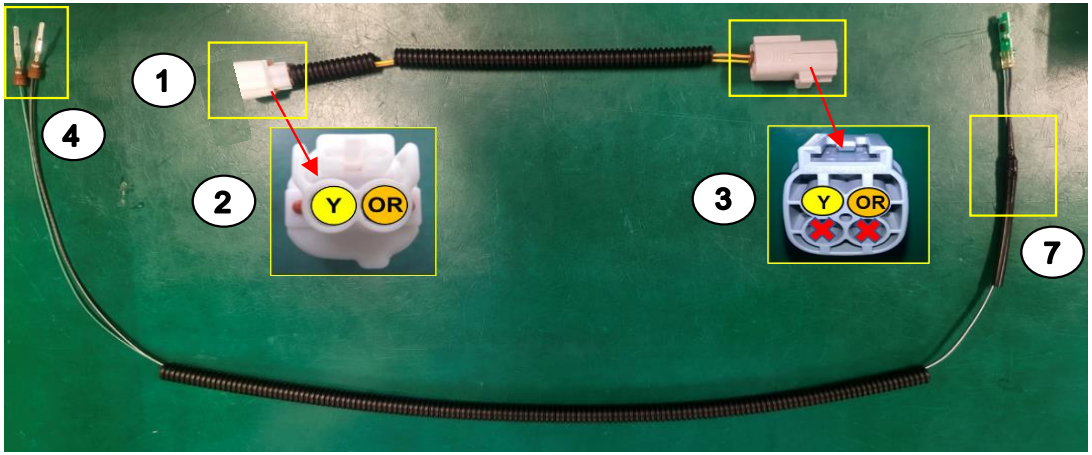

1. No Unlock/half-locked connector
2. 3 No Wrong insertion
4. No Deformed Terminal
5. No Terminal Backing Out
6. No Missing parts (COT and SV tube (Vinyl)
7. No Missing tape (Black tape)

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