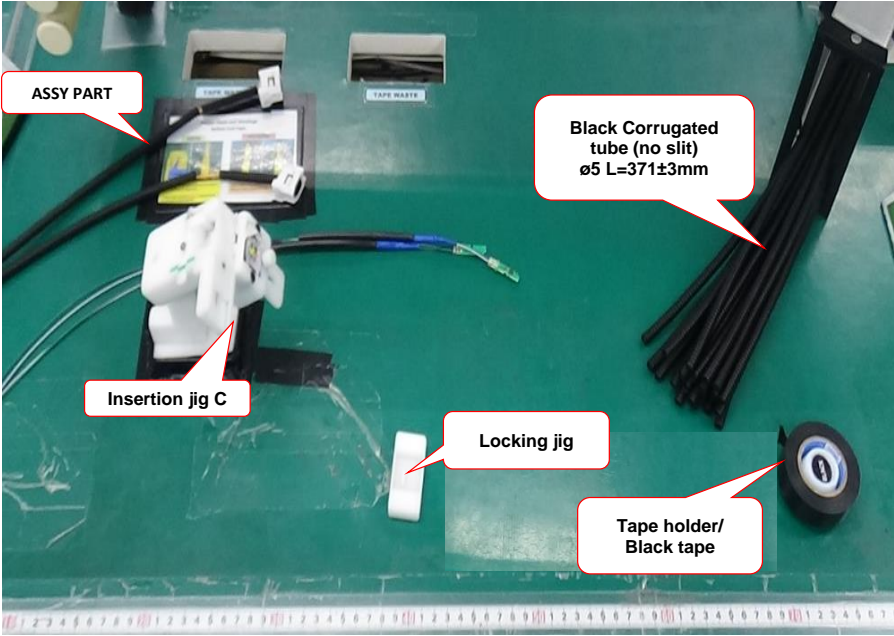
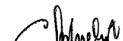


	WORK INSTRUCTION TAPING ASEMBLY PROCESS				Effectivity Date:	August 20, 2024	
	Process Name/Title:				Validity Date:	n/a	
	Model code/Part number: 920B / 7R0117-7025		Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:	WI-ENG-PDE-982B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.: 1 of 6

PARTS:		1. Assy parts: Black tape; Black Corrugated tube (no slit) ø5 L=371±3mm		JIG:	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P2	<div>TABLE LAY-OUT</div> 		<div>Safety Instruction</div> <p>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</p> <div>Housekeeping</div> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <div>Alert level</div> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	1. No missing parts/tools 2. No excess parts/tools

Revision History							Prepared by	Reviewed by	Approved by	Noted by
08/20/24	1	Change purpose from Pre-launch to Masspro.	M.Ariola	C.Villanueva	A.Arañes	n/a	 M.Ariola	 C.Villanueva	 A.Arañes	n/a
07/19/24	0	Initial issue.	M.Ariola	C.Villanueva	A.Arañes	n/a				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	July 19, 2024		

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

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920B / 7R0117-7025

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TRMX

Car Model:

TOYOTA-TACOMA

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WI-ENG-PDE-982B

Purpose:

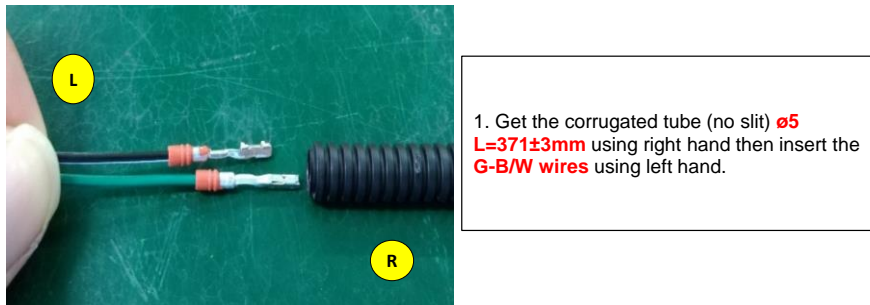
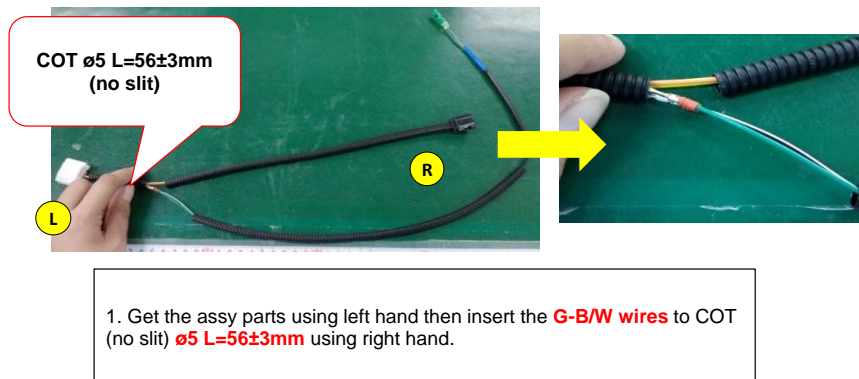
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:				JIG:	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P2	Wire insertion to COT (no slit) ø5 L=371±3mm	<div></div>	n/a	1. No wrong use of parts 2. No deformed terminal
3		Wire insertion to assy parts	<div><div></div></div>	n/a	1. No wrong insertion 2. No deformed terminal

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PARTS:		1. Assy parts		JIG:	1.Insertion Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	<div><div>Insertion Jig</div><div>Visual reference</div><div>I-mark</div><div>Lock</div><div>Connector Orientation</div><div>Insertion Jig Orientation</div><div>Press</div><div>Press</div><div>Release</div></div> <p>Connector setting to Insertion jig 6189-1142 (W) (Assy parts)</p> <p>1. Press the lower wire guide using right thumb to make sure connector with inserted wires will be inserted.</p> <p>2. Press the Insertion jig lock using left thumb. Get the assy parts and insert the connector using right hand.</p> <p>3. After insertion, release the insertion jig lock using left thumb.</p>		n/a	<div><div>1. Use the provided jig per model</div><div>2. No wrong orientation of connector</div><div>3. No wrong use of connector</div><div>4. No damaged connector</div><div>CONNECTOR ORIENTATION ILLUSTRATION</div><div>I-mark is align</div><div>1 hole is open</div><div>GOOD</div></div>

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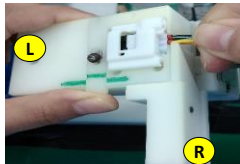
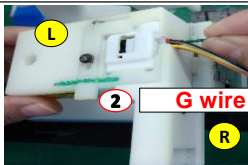

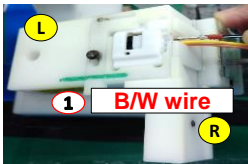


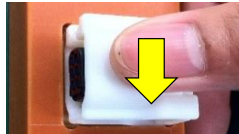
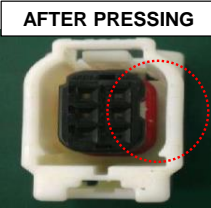
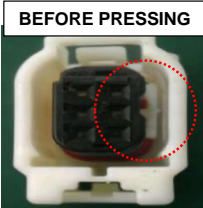
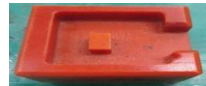
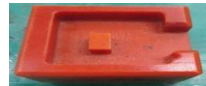
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PARTS:	1. Assy parts		JIG:	1.Insertion jig 2.Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2 Wire insertion to Connector (Assy parts)	<div><div>1. Hold the insertion jig using left hand. Get the B/W wire then insert to terminal slot 1 using right hand.</div><div>2. Press the button using right thumb. Slot for G-wire will be opened.</div><div>3. Get the G wire then insert to terminal slot 2 using right hand.</div><div>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.</div></div> <td>n/a</td> <td><div>Note: During insertion, hold the wire not <u>rubber seal</u> to prevent sagging.</div><div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div><div>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.</div><div>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div></td>	n/a	<div>Note: During insertion, hold the wire not <u>rubber seal</u> to prevent sagging.</div>  <div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>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.</div> <div>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>
6		Connector lock	<div><div>Put the connector into locking jig using right hand then press 2x. Check the connector lock if properly lock.</div><div></div></div> <td><div>LOCKING JIG</div></td> <td><div>Important reminders/Note/s: 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</div><div>1. Use the provided locking jig per model 2. No unlock/half-lock connector 3. No damaged connector</div></td>	<div>LOCKING JIG</div> 

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

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920B / 7R0117-7025

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Document No.:

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


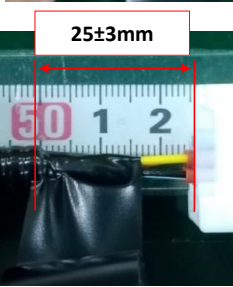
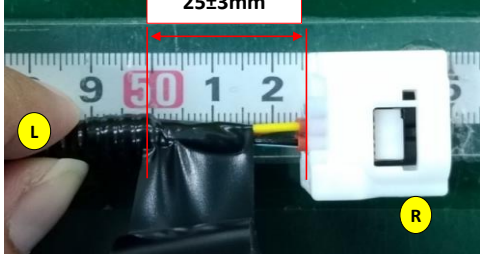
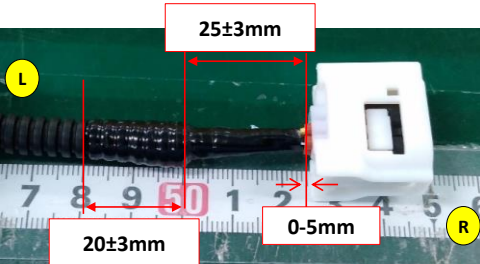

☒ MASSPRO

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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P2 Taping 2 COT to wire near connector	<div><p>Start of taping</p></div> <div><p>1. Hold the COT then get Black tape using right hand then start taping process using both hands.</p></div> <div><p>25±3mm</p><p>2. Measure from end of COT up to edge of connector 25±3mm then continue the taping process using both hands.</p></div> <div><p>25±3mm</p><p>20±3mm</p><p>0-5mm</p><p>3. After taping, check the measurement and taping condition.</p></div>		<div>MEASURING TAPE</div> 	<p>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document reference/s: 1. Refer to WI-PRO-ASY-001 for taping procedure.</p> <ul style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension

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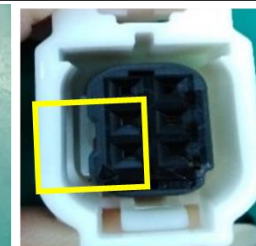
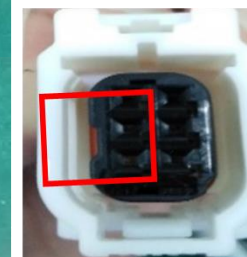
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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS**P2****7R0117-7025****GOOD****NO GOOD****① ②****No WRONG INSERT****No TERMINAL BACKING OUT****③****NO UNLOCK/HALFLOCK CONNECTOR****④****NO MISSING TAPE**

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