
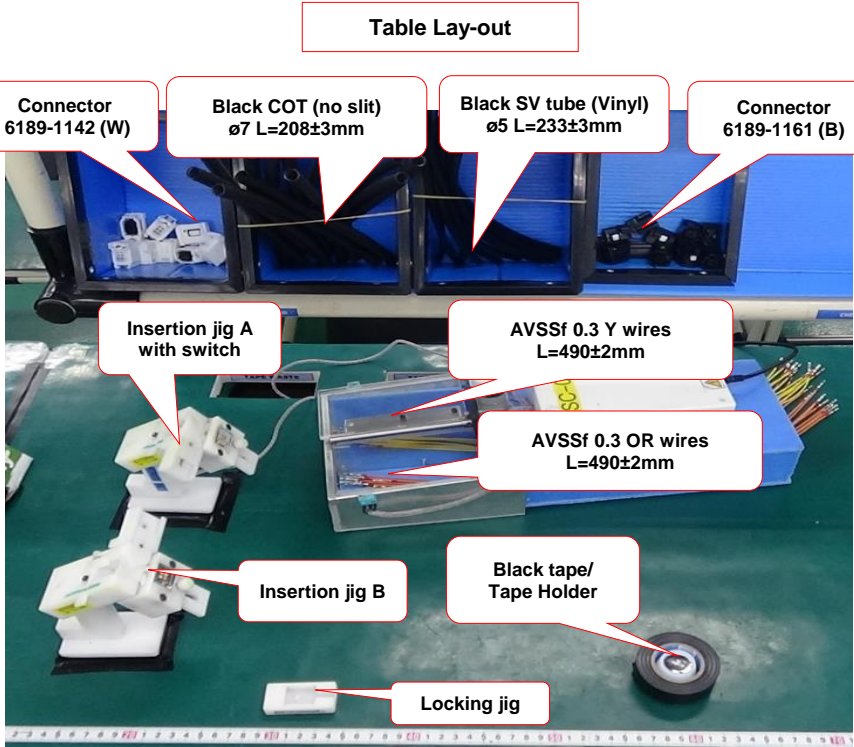





|   |   |  |                       |                                 |                   |                         |        |  |
|---|---|--|-----------------------|---------------------------------|-------------------|-------------------------|--------|--|
|  | <b>WORK INSTRUCTION</b><br><b>TAPING ASSEMBLY PROCESS</b>   |  |                       |                                 | Effectivity Date: | October 01, 2024        |        |  |
|   | Process Name/Title:   |  |                       |                                 | Validity Date:    | n/a                     |        |  |
|   | Model code/Part number: <b>780B / 7R0103-7023B</b>  |  | Customer: <b>TRMX</b> | Car Model: <b>TOYOTA-TUNDRA</b> | Document No.:     | <b>WI-ENG-PDE-1078A</b> |        |  |
|   | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO |  | Revision No.:         |                                 | 1                 | Page No.:               | 1 of 8 |  |

|               |                     |  |  |  |  |   |  |   |  |
|---------------|---------------------|--|--|--|--|---|--|---|--|
| <b>PARTS:</b> |                     | 1. Connector 6189-1142 (W); Black Corrugated tube (no slit) ø7 L=208±3mm; Black SV tube (Vinyl) ø5 L=233±3mm; Connector 6189-1161 (B); AVSSf 0.3 OR wires L=490±2mm; AVSSf 0.3 Y wires L=490±2mm; Black Tape |  |  |  | JIG:  |  | 1. Insertion jig with switch cover<br>2. locking jig  |  |
| <b>NO.</b>    | <b>PROCESS NAME</b> | <b>WORK PROCEDURE/ ILLUSTRATION</b>  |  |  |  | <b>TOOLS/PPE</b>  |  | <b>QUALITY POINTERS</b>   |  |
| 1             | P1                  | <p><b>Table Lay-out</b></p>   |  |  |  | <p><b>Safety Instruction</b><br/>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b><br/>1. Maintain and always practice 5's.<br/>2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b><br/>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> |  | <p>Document reference/s:<br/>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No missing parts/tools<br/>2. No excess parts/tools</p> |  |


  

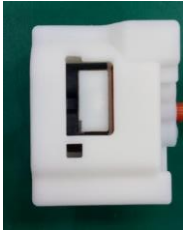
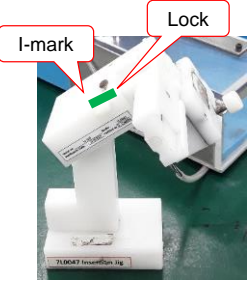
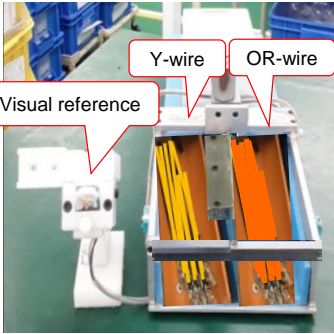
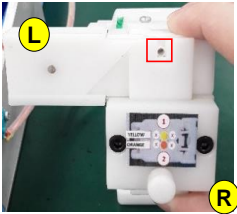
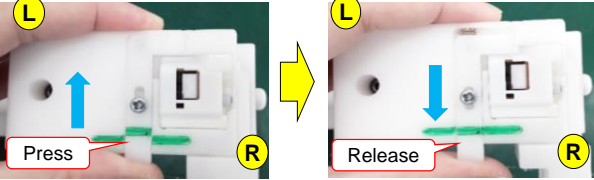
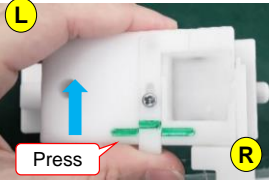
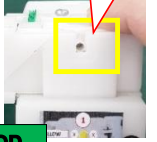

|                  |         |  |            |               |           |             |  |  |  |     |
|------------------|---------|--|------------|---------------|-----------|-------------|--|--|--|-----|
| Revision History |         |  |            |               |           | Prepared by | Reviewed by  | Approved by  | Noted by   |     |
| 10/01/24         | 1       | Change from Pre-launch to Masspro.                                     | D.Castillo | C. Villanueva | A. Arañes | n/a         | <br>D. Castillo | <br>C. Villanueva | <br>A. Arañes | n/a |
| 09/24/24         | 0       | Initial issue. Transfer some process to P2 due to process improvement. | D.Castillo | C. Villanueva | A. Arañes | n/a         |  |  |  |     |
| Eff. Date        | Rev. No | Details of Change  | Revised    | Reviewed      | Approved  | Noted       |  |  |  |     |

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|---|---|--|-----------------------|---------------------------------|-------------------------|-------------------------|---------------|
|  | <b>WORK INSTRUCTION</b>   |  |                       | Effectivity Date:               | <b>October 01, 2024</b> |                         |               |
|   | Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>  |  |                       | Validity Date:                  | <b>n/a</b>              |                         |               |
|   | Model code/Part number: <b>780B / 7R0103-7023B</b>  |  | Customer: <b>TRMX</b> | Car Model: <b>TOYOTA-TUNDRA</b> | Document No.:           | <b>WI-ENG-PDE-1078A</b> |               |
|   | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO |  |                       | Revision No.:                   | <b>1</b>                | Page No.:               | <b>2 of 8</b> |

|               |  |   |                  |   |     |
|---------------|--|---|------------------|---|-----|
| <b>PARTS:</b> | 1. Connector 6189-1142 (W)                             |   |                  | JIG:  | n/a |
| <b>NO.</b>    | <b>PROCESS NAME</b>                                    | <b>WORK PROCEDURE/ ILLUSTRATION</b>   | <b>TOOLS/PPE</b> | <b>QUALITY POINTERS</b>   |     |
| 2             | P1<br>Connector setting to Insertion jig 6189-1142 (W) | <div><div><b>Insertion Jig with Switch Cover</b></div><div></div><div></div><div><div>1. Press the insertion jig lock using left hand.</div><div>2. Get the connector <b>6189-1142 (W)</b> using right hand and insert to insertion jig. Release the lock after insertion.</div><div>3. Push the guide using right hand. The slot for <b>Y wire</b> will be opened.</div></div></div> | n/a              | <div><b>CONNECTOR ORIENTATION ILLUSTRATION</b></div> <div></div> <div><b>GOOD</b></div> <div>1. Use the provided jig per model<br/>2. No wrong orientation of connector<br/>3. No wrong use of connector<br/>4. No damaged connector</div> <div><b>Important reminders/Note/s:</b><br/><b>1. Follow the connector orientation</b></div> |     |

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**October 01, 2024**

Model code/Part number:

**780B / 7R0103-7023B**

Customer:

**TRMX**

Car Model:

**TOYOTA-TUNDRA**

Document No.:

**WI-ENG-PDE-1078A**

Purpose:



PROTOTYPE



PRE-LAUNCH




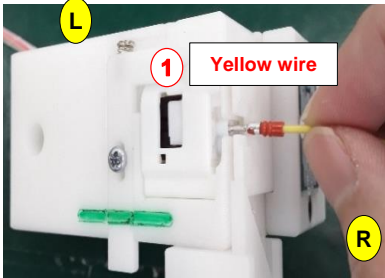
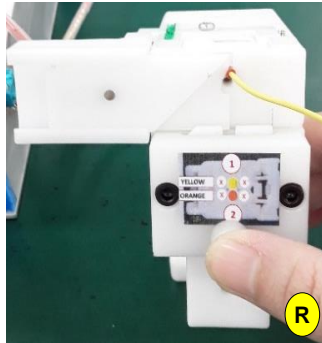
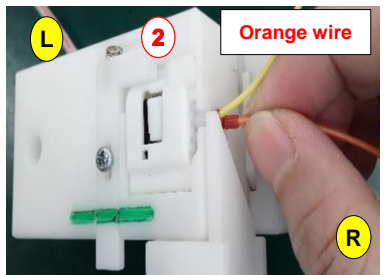
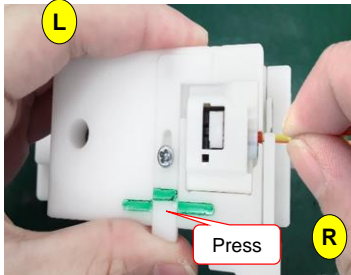
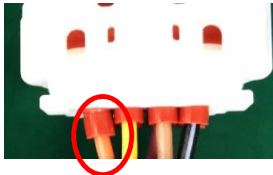
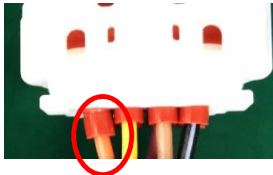
MASSPRO

Revision No.:

1

Page No.:


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|        |   |   |  |           |   |
|--------|---|---|--|-----------|---|
| PARTS: |   | 1. AVSSf 0.3 OR wire L=490±2mm<br>2. AVSSf 0.3 Y wire L=490±2mm   |  | JIG:      | 1. Insertion jig with switch cover  |
| NO.    | PROCESS NAME                                    | WORK PROCEDURE/ ILLUSTRATION  |  | TOOLS/PPE | QUALITY POINTERS  |
| 3      | P1<br>Wire Insertion to connector 6189-1142 (W) | <div><div></div><div></div><div></div><div></div><div></div><div>1. Hold the insertion jig using left hand. Get the <b>Yellow wire</b> then insert to terminal slot <b>1</b> using right hand.</div><div>2. Press the button using right thumb. Slot for <b>Orange wire</b> will be opened.</div><div>3. Get the <b>Orange wire</b> then insert to terminal slot <b>2</b> 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><p><b>Important reminders/Note/s:</b></p><p>1. Please hold the wire near terminal.</p><p>2. Make sure wires are properly inserted.</p><p>Conduct Pull-Push-Pull-Push after insertion.</p><p>Do not exert extra force.</p><p><b>Document references:</b></p><p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p><p>1. No loose insertion</p><p>2. No wrong insertion</p><p>3. One by one insertion</p><p>4. No deformed terminal</p><p>5. No wrong wire facing</p><div>Note: During insertion, hold the wire not rubber seal to prevent sagging.<br/></div></td> |  | n/a       | <p><b>Important reminders/Note/s:</b></p> <p>1. Please hold the wire near terminal.</p> <p>2. Make sure wires are properly inserted.</p> <p>Conduct Pull-Push-Pull-Push after insertion.</p> <p>Do not exert extra force.</p> <p><b>Document references:</b></p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>1. No loose insertion</p> <p>2. No wrong insertion</p> <p>3. One by one insertion</p> <p>4. No deformed terminal</p> <p>5. No wrong wire facing</p> <div>Note: During insertion, hold the wire not rubber seal to prevent sagging.<br/></div> |



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|---|--------------------------------|--|--|--|-------------------------------------|---------------------------------|---|-------------------------|---------------|---|-----------|
|  | <b>WORK INSTRUCTION</b>        |  |  |  | Effectivity Date:                   | <b>October 01, 2024</b>         |   |                         |               |   |           |
|   | <b>TAPING ASSEMBLY PROCESS</b> |  |  |  | Validity Date:                      | <b>n/a</b>                      |   |                         |               |   |           |
|   | Process Name/Title:            |  | Model code/Part number: <b>780B / 7R0103-7023B</b> |  | Customer: <b>TRMX</b>               | Car Model: <b>TOYOTA-TUNDRA</b> | Document No.:                               | <b>WI-ENG-PDE-1078A</b> |               |   |           |
|   | Purpose:                       |  | <input type="checkbox"/> PROTOTYPE                 |  | <input type="checkbox"/> PRE-LAUNCH |                                 | <input checked="" type="checkbox"/> MASSPRO |                         | Revision No.: | 1 | Page No.: |

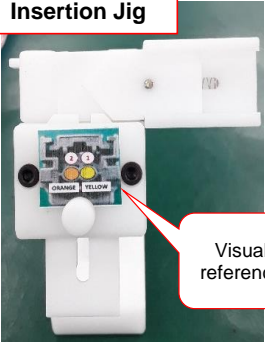
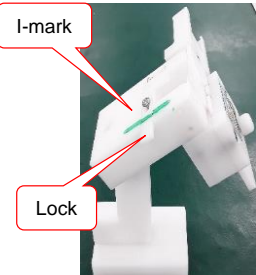
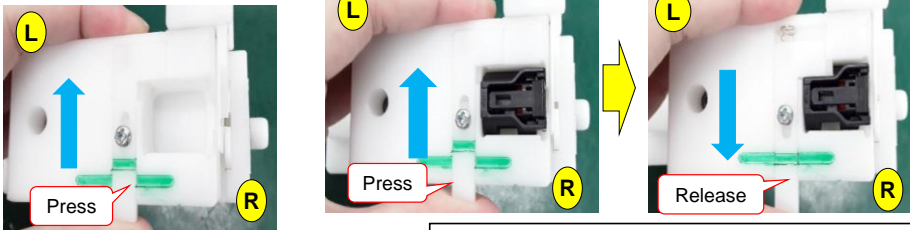
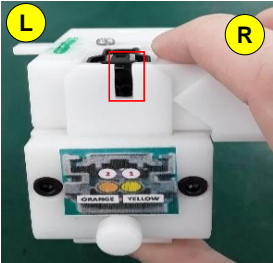




  

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|---------------|---|--|--|--|------------------|---|
| <b>PARTS:</b> | 1. Assy parts<br>2. Black Corrugated tube (no slit) $\phi 7$ L=208 $\pm$ 3mm<br>3. Black SV tube (Vinyl) $\phi 5$ L=233 $\pm$ 3mm |  |  |  | JIG:             | n/a   |
| <b>NO.</b>    | <b>PROCESS NAME</b>   | <b>WORK PROCEDURE/ ILLUSTRATION</b>  |  |  | <b>TOOLS/PPE</b> | <b>QUALITY POINTERS</b>                             |
| 4             | Wire insertion to Black Corrugated tube (no slit) $\phi 7$ L=208 $\pm$ 3mm  | <div>  </div> <div>           1. Get the corrugated tube <b><math>\phi 7</math> L=208<math>\pm</math>3mm</b> using right hand then insert the <b>Y-OR wire</b> using left hand.         </div> |  |  | n/a              | 1. No wrong use of parts<br>2. No deformed terminal |
| 5             | Wire insertion to Black SV tube (Vinyl) $\phi 5$ L=233 $\pm$ 3mm  | <div>  </div> <div>           1. Get the Vinyl tube <b><math>\phi 5</math> L=233<math>\pm</math>3mm</b> using right hand then insert the <b>Y-OR wire</b> using left hand.         </div>     |  |  | n/a              | 1. No wrong use of parts<br>2. No deformed terminal |

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|    | <b>WORK INSTRUCTION</b>                            |  |                       | Effectivity Date:               | <b>October 01, 2024</b>                |  |  |
|   | <b>TAPING ASSEMBLY PROCESS</b>                     |  |                       | Validity Date:                  | n/a                                    |  |  |
|   | Process Name/Title:                                |  |                       | Document No.:                   | WI-ENG-PDE-1078A                       |  |  |
|   | Model code/Part number: <b>780B / 7R0103-7023B</b> |  | Customer: <b>TRMX</b> | Car Model: <b>TOYOTA-TUNDRA</b> | Revision No.: 1    Page No.:    5 of 8 |  |  |
| Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO |  |  |                       |                                 |  |  |  |

|        |  |  |  |           |  |  |
|--------|--|--|--|-----------|--|--|
| PARTS: |  | 1. Connector 6189-1161 (B)   |  | JIG:      | 1. Insertion jig   |  |
| NO.    | PROCESS NAME   | WORK PROCEDURE/ ILLUSTRATION   |  | TOOLS/PPE | QUALITY POINTERS   |  |
| 6      | P1<br>Connector setting to Insertion jig 6189-1161 (B) | <div><div>Insertion Jig</div><div></div><div></div><div>Visual reference</div><div>Connector Orientation</div><div></div><div>Press</div><div>Release</div><div></div><div>1. Press the insertion jig lock using left hand.</div><div>2. Get the connector 6189-1161 (B) using right hand and insert to insertion jig. Release the lock after insertion.</div><div>3. Push the guide using right hand. The slot for <b>Y wire</b> will be opened.</div></div> <td>n/a</td> <td colspan="2"><div>CONNECTOR ORIENTATION ILLUSTRATION</div><div></div><div></div><div>1. Use provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div><div><b>Important reminders/Note/s:</b></div><div>1. Follow the connector orientation</div></td> |  | n/a       | <div>CONNECTOR ORIENTATION ILLUSTRATION</div> <div></div> <div></div> <div>1. Use provided jig per model</div> <div>2. No wrong usage of parts</div> <div>3. No wrong orientation of connector</div> <div>4. No damaged connector</div> <div><b>Important reminders/Note/s:</b></div> <div>1. Follow the connector orientation</div> |  |

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**October 01, 2024**

Model code/Part number:

**780B / 7R0103-7023B**

Customer:

**TRMX**

Car Model:

**TOYOTA-TUNDRA**

Document No.:

**WI-ENG-PDE-1078A**

Purpose:



PROTOTYPE



PRE-LAUNCH




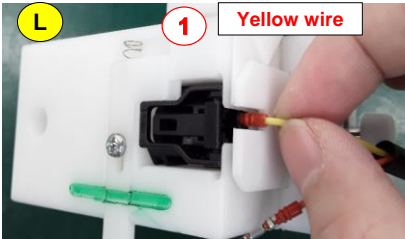
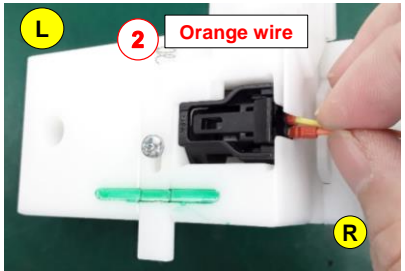
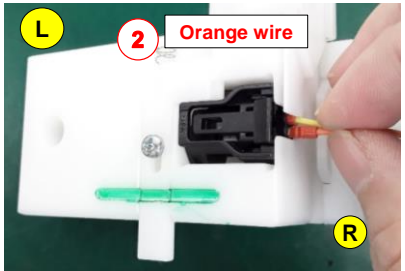
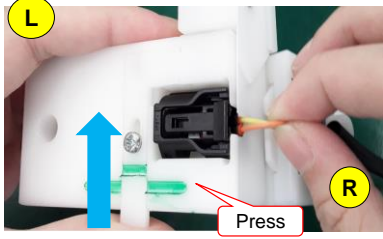
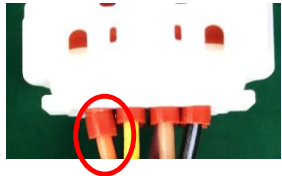
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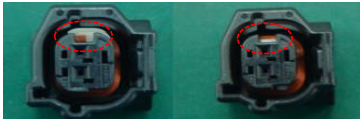




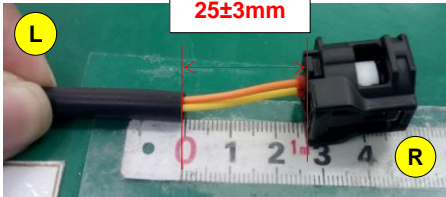
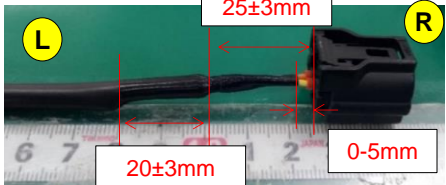
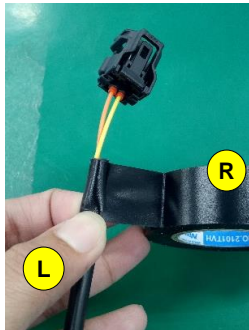

|               |  |   |                  |  |
|---------------|--|---|------------------|--|
| <b>PARTS:</b> |  | 1. Assy parts   | JIG:             | 1. Insertion jig   |
| <b>NO.</b>    | <b>PROCESS NAME</b>                                | <b>WORK PROCEDURE/ ILLUSTRATION</b>   | <b>TOOLS/PPE</b> | <b>QUALITY POINTERS</b>  |
| 7             | P1<br>Wire insertion to connector<br>6189-1161 (B) | <div><p>Wire facing</p></div> <div><p>1. Hold the insertion jig using left hand. Get the <b>Yellow wire</b> then insert to terminal slot <b>1</b> using right hand.</p></div> <div><p>2. Press the button using right thumb. Slot for <b>Orange wire</b> will be opened.</p></div> <div><p>3. Get the <b>Orange wire</b> then insert to terminal slot <b>2</b> 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> | n/a              | <p><b>Important reminders/Note/s:</b></p> <p>1. Please hold the wire near terminal.<br/>2. Make sure wires are properly inserted.<br/>Conduct Pull-Push-Pull-Push after insertion.<br/>Do not exert extra force.</p> <p><b>Document references:</b></p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>1. No loose insertion<br/>2. No wrong insertion<br/>3. One by one insertion<br/>4. No deformed terminal<br/>5. No wrong wire facing</p> <p>Note: During insertion, hold the wire not rubber seal to prevent sagging.</p>  |

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|  | WORK INSTRUCTION  |  |                | Effectivity Date:        | October 01, 2024 |                  |        |
|   | Process Name/Title: TAPING ASSEMBLY PROCESS   |  |                | Validity Date:           | n/a              |                  |        |
|   | Model code/Part number: 780B / 7R0103-7023B   |  | Customer: TRMX | Car Model: TOYOTA-TUNDRA | Document No.:    | WI-ENG-PDE-1078A |        |
|   | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO |  |                | Revision No.:            | 1                | Page No.:        | 7 of 8 |

|        |  |  |  |   |  |
|--------|--|--|--|---|--|
| PARTS: | 1. Assy parts<br>2. Black tape                       |  |  | JIG:  | n/a  |
| NO.    | PROCESS NAME   | WORK PROCEDURE/ ILLUSTRATION   |  | TOOLS/PPE   | QUALITY POINTERS   |
| 8      | Connector lock                                       | <div></div> <div><br/>Before Pressing    After Pressing</div> <div><br/>Unlock Condition</div> <div><br/>Half lock Condition</div> <div><br/>Full lock Condition</div> <div>Put the connector into locking jig using right hand then press <b>2x</b>. Check the connector lock if properly lock.</div> |  | <div>LOCKING JIG</div>       | <b>Important reminders/Note/s:</b><br><b>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b><br><br>1. Use the provided locking jig per model<br>2. No unlock/half-lock connector<br>3. No damaged connector   |
| 9      | P1<br><br>Taping 1 Vinyl tube to wire near connector | <div><br/>25±3mm</div> <div>1. Hold the SV tube (Vinyl) using left hand. Measure the end of Sv tube (Vinyl) up to the connector 25±3mm using right hand.</div> <div><br/>25±3mm<br/>20±3mm<br/>0-5mm</div> <div><br/>2. Hold the Vinyl tube using left hand. Get the Black tape using right hand and start taping using both hands.</div> <div>3. After taping, check the measurement and taping condition.</div>   |  | <div>MEASURING TAPE</div>  | <b>Important reminders and Note/s:</b><br><b>1. Please use calibrated/verified measuring tape when getting the measurement.</b><br><br><b>Document reference/s:</b><br><b>1. Refer to WI-PRO-ASY-001 for taping procedure.</b><br><br>1. No flip-out tape<br>2. No peel-off tape<br>3. No loose tape<br>4. No missing tape<br>5. No wrong use of tape<br>6. No wrong dimension |

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

October 01, 2024

Model code/Part number:

**780B / 7R0103-7023B**

Customer:

**TRMX**

Car Model:

**TOYOTA-TUNDRA**

Document No.:

**WI-ENG-PDE-1078A**

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P1****7R0103-7023B****1 2 No WRONG INSERT****4 No TERMINAL BACKING OUT****3 No UNLOCKED/ HALF-LOCKED CONNECTOR****5 No MISSING PARTS**

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