

	<b>WORK INSTRUCTION</b>				Effectivity Date:		September 19, 2024		
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a		
	Process Name/Title:		Model code/Part number: <b>920B / 7R0122-7022</b>		Customer: <b>TRMX</b>		Car Model: <b>TOYOTA-TACOMA</b>		
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.:		WI-ENG-PDE-721A		
				Revision No.:		2		Page No.:	1 of 10

<b>PARTS:</b>	1. Assy parts: AVSSf 0.3 wires Y L=384±2mm; AVSSf 0.3 wires OR L=384±2mm; Connector 7188-0996 (W); Black twisted tube Ø5 L=182±4mm; Black SV tube (Vinyl) Ø7 L= 314±3mm; Black tape				<b>JIG:</b>	1. Insertion jig with controller 2. Insertion jig with switch cover 3. locking jig				
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>				<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>			
1	P1	<div style="text-align: center;">Table Lay-out</div>				<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> <b>Housekeeping</b>            1. Maintain and always practice 5's.            2. Personal things on the workplace is prohibited. Keep it in your locker.         </div> <div style="border: 1px solid red; padding: 5px;"> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>		<b>Document reference/s:</b> 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to WI-ENG-PDE-720 for 7R0122-7021A Offline Assembly Process  1. No missing parts/tools 2. No excess parts/tools		


Revision History								Prepared by		Reviewed by		Approved by		Noted by	
09/19/24	2	Improved Visual inspection/Quality checkpoint.	D.Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a					
09/06/23	1	Change purpose from pre-launch to mass pro.	M. Manalac	J. Lotere	C. Villanueva	A. Arañes									
09/01/23	0	Initial issue.	M. Manalac	J. Lotere	C. Villanueva	A. Arañes									
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:		September 01, 2023						

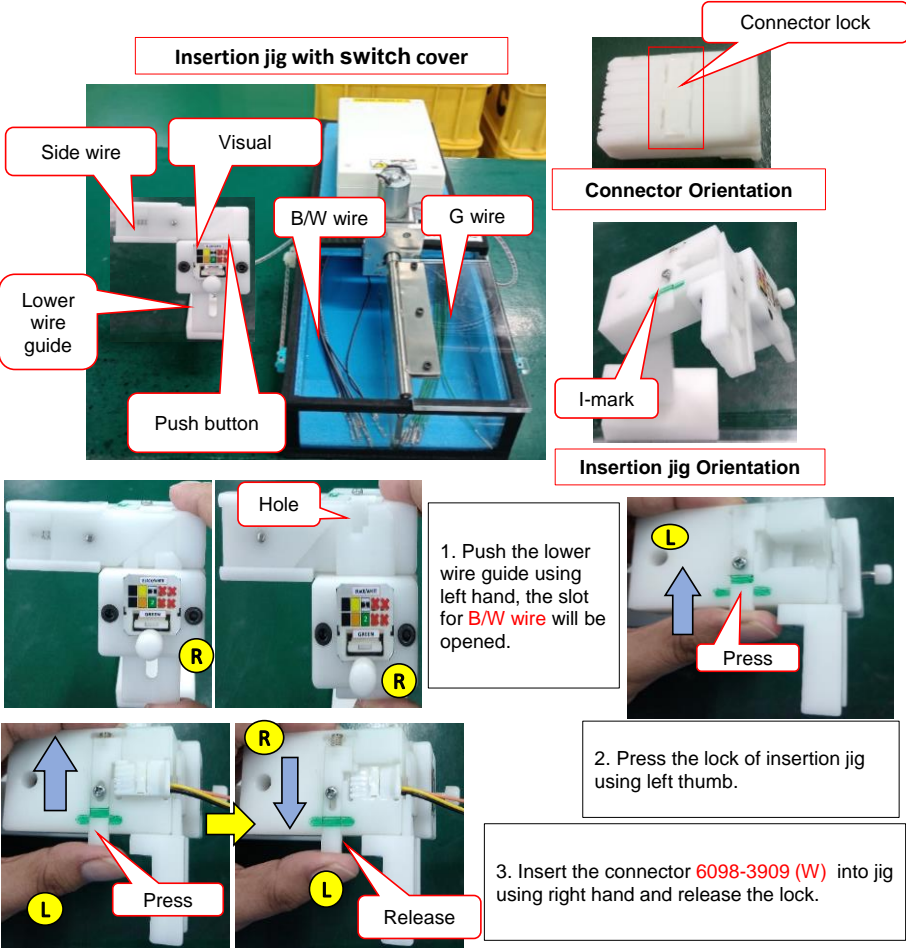
  

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	Model code/Part number: <b>920B / 7R0122-7022</b>		Customer: <b>TRMX</b>	Car Model: <b>TOYOTA-TACOMA</b>	Document No.:	<b>WI-ENG-PDE-721A</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	<b>2</b>	Page No.:	<b>2 of 10</b>


<b>PARTS:</b>		1. Connector 6098-3909 (W)		JIG:	1. Insertion jig with switch cover	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
2	P1 Connector setting to insertion jig 6098-3909 (W)	<div><p>1. Push the lower wire guide using left hand, the slot for B/W wire will be opened.</p><p>2. Press the lock of insertion jig using left thumb.</p><p>3. Insert the connector 6098-3909 (W) into jig using right hand and release the lock.</p></div>	n/a	<p><b>Important reminders/Note/s:</b></p> <p>1. Follow the connector orientation</p> <p>2. Cannot insert the inverted connector.</p> <p>1. Use provided jig per model</p> <p>2. No wrong usage of parts</p> <p>3. No wrong orientation of connector</p> <p>4. No damaged connector</p>		


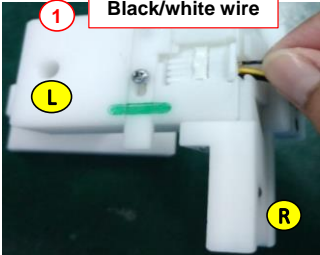
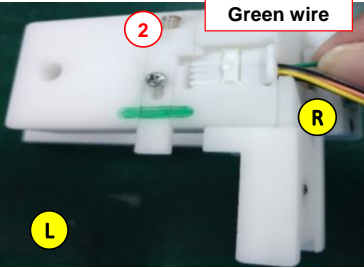
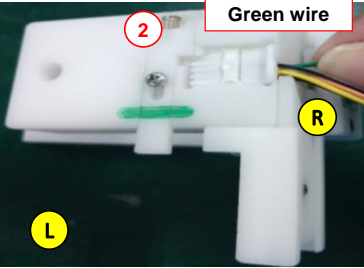
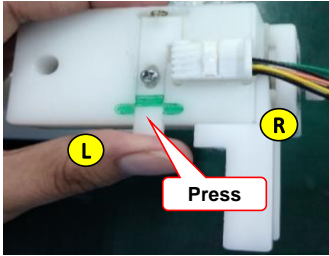
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	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 920B / 7R0122-7022		Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.: WI-ENG-PDE-721A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	2	Page No.:	3 of 10


PARTS:		1. AVSSf 0.3 wires Y L=384±2mm 2. AVSSf 0.3 wires OR L=384±2mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1  Wire insertion to Connector 6098-3909 (W)	<div><p>Terminal facing</p></div> <div><p>1. Get the <b>Black/white wire</b> using right hand then insert to terminal <b>slot 1</b> using right hand.</p></div> <div><p>2. Press the button using left hand, the slot for <b>Green wire</b> will be opened.</p></div> <div><p>3. Get the <b>Green wire</b> using right hand then insert to terminal <b>slot 2</b> using right hand.</p></div> <div><p>4. After insertion, press the lock guide 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. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. 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 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p>

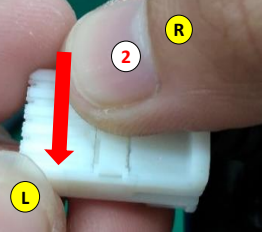
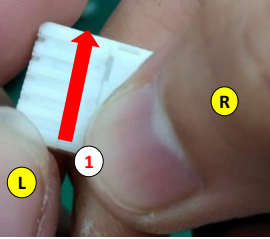

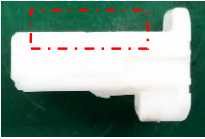
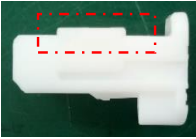

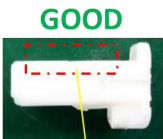


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	Model code/Part number: <b>920B / 7R0122-7022</b>		Customer: <b>TRMX</b>	Car Model: <b>TOYOTA-TACOMA</b>	Document No.: <b>WI-ENG-PDE-721A</b>		
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<b>PARTS:</b>	1. Assy parts 2. Black SV tube (Viny) Ø7 L=314±3mm			JIG:	1. Locking jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
4	P1 Connector lock	<div></div> <div>1. Put the connector into locking jig using right hand then press <b>2x</b> using both hands. Touch the connector lock to confirm if properly locked.</div> <div>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</div> <div><div>CONNECTOR LOCK CONDITION</div><div></div><div></div></div>		<div>LOCKING JIG</div>	<div><b>Important reminders/Note/s:</b> 1. <b>MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</b></div> <div><b>Document reference/s:</b> 1. Refer to WI-PRO-KIT-001 Proper locking and checking of connector lock</div> <div>1. Use the provided locking jig per model 2. No unlock/half-locked connector</div>
5	Wire insertion to Black SV tube (Vinyl) Ø7 L=314±3mm	<div></div> <div>1. Get the <b>Black SV tube (Viny) Ø7 L=314±3mm</b> using right hand then insert the <b>all wires</b> using left hand.</div>		n/a	1. No wrong use of parts 2. No deformed terminal

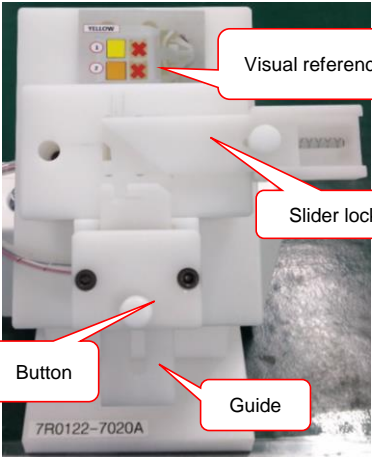
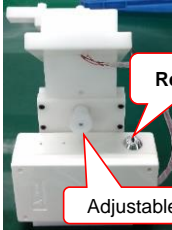
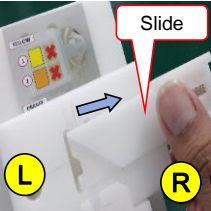
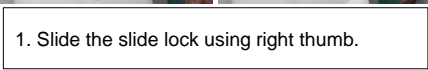

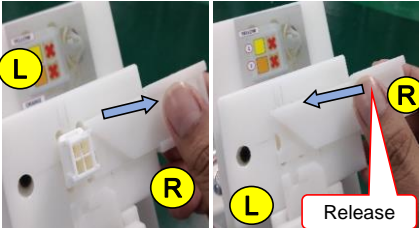
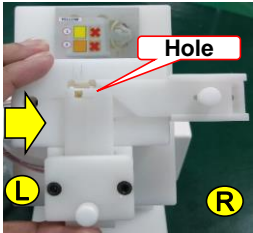
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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	2	Page No.:	5 of 10

<b>PARTS:</b>	1. Connector 7188-0996 (W)			JIG:	1. Insertion jig with controller			
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
6	P1  Connector setting to insertion jig 7188-0996 (W)	<div><div>Insertion jig</div><div>Insertion jig (Back view)</div><div>Insertion jig Orientation</div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div>1. Slide the slide lock using right thumb.</div><div>2. Insert the connector 7188-0996 (W) into jig using left hand and release the side lock.</div><div>3. Push the guide using left hand. The slot for Yellow wire will be opened.</div></div> <td>n/a</td> <td colspan="3"><b>Important reminders/Note/s:</b> <i>1. Cannot insert the inverted connector.</i>  1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</td>			n/a	<b>Important reminders/Note/s:</b> <i>1. Cannot insert the inverted connector.</i>  1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector		


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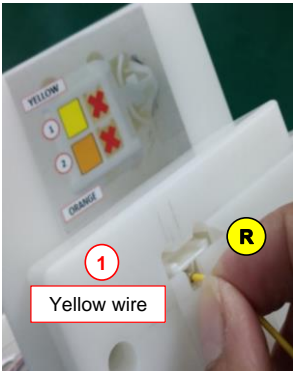
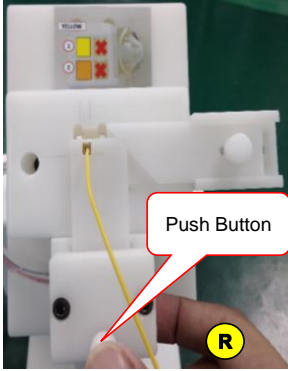
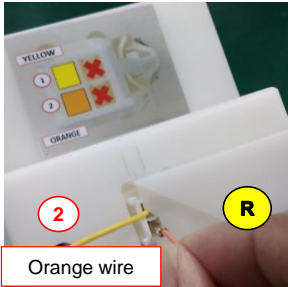
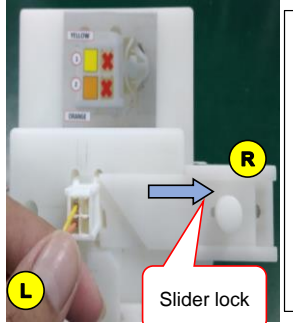
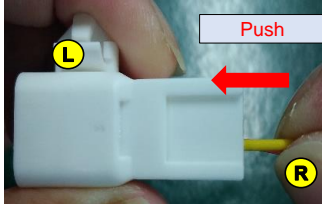
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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	2	Page No.:	6 of 10

<b>PARTS:</b>	1. Assy parts			JIG:	1. Insertion jig with controller			
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
7	P1	<div><div>Terminal facing</div><div>1. Get the <b>Yellow wire</b> then insert to terminal slot <b>1</b> using right hand. Conduct <b>Pull-Push-Pull-Push</b> after insertion.</div><div>2. Press the button using left hand. The 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. Conduct <b>Pull-Push-Pull-Push</b>. After insertion, press the button using left hand. <b>GO</b> sound will be heard.</div><div>4. Slide the lock using right thumb and then hold the wires and gently pull out the connector from jig using left hand.</div><div>5. After removing the connector from jig, conduct <b>Pushing (1x)</b> of <b>Y wire</b> using right hand to confirm that wire is fully inserted. Repeat the process for <b>OR wire</b>.</div></div>			n/a	<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><b>Important reminders/Note/s:</b> 1. <i>Please hold the wire near terminal.</i> 2. <i>Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.</i> <i>Do not exert extra force.</i> 3. <i>Insertion jig will alarm if will not conduct Pull-Push-Pull-Push method.</i> 4. <i>Insertion jig will alarm if Yellow wire will not insert before 5 seconds.</i> 5. <i>Conduct Pushing of wires after removing the connector from jig.</i> 6. <i>Pushing of wires will be done one by one of every inserted wires</i></div> <div><b>Document references:</b> 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div>		

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## WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

September 19, 2024

Model code/Part number:

920B / 7R0122-7022

Customer:

TRMX

Car Model: TOYOTA-TACOMA

Document No.:

WI-ENG-PDE-721A

Purpose:



PROTOTYPE



PRE-LAUNCH



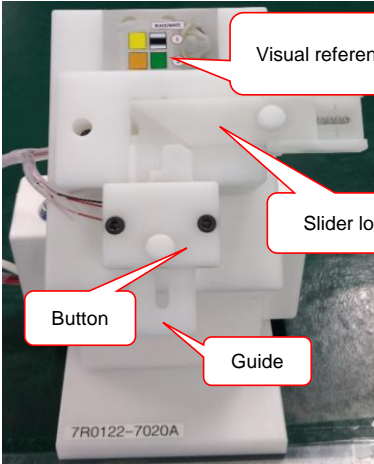
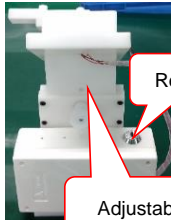


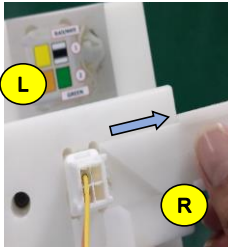
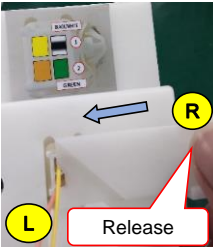
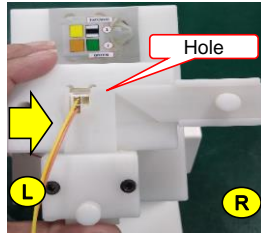
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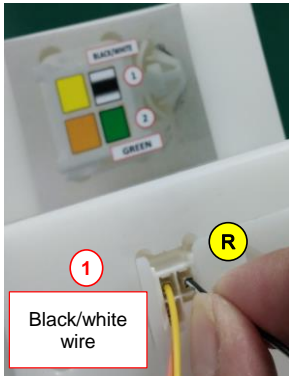
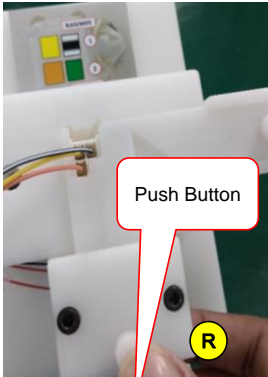
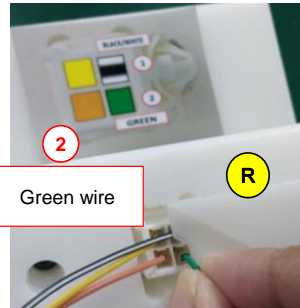
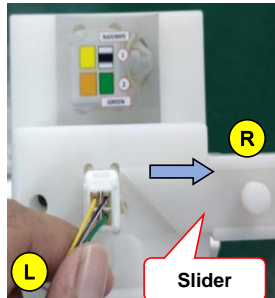
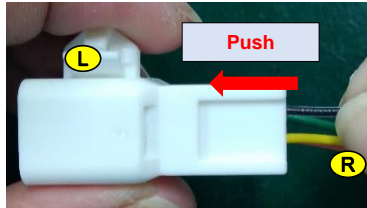
PARTS:	1. Assy parts		JIG:	1. Insertion jig with controller	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1	<div>Connector setting to insertion jig 7188-0996 (W) (Assy parts)</div> <div><div><div>Insertion jig</div><div></div></div><div><div>Insertion jig (Back view)</div><div></div></div><div><div>Insertion jig Orientation</div><div></div></div><div><div></div><div><div></div><div><div></div><div><div></div></div></div><div><div>1. Slide the slide lock using right thumb.</div><div>2. Insert the connector 7188-0996 (W) into jig using left hand and release the side lock.</div><div>3. Push the guide using left hand. The slot for B/W wire will be opened.</div></div></div><div><div>Connector Orientation</div></div></div><div>n/a</div><td><div><b>Important reminders/Note/s:</b> 1. Cannot insert the inverted connector.</div><div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</div></td></div>		<div><b>Important reminders/Note/s:</b> 1. Cannot insert the inverted connector.</div> <div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</div>	

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		Model code/Part number: 920B / 7R0122-7022		Customer: TRMX	Car Model: TOYOTA-TACOMA		Document No.:		WI-ENG-PDE-721A	
		Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		2	Page No.:	8 of 10

PARTS:	1. Assy parts				JIG:	1. Insertion jig with controller				
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS			
9	P1	<div><div></div><div><div>1. Get the <b>Black/white wire</b> then insert to terminal slot <b>1</b> using right hand. Conduct <b>Pull-Push-Pull-Push</b> after insertion.</div></div><div><div>2. Press the button using left hand. The slot for <b>Green wire</b> will be opened.</div></div><div><div>3. Get the <b>Green wire</b> then insert to terminal slot <b>2</b> using right hand. Conduct Pull-Push-Pull-Push. After insertion, press the button using left hand. <b>GO</b> sound will be heard.</div></div><div><div>4. Slide the lock using right thumb and then hold the wires and gently pull out the connector from jig using left hand.</div></div><div><div>5. After removing the connector from jig, conduct <b>Pushing (1x)</b> of <b>B/W wire</b> using right hand to confirm that wire is fully inserted. Repeat the process for <b>G wire</b>.</div></div></div> <div>n/a</div> <div><div>1. No loose insertion</div><div>2. No wrong insertion</div><div>3. One by one insertion</div><div>4. No deformed terminal</div><div>5. No wrong wire facing</div><div><b>Important reminders/Note/s:</b></div><div>1. Please hold the wire near terminal.</div><div>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.</div><div>Do not exert extra force.</div><div>3. Insertion jig will alarm if will not conduct Pull-Push-Pull-Push method.</div><div>4. Insertion jig will alarm if Yellow wire will not insert before 5 seconds.</div><div>5. Conduct Pushing of wires after removing the connector from jig.</div><div>6. Pushing of wires will be done one by one of every inserted wires</div><div><b>Document references:</b></div><div>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div><div>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div></div>								

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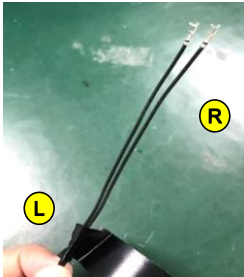
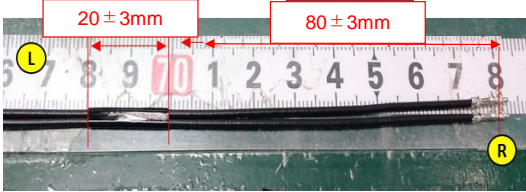


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	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>September 19, 2024</b>							
	<b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a							
	Process Name/Title:			Model code/Part number:	<b>920B / 7R0122-7022</b>	Customer:	<b>TRMX</b>	Car Model:	<b>TOYOTA-TACOMA</b>	Document No.:	<b>WI-ENG-PDE-721A</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:		2	Page No.:	9 of 10		

<b>PARTS:</b>		1. Assy parts 2. Black tape			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
10	P1 Spot taping 1	<div><p>1. Hold the wires using left hand and measure from wire up to terminal pointed tip <b>100±3mm</b>.</p></div> <div><p>2. Get the <b>Black tape</b> and start taping on the Black wires. Conduct <b>2 windings</b> of tape before cutting using both hands.</p></div> <div><p>3. After taping, check the measurement and taping condition.</p></div>			<div><b>MEASURING TAPE</b></div> 	<p><b>Important reminders/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></p> <p>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</p>
11	Wire insertion to Black twisted tube Ø5 L=182±4mm	<div><p>1. Get the Black twisted tube <b>Ø5 L=182±4mm</b> using right hand then insert the <b>B-B wire</b> using left hand.</p></div>			n/a	<p>1. No wrong use of parts 2. No deformed terminal</p>

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

September 19, 2024

Validity Date:

n/a

Model code/Part number:

920B / 7R0122-7022

Customer:

TRMX

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TOYOTA-TACOMA

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WI-ENG-PDE-721A

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

2

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### PARTS:

1. Assy parts

JIG:

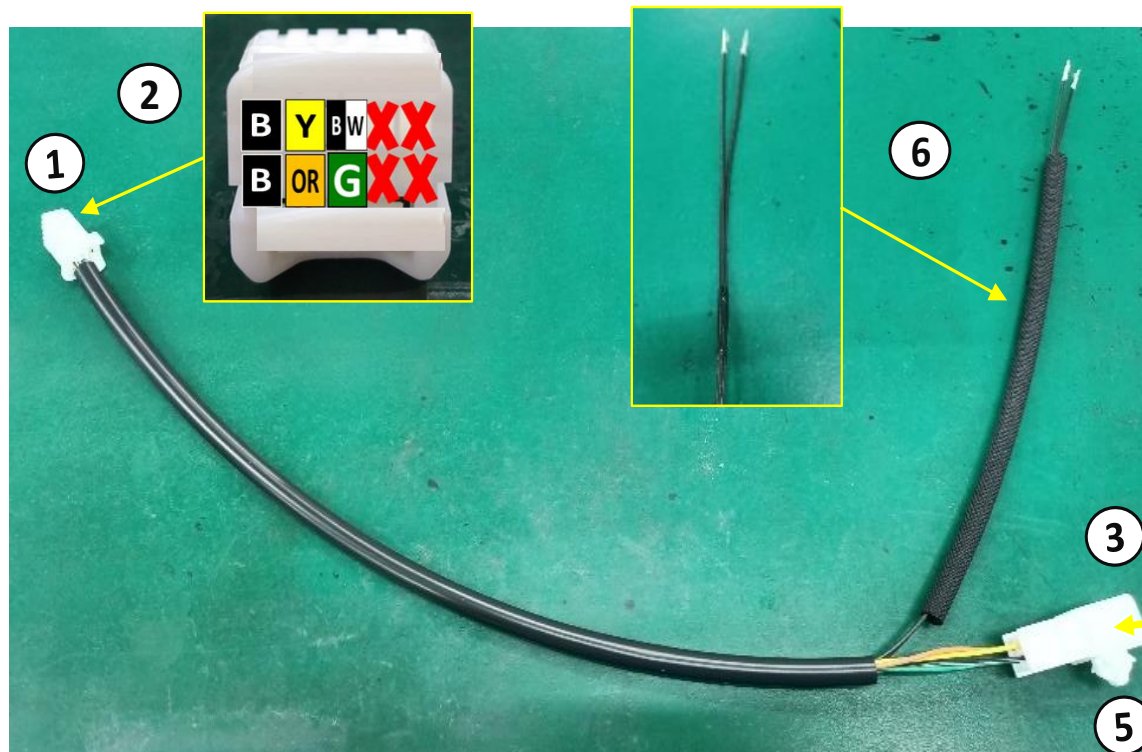
n/a



### VISUAL INSPECTION/ QUALITY CHECKPOINTS

# TAPING - P1

# 7R0122-7022



- ① No **Unlock/Halflocked Connector**
- ② ③ No **Wrong Insert**
- ④ No **Terminal Backing Out**
- ⑤ No **Deformed terminal**
- ⑥ No **Missing Spot tape (Black tape)**



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