


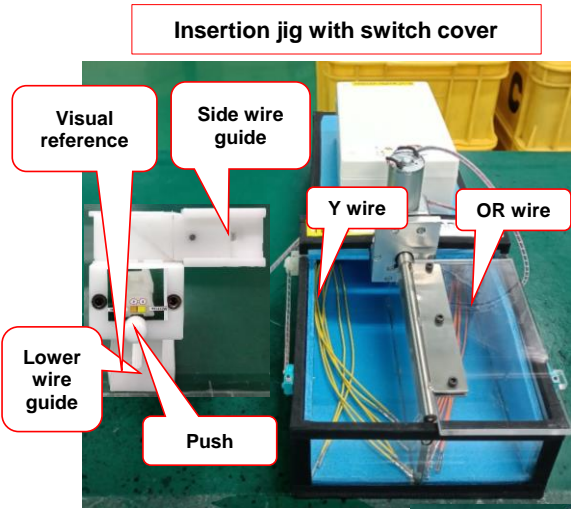
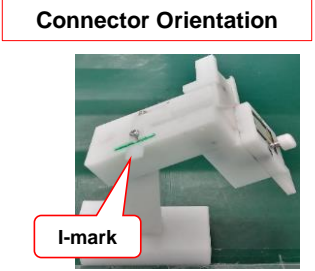
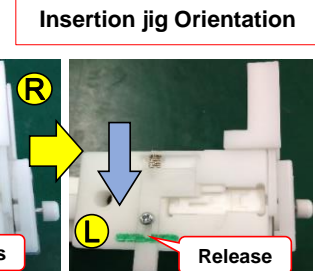
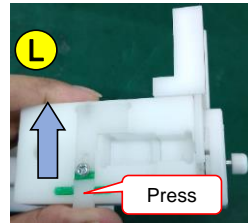
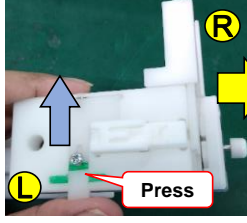
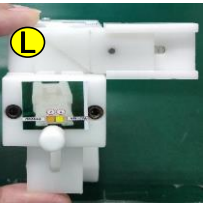
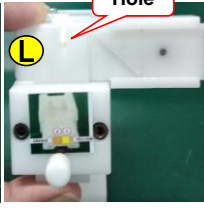
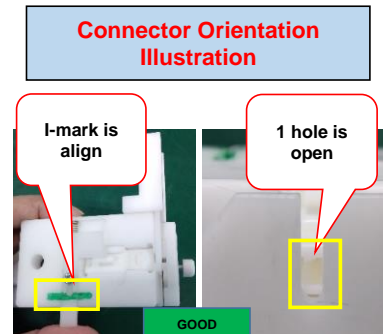
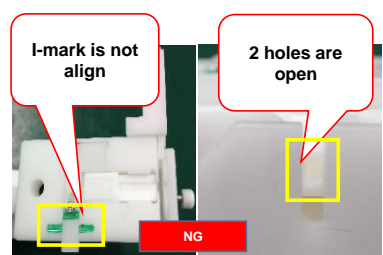
	WORK INSTRUCTION				Effectivity Date:		October 09, 2024		
	OFFLINE ASSEMBLY PROCESS				Validity Date:		n/a		
	Process Name/Title:		Model code/Part number: 920B / 7R0115-7021A		Customer: TRMX		Car Model: TOYOTA-TACOMA		
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.:		WI-ENG-PDE-675		
				Revision No.:		1		Page No.:	1 of 8

PARTS:	1. Connector 7189-0995 (W); AVSSf 0.3 wires Y-OR L=338±2mm; Black SV Tube (Vinyl) Ø7 L=267±3mm; Connector 6098-6653 (W); Clip clamp 82711-12B10 (W)			JIG:	1. Insertion jig with controller 2. Insertion jig with Switch cover 3. Locking jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
1	Offline Table lay-out	<div style="text-align: center;"> Table Lay-out </div>		<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> <u>Safety Instruction</u> 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;"> <u>Housekeeping</u> 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;"> <u>Alert level</u> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>		Important reminders/Note/s: 1. Cannot insert the inverted connector. 2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 1. No missing parts/tools 2. No excess parts/tools	

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
											n/a				
10/09/24	1	Inclusion of car model "TOYOTA-TACOMA" and Measurement. Improved Visual inspection/Quality checkpoints.	D.Castillo	C.Villanueva	A. Arañes	N/A									
05/19/23	0	Initial issue.	D.Castillo	J.Loterte	C.Villanueva	A. Arañes									
Eff. Date	Rev. No	Details of Change					Revised	Reviewed	Approved	Noted	Est. Date:	May 19, 2023			


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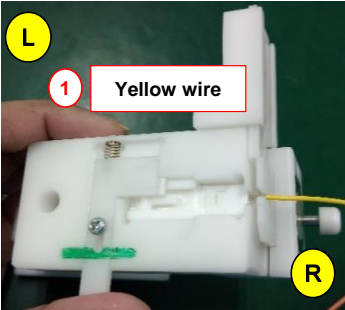
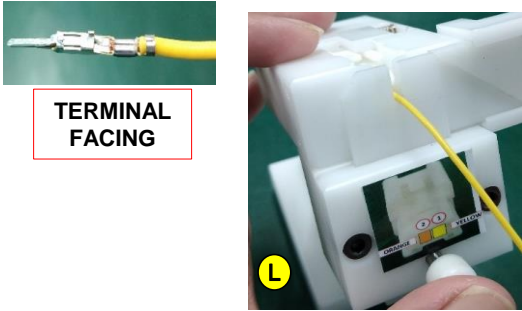
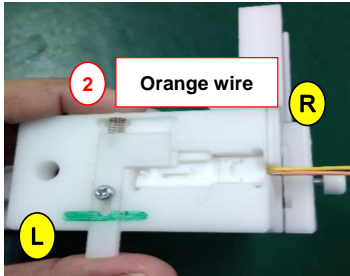
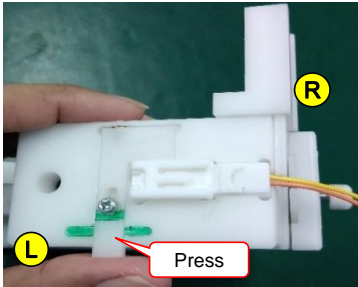
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	Model code/Part number:	920B / 7R0115-7021A	Customer:	TRMX	Car Model:	TOYOTA-TACOMA	
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	2 of 8

PARTS:		1. Connetcor 6098-6653 (W)		JIG:	1. Insertion njig with switch cover		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
2	Offline Connector setting to insertion jig 6098-6653 (W)	<div> <div>Insertion jig with switch cover</div>  <div>Connector Orientation</div>  <div>Insertion jig Orientation</div>  <div> <div>1. Press the lock of insertion jig using left thumb.</div>  <div>Press</div> <div>2. Insert the connector 6098-6653 (W) into jig using right hand and release the lock.</div>  <div>Press</div> <div>3. Push the lower wire guide using left hand, the slot for Yellow wire will be opened.</div>  <div>Release</div> <div>Hole</div>  </div> </div>			n/a	<div> <div>Connector Orientation Illustration</div>  <div>GOOD</div>  <div>NG</div> </div> <ol style="list-style-type: none"> 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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	Model code/Part number: 920B / 7R0115-7021A		Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:	WI-ENG-PDE-675	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	3 of 8


PARTS:	1. AVSSf 0.3 wires Y L=338±2mm 2. AVSSf 0.3 wires OR L=338±2mm			JIG:	1. Insertion njig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Offline Wire insertion to Connector 6098-6653 (W)	<div></div> <div>1. Get the Yellow wire using right hand then insert to terminal slot 1 using right hand.</div> <div></div> <div>2. Press the button using left hand, the slot for Orange wire will be opened.</div> <div></div> <div>3. Get the Orange wire using right hand then insert to terminal slot 2 using right hand.</div> <div></div> <div>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.</div>		n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p>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.</p> <p>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>


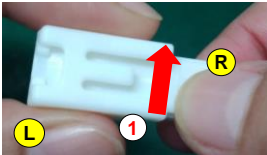
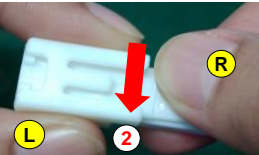
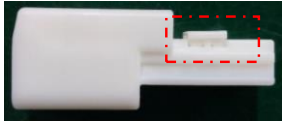
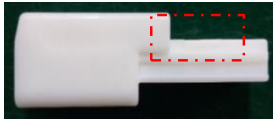

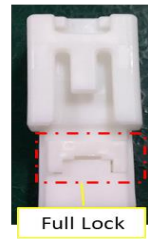
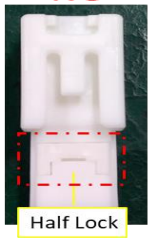
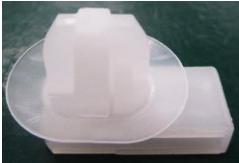
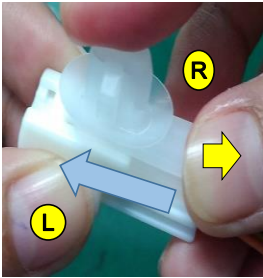
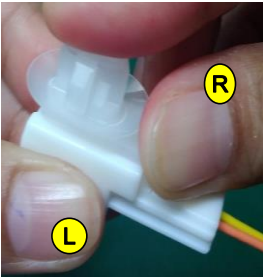
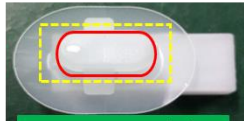
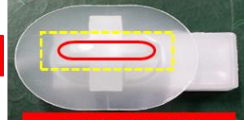
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	Process Name/Title: OFFLINE ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number:	920B / 7R0115-7021A	Customer:	TRMX	Car Model:	TOYOTA-TACOMA	
	Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Document No.:	WI-ENG-PDE-675	
				Revision No.:	1	Page No.:	4 of 8

PARTS: 1. Assy parts 2. Clamp 82711-12B10 (W)				JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	Connector lock	<div>    </div> <div> <p>1. Put the connector into locking jig using right hand then press 2x using both hands. Touch the connector lock to confirm if properly locked.</p> <p>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</p> </div> <div>   <div> <div>Before Pressing</div> <div>After Pressing</div> </div> </div>		<div> <div>LOCKING JIG</div>  </div>	<p>Important reminders/Note/s:</p> <p>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</p> <p>1. Use the provided locking jig per model 2. No unlock/half-locked connector</p> <div> <div> <div>GOOD</div>  <div>Full Lock</div> </div> <div> <div>NG</div>  <div>Half Lock</div> </div> </div>
5	Clamp Attachment 82711-12B10 (W)	<div>  <div> <div>CLAMP ORIENTATION</div> </div> </div> <div>   <div> <p>1. Hold the connector using left hand, get the clip type clamp 82711-12B10 (W) then insert the clamp using right hand.</p> <p>Note: Sound will be heard if properly inserted.</p> </div> </div>		n/a	<p>1. No wrong use of parts 2. No loose attachment</p> <div> <div> <div>CLIP CLAMP ILLUSTRATION</div> <div> <div>GOOD</div>  <div>82711-12B10 (W)</div> </div> <div> <div>NG</div>  <div>82711-1E360 (W)</div> </div> </div> </div>

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	5 of 8

PARTS:	1. Assy parts 2. Black SV Tube (Vinyl) Ø7 L=267±3mm 3. Connector 7189-0995 (W)			JIG:	1. Inertion jig with controller
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	Wire insertion to Black SV Tube (Vinyl) Ø7 L=267±3mm	 <div>1. Get the SV tube (Vinyl) Ø7 L=267±3mm using right hand then insert the Y-OR wire using left hand.</div>		n/a	1. No wrong use of parts 2. No deformed terminal
7	Offline Connector setting to insertion jig 7189-0995 (W)	<div><div>Insertion jig</div><div>Visual reference</div><div>Slider</div><div>Button</div><div>Guide</div><div>7R0115-7020A</div></div> <div><div>Insertion jig (Back view)</div><div>Reset</div><div>Adjustable</div></div> <div><div>Insertion jig Orientation</div><div>Slide</div><div>1. Slide the slide lock using right thumb.</div></div> <div><div>Connector Orientation</div><div>2. Insert the connector 7189-0995 (W) into jig using left hand and release the side lock.</div></div> <div><div>Release</div><div>3. Push the guide using left hand. The slot for Yellow wire will be opened.</div></div> <div><div>Hole</div></div>		n/a	Important reminders/Note/s: 1. Cannot insert the inverted connector. 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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Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Document No.:

WI-ENG-PDE-675

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PRE-LAUNCH




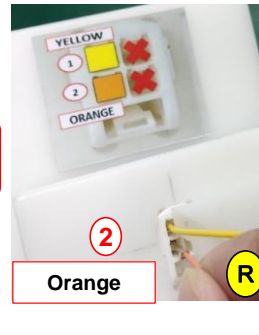
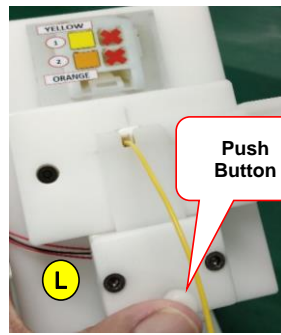
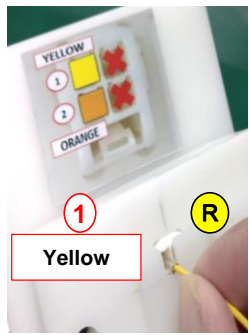
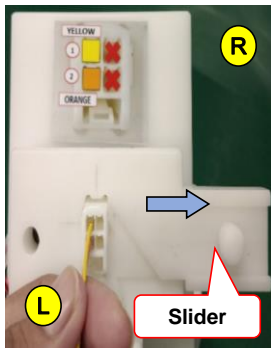
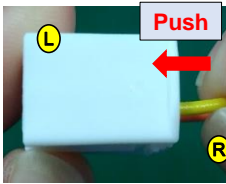
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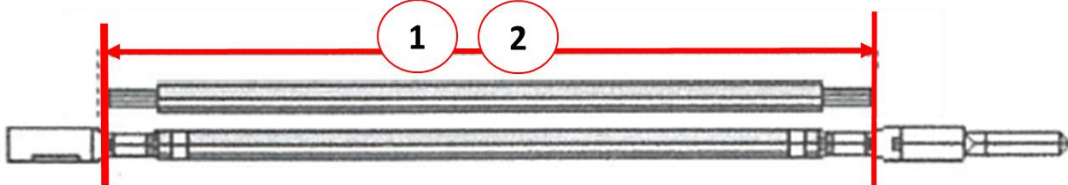
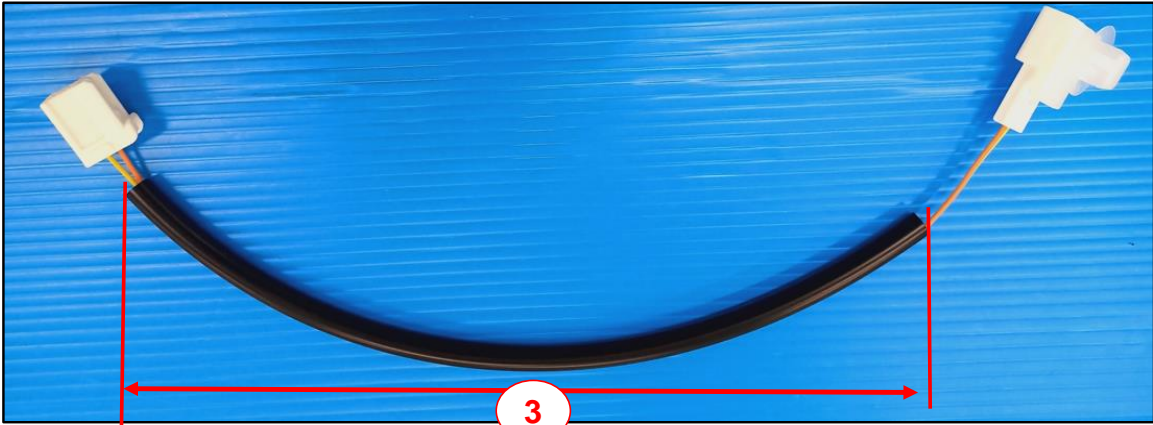

PARTS:	1. Assy parts			JIG:	1. Inertion jig with controller
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	Offline	Wire insertion to connector 7189-0995 (W)	<div><p>TERMINAL FACING</p><p>1. Get the Yellow wire then insert to terminal slot 1 using right hand. Conduct Pull-Push-Pull-Push after insertion.</p><p>2. Press the button using left hand. The slot for Orange wire will be opened.</p><p>3. Get the Orange wire then insert to terminal slot 2 using right hand. Conduct Pull-Push-Pull-Push. After insertion, press the button using left hand. GO sound will be heard.</p><p>4. Slide the lock using right thumb and then hold the wires and gently pull out the connector from jig using left hand.</p><p>5. After removing the connector from jig, conduct Pushing (1x) of Y wire using right hand to confirm that wire is fully inserted. Repeat the process for OR wire.</p></div>	n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p> <p>Important reminders/Note/s:</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>3. Insertion jig will alarm if will not conduct Pull-Push-Pull-Push method.</p> <p>4. Insertion jig will alarm if Yellow wire will not insert before 5 seconds.</p> <p>5. Conduct Pushing of wires after removing the connector from jig.</p> <p>6. Pushing of wires will be done one by one of every inserted wires</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p>

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	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			JIG:	n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
9	Offline Measurement	<p>Note:</p> <p>1. Measurement point: End of core wire to the end of core wire</p> <p>2. Terminal is reference only.</p>   <p>SV tube (Vinyl) Ø7 L=267 ±3</p>	<div>MEASURING TAPE</div> 	<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p>			

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Document No.:

WI-ENG-PDE-675

Purpose:



PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Assy parts

JIG:

n/a



VISUAL INSPECTION/ QUALITY CHECKPOINTS

OFFLINE INSERTION

7R0115-7021A



① No **Unlock/Half-locked Connector**

④ No **Deformed terminal**

⑥ No **Missing Clip clamp**

② ③ No **Wrong Insert**

⑤ No **Terminal Backing Out**

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