



## WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

January 21, 2025

Validity Date:

n/a

Model code/Part number:

920B / 7R0115-7021A

Customer:

TRMX

Car Model: TOYOTA-TACOMA

Document No.:

WI-ENG-PDE-655A

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

3

Page No.:

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## PARTS:

1. Assy parts; Black twist tube 2420F Ø5 L=189±4mm; AVSSf 0.3 wires B L=534±3mm; Black tape

JIG:

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

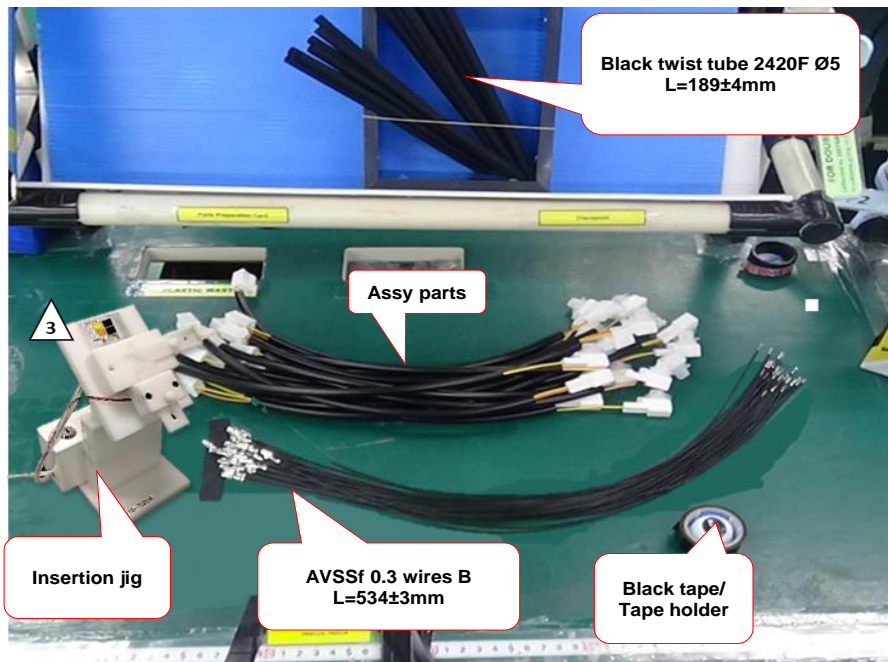
QUALITY POINTERS

1

P1

Table lay-out

Table Lay-out



## Safety Instruction

Be sure to wear prescribed 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



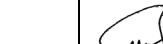
For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

## Important reminders/Note/s:

1. Refer to WI-ENG-PDE-675 for Offline assembly process
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

01/21/25	3	Inclusion of Insertion jig as countermeasure to QC claim (Not fully inserted).	D.Castillo	C.Villanueva	A. Arañes	N/A	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
10/09/24	2	Transfer Taping 2 to P2 due to process improvement. Inclusion of car model "TOYOTA-TACOMA". Improved Table lay-out and Visual inspection/Quality checkpoints.	D.Castillo	C.Villanueva	A. Arañes	N/A				
05/19/23	1	Change document from pre-launch to masspro. Inclusion of table lay-out. Transfer process to Offline assembly process.	D.Castillo	J.Loterte	C.Villanueva	A. Arañes				
03/21/23	0	Initial issue.	D.Castillo	J.Loterte	C.Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted				
Est. Date:							March 21, 2023			

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	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	3	Page No.: 2 of 6


PARTS:	1. Assy parts			JIG:	1. Insertion jig		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
2	P1 <div>Connector setting to insertion jig 7189-0995 (W) (Assy parts)</div>	<div><div>Insertion jig</div><div>Insertion jig (Back view)</div><div>Insertion jig Orientation</div><div>Visual reference</div><div>Reset</div><div>Adjustable</div><div>Slider</div><div>Button</div><div>Guide</div><div>Slide</div><div>Release</div><div>Hole</div><div>Connector Orientation</div><div>7R0115-7020A</div></div> <div><div>1. Slide the slide lock using right thumb.</div><div>2. Insert the connector 7189-0995 (W) into jig using left hand and release the side lock.</div><div>3. Push the guide using left hand. The slot for Black wire will be opened.</div></div>		n/a	<div>Important reminders/Note/s:</div> <div>1. Cannot insert the inverted connector.</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>		


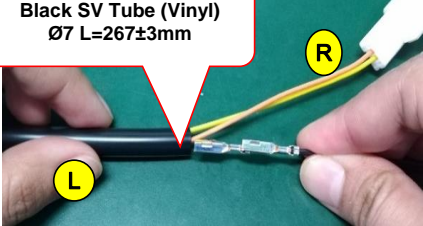
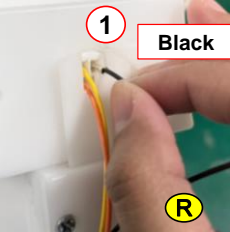
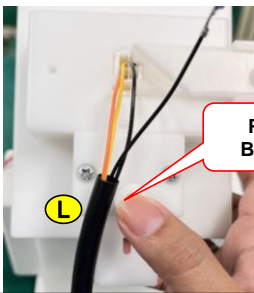
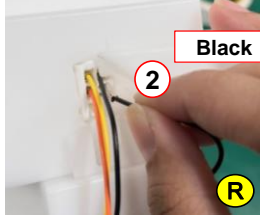
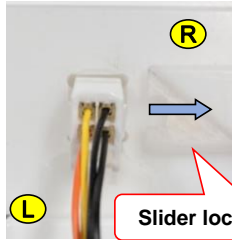
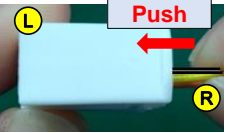
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PARTS:	1. Assy parts 2. AVSSf 0.3 wires B L=534±3mm [2pcs]			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	Wire insertion to assy parts	<div><div>Black SV Tube (Vinyl) Ø7 L=267±3mm</div><div>1. Hold the SV tube (Vinyl) Ø7 L=267±3mm using left hand and get 2 pcs of Black wire then insert using right hand.</div></div>		n/a	1. No wrong use of parts 2. No deformed terminal
4	Wire insertion to Connector 7189-0995 (W)	<div><div>3</div><div>P1</div><div><div>1</div><div>Black</div><div>1. Get the Black wire then insert to terminal slot 1 using right hand. Conduct Pull-Push-Pull-Push after insertion.</div></div><div><div>2</div><div>Push Button</div><div>2. Press the button using left hand. The slot for Black wire will be opened.</div></div><div><div>3</div><div>Black</div><div>3. Get the Black 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.</div></div><div><div>4</div><div>Slider lock</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</div><div>Push</div><div>5. After removing the connector from jig, conduct Pushing (1x) of B wire using right hand to confirm that wire is fully inserted. Repeat the process for B wire.</div></div></div>			

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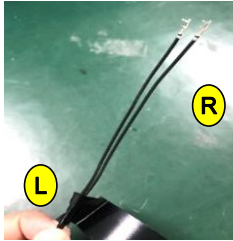
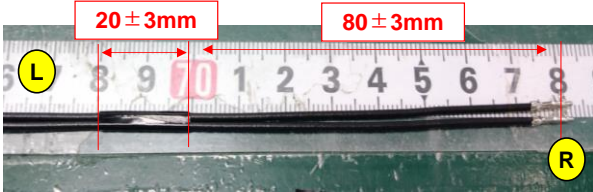

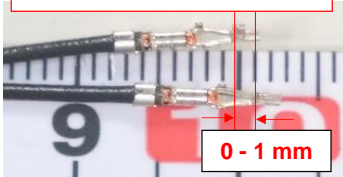

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<b>PARTS:</b>		1. Assy parts 2. Black twist tube 2420F Ø5 L=189±4mm 3. Black tape		JIG:	1. Insertion njig with switch cover
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
5	P1  Spot taping 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>2x 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>  <p><b>MEASURING TAPE</b></p> </div>	<div>  <p><b>Wire alignment tolerance</b></p> </div> <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> <p><b>Important reminders/Note/s:</b>  <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b> </p>
6	Wire insertion to Black twist tube 2420F Ø5 L=189±4mm	<div>  </div> <p>           1. Get the Black Twist tube 2420F <b>Ø5 L=189±4mm</b> using right hand then insert the <b>B-B wire</b> using left hand.         </p>		n/a	<p>           1. No wrong use of parts            2. No deformed terminal         </p>

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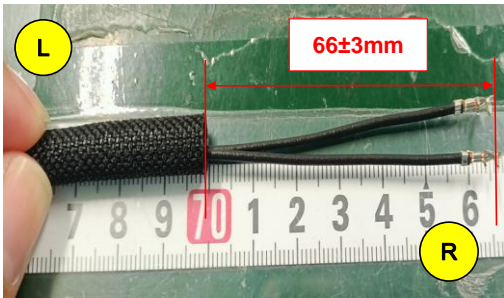
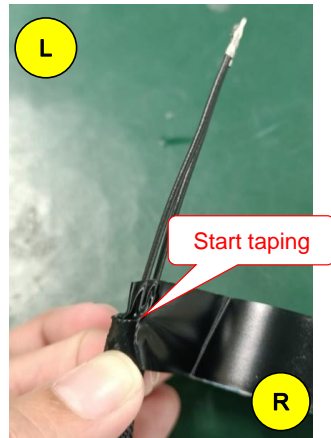
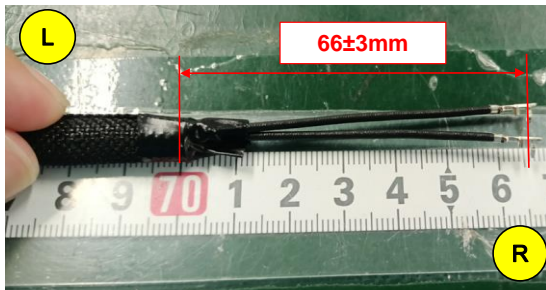

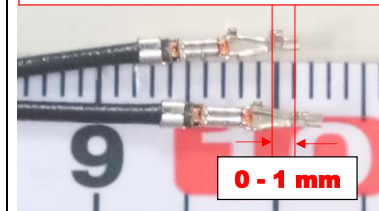
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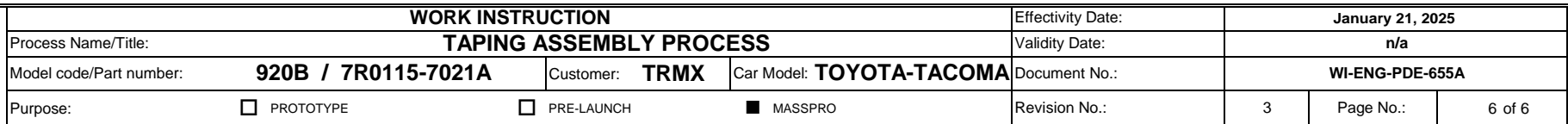
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PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1 Taping 2 Twisted tube to wire near terminal	<div><p>1. Measure from Black twist tube 2420F <b>66±3mm</b> up to terminal tip.</p></div> <div><p>2. Hold the assy parts using left hand. Get Black tape using right hand.</p></div> <div><p>3. After taping, Check the measurement taping condition and wire alignment.</p></div>		<div><b>MEASURING TAPE</b></div> 	<div><b>Important reminders/Note/s:</b></div> <div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension 7. No insufficient tape</div> <div><b>Wire alignment tolerance</b></div> 

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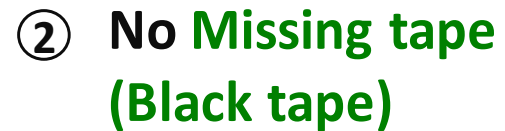


### 1. Assy parts

JIG:

	n/a
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**7R0115-7021A**



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