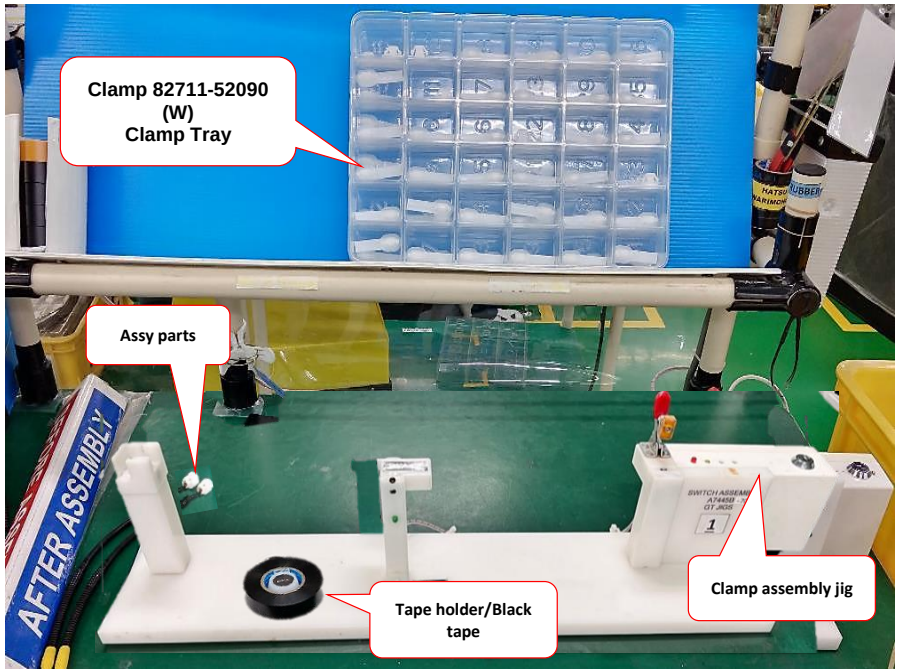
	WORK INSTRUCTION			Effectivity Date:	February 7, 2025	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 257B / A7445C1	Customer: TRQSS	Car Model: TOYOTA-TACOMA	Document No.:	WI-ENG-PDE-1180B	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.: 1 of 6

PARTS:	1. Assy parts; Clamp 82711-52090 (W); Black tape [1pcs.]	JIG:	1. Insertion jig with switch cover

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2		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.	1. No missing parts/tools 2. No excess parts/tools 3. No wrong positions of parts/tools

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
2/7/2025	0	Initial issue.	A.Buban	C. Villanueva	A. Arañes	n/a

Prepared by	Reviewed by	Approved by	Noted by
A.Buban	C. Villanueva	A. Arañes	N/A
Est. Date:	February 3,2025		

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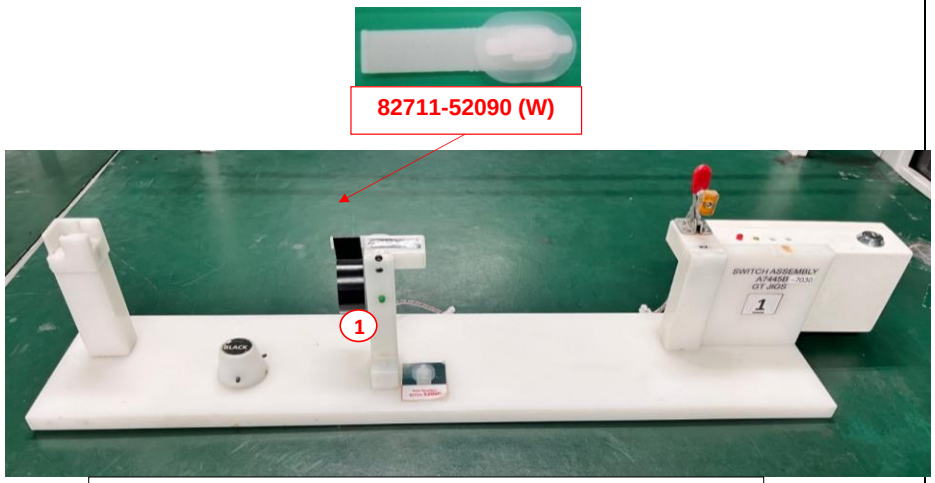
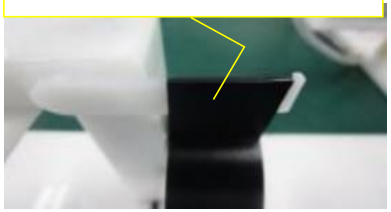
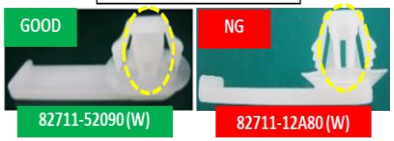
	Model code/Part number: 257B / A7445C1	Customer: TRQSS	Car Model: TOYOTA-TACOMA	Document No.:	WI-ENG-PDE-1180B	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.: 2 of 6

PARTS:	1. Clamp 82711-52090 (W) 2. Black tape	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P2	Clamp Setting	 1. Get **1pc**. of clamp **82711-52090 (W)** using both hands then set to location **1** using both hands. 2. Initially attach **Black tape** on clamp location **1** using both hands.		**STANDARD TAPING FOR CLAMP** One wind for uder clamp  ***Important reminders/Note/s:*** *1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.* 1. No wrong use of clamp 2. No damaged clamp 3. No missing clamp 4. No wrong use of tape 5. No missing tape CLAMP ILLUSTRATION 

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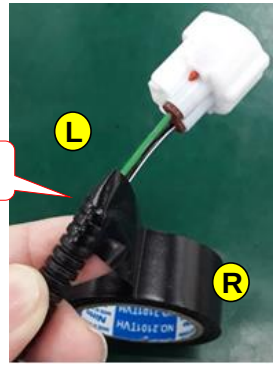
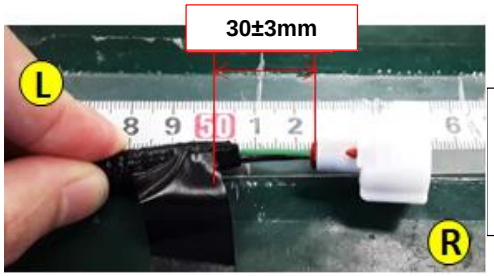
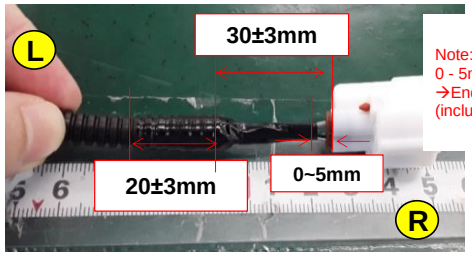
	Model code/Part number: 257B / A7445C1	Customer: TRQSS	Car Model: TOYOTA-TACOMA	Document No.:	WI-ENG-PDE-1180B	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.: 3 of 6

PARTS:	1. Assy parts 2. Black tape	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P2	Taping 3 Black corrugated tube to wire near connector	 1. Hold the corrugated tube using left hand. Get **Black tape** using right hand and start pre-taping using both hands.  2. Measure the corrugated tube up to connector **30±3mm** using left hand then proceed to taping using both hands.  Note: 0 - 5mm →End tape up to connector (includes rubber seal) 3. After taping, check the measurement and taping condition.	MEASURING TAPE 	***Important reminders and Note/s:*** ***1. Please use calibrated/verified measuring tape when getting the measurement.*** ***Document reference/s:*** ***1. Refer to WI-PRO-ASY-001A for taping procedure.*** 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

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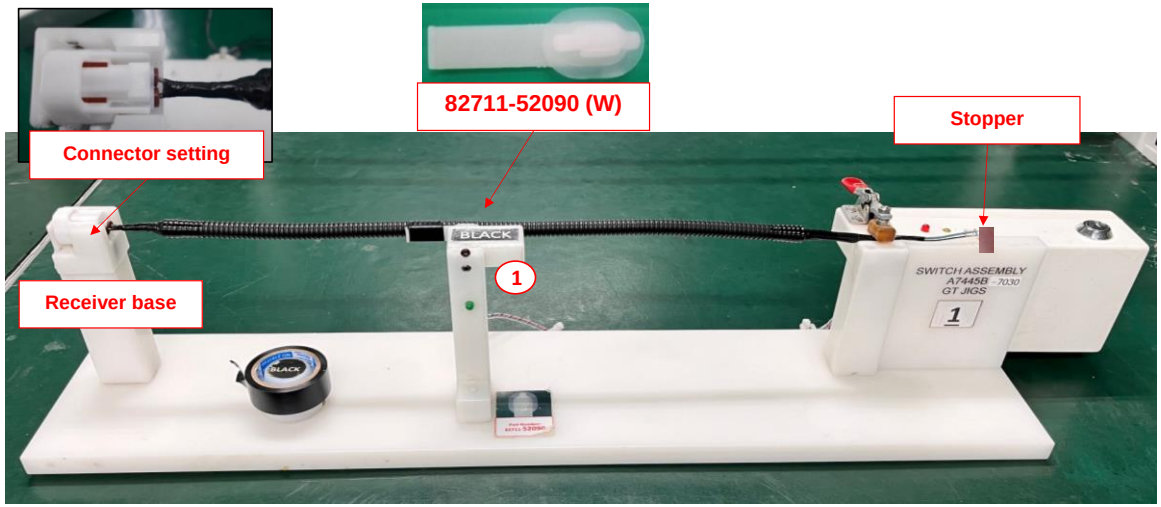
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.: 4 of 6

PARTS:	1. Assy parts	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P2	Clamp Assembly			***Important reminders/Note/s:*** *1. Make sure no gap between stopper and terminals.* *2. Make 2-3 windings for clamp taping* 1. No loose attachment of clamp 2 .No damage clamp 3. No missed tape 4. No missing parts 5. No wrong use of tape

1. Get the assy parts and set into jig. *(See above picture for the correct setting).* First, set the connector **6189-0451 (W)** to **Receiver base 1** and lock. Last, set the **G-B/W wires** together within the stopper then press by toggle clamp. Continue the process if sequence light in **location 1** was **ON.**

2. Check if **LED light** for **POWER ON, CLAMP ON** was **ON.** Check also if **clamp location 1** sequence light is **ON**. If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction then continue the process. Continue if the sequence light of location **1** was ON.

3. Hold the tape on clamp location **1** and start taping using both hands. Make **3 windings** then cut the tape. Press the **SW button** after taping. **GO** buzzer will be heard.

4. Conduct **POINT CHECKING** before removing of harness from jig.

5. After point checking. Remove the harness from toggle clamp up to connector receiver base.

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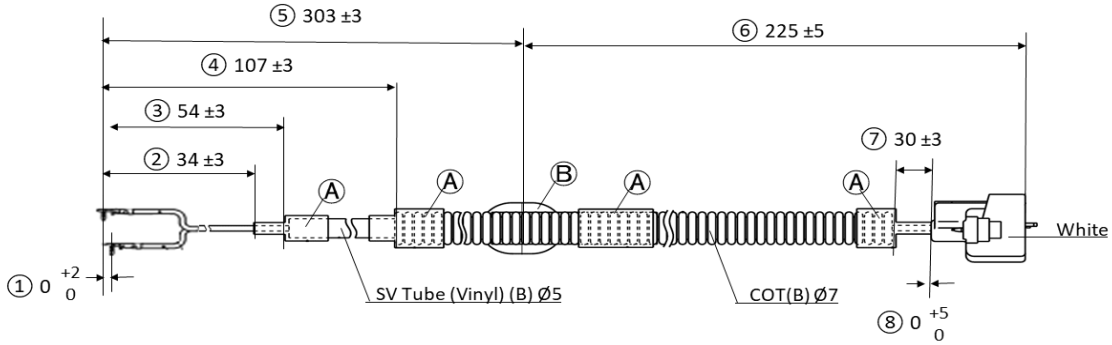
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	0	Page No.: 5 of 6

PARTS:	1. Assy parts	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P2	Measurement		MEASURING TAPE	1. No wrong dimension. ***Important reminders and note/s:*** *1. Please use calibrated/verified measuring tape when getting the measurement.* *2. For Hatsumono, Nakamono and Owarimono.* ***Document reference/s:*** *1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection*



NOTE:
Ⓐ - Taping (B)
Ⓑ - Clamp (W)
***Unit of measurement is in millimeter (mm)**

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PARTS:	1. Assy parts	JIG:	n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING - P2 A7445C1

1 No Unlocked/ Half-locked connector

2 No Wrong Insert

3 No Terminal Backing Out

4 5 6 No Missing Tape

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