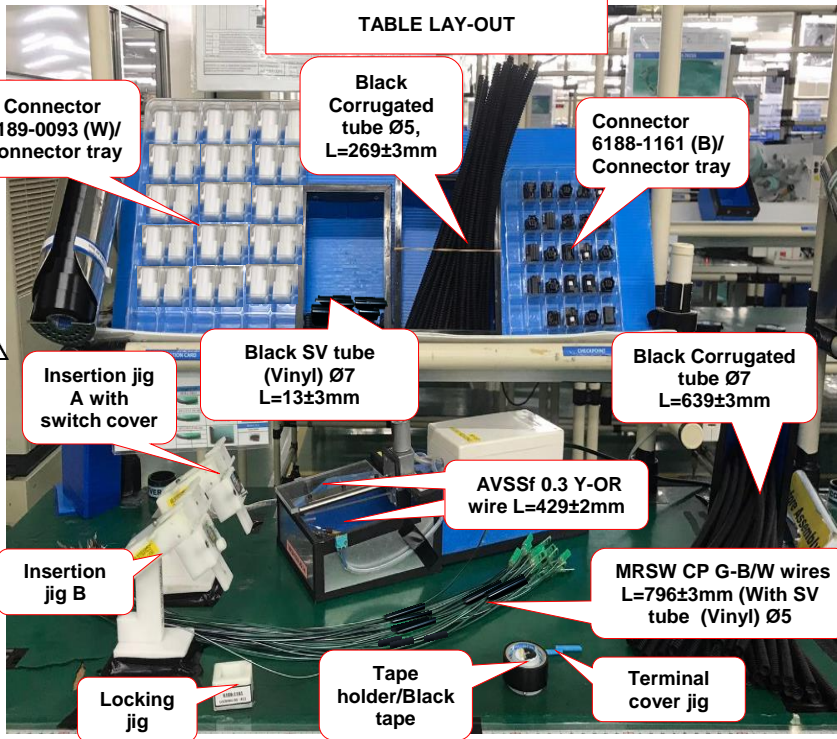
	WORK INSTRUCTION				Effectivity Date:		September 20, 2023	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 420B/440B / A7448C		Customer: TRQSS	Car Model: TOYOTA-LAND CRUISER	Document No.:		WI-ENG-PDE-735A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		1	Page No.: 1 of 10

PARTS:		1. Connector 6188-0093 (W); AVSSf 0.3 Y-OR wire L=429±2mm; Black SV tube (Vinyl) Ø7 L=13±3mm; Black Corrugated tube Ø5, L=269±3mm; Connector 6188-1161 (B); MRSW CP G-B/W wires L=796±3mm (With SV tube (Vinyl) Ø5, L=73±3mm; Black Corrugated tube Ø7, L=639±3mm; Black tape		JIG:		1. Insertion jig with switch cover 2. Insertion jig 3. Locking jig	
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
1	P1 Table lay-out			<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		1. No missing parts/tools 2. No excess parts/tools Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance	

Revision History								Prepared by		Reviewed by		Approved by		Noted by	
09/20/2023 1 Change from Pre-launch to Masspro. Update Work procedure/Illustration (page 1 to 4); Additional table lay-out								M. Ariola		J. Loterte		C. Villanueva		A. Arañes	
09/11/2023 0 Initial Issue.								M. Ariola		J. Loterte		C. Villanueva		A. Arañes	
Eff. Date		Rev. No		Details of Change				Revised		Reviewed		Approved		Noted	
								Est. Date:		September 11, 2023					

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PARTS:		1. Connector 6188-0093 (W)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1 Connector setting to insertion jig 6189-0093 (W)	<div><div>Insertion jig with switch cover</div><div><div>Yellow wire</div><div>Orange wire</div><div>Visual reference</div></div><div><div>I-mark</div><div>Lock</div><div>INSERTION JIG ORIENTATION</div></div><div><div>CONNECTOR ORIENTATION</div></div><div><div>L</div><div>R</div><div>Press</div></div><div><div>L</div><div>R</div><div>Press</div></div><div><div>L</div><div>R</div><div>Release</div></div><div><div>1. Press the lock using left hand.</div></div><div><div>2. Get the connector 6188-0093 (W) using right hand then insert to insertion jig. Release the lock after insertion. Note: Follow the connector orientation.</div></div><div><div>3. Push the lower wire guide upward using right hand. Slot for Yellow wire will be opened.</div></div></div>		n/a	1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector

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Car Model: TOYOTA-LAND CRUISER

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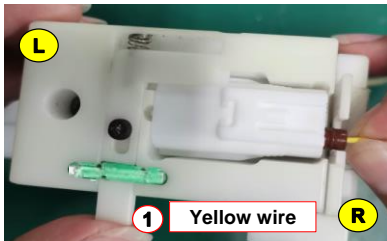
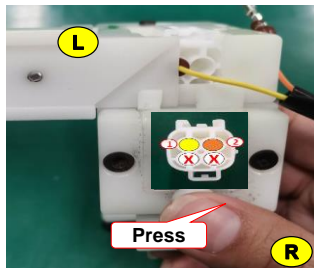
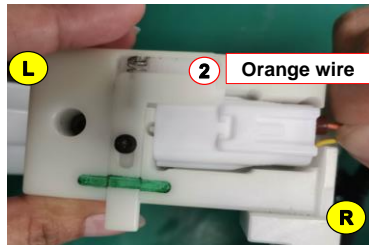
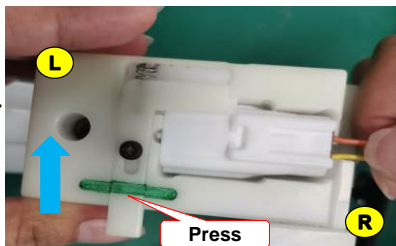
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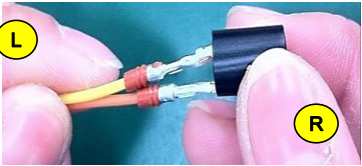

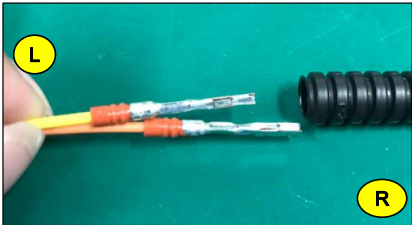

PARTS:		1. Connector 6188-0093 (W) 2. AVSSf 0.3 Y-OR wire L=429±2mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to insertion 6189-0093 (W)	<div><div></div><div>WIRE FACING</div></div> <div><div></div><div>1. Hold the insertion jig using left hand. Get the Yellow wire then insert to terminal slot 1 using right hand.</div></div> <div><div></div><div>2. Press the button using right thumb. The slot for Orange wire will be opened.</div></div> <div><div></div><div>3. Get the Orange wire then insert to terminal slot 2 using right hand.</div></div> <div><div></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>		n/a	<div>1. No wrong insertion of wires 2. No loose insertion 3. No wrong insertion 4. One by one insertion 5. No deformed terminal 6. No wrong wire facing</div> <div>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.</div> <div>Document references: 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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	Process Name/Title:		Model code/Part number: 420B/440B / A7448C		Customer: TRQSS	Car Model: TOYOTA-LAND CRUISER	Document No.:	WI-ENG-PDE-735A			
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:	1	Page No.:

PARTS:		1. Assy parts 2. Black SV tube (Vinyl) Ø7 L=13±3mm		3. Black Corrugated tube Ø5, L=269±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS
4	Wire insertion to Black SV tube (Vinyl) Ø7 L=13±3mm	<div>   </div> <div> 1. Get the Black SV tube (Vinyl) Ø7 L=13±3mm using right hand then insert the Yellow and Orange wire using left hand. </div>				n/a	1. No wrong use of parts 2. No deformed terminal
5	Wire insertion to Black Corrugated tube Ø5, L=269±3mm	<div>   </div> <div> 1. Get the Black corrugated tube (No slit), Ø7 L=269±3mm using right hand then insert the Y-OR wire using right hand. </div>				n/a	1. No wrong use of tape. 2. No deformed terminal

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PARTS:		1. Assy parts 2. Connector 6188-1161 (B)		JIG:	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1	Connector setting to insertion jig 6188-1161 (B)		n/a	<div><div>1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing</div><div>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.</div><div>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div></div>

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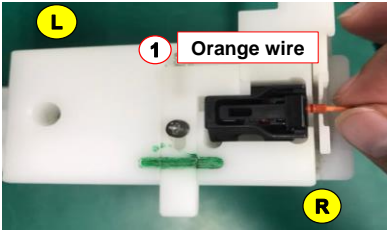
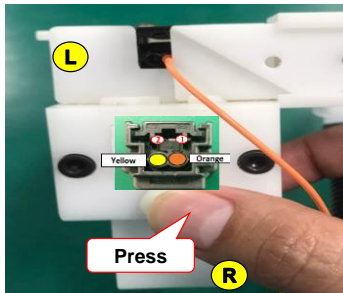
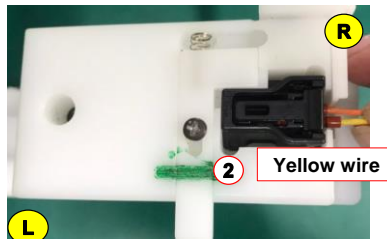
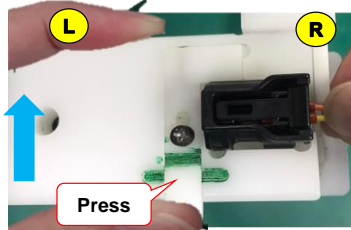
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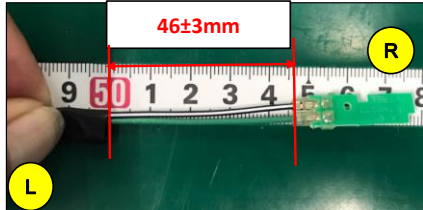
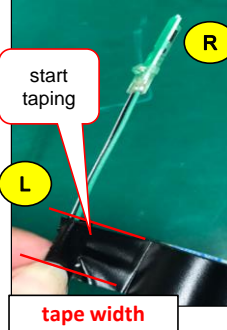
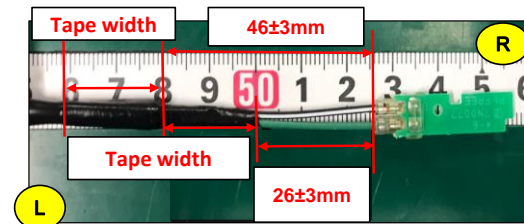

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PARTS:	1. Assy parts 2. Connector 6188-1161 (B)			JIG:	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
7	P1 Wire insertion to Connector 6188-1161 (B)	<div>WIRE FACING</div> <div>1 Orange wire 1. Hold the insertion jig using left hand. Get the Orange wire then insert to terminal slot 1 using right hand.</div> <div>Press 2. Press the button using right thumb. The slot for Yellow wire will be opened.</div> <div>2 Yellow wire 3. Get the Yellow wire then insert to terminal slot 2 using right hand.</div> <div>Press 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>	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>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.</div> <div>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>	

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		WORK INSTRUCTION				Effectivity Date:		September 20, 2023		
		TAPING ASSEMBLY PROCESS				Validity Date:		n/a		
		Model code/Part number: 420B/440B / A7448C		Customer: TRQSS	Car Model: TOYOTA-LAND CRUISER		Document No.:		WI-ENG-PDE-735A	
		Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		1	Page No.:	7 of 10
PARTS:		1. Assy parts 2. Black tape 3. MRSW CP G-B/W wires L=796±3mm (With SV tube (Vinyl) Ø5, L=73±3mm)				JIG:		1. Locking jig		
NO.		PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS		
8		Connector lock		<div><div></div><div><p>1. Put the connector into locking jig using both hands and then press 2x. Check the connector lock if properly lock.</p></div><div><div><div></div><div></div></div><div><div><div></div><div></div><div></div></div></div></div></div>		<div>LOCKING JIG</div> <div></div>		<div>Important reminders/Note/s:</div> <div>1. Manual locking may caused damaged connector lock</div> <div>1. Use provided locking jig per model.</div> <div>2. No unlock/half-locked connector</div>		
9		P1 Taping 2 Black SV tube (Vinyl) to wire near hotmelted wires		<div><div><div></div><div><p>1. Get the hotmelted G-B/W wires with Black SV tube (Vinyl) then measure from end of SV tube (Vinyl) up to the edge of hotmelted wires 46±3mm using both hands.</p></div><div><div><div></div><div><p>start taping</p></div><div><p>tape width</p></div></div><div><p>2. Hold the assy parts using left hand, get the black tape using right hand and then continue the taping process using both hands.</p></div><div><div><div></div><div><p>Tape width</p></div><div><p>46±3mm</p></div><div><p>Tape width</p></div><div><p>26±3mm</p></div></div><div><p>3. After taping, Check the measurement and taping condition.</p></div></div></div></div></div>		<div>MEASURING TAPE</div> <div></div>		<div>Important reminders/Note/s:</div> <div>1. Please use calibrated and verified measuring tape when getting the measurement.</div> <div>1. No flip-out tape</div> <div>2. No peel-of tape</div> <div>3. No loose tape</div> <div>4. No missing tape</div> <div>5. No wrong use of tape</div> <div>6. No wrong dimension</div>		

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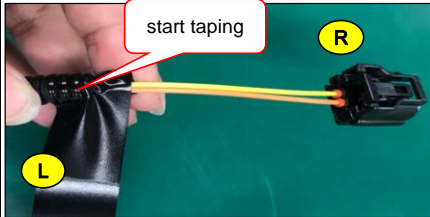

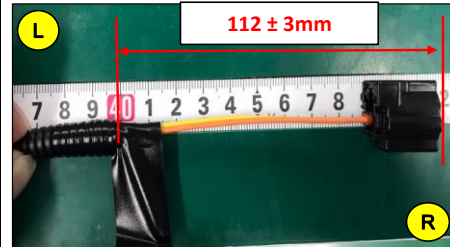


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PARTS:		1. Assy parts 2. Black tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	P1 Taping 1 Black Corrugated tube to Wire near connector	<div><div><p>start taping</p><p>R</p><p>L</p></div><div><p>1. Hold the assy parts using left hand then conduct pre-taping using both hands.</p></div><div><p>L</p><p>R</p><p>Tape width</p></div><div><p>2. Confirm tape width measurement from end of tape up to end of corrugated tube then continue the taping process using both hand.</p></div><div><p>L</p><p>R</p><p>112 ± 3mm</p></div><div><p>3. Measure from end of COT up to Connector 112±2mm then continue the taping process using both hand.</p></div><div><p>L</p><p>R</p><p>112 ± 3mm</p><p>Tape width</p><p>0~5mm</p></div><div><p>4. After taping, check the measurement and tape condition.</p></div></div> <div><div>MEASURING TAPE</div></div> <div><div>1. No flip-out tape 2. No peel-of tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension</div><div>Important reminders/Note/s: 1. Please use calibrated and verified measuring tape when getting the measurement.</div></div>			

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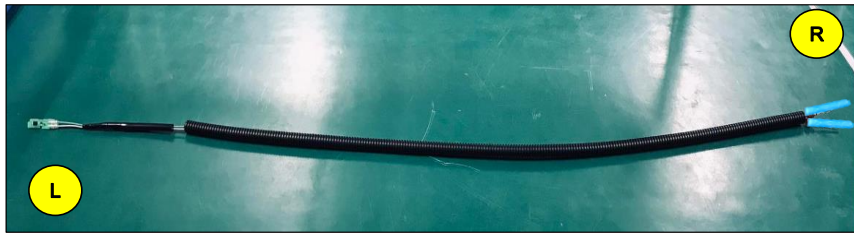


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PARTS:		1. Assy parts 2. Black Corrugated tube Ø7 L=639±3mm	JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
11	P1	<p>Wire insertion to Black Corrugated tube Ø7 L=639±3mm</p> <div><p>1. Get the terminal cover jig left hand then insert to both terminals (Hotmelted wires G-B/W) using both hands.</p><p>2. Hold the Black corrugated tube (Ø7 L=639±3mm) using left hand then insert the (Hotmelted wires G-B/W) using right hand.</p><p>3. After insertion, remove the terminal cover jig using right hand.</p></div>	<p>TERMINAL COVER</p> 	1. No wrong usage of parts 2. No damaged rubber seal

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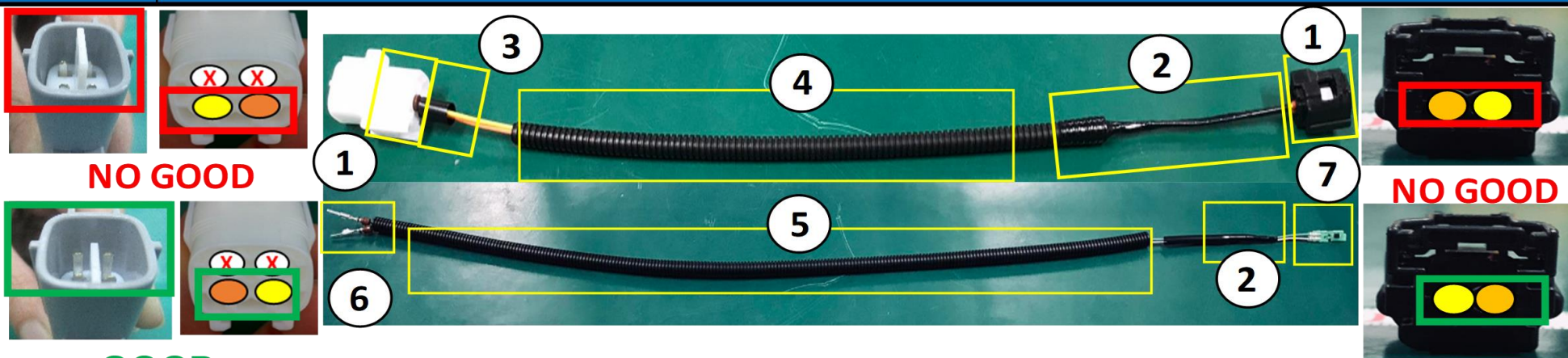
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PARTS:

n/a

JIG:

n/a

QUALITY CHECKPOINTS**P1****A7448C****GOOD****GOOD**

① No **WRONG INSERT**
No **UNLOCKED/HALF-LOCKED**
No **TERMINAL BACKING OUT**

③ No **BLACK SV TUBE (VINYL)**

④ ⑤ No **MISSING BLACK CORRUGATED TUBE**

② No **MISSING TAPE**

⑥ ⑦ No **DEFORMED TERMINAL/HOTMELTED WIRE**

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