



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

February 25, 2025

Model code/Part number:

920B / 7R0121-7021A

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Document No.:

WI-ENG-PDE-652A

Purpose:

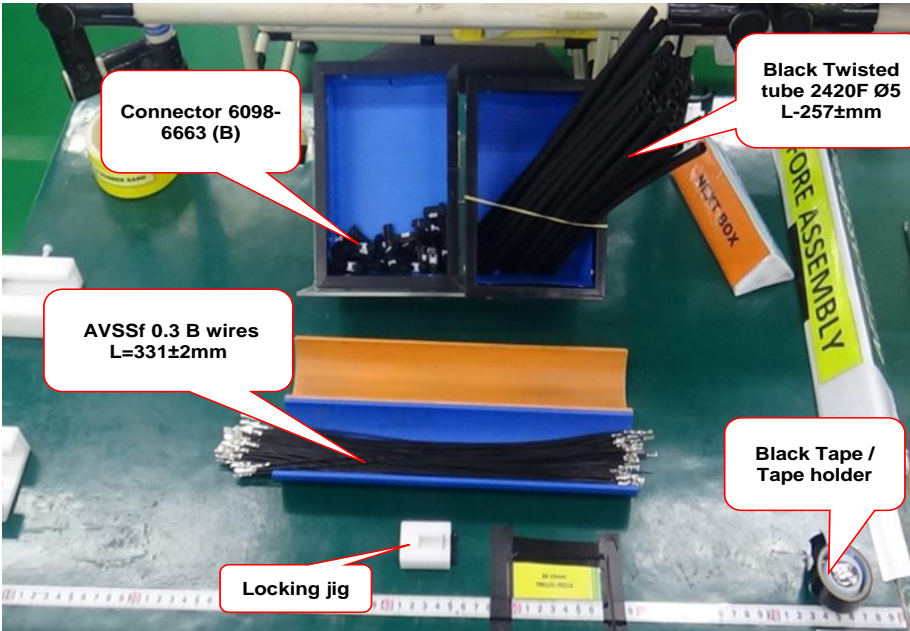
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO


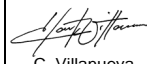
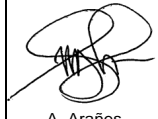
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PARTS:		1. Assy parts; Connector 6098-6663 (B); AVSSf 0.3 B L=331±2mm; Black Twist tube 2420F Ø5 L=257±3mm; Black tape		JIG:	1. Locking jig
NO.	PROCESS NAME	<div>3</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
1	P1	Table Lay-out	<div>Table Lay-out</div> <div></div>	<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>	<div>Documents reminder/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</div> <div>1. No missing parts/tools 2. No excess parts/tools</div>


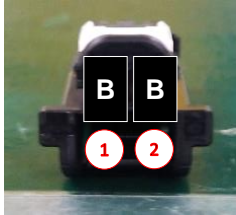

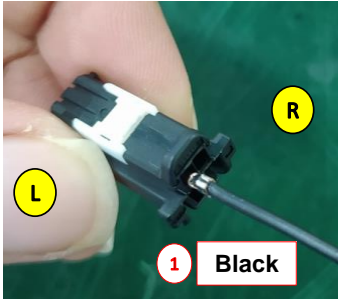
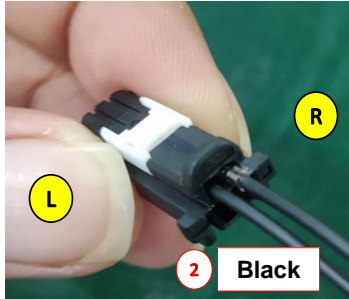
Revision History							Prepared by	Reviewed by	Approved by	Noted by
02/25/25	3	Transfer Wire insertion to connector and connector lock process from Offline assembly process due to line balancing. Update Table lay-out and Visual inspection/Quality checkpoints.	D.Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
09/21/24	2	Change process name from Spot taping 1 to Taping 1 Twist tube to wire near terminal (Black tape) and transfer Twist tube to wire near terminal (Tesa tape) to P2 due to process improvement. Inclusion of car model "TOYOTA-TACOMA". Improved table lay-out and visual inspection/quality checkpoint.	D.Castillo	C. Villanueva	A. Arañes	n/a				
05/24/23	1	Changed Purpose from Pre-launch to Masspro. Changed table lay-out. Inclusion of Quality Checkpoints. Transferred process no. 2 (Wire insertion to Black twist tube) from OFFLINE ASSEMBLY PROCESS to TAPING ASSEMBLY PROCESS (P1) due to change process distribution.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
03/17/23	0	Initial issue. Added spot taping (Black Vinyl tape) covering the end of tesa tape.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	March 17, 2023		

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	Model code/Part number: 920B / 7R0121-7021A		Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:		WI-ENG-PDE-652A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		3	Page No.:	2 of 5	

PARTS:		1. Connector 6098-6663 (B) 2. AVSSf 0.3 B L=331±2mm [2pcs]		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1 Wire insertion to Connector 6098-6663 (B)	<div style="display: flex; justify-content: space-around; align-items: flex-start;"> <div style="text-align: center;">  <p>CONNECTOR ORIENTATION</p> </div> <div style="text-align: center;">  <p>VISUAL REFERENCE</p> </div> <div style="text-align: center;">  <p>WIRE FACING</p> </div> </div> <div style="display: flex; justify-content: space-around; align-items: flex-start; margin-top: 20px;"> <div style="text-align: center;">  <p>1. Hold the connector 6098-6663 (B) then get the first Black wire and insert to terminal slot 1 using right hand.</p> </div> <div style="text-align: center;">  <p>2. Hold the connector 6098-6663 (B) then get the second Black wire and insert to terminal slot 2 using right hand.</p> </div> </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 during insertion.</p> <p>2. Insertion must be from left to right.</p> <p>3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>Documents reminder/s:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</p> <p>2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>

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PARTS:

1. Assy parts

JIG:

1. Locking Jig

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

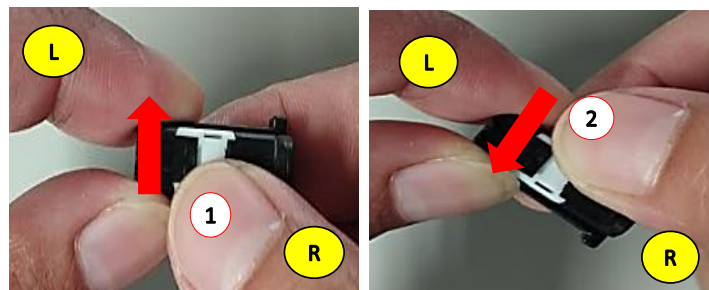
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P1

Connector lock



1. Put the connector into locking jig using right hand then press to lock **2x** using both hands. Touch the connector lock if properly locked.

**LOCKING JIG**

2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.

Important reminders/note/s:

1. Manual locking may cause damage connector lock.

1. No Unlock and half-locked
2. Use provided jig tools per model to avoid damaged lock.

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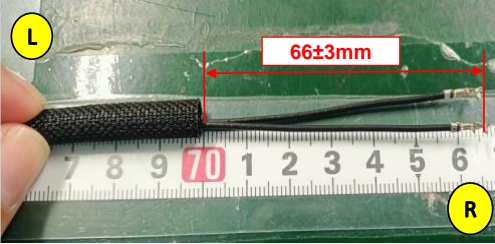

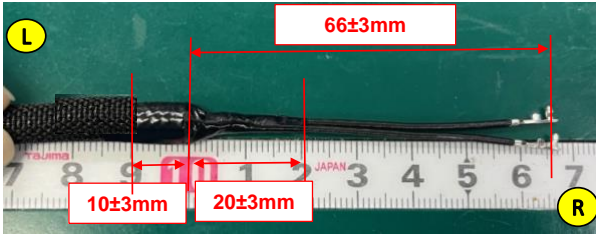

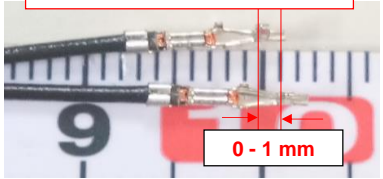
PARTS:

1. Assy parts
2. Black Twist tube 2420F Ø5 L=257±3mm

3. Black tape

JIG:

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Wire insertion to Black Twist tube 2420F Ø5 L=257±3mm	 <p>1. Get the Black twist tube 2420F Ø5 L=257±3mm using right hand and insert B-B wires using left hand.</p>	n/a	<ol style="list-style-type: none">1. No wrong use of parts2. No deformed terminal
5	P1 Taping 1 Black Twist tube to wire near terminal	 <p>1. Measure from Black twist tube 2420F 66±3mm up to terminal tip.</p>  <p>2. Hold the assy parts using left hand . Get Black tape using right hand. Start taping process, make 2 windings pre-tape. 1/3 shifting until reach the wire and make 2 windings then cut the tape.</p>  <p>3. After spot taping, check the measurement, taping condition and alignment of wires.</p>	 <p>Measuring tape</p>	<ol style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension <p>Important reminders/note/s:</p> <p><i>1. Please use calibrated/verified measuring tape when getting the measurement.</i></p> <p>Wire alignment tolerance</p> 

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1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

TAPING - P1

7R0121-7021A



① No Unlocked/Half-locked connector

② No Terminal backing out

③ No Missing Tape

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