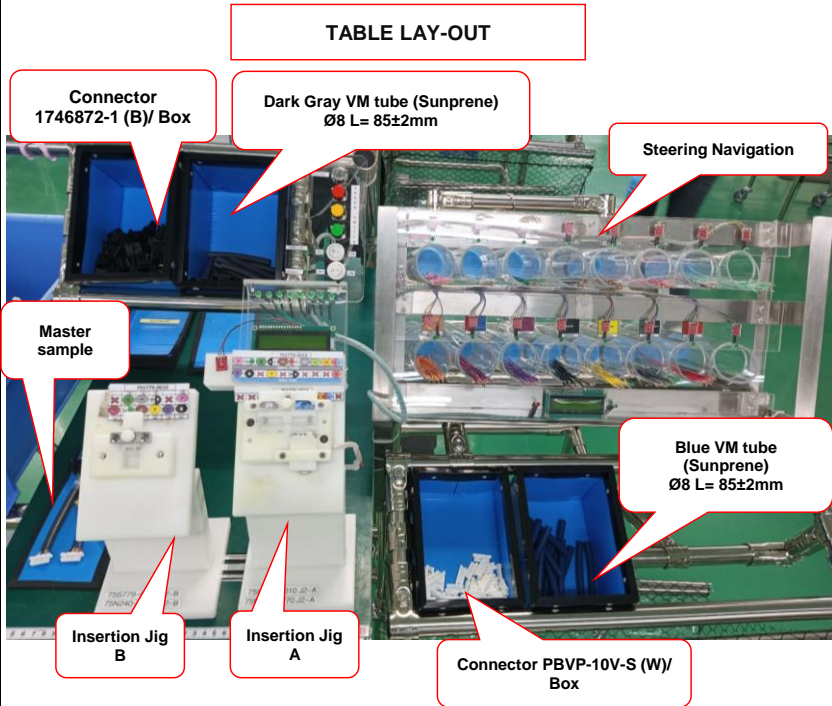



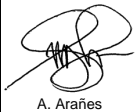
	<b>WORK INSTRUCTION</b> <b>TAPING ASSEMBLY PROCESS</b>				Effectivity Date: <b>March 03, 2025</b>	
	Process Name/Title:				Validity Date: <b>n/a</b>	
	Model code/Part number: <b>345D / 75S779-0010</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA YARIS</b>	Document No.: <b>WI-ENG-PDE-634</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: <b>3</b>		Page No.: <b>1 of 18</b>	


  

<b>PARTS:</b> 1. Connector PBVP-10V-S (W) [2pcs.]; Connector 1746872-1 (B); AVSS 0.3 R/L L=208±2mm; OR L=208±2mm; LG L=208±2mm; GR L=130±2mm; R/W L=208±2mm; BR L=130±2mm; B/W L=209±2mm; G L=130±2mm; W/G L=130±2mm; P L=131±2mm; AVSS 0.3 R L=131±2mm; GR/B L=130±2mm; Y L=130±2mm; B L=130±2mm; V L=130±2mm; Dark Gray VM tube (Sunprene) ø8 L=85±2mm; Blue VM tube (Sunprene) ø8 L=85±2mm.		JIG: 1. Insertion jig 2. Steering Navigation	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>
1	P1  Table lay-out		<div> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div> <b>Housekeeping</b>            1. Maintain and always practice 5's.            2. Personal things on the workplace is prohibited. Keep it in your locker.         </div> <div> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>

Revision History						Prepared by	Checked by	Reviewed by	Approved by	
03/03/24	3	Improved insertion jig; Change connector (PBVP-10V-S) orientation, terminal orientation and color sequence as customer claim countermeasure. Inclusion of Table lay-out. Improved Measurement. Change document number of Steering Electrical test (WI-QAD-QAC-252).	D.Castillo	J. Loterte	C. Villanueva	A. Arañes	 D. Castillo	 J. Loterte	 C. Villanueva	 A. Arañes
04/26/24	2	Change the folding facing due to improvement of abnormality. Update the Work procedure/Illustration of Process 11-12. Update Quality pointers. Change hand method (Process 3). Change Electrical test document number due to transfer process from Production to QC. Inclusion of Car model "TOYOTA-YARIS"	D.Castillo	n/a	C.Villanueva	A. Arañes				
04/18/23	1	Change from pre-launch to Masspro.	D.Castillo	J. Loterte	C. Villanueva	A. Arañes				
02/03/23	0	Initial issue.	D.Castillo	J. Loterte	Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Checked by	Reviewed	Approved	Est. Date: February 03, 2025

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

March 03, 2025

Validity Date:

n/a

Model code/Part number:

345D / 75S779-0010

Customer:

TRJ

Car Model:

TOYOTA YARIS

Document No.:

WI-ENG-PDE-090

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

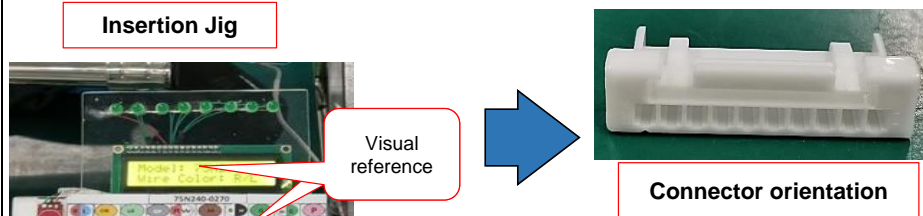
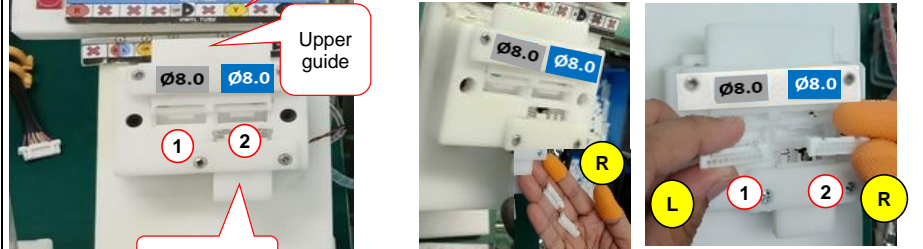
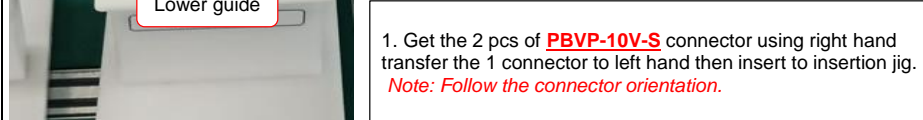
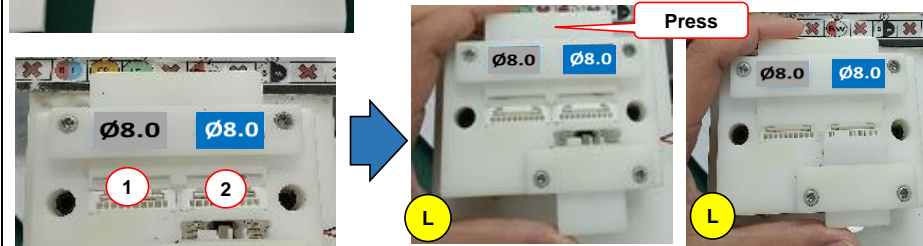
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PARTS:		1. Connector PBVP-10V-S (W) [2pcs]		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1 <div>Connector setting to insertion jig PBVP-10V-S (W)</div>	<div><div>Insertion Jig</div><div><div>Visual reference</div><div>Connector orientation</div></div><div><div>Upper guide</div><div>Lower guide</div></div><div><div>1. Get the 2 pcs of <b>PBVP-10V-S</b> connector using right hand transfer the 1 connector to left hand then insert to insertion jig. <i>Note: Follow the connector orientation.</i></div></div><div><div>Press</div><div>2. Press the upper and lower guide using left hand in same timing. Holes that need to be insert are only open.</div></div></div>		n/a	1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Model code/Part number:

345D / 75S779-0010

Customer:

TRJ

Car Model:

TOYOTA YARIS

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

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Effectivity Date:

March 03, 2025

Validity Date:

n/a

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### PARTS:

1. AVSS 0.3 R/L L=208±2mm; OR L=208±2mm; LG L=208±2mm; GR L=130±2mm; R/W L=208±2m; BR L=130±2mm; B/W L=209±2mm; G L=130±2mm; W/G L=130±2mm; P L=131±2mm;

JIG:

1. Insertion jig
2. Steering Navigation

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

P1

Wire insertion to  
Connector  
PBVP-10V-S (W)

### INSERTION SEQUENCE FROM LEFT TO RIGHT

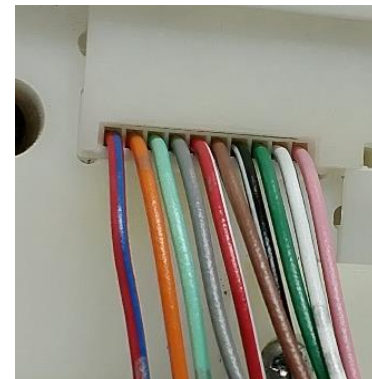
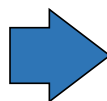


### TERMINAL FACING



### WIRE INSERTION ILLUSTRATION

1	2	3	4	5	6	7	8	9	10
R/L	OR	LG	GR	R/W	BR	B/W	G	W/G	P
208	208	208	130	208	130	109	130	130	131



1. Get the R/L wire using left hand and transfer to right hand then insert to connector. Repeat the process for OR-LG-GR-R/W-BR-B/W-G-W.G-P wires. Check the wire after insertion.

*Note: Follow the insertion sequence based on the illustration.*

### STEERING NAVIGATION (2 layer)



### CONTROLLER



### Important reminders/Note/s:

1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
2. Please hold the wire near terminal during insertion.
3. Insertion of wire must be from left to right.

### Important reminders/Note/s:

1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
3. Refer to GL-PRO-ASY for Pull-Push procedure.

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

March 03, 2025

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Model code/Part number:

**345D / 75S779-0010**Customer: **TRJ**

Car Model:

**TOYOTA YARIS**

Document No.:

**WI-ENG-PDE-090**

Purpose:

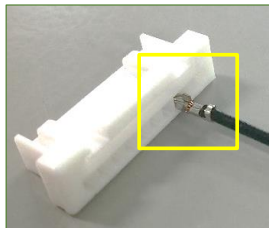
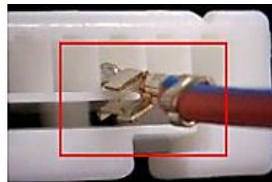
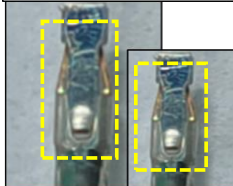
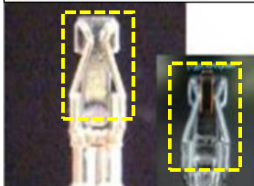
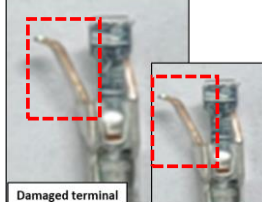
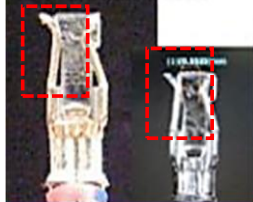
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. AVSS 0.3 R/L L=208±2mm; OR L=208±2mm; LG L=208±2mm; GR L=130±2mm; R/W L=208±2m; BR L=130±2mm; B/W L=209±2mm; G L=130±2mm; W/G L=130±2mm; P L=131±2mm;		JIG:	1. Insertion jig 2. Steering Navigation
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1  Wire insertion to Connector PBVP-10V-S (W) (Continuation)	<div><div>Proper alignment of terminal to connector</div></div> <div><div>Improper alignment of terminal to connector</div></div> <div><div>BACK VIEW OF TERMINAL</div><div>GOOD Terminal condition</div></div> <div><div>FRONT OF TERMINAL</div><div>GOOD Terminal condition</div></div> <div><div>BACK VIEW OF TERMINAL</div><div>Damaged terminal NO GOOD Terminal condition</div></div> <div><div>FRONT VIEW OF TERMINAL</div><div>NO GOOD Terminal condition</div></div> <div>Note: <i>*Make sure the terminal was in proper alignment before insert. *Avoid hitting the terminal into the connector during wire insertion, if encountered abnormality stop the process and call the attention of Immediate superior and Automatically disposed and replace the unit.</i></div>			1. Use provided jig per model 2. No wrong usage of parts 3. One by one insertion 4. No wrong insertion 5. No deformed terminal 6. No stuck of terminal tip  <b>Important reminders/Note/s:</b>  <i>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 2. Please hold the wires near terminal during insertion. 3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector. 4. Insertion of wires must be from left to right.</i>  <b>Document reference/s:</b>  <i>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance. 2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.. 3. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</i>


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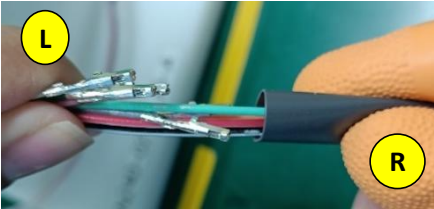
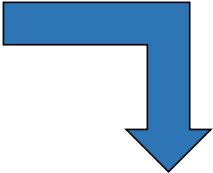

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	<b>WORK INSTRUCTION</b>				Effectivity Date:		March 03, 2025	
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Model code/Part number: <b>345D / 75S779-0010</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA YARIS</b>	Document No.:		<b>WI-ENG-PDE-090</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		3	Page No.: 5 of 18

<b>PARTS:</b>		1. Assy parts 2. Dark Gray VM tube (Sunprene) Ø8 L=85±2mm		JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
4	P1 <div>3</div>  Wire insertion to Dark Gray VM tube (Sunprene) Ø8 L=85±2mm	<div><div><div><div><div>L</div></div><div><div>L</div></div></div><div><div>1. Get the <b>Dark Gray VM tube (Sunprene) Ø8 L=85±2mm</b> using right hand. Hold the wires using left hand and insert the wires using right hand.</div></div></div><div> </div></div>		n/a	1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Model code/Part number:

345D / 75S779-0010

Customer:

TRJ

Car Model:

TOYOTA YARIS

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

March 03, 2025

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### PARTS:

1. AVSS 0.3 R L=131±2mm; GR/B L=130±2mm; Y L=130±2mm; B L=130±2mm; V L=130±2mm

JIG:

1. Insertion jig
2. Steering Navigation

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE

### QUALITY POINTERS

5

P1

Wire insertion to  
Connector  
PBVP-10V-S (W)

#### INSERTION SEQUENCE FROM LEFT TO RIGHT



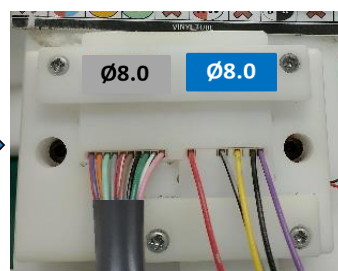
#### WIRE INSERTION ILLUSTRATION

1	2	3	4	5
R	GR/B	Y	B	V
131	130	130	130	130



Note: Holes that need to be insert are only open.

Lower guide



1. Get the **R wire** using right hand and insert to connector. Repeat the process for **GR/B-Y-B-V wires**. Check the wire after insertion.

Note: Follow the insertion sequence based on the above illustration.

#### STEERING NAVIGATION(2 layer)



#### CONTROLLER



1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

#### Important reminders/Note/s:

1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
2. Please hold the wire near terminal during insertion.
3. Insertion of wire must be from left to right.

#### Document reference/s:

1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
3. Refer to GL-PRO-ASY-029 for Pull-Push-Push procedure.

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Model code/Part number:

**345D / 75S779-0010**

Customer:

**TRJ**

Car Model:

**TOYOTA YARIS**

Document No.:

**WI-ENG-PDE-090**

Purpose:

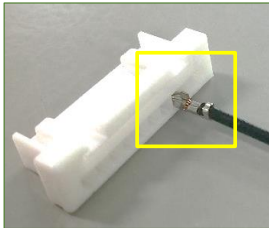
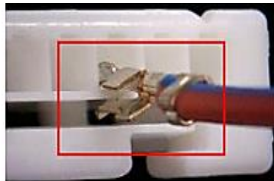
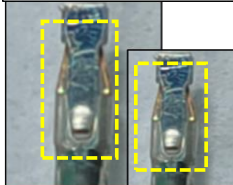
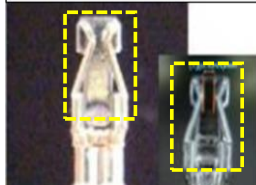
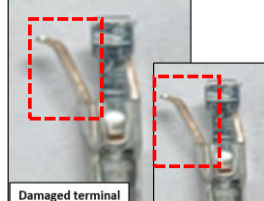
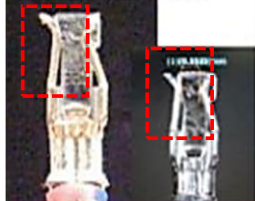
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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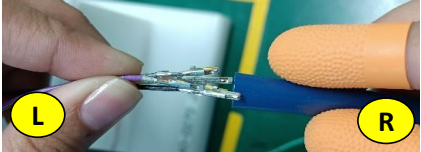
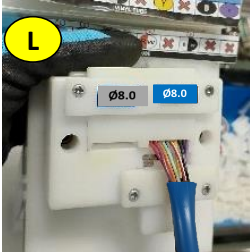
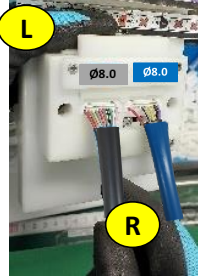
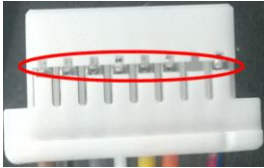

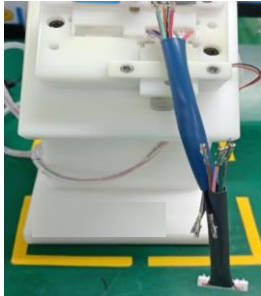
PARTS:		1. AVSS 0.3 R L=131±2mm; GR/B L=130±2mm; Y L=130±2mm; B L=130±2mm; V L=130±2mm		JIG:	1. Insertion jig 2. Steering Navigation
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1  Wire insertion to Connector PBVP-10V-S (W) (Continuation)	<div><div>Proper alignment of terminal to connector</div></div> <div><div>Improper alignment of terminal to connector</div></div> <div><div>BACK VIEW OF TERMINAL</div><div>GOOD Terminal condition</div></div> <div><div>FRONT OF TERMINAL</div><div>GOOD Terminal condition</div></div> <div><div>BACK VIEW OF TERMINAL</div><div>Damaged terminal NO GOOD Terminal condition</div></div> <div><div>FRONT VIEW OF TERMINAL</div><div>NO GOOD Terminal condition</div></div> <div>Note: <b>*Make sure the terminal was in proper alignment before insert.</b> <b>*Avoid hitting the terminal into the connector during wire insertion, if encountered abnormality stop the process and call the attention of Immediate superior and Automatically disposed and replace the unit.</b></div>			1. Use provided jig per model 2. No wrong usage of parts 3. One by one insertion 4. No wrong insertion 5. No deformed terminal 6. No stuck of terminal tip  <b>Important reminders/Note/s:</b> <b>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</b> <b>2. Please hold the wires near terminal during insertion.</b> <b>3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</b> <b>4. Insertion of wires must be from left to right.</b>  <b>Document reference/s:</b> <b>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</b> <b>2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..</b> <b>3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b> <b>4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</b>

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	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>March 03, 2025</b>		
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>345D / 75S779-0010</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA YARIS</b>	Document No.:	<b>WI-ENG-PDE-090</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	3	Page No.:	8 of 18

<b>PARTS:</b>		1. Assy parts 2. Blue VM tube (Sunprene) Ø8 L=85±2mm		JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>3</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
6	P1 Wire insertion to Blue VM tube (Sunprene) Ø8 L=85±2mm	<div><p>1. Get the <b>Blue VM tube (Sunprene) Ø8 L=85±2mm</b> using right hand. Hold the wire using left hand then insert the wires.</p></div> <div><p>2. Press the Upper button using left hand. Remove the 1st connector with inserted wires and Dark Gray VM tube (Sunprene) using right hand.</p><p>3. Press the upper guide using left hand and press the lower button using right hand. Holes that need to be inserted are only open. Check the wire insertion condition.</p><p><b>Note: Second connector with inserted wire and Blue VM tube (Sunprene) will stay in the jig.</b></p></div>		N/A	<p><b>Document reference/s:</b></p> <p>1. Refer to <i>GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.</i></p> <p>1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires</p> <div><p><b>Terminal tip must be visible</b></p></div>
7	Wire insertion to assy parts	<div><p>1. Hold the <b>Blue VM tube (Sunprene)</b> using left hand and insert the wires from <b>Dark Gray VM tube (Sunprene)</b> using right hand.</p></div> 		N/A	<p>1. No wrong use of parts 2. No deformed terminal 3. No tangled wires</p>

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Model code/Part number:

345D / 75S779-0010

Customer:

TRJ

Car Model:

TOYOTA YARIS

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

March 03, 2025

Validity Date:

n/a

Document No.:

WI-ENG-PDE-090

Revision No.:

3

Page No.:

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### PARTS:

1. Assy parts

JIG:

1. Insertion jig
2. Steering Navigation

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

8

P1

Wire insertion to  
Connector  
PBVP-10V-S (W)

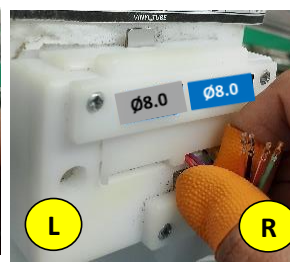
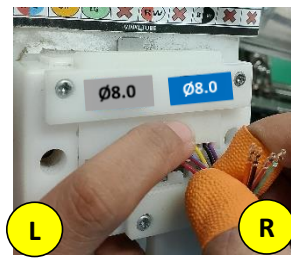
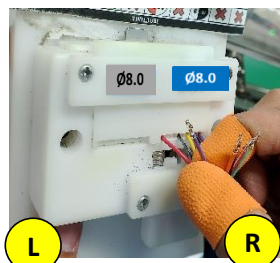
### INSERTION SEQUENCE FROM LEFT TO RIGHT



### WIRE FACING

### WIRE INSERTION ILLUSTRATION

	1	2	3		4		5		
R	R/L	OR	LG	GR/B	R/W	Y	B/W	B	V
131	208	208	208	130	208	130	209	130	130



2. Hold the **R/L wire** using right hand and support the wire by left index finger then insert to connector slot 1 using right hand. Repeat the process on **OR-LG-R/W-B/W wires**. Check the wire after insertion

*Note: Follow the insertion sequence based on the above illustration.*

### STEERING NAVIGATION(2 layer)



### CONTROLLER



1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

### Important reminders/Note/s:

1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
2. Please hold the wire near terminal during insertion.
3. Insertion of wire must be from left to right.

### Document reference/s:

1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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## TAPING ASSEMBLY PROCESS

Effectivity Date:

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Validity Date:

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Model code/Part number:

345D / 75S779-0010

Customer: TRJ

Car Model: TOYOTA YARIS

Document No.:

WI-ENG-PDE-090

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

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### PARTS:

1. Assy parts

JIG:

1. Insertion jig
2. Steering Navigation

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

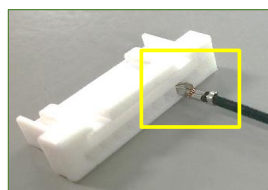
QUALITY POINTERS

8

P1

Wire insertion to  
Connector  
PBVP-10V-S (W)  
(Continuation)

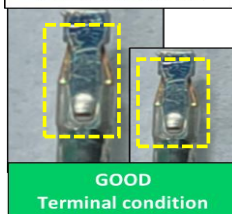
Proper alignment of terminal to connector



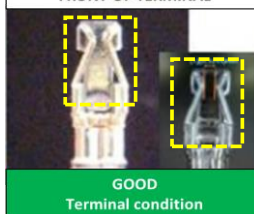
Improper alignment of terminal to connector



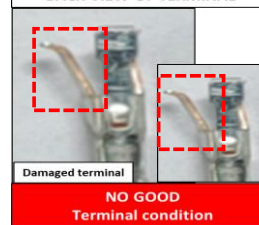
BACK VIEW OF TERMINAL



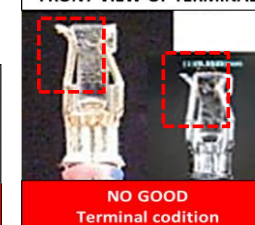
FRONT OF TERMINAL



BACK VIEW OF TERMINAL



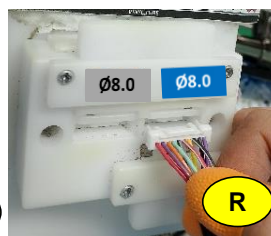
FRONT VIEW OF TERMINAL



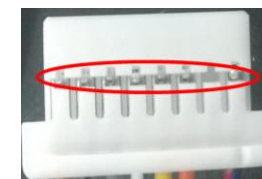
Note:

**\*Make sure the terminal was in proper alignment before insert.**

**\*Avoid hitting the terminal into the connector during wire insertion, if encountered abnormality stop the process and call the attention of Immediate superior and Automatically disposed and replace the unit.**



3. Press the Upper button using left hand then remove the assy part using right hand. Check the wire insertion condition.



Terminal tip must be visible

1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

**Important reminders/Note/s:**

1. **Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.**
2. **Please hold the wires near terminal during insertion.**
3. **Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.**
4. **Insertion of wires must be from left to right.**


**Document reference/s:**


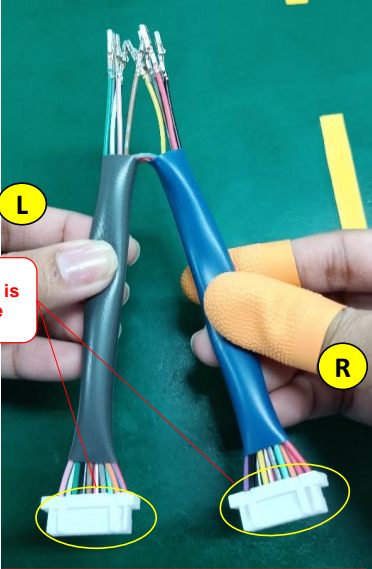
1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.

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	<b>WORK INSTRUCTION</b>				Effectivity Date:		March 03, 2025	
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Model code/Part number: <b>345D / 75S779-0010</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA YARIS</b>	Document No.:		<b>WI-ENG-PDE-090</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		3	Page No.: 11 of 18

<b>PARTS:</b>		1. Assy parts		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
9	P1	Wire folding <div><p>BEFORE FOLDING</p><p>AFTER FOLDING</p><p>1. Hold the assy parts using both hands then conduct wire arrangement.</p></div>	N/A	1. No deformed terminals 2. No tangled wires 3. No wrong facing	

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March 03, 2025

Validity Date:

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345D / 75S779-0010

Customer:

TRJ

Car Model:

TOYOTA YARIS

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Purpose:

☐ PROTOTYPE

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### PARTS:

1. Connector 1746872-1 (B)

JIG:

1. Insertion jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

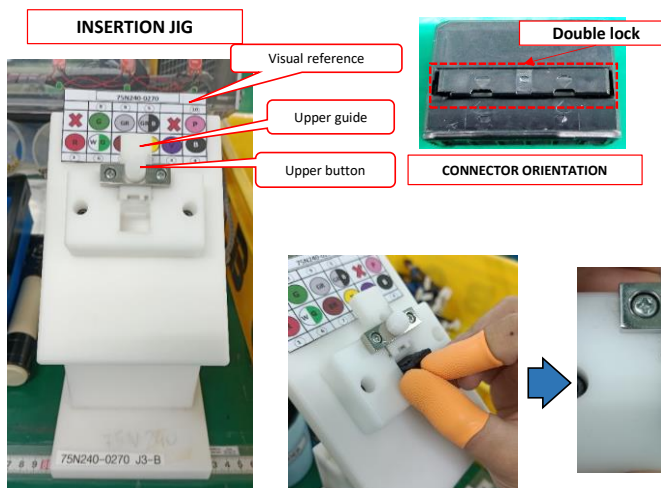
### TOOLS/PPE

### QUALITY POINTERS

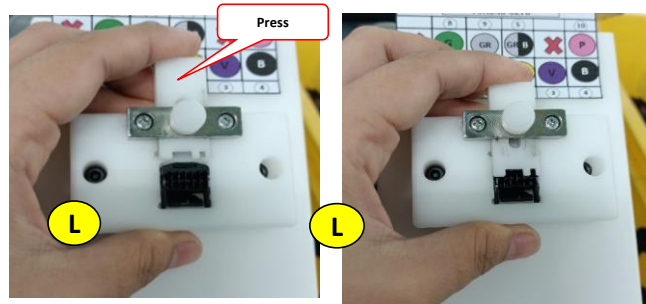
10

P1

Connector setting to  
insertion jig  
1746872-1 (B)



1. Get the connector **1746872-1 (B)** and insert to insertion jig using right hand.  
*Note: Follow the connector orientation*

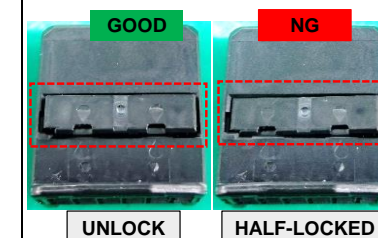


2. Press the upper guide using left hand. Holes that need to be insert are only open.

N/A

1. Use the provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No damaged connector

### CONNECTOR LOCK APPEARANCE CHECK



### Important reminders/Note/s:

1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.
2. Check the connector before insertion.

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## WORK INSTRUCTION

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Model code/Part number:

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Customer:

TRJ

Car Model:

TOYOTA YARIS

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WI-ENG-PDE-090

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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## PARTS:

1. Assy parts

JIG:

1. Insertion jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

## TOOLS/PPE

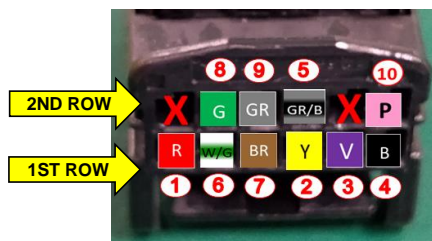
## QUALITY POINTERS

11

P1

Wire insertion to  
Connector  
1746872-1 (B)

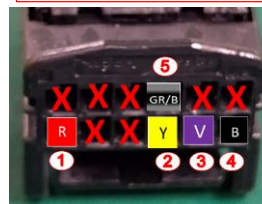
## INSERTION SEQUENCE FROM LEFT TO RIGHT



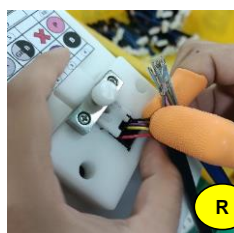
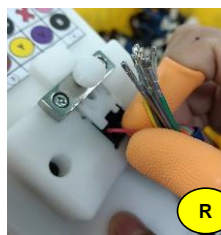
## WIRE INSERTION ILLUSTRATION

	8	9	5		10
X	G	GR	GR/B	X	P
130	130	130	130	131	131
1	6	7	2	3	4
R	W/G	BR	Y	V	B
131	130	130	130	130	130

## BLACK VM TUBE

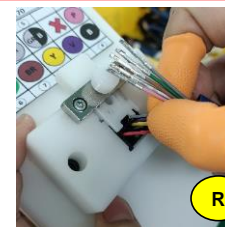


## FIRST ROW (LEFT TO RIGHT)



1. Insert first the wires from **Black VM tube (Sunprene)**. Hold the **R wire** and insert to terminal slot 1 using right hand. Repeat the process for **Y-V-B wires**.  
*Note: Follow the insertion sequence based on the illustration stated above.*

## SECOND ROW (LEFT TO RIGHT)



2. Hold the **GR/B wire** and insert to terminal slot 5.  
*Note: Follow the insertion sequence based on the illustration stated above.*

N/A

1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

## Important reminders/Note/s:

1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.
2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
3. Please hold the wire near terminal during insertion.

## Document reference/s:

1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**March 03, 2025**

Model code/Part number:

**345D / 75S779-0010**

Customer:

**TRJ**

Car Model:

**TOYOTA YARIS**

Document No.:

**WI-ENG-PDE-090**

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
11	P1  Wire insertion to Connector 1746872-1 (B) (Continuation)	<div><div>BLUE VM TUBE</div><div></div><div><p>3. Hold the <b>W/G wire</b> using right hand and support the wire by left index finger then insert to terminal slot 6 using right hand. Repeat the process for <b>BR wire</b>. <i>Note: Follow the insertion sequence based on the above illustration.</i></p><div><p>4. Hold the <b>G wire</b> and insert to terminal slot 8 using right hand. Repeat the process for <b>GR-P wires</b>. <i>Note: Follow the insertion sequence based on the illustration.</i></p><div><p>5. Press the Upper button using left hand then remove the assy part using right hand.</p></div></div></div></div>	N/A	<div>1. Use provided jig per model 2. No wrong usage of parts 3. One by one insertion 4. No wrong insertion 5. No deformed terminal 6. No stuck of terminal tip</div> <div><b>Important reminders/Note/s:</b>  1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 3. Please hold the wire near terminal during insertion.</div> <div><b>Document reference/s:</b>  1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion. 2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure. 3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>

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**345D / 75S779-0010**

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Purpose:




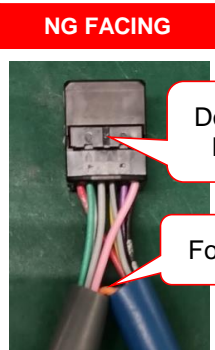
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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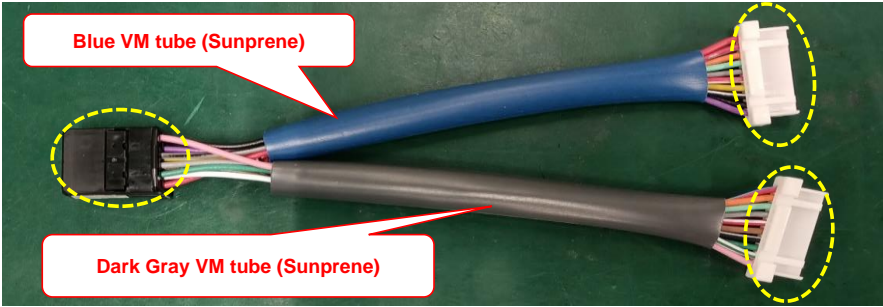
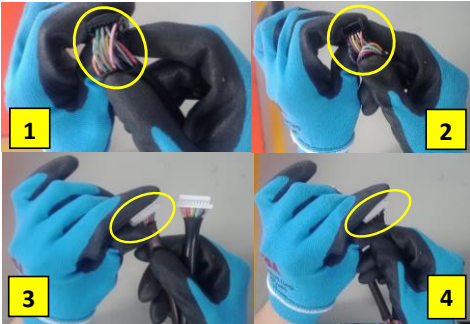
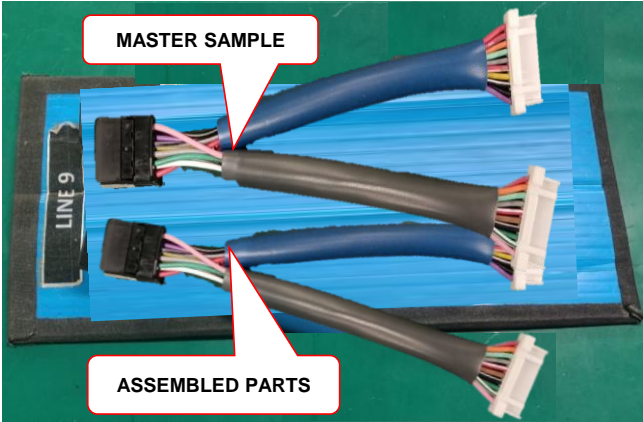


<b>PARTS:</b>		1. Assy parts		JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
12	P1	<div><div>Folding in the back</div><div>GOOD FACING</div><div>Folding in the front</div><div>WRONG FACING</div><div>1. Hold the harness using both hands. Arrange the wire properly to avoid tangled wires.</div><div>GOOD FACING</div><div>Connector lock</div><div>Folding</div><div>NG FACING</div><div>Double lock</div><div>Folding</div></div> <div>Terminal tip is not visible</div> <div>Terminal tip is visible</div> <div>N/A</div> <div>1. No wrong orientation of connector 2. No tangled wires 3. No wrong facing of wire folding</div>			

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	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>345D / 75S779-0010</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA YARIS</b>	Document No.:	<b>WI-ENG-PDE-090</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	3	Page No.:	16 of 18

<b>PARTS:</b>	1. Assembled parts 2. Master sample			JIG:	n/a			
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
13	P1	Visual/By two's inspection						
		<div>1. Check the Connector lock, locking of connector is included to Steering electrical test.</div> <div>2. Check the wire alignment. Make sure no tangled wires.</div> <div>3. Check the terminal if with backing out (not fully inserted) or deformed terminal.</div> <div></div> <div>5. Check the orientation of harness.</div> <div>6. Compare to <b>Master sample</b> by tapping.</div> <div></div> <div></div>			<div>MASTER SAMPLE</div> <div></div> <div><b>Document reference/s:</b> 1. Refer to <b>WI-QAD-QAC-252</b> Steering Electrical Test</div> <div></div>			

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**345D / 75S779-0010**Customer: **TRJ**

Car Model:

**TOYOTA YARIS**

Document No.:

**WI-ENG-PDE-090**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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**PARTS:**

1. Assy parts

JIG:

n/a

**NO.****PROCESS NAME****3****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****MEASURING TAPE****Important reminders and note/s:**

**1. Please use calibrated /verified measuring tape when getting the measurement.**

**2. For Hatsumono, Nakamono and Owarimono.**

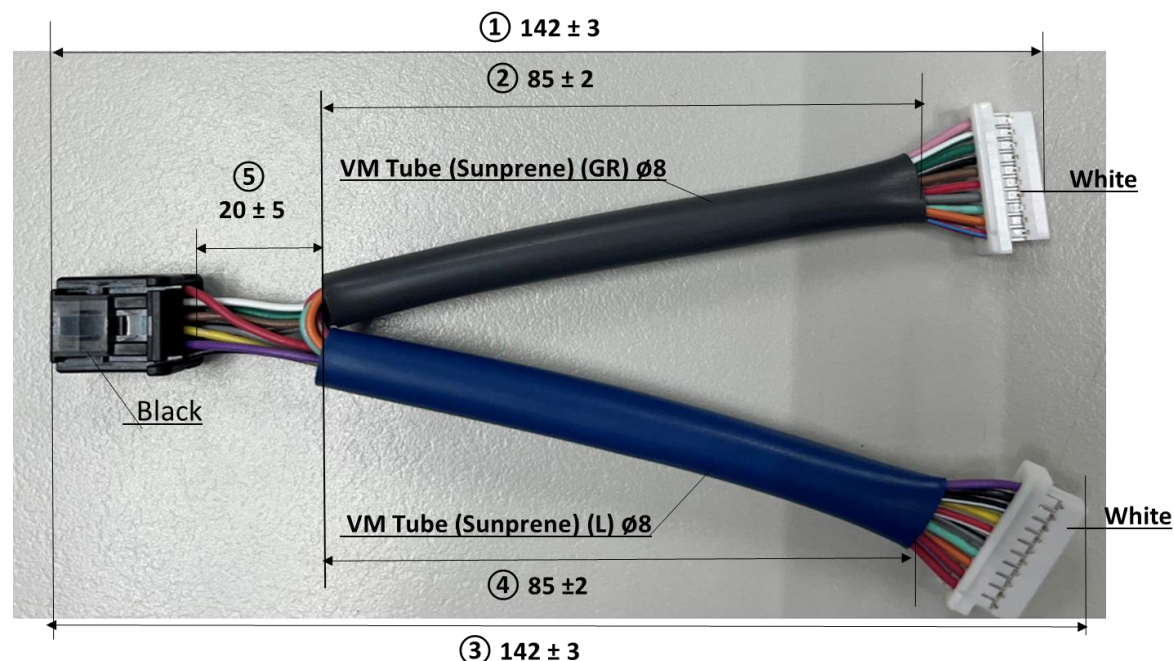
**Document reference/s:**

**1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection**

14

P1

Measurement



1. No wrong dimension.

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### PARTS:

1. Assy parts

JIG:

n/a

### VISUAL INSPECTION/ QUALITY CHECKPOINTS

# 75S779-0010

1. Check the connector lock, should be unlock.

2. Check the wire alignment. Make sure no tangled wires.

Blue VM Tube (Sunprene)

Dark Gray VM Tube (Sunprene)

3. Check the terminal if with backing out (no fully inserted) or deformed terminal.

4. Check the orientation of harness.

5. Check if no missing parts.

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