

	WORK INSTRUCTION				Effectivity Date:		September 12, 2024	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 300D / 75Q697-0351		Customer: TRJ	Car Model: TOYOTA-CROWN	Document No.: WI-ENG-PDE-349	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		6	Page No.: 1 of 18

PARTS:	1. Connector PBVP-10V-S (W) [2pcs.]; Connector 1746872-1 (B); AVSS 0.3 R, Y, V, B, GR/B L=170±2mm; AVSS 0.3 W/G, BR, G, GR, P L=176±2mm; AVSS 0.3 LG, R/L, B/W, R/W, OR L=321±2mm; Black VM tube (Sunprene) Ø8 L=128±3mm; Dark Brown VM tube (Sunprene) Ø8 L=134±3mm				JIG:	1. Insertion jig 2. Steering Navigation	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE		QUALITY POINTERS		
1	P1 Table lay-out	<div style="text-align: center;"> </div>		<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px solid red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>		Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 1. No deformed terminal 2. No wrong usage of parts	

Revision History						Prepared by	Reviewed by	Approved by	Noted by
09/12/24	6	Improved insertion jig; Change connector (PBVP-10V-S) orientation, terminal orientation and color sequence as customer claim countermeasure. Inclusion of Table lay-out. Improved Wire arrangement, Measurement and Visual inspection/Quality checkpoints. Change document number of Steering Electrical test (WI-QAD-QAC-252).	D.Castillo	C. Villanueva	A. Arañes	n/a			
02/25/23	5	Improve work procedure/Illustration; Change VM tube (Sunprene) from Brown VM tube (Sunprene) to Dark Brown VM tube (Sunprene); Standardize tube description: VM tube (Sunprene); Inclusion of Quality checkpoints.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes			
09/30/22	4	Improved the insertion jig and procedure.	D.Castillo	J. Loterte	C. Villanueva	A. Arañes			
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 24, 2018	

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Model code/Part number:

300D / 75Q697-0351

Customer:

TRJ

Car Model:

TOYOTA-CROWN

Document No.:

WI-ENG-PDE-349

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH



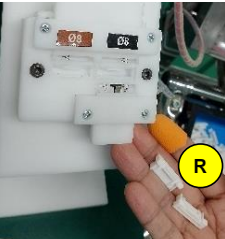
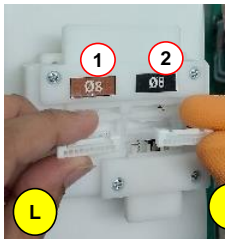

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PARTS:		1. Connector PBVP-10V-S (W) [2pcs]		JIG:	1. Insertion jig
NO.	PROCESS NAME	6	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1		<p>Insertion Jig</p>  <p>Visual reference</p>  <p>Connector orientation</p>   <p>Upper guide</p> <p>Lower guide</p> <p>1. Get the 2 pcs of PBVP-10V-S connector using right hand transfer the 1 connector to left hand then insert to insertion jig. <i>Note: Follow the connector orientation.</i></p>  <p>Press</p> <p>2. Press the upper and lower guide using left hand in same timing. Holes that need to be insert are only open.</p>	n/a	<ol style="list-style-type: none">1. Use the provided jig per model2. No wrong usage of parts3. No wrong orientation of connector4. No damaged connector

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Process Name/Title:

TAPING ASSEMBLY PROCESS

Model code/Part number:

300D / 75Q697-0351

Customer:

TRJ

Car Model:

TOYOTA-CROWN

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

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PARTS:

1. AVSS 0.3 W/G L=176±2mm; G L=176±2mm; R/L L=321±2mm; BR L=176±2mm; R/W L=321±2mm; P L=176±2mm; LG L=321±2mm; GR L=176±2mm; OR L=321±2mm; B/W L=321±2mm;

JIG:

1. Insertion jig
2. Steering Navigation

NO.

PROCESS NAME

6

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

INSERTION SEQUENCE FROM LEFT TO RIGHT



WIRE FACING



WIRE INSERTION ILLUSTRATION

1	2	3	4	5	6	7	8	9	10
W/G	G	R/L	BR	R/W	P	LG	GR	OR	B/W
176	176	321	176	321	176	321	176	321	321

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.

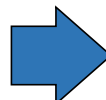
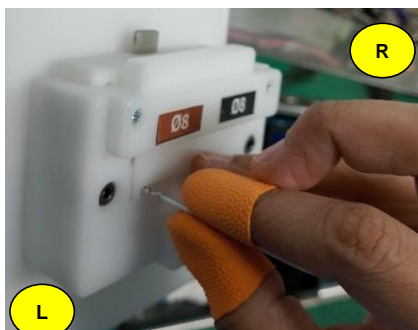
Important reminders/Note/s:

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.

3

P1

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




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

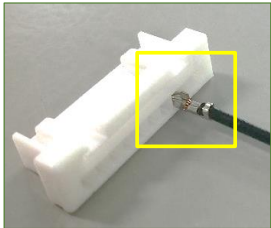

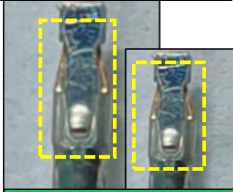
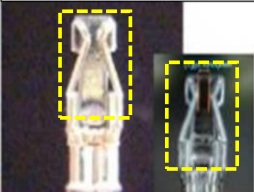
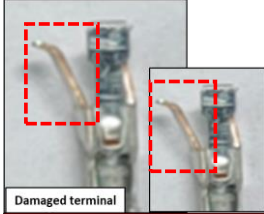

Note: Follow the insertion sequence based on the illustration.

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	Model code/Part number: 300D / 75Q697-0351		Customer: TRJ	Car Model: TOYOTA-CROWN	Document No.: WI-ENG-PDE-349		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	6	Page No.:	4 of 18


PARTS:	1. AVSS 0.3 W/G L=176±2mm; G L=176±2mm; R/L L=321±2mm; BR L=176±2mm; R/W L=321±2mm; P L=176±2mm; LG L=321±2mm; GR L=176±2mm; OR L=321±2mm; B/W L=321±2mm;			JIG:	1. Insertion jig 2. Steering Navigation		
NO.	PROCESS NAME	<div>6</div> 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: *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.</div>	<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>Important reminders/Note/s:</div> <div>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.</div> <div>Document reference/s:</div> <div>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.</div>				

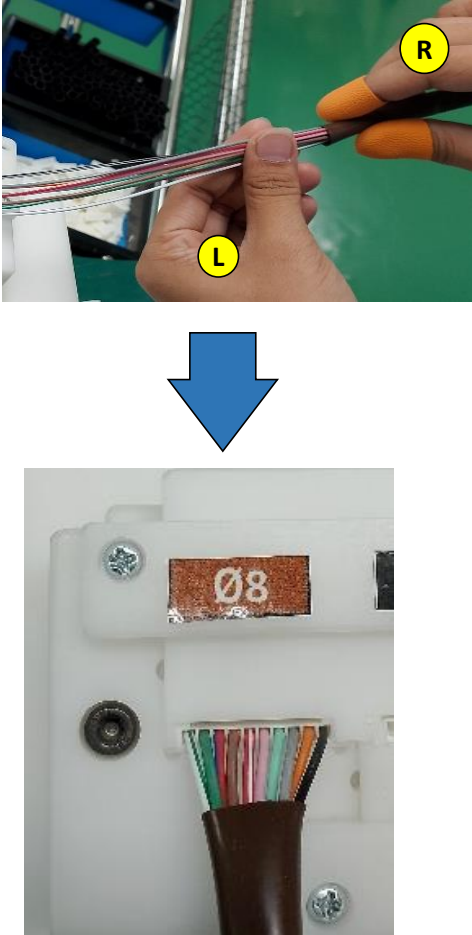
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	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:		6	Page No.:

PARTS:		1. Assy parts 2. Dark Brown VM tube (Sunprene) Ø8 L=134±2mm		JIG:	1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
4	P1	<div></div> <p>Wire insertion to Dark Brown VM tube (Sunprene) Ø8 L=134±2mm</p>		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:

300D / 75Q697-0351

Customer:

TRJ

Car Model:

TOYOTA-CROWN

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

September 12, 2024

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PARTS:

1. AVSS 0.3 B L=170±2mm; V L=170±2mm; GR/B L=170±2mm; Y L=170±2mm; R L=170±2mm

JIG:

1. Insertion jig
2. Steering Navigation

NO.

PROCESS NAME

6

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

5

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		
X	B	V	X	GR/B	Y	X	R	X	X
	170	170		170	170		170		



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

Lower guide



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

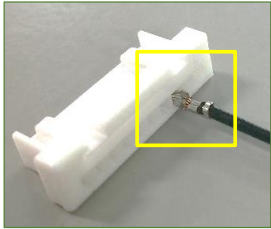
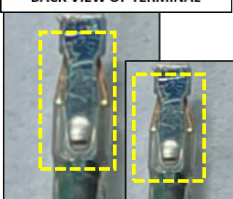
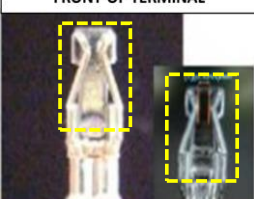

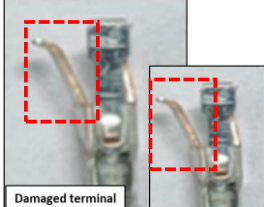
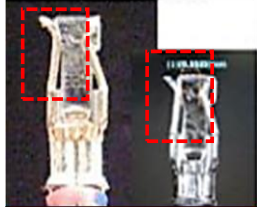
1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
3. Refer to GL-PRO-ASY-029 for Pull-Push-Push procedure.

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	6	Page No.:	7 of 18


PARTS:	1. AVSS 0.3 B L=170±2mm; V L=170±2mm; GR/B L=170±2mm; Y L=170±2mm; R L=170±2mm			JIG:	1. Insertion jig 2. Steering Navigation		
NO.	PROCESS NAME	<div>6</div> 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>BACK VIEW OF TERMINAL</div><div>GOOD Terminal condition</div><div>FRONT OF TERMINAL</div><div>GOOD Terminal condition</div></div> <div><div>Improper alignment of terminal to connector</div><div>BACK VIEW OF TERMINAL</div><div>Damaged terminal NO GOOD Terminal condition</div><div>FRONT VIEW OF TERMINAL</div><div>NO GOOD Terminal condition</div></div> <div>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.</div>		<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>Important reminders/Note/s:</div> <div>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.</div> <div>Document reference/s:</div> <div>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.</div>			

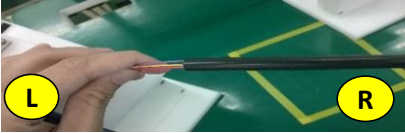
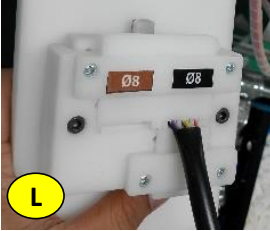

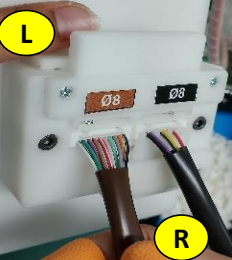
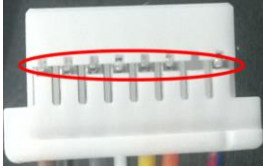
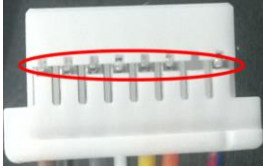

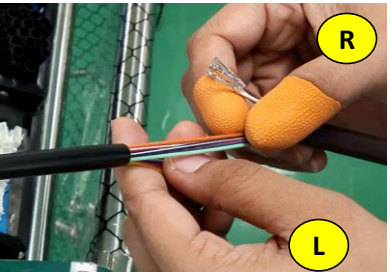
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	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		6	Page No.:	8 of 18	

PARTS:		1. Assy parts 2. Black VM tube (Sunprene) Ø8 L=128±2mm		JIG:	1. Insertion jig	
NO.	PROCESS NAME	6	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
6	P1 Wire insertion to Black VM tube (Sunprene) Ø8 L=128±2mm	<div><p>1. Get the Black VM tube (Sunprene) Ø8 L=128±2mm 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 Brown VM tube (Sunprene) using right hand.</p><p>3. Press the upper guide using left hand and press the lower button using left hand. Holes that need to be inserted are only open. Check the wire insertion condition.</p><p>Note: Second connector with inserted wire and Black VM tube (Sunprene) will stay in the jig.</p></div> <td>N/A</td> <td colspan="2"><p>Document reference/s:</p><p>1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.</p><p>1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires</p><div><p>Terminal tip must be visible</p></div></td>		N/A	<p>Document reference/s:</p> <p>1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.</p> <p>1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires</p> <div><p>Terminal tip must be visible</p></div>	
7	Wire insertion to assy parts	<div><p>1. Hold the Black VM tube (Sunprene) using left hand and insert the wires from Dark Brown VM tube (Sunprene) using right hand.</p></div> <td>N/A</td> <td colspan="2"><p>1. No wrong use of parts 2. No deformed terminal 3. No tangled wires</p></td>		N/A	<p>1. No wrong use of parts 2. No deformed terminal 3. No tangled wires</p>	

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300D / 75Q697-0351

Customer:

TRJ

Car Model:

TOYOTA-CROWN

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:

1. Assy parts

JIG:

1. Insertion jig
2. Steering Navigation

NO.

PROCESS NAME

6

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

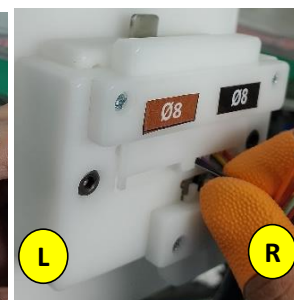
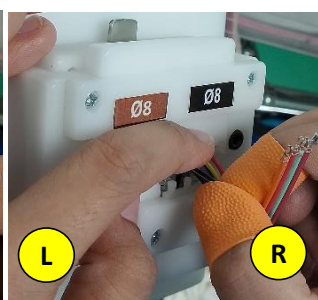
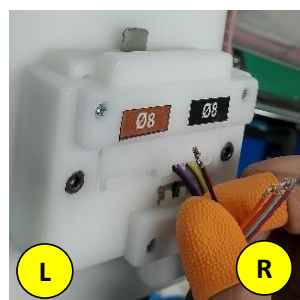
INSERTION SEQUENCE FROM LEFT TO RIGHT



WIRE FACING

WIRE INSERTION ILLUSTRATION

1			2			3		4	5
B/W	B	V	LG	GR/B	Y	R/L	R	OR	R/W
321	170	170	321	170	170	321	170	321	321



2. Hold the **B/W** 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 **LG-R/L-OR-R/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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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

September 12, 2024

Model code/Part number:

300D / 75Q697-0351

Customer: TRJ

Car Model: TOYOTA-CROWN

Document No.:

WI-ENG-PDE-349

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

6

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PARTS:

1. Assy parts

JIG:

1. Insertion jig
2. Steering Navigation

NO.

PROCESS NAME

6

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

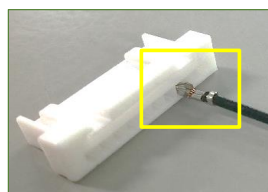
QUALITY POINTERS

8

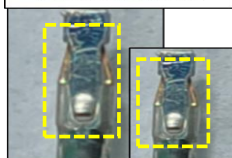
P1

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

Proper alignment of terminal to connector

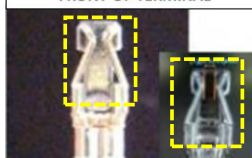


BACK VIEW OF TERMINAL



GOOD
Terminal condition

FRONT OF TERMINAL

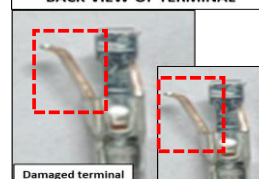


GOOD
Terminal condition

Improper alignment of terminal to connector



BACK VIEW OF TERMINAL



Damaged terminal
NO GOOD
Terminal condition

FRONT VIEW OF TERMINAL

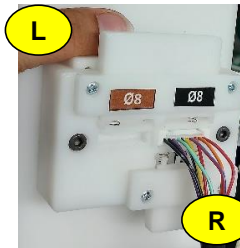
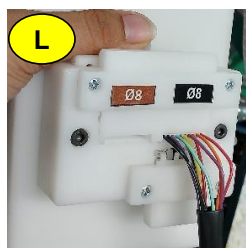


NO GOOD
Terminal condition

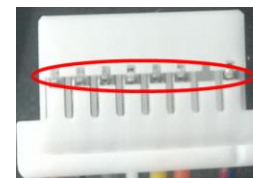
Note:

***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.

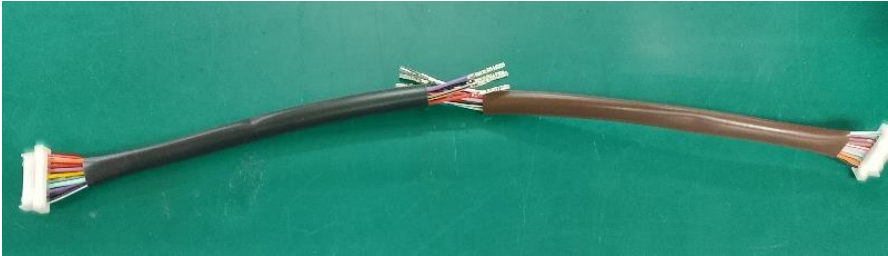
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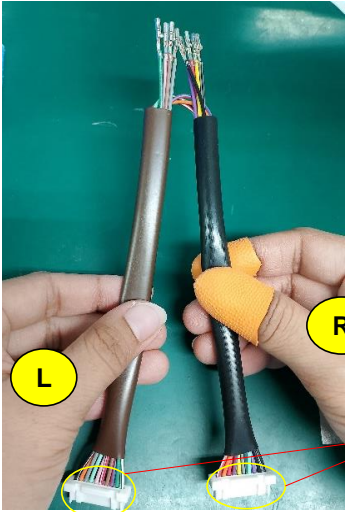
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	WORK INSTRUCTION				Effectivity Date:		September 12, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 300D / 75Q697-0351		Customer: TRJ	Car Model: TOYOTA-CROWN	Document No.:		WI-ENG-PDE-349	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		6	Page No.: 11 of 18

PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1	Wire folding		N/A	1. No deformed terminals 2. No tangled wires 3. No wrong facing



BEFORE FOLDING



AFTER FOLDING

1. Hold the assy parts using both hands then conduct wire arrangement.

Terminal tip is not visible

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Validity Date:

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300D / 75Q697-0351

Customer:

TRJ

Car Model:

TOYOTA-CROWN

Document No.:

WI-ENG-PDE-349

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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6

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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

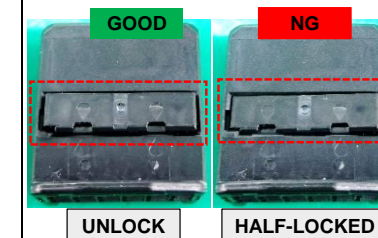
Connector setting to
insertion jig
1746872-1 (B)



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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Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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6

Page No.:

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PARTS:

1. Assy parts

JIG:

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

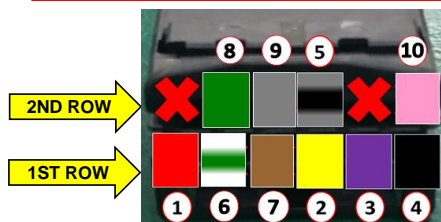
QUALITY POINTERS

11

P1

Wire insertion to
Connector
1746872-1 (B)

INSERTION SEQUENCE FROM LEFT TO RIGHT



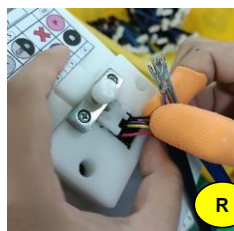
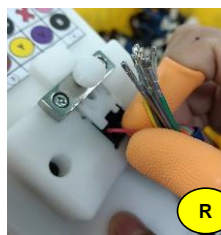
WIRE INSERTION ILLUSTRATION

	8	9	5		10
X	G	GR	GR/B	X	P
1	176	176	170		176
R	W/G	BR	Y	V	B
170	176	176	170	170	170

BLACK VM TUBE

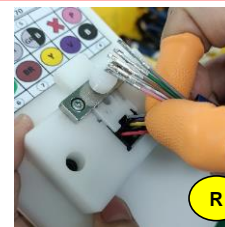


FIRST ROW (LEFT TO RIGHT)



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:

September 12, 2024

Model code/Part number:

300D / 75Q697-0351

Customer:

TRJ

Car Model:

TOYOTA-CROWN

Document No.:

WI-ENG-PDE-349

Purpose:

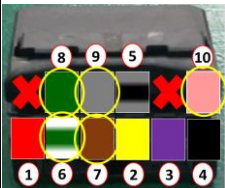
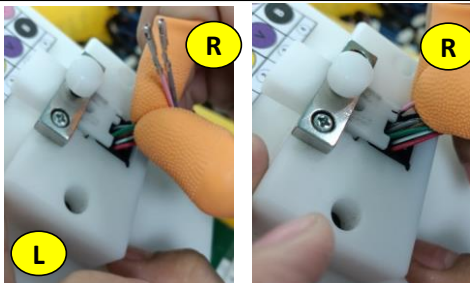
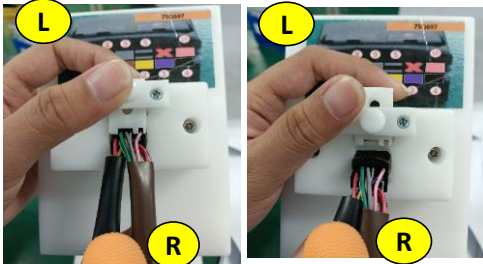
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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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>DARK BROWN VM TUBE</div><div>3. Hold the W/G wire using right hand and support the wire by left index finger then insert to terminal slot 2 using right hand. Repeat the process for BR wire. <i>Note: Follow the insertion sequence based on the above illustration.</i></div><div>4. Hold the G wire and insert to terminal slot 8 using right hand. Repeat the process for GR-P wires. <i>Note: Follow the insertion sequence based on the illustration.</i></div><div>5. Press the Upper button using left hand then remove the assy part using right hand.</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>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.</div> <div>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.</div>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

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Process Name/Title:

Model code/Part number:

300D / 75Q697-0351

Customer: TRJ

Car Model: TOYOTA-CROWN

Validity Date:

n/a

Document No.:

WI-ENG-PDE-349

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


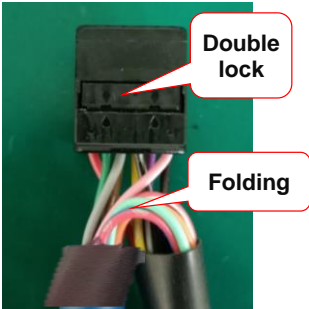
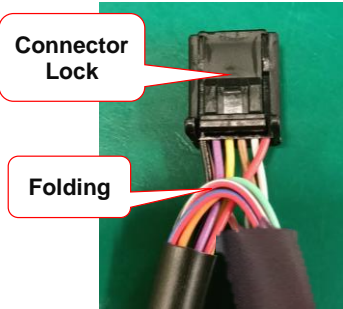

☒ MASSPRO

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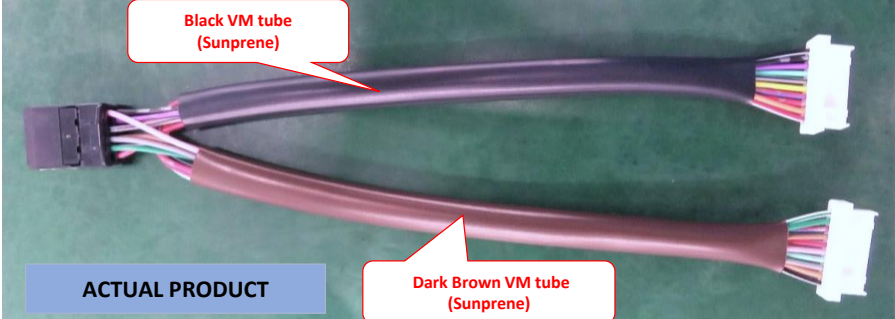

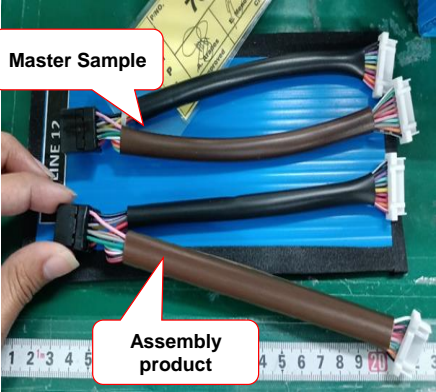


PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	6 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
12	P1	Wire Arrangement	<div><div>Folding at the back</div><div>Terminal tip is Not visible</div><div>GOOD FACING</div></div> <div><div>Terminal tip is visible</div><div>NG FACING</div><div>GOOD FACING</div><div>NG FACING</div><div>1. Hold the harness using both hands. Arrange the wire properly to avoid tangled wires.</div><div>Connector Lock</div><div>Folding</div><div>Double lock</div><div>Folding</div></div>	N/A	1. No wrong orientation of connector 2. No tangled wires 3. No wrong facing of wire folding

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	6	Page No.:	16 of 18

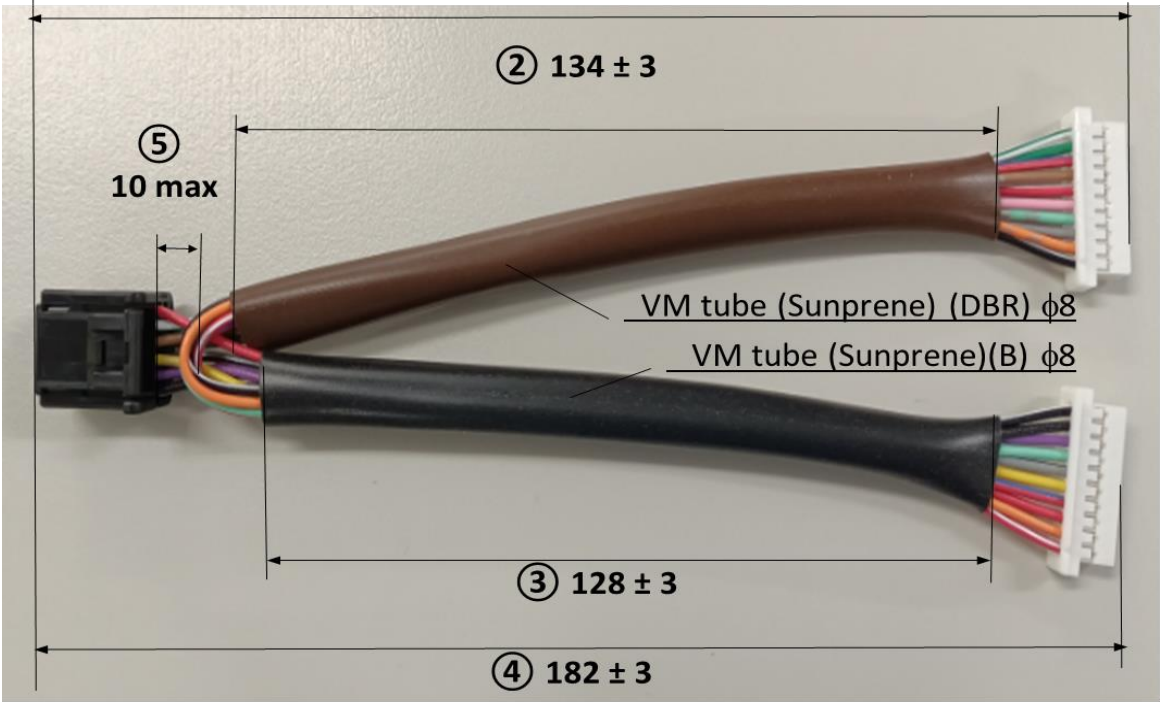

PARTS:		1. Assembled parts 2. Master sample			JIG:	n/a		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
13	P1	<div>1. Check the connector lock. Locking of connector is included to Steering electrical test.</div> <div>2. Check the wire alignment. Make sure no tangled wires</div> <div>3. Check the terminal if with backing out (not fully inserted) or no deformed terminal.</div> <div></div> <div>ACTUAL PRODUCT</div> <div>4. Check the orientation of harness.</div> <div>5. Compare to Master sample by tapping</div> <div></div> <div></div>			<div>6</div> <div>Document reference/s: 1. Refer to WI-QAD-QAC-252 Steering Electrical Test</div> <div>MASTER SAMPLE</div> <div></div> <div>MASTER SAMPLE</div> <div>MEASURING TAPE</div> <div></div>			

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	6	Page No.:	17 of 18

PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	<div><div>6</div>WORK PROCEDURE/ ILLUSTRATION</div>	TOOLS/PPE	QUALITY POINTERS	
14	P1	Measurement	<div><div>MEASURING TAPE</div></div>	<div>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</div> 1. No wrong dimension.	

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☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:

1. Assy parts

JIG:

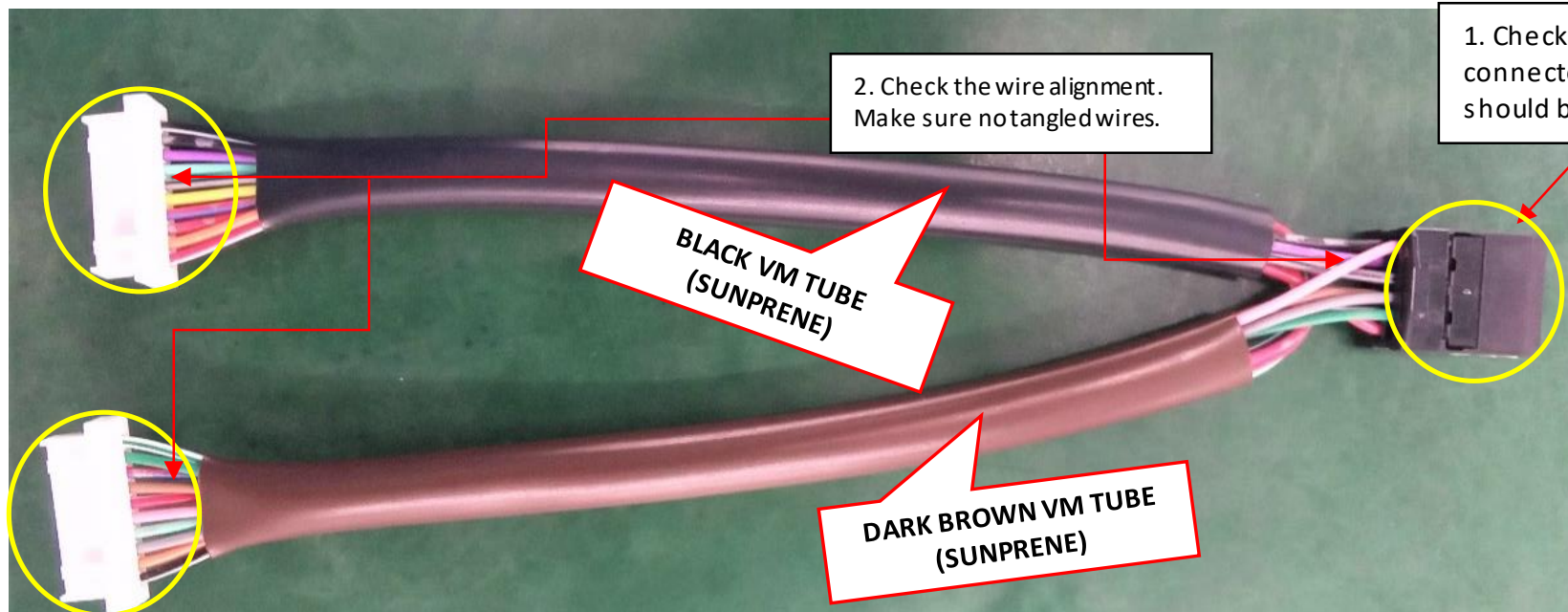
n/a



VISUAL INSPECTION/ QUALITY CHECKPOINTS

STEERING

75Q697-0351



1. Check the connector lock, should be unlock.

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

BLACK VM TUBE (SUNPRENE)

DARK BROWN VM TUBE (SUNPRENE)

3. Check the orientation of harness.

4. Check if no missing parts.

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

6. Compare to master sample.

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