



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

January 16, 2025

Validity Date:

n/a

Model code/Part number:

412D / 628127-0001

Customer: TRJ

Car Model:

TOYOTA-RAV4

Document No.:

WI-ENG-PDE-1156A

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1. Connector PARP-03V-E (L); Connector PARP-03V (W); AVSS 0.3 W wire L=314±2mm; AVSS 0.3 P-B wires L=268±2mm; White VM tube (Sunprene) Ø4.5, L=184±4mm; Connector PARP-03V (W); Black VM tube (Sunprene) Ø4, L=45±3mm; Black VM tube (Sunprene) Ø5.5, L=20±3mm; Retainer (PMS-03V-S (W); Black tape; Connector PBVP-04V-S; AVSS 0.3 G-W/G-BR wires L=184±2mm; Blue VM tube (Sunprene) Ø4.5, L=68±3mm; AVSS 0.3 OR wire L=162±2mm

JIG:

1. Insertion jig
2. Paddle switch navigation

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

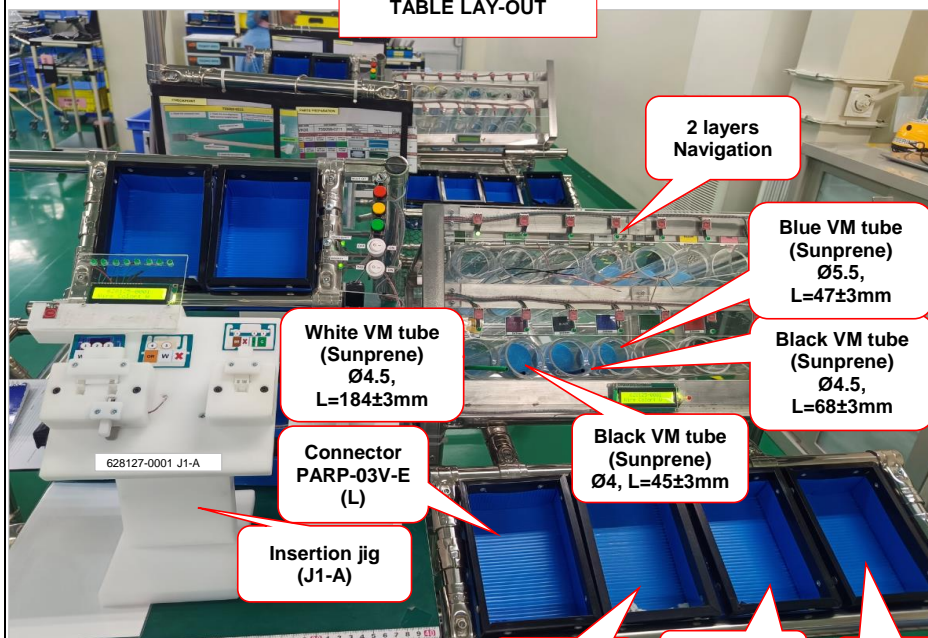
TOOLS/PPE

QUALITY POINTERS

1

P1

Table lay-out

**Safety Instruction**

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. No missing parts/tools
2. No excess parts/tools

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.

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

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date	Prepared by	Reviewed by	Approved by	Noted by
01/16/25	1	Change Purpose from Pre-launch to Masspro. Update the Work Procedure/illustration, provide insertion jigs and Steering Navigation; Additional table lay-out; Update the Quality Checkpoint.	M. Ariola	C. Villanueva	A.Arañes	n/a		M. Ariola	C. Villanueva	A.Arañes	n/a
01/07/25	0	Initial issue.	M. Ariola	C. Villanueva	A.Arañes	n/a					

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PARTS:
1. Connector PARP-03V-E (L)
2. Connector PARP-03V (W)

JIG:

1. Insertion jig
2. Paddle switch navigation

NO.

PROCESS NAME

1

WORK PROCEDURE/ ILLUSTRATION

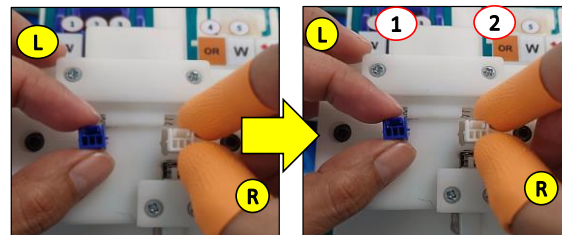
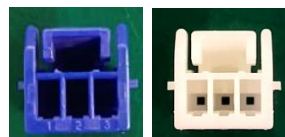
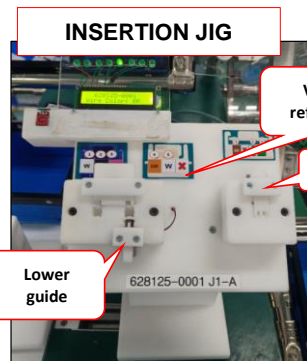
TOOLS/PPE

QUALITY POINTERS

2

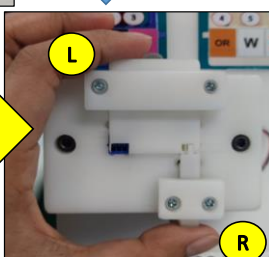
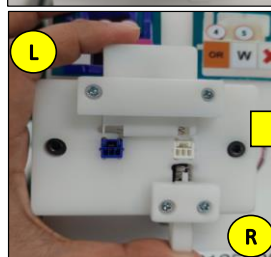
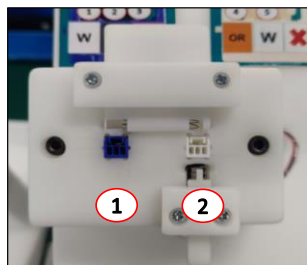
P1

Connector setting to
insertion jig
Connector PARP-03V-E
(L) and
Connector PARP-03V (W)



1. Get 1pc. of connector **PARP-03V-E (L)** using left hand and 1pc. of Connector **PARP-03V (W)** then insert to insertion jig using both hands.

Note: Follow the connector orientation



3. Press the upper and lower guide using left hand in same timing. Holes that need to be insert are only open.

STEERING NAVIGATION
(2 layers)



CONTROLLER



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PARTS:

1. AVSS 0.3 W wire L=314±2mm
2. AVSS 0.3 P-B wires L=268±2mm

JIG:

1. Insertion jig
2. Paddle switch navigation

NO.

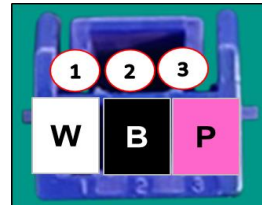
PROCESS NAME

1

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

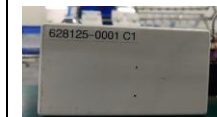
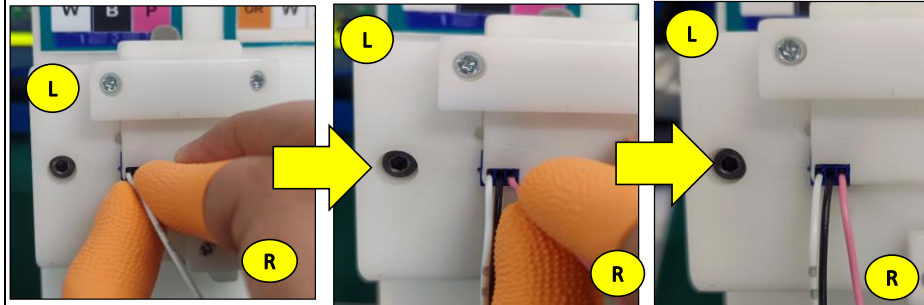
INSERTION SEQUENCE FROM LEFT
TO RIGHTTERMINAL
FACING

WIRE INSERTION ILLUSTRATION

1	2	3
W	B	P
314	268	268

STEERING NAVIGATION
(2 layers)

CONTROLLER

Wire insertion to
Connector PARP-03V (W)

1. Get the **W** wire using right hand then insert to connector Conduct **2x** push pull after wire insertion. Repeat the process to **B** and **Pink** wire.

Note: Follow the insertion sequence based on the illustration.

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

Document references:

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

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PRE-LAUNCH




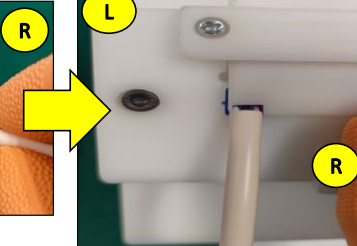

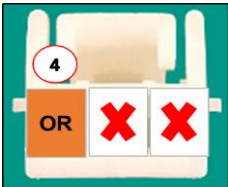
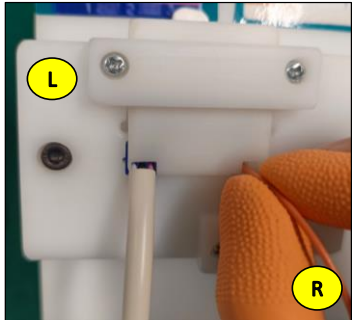

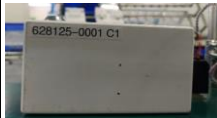
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PARTS:		1. Assy parts 2. White VM tube (Sunprene) Ø4.5, L=184±4mm 3. Connector PARP-03V (W)		4. AVSS 0.3 OR wires L=162±2mm		JIG:	1. Insertion jig 2. Paddle switch navigation									
NO.	PROCESS NAME		1 WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS									
4	Wire insertion to White VM tube (Sunprene) Ø4.5, L=184±4mm		<div><div></div><div></div><div></div><div><div>1. Hold the wires using left hand, get the White VM tube (Sunprene) Ø4.5, L=184±4mm using right hand then insert the wires using both hands</div></div></div>			n/a	1. No wrong usage of parts. 2. No deformed terminal. 3. No tangled wires.									
5	P1	Wire insertion to Connector PARP-03V (W)	<div><div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div><div></div><div></div><div><div>WIRE INSERTION ILLUSTRATION</div><table><tr><td>1</td><td></td><td></td></tr><tr><td>OR</td><td>X</td><td>X</td></tr><tr><td>162</td><td></td><td></td></tr></table><div>1. Get the OR wire using right hand then insert to connector. Conduct 2x push pull after wire insertion. Note: Follow the insertion sequence based on the illustration.</div></div></div>			1			OR	X	X	162			<div>STEERING NAVIGATION (2 layers)</div> <div></div> <div>CONTROLLER</div> <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. 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. 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 references: 1. Refer to WI-PRO-CNC-017 2. Refer to WI-ENG-PDE-044 for the Steering Navigation Controller procedure. 3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
1																
OR	X	X														
162																

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Car Model:

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Purpose:



PROTOTYPE



PRE-LAUNCH



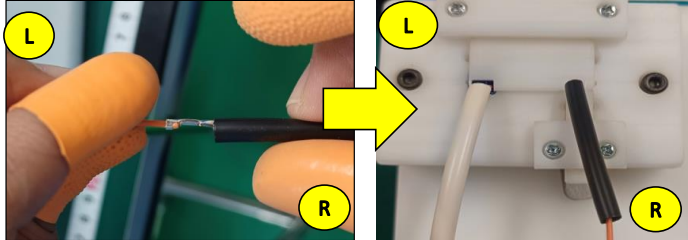
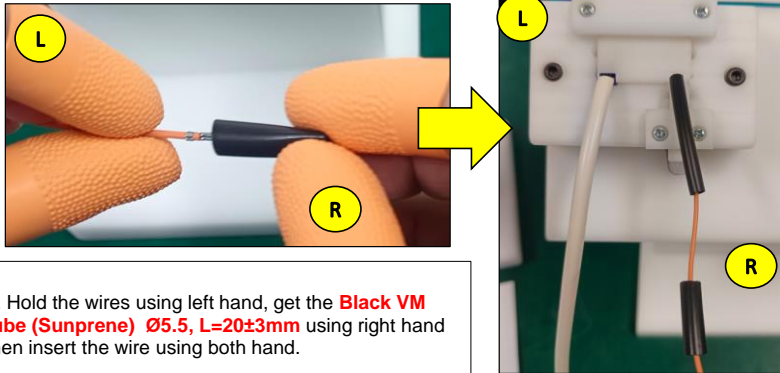
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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) Ø4, L=45±3mm 3. Black VM tube (Sunprene) Ø5.5, L=20±3mm		JIG:	1. Insertion jig 2. Paddle switch navigation
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	Wire insertion to Black VM tube (Sunprene) Ø4, L=45±3mm	 <div>1. Hold the wires using left hand, get the Black VM tube (Sunprene) Ø4, L=45±3mm using right hand then insert the wire using both hand.</div>		n/a	1. No wrong usage of parts. 2. No deformed terminal. 3. No tangled wires.
7	P1 Wire insertion to Black VM tube (Sunprene) Ø5.5, L=20±3mm	 <div>1. Hold the wires using left hand, get the Black VM tube (Sunprene) Ø5.5, L=20±3mm using right hand then insert the wire using both hand.</div>		n/a	1. No wrong usage of parts. 2. No deformed terminal. 3. No tangled wires. 4. No Missing tubes

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PROTOTYPE



PRE-LAUNCH



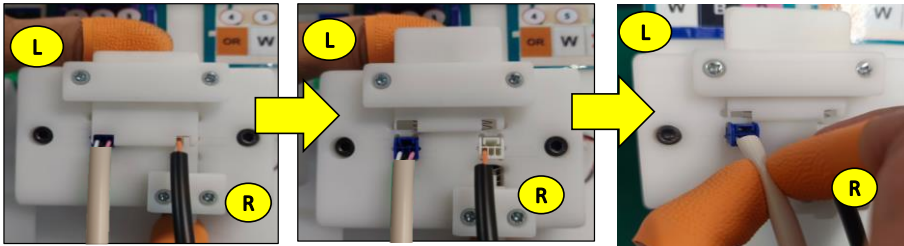
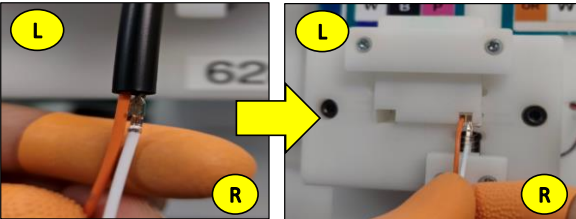
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PARTS:		1. Assy parts		JIG:	1. Insertion jig 2. Paddle switch navigation
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1 Wire insertion to Black VM tube (Sunprene) Ø5.5, L=20±3mm (Continuation)	 <p>2. Press the upper and lower button using both hands. Remove the 1st Connector with inserted wires using right hand. After removal of harness, Press the Upper guide using left hand. Note: Second connector with inserted wire and Black VM tube (Sunprene) should stay on the jig.</p>  <p>3. Hold the 1st Black VM tube (Sunprene) using left hand then insert the wires of assy parts (Connector to wires) using right hand. Repeat the process to 2nd Black VM tube (Sunprene)</p>		n/a	1. No wrong usage of parts. 2. No deformed terminal. 3. No tangled wires.

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PARTS:

1. Assy parts

JIG:

1. Insertion jig
2. Paddle switch navigation

NO.

PROCESS NAME



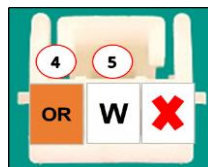
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

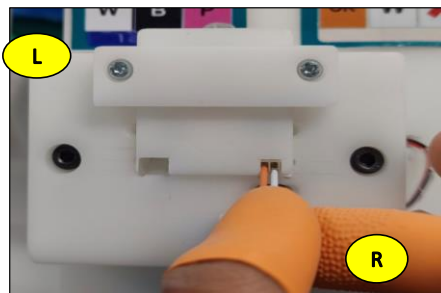
QUALITY POINTERS

8

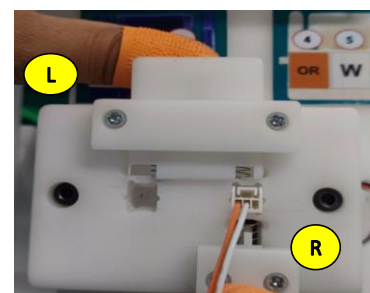
P1

Wire insertion to
Connector PARP-03V (W)
(Continuation)INSERTION SEQUENCE FROM
LEFT TO RIGHTTERMINAL
FACING

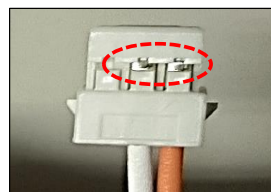
1	2	3
OR	W	X
162	314	X

WIRE INSERTION
ILLUSTRATION

1. Get the **W** wire using right hand then insert to connector. Conduct **2x** push pull after wire insertion.
Note: Follow the insertion sequence based on the illustration.



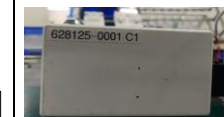
2. Press the upper button using left hand. Remove the **2nd** connector with inserted wires using right hand.



3. After insertion, check the terminal tip condition, **must be visible.**

STEERING NAVIGATION
(2 layers)

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

Document references:

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

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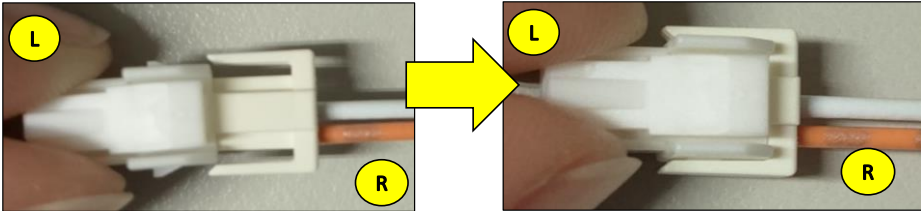
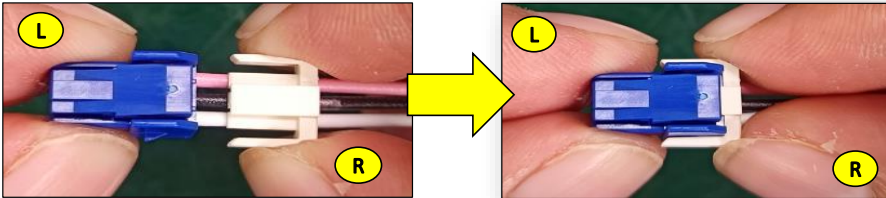
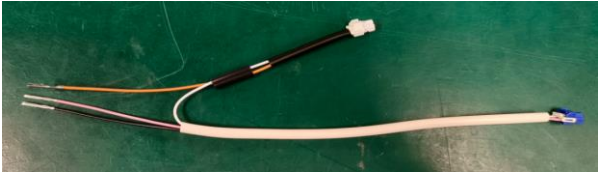
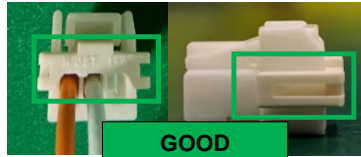
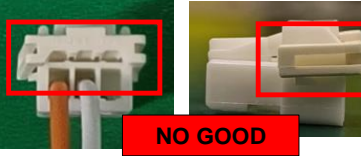
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PARTS:	1. Retainer (PMS-03V-S (W)) [2pcs] 2. Assy parts			JIG:	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
9	P1 Retainer attachment PMS-03V-S (W)	<div></div> <div>1. Hold the Connector using left hand, get the Retainer PMS-03V-S (W) then insert the clamp using right hand. Note: Sound will be heard if properly inserted.</div> <div></div> <div>2. Hold the Connector using left hand, get the Retainer PMS-03V-S (W) then insert the clamp using right hand. Note: Sound will be heard if properly inserted. (After insertion, set aside the assy parts)</div> <div></div>	n/a	<div>1. Retainer must be fully inserted 2. No missing retainers 3. No Unlock/halflocked</div> <div>RETAINER ORIENTATION</div> <div>GOOD</div> <div>NO GOOD</div>	

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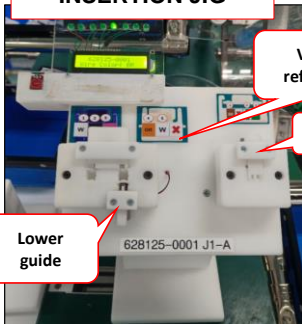
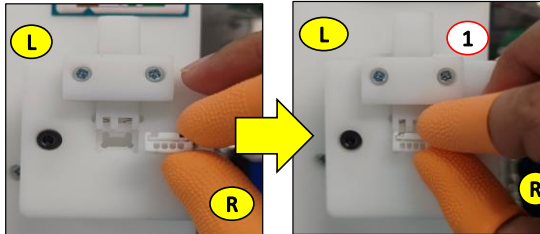
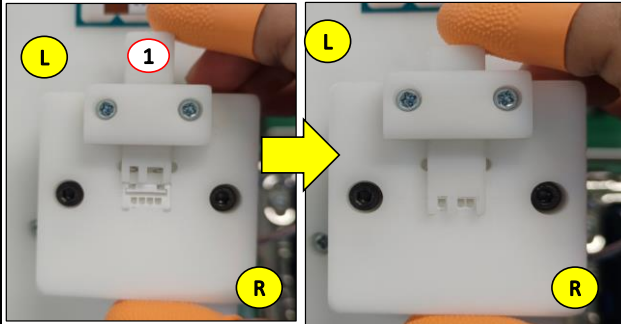


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PARTS:		1. Connector PBVP-04V-S		JIG:	1. Insertion jig 2. Paddle switch navigation
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	P1 Connector setting Connector PBVP-04V-S (W)	<div><div><div>INSERTION JIG</div><div></div></div><div><div>CONNECTOR ORIENTATION</div><div></div><div>1. Get 1pc. of connector PBVP-04V-S using right hand then insert to insertion jig. <i>Note: Follow the connector orientation</i></div></div><div><div></div><div>2. Press the lower guide using right hand in same timing. Holes that need to be insert are only open.</div></div></div>		<div>STEERING NAVIGATION (2 layers)</div> <div></div> <div>CONTROLLER</div> <div></div>	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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Model code/Part number:

412D / 628127-0001

Customer: TRJ

Car Model: TOYOTA-RAV4

Document No.:

WI-ENG-PDE-1156A

Purpose:



PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Connector PBVP-04V-S
2. AVSS 0.3 G-W/G-BR wires L=184±2mm

JIG:

1. Insertion jig
2. Paddle switch navigation

NO.

PROCESS NAME

1

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

11

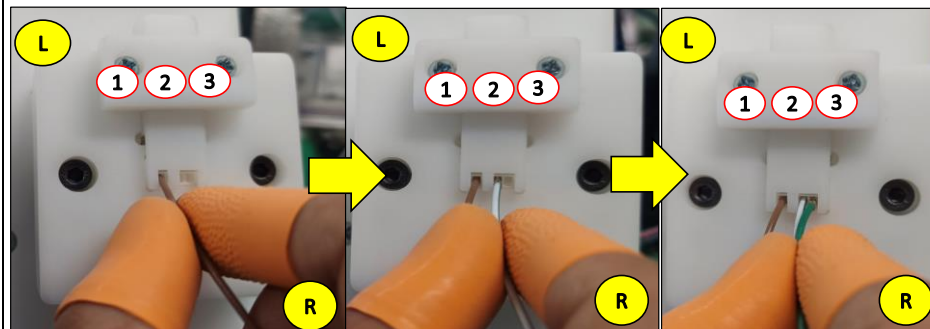
P1

Wire insertion to
Connector PBVP-04V-SINSERTION SEQUENCE FROM
LEFT TO RIGHT

TERMINAL FACING

WIRE INSERTION ILLUSTRATION

1	2	3	4
BR	X	W/G	G
184		184	184

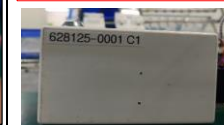


1. Get the **BR** wire using right hand then insert to connector Conduct **2x** push pull after wire insertion. Repeat the process to **W/G** and **G** wires.

Note: Follow the insertion sequence based on the illustration.

STEERING NAVIGATION
(2 layers)

CONTROLLER

**Important reminders/Note/s:**

1. Please hold the wire near terminal.
2. Make sure wires are properly inserted.
3. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
4. 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 references:

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

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

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January 16, 2025

Process Name/Title:

Validity Date:

n/a

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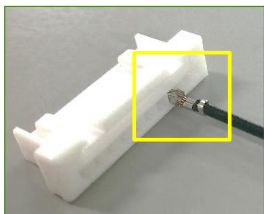

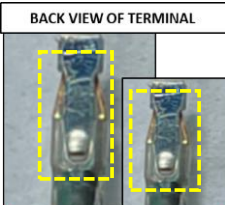
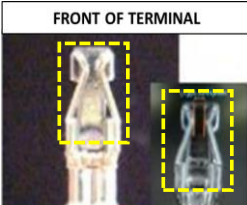
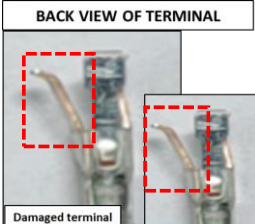
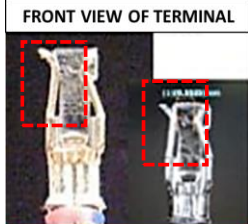
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PARTS:		1. Assy parts		JIG:	1. Insertion jig 2. Paddle switch navigation
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1	<p>Proper alignment of terminal to connector</p>  <p>Improper alignment of terminal to connector</p>  <p>BACK VIEW OF TERMINAL</p>  <p>GOOD Terminal condition</p> <p>FRONT OF TERMINAL</p>  <p>GOOD Terminal condition</p> <p>BACK VIEW OF TERMINAL</p>  <p>Damaged terminal NO GOOD Terminal condition</p> <p>FRONT VIEW OF TERMINAL</p>  <p>NO GOOD Terminal condition</p> <p>Note:</p> <p><i>*Make sure the terminal was in proper alignment before insert.</i> <i>*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></p>			<p>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.</p> <p>Important reminders/Note/s:</p> <p><i>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</i> <i>2. Please hold the wires near terminal during insertion.</i> <i>3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</i> <i>4. Insertion of wires must be from left to right.</i></p> <p>Document reference/s:</p> <p><i>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i> <i>2. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</i></p>

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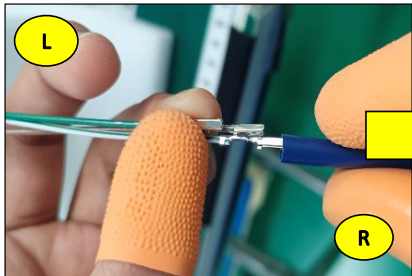
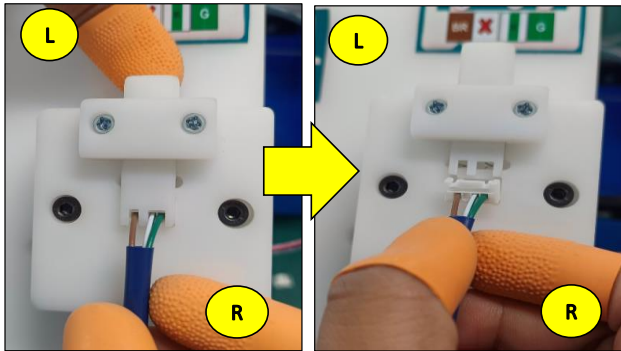

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PARTS:		1. Assy parts 2. Blue VM tube (Sunprene) Ø4.5, L=68±3mm	JIG:	1. Insertion jig 2. Paddle switch navigation
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
12	P1 Wire insertion to Blue VM tube (Sunprene) Ø4.5, L=68±3mm	<div></div> <div><p>1. Hold the wires using left hand, get the Blue VM tube (Sunprene) Ø4.5, L=68±3mm using right hand then insert the wires using both hands.</p></div> <div></div> <div><p>2. After insertion, Press the Upper button using left hand then remove the assy parts using right hand. Check the insertion condition.</p></div>	n/a	<div></div> <div><p>Terminal tip must be visible.</p></div> <div><p>Important reminders/Note/s:</p><p>1. Refer to GL-PRO-ASY-025 for inspection Standard for Coupler Insertion.</p><p>2. Refer to GL-PRO-ASY-043 for verification of Fully inserted wires.</p></div>

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PARTS:

n/a

JIG:

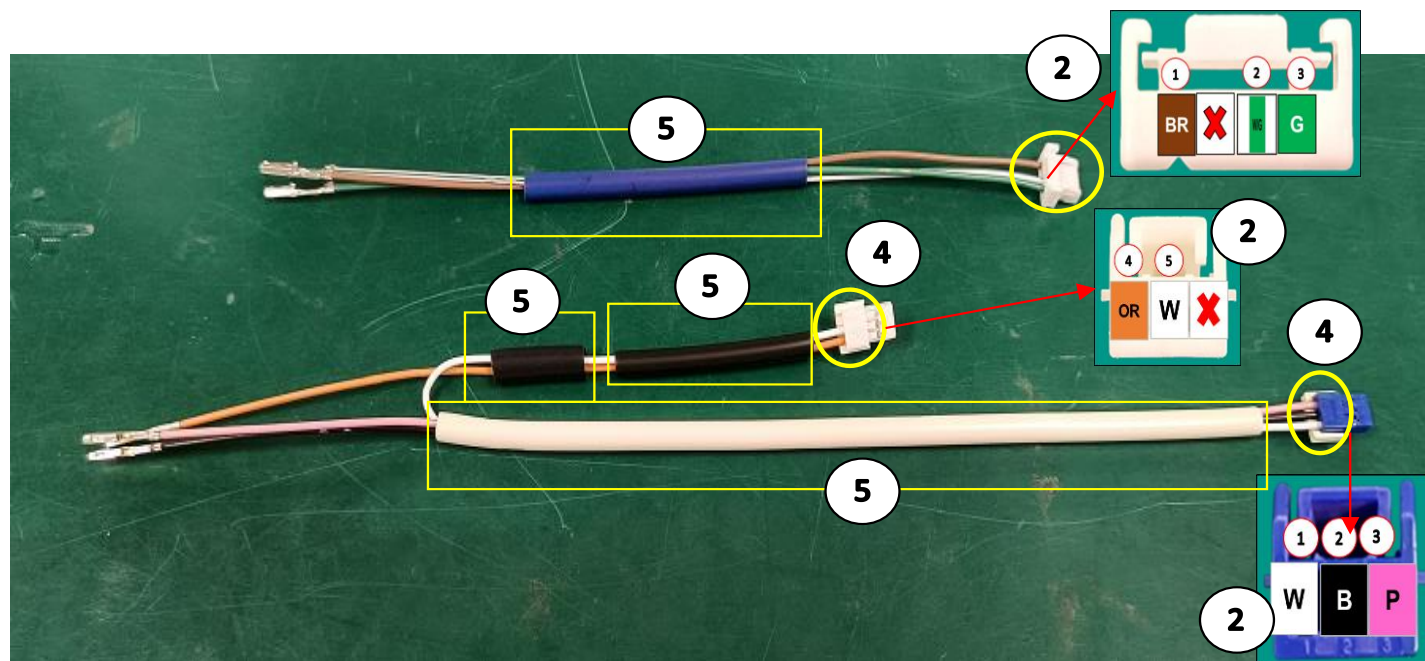
n/a

1

VISUAL INSPECTION/ QUALITY CHECKPOINTS

P1

628127-0001



1. No deformed terminal

2. No wrong insertion

3. No Terminal backing out

4. No missing retainers

5. No Missing VM tube (Sunprene)

6. No wrong used of tubes

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