WORK INSTRUCTION Effectivity Date: July 4,2024												
		Process Name/Title:	TAPIN	G ASSEMBLY PR	OCESS		Validi	ty Date:		n/a		
- I U	7	Model code/Part number:	310D / 75S744-7050A	Customer: TRJ	Car Model:	RAV4	Docur	ment No.:		WI-ENG-PDE-8	68	
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO		Revis	ion No.:	0	Page No.:	1 of 7	
1. AVSS 0.3 GR/B L=113±2mm; 2. Light Blue tape (19mm) 3. White SV tube (Vinyl) ø3; t=0.5; L=64±3mm								1. Measurin	1. Measuring Tape			
	Р	ROCESS NAME	WORK F	PROCEDURE/ ILLUS	STRATION			TOOLS/PPE	(QUALITY POIN	TERS	
		Wire Insertion of GR/B to White SV tube (Vinyl) ø3; t=0.5; L=64±3mm				=64±3mm using	pr. (9	Be sure to wear required personal otective equipmer during operation gloves, finger cots, etc.)	n 2. No peel- 3. No loose 4. No miss 5. No wron 6. No wron	off tape tape ing tape g use of tape g dimension	10 7 8 9 1	
	n/a	Taping Vinyl to Wire near terminal	60	1 2 3 4	3. After taping, check and taping condition.	k the dimension	2. pl	practice 5's. Personal things of the workplace is rohibited. Keep it in your locker. Alert level or any trouble, information Assembly Assista Supervisor or Line	Importa 1.Please measurir measure	ont reminders/nuse calibrated/way tape when get	note/s:	
			NOTE	: SET ASIDE THE ASS	Y PARTS				Docume 1. Please	refer to WI-PRO		
1			Revision History					Prepared by	Reviewed by	Approved by	Noted by	
0 Ini	itial Issu	ne			A Hernandez C Vii	Ilanueva A Arañes		Ohmendez 2	Joseph House	A Arabes	N/A	
ev. No			Details of Change				loted by	()	•	, , , , , , , , , , , , , , , , , , , ,	14/7	
	2. 3	1. AVSS 2. Light B 3. White P	Model code/Part number: Purpose: 1. AVSS 0.3 GR/B L=113±2mm; 2. Light Blue tape (19mm) 3. White SV tube (Vinyl) Ø3; t=0.5; L= PROCESS NAME Wire Insertion of GR/B to White SV tube (Vinyl) Ø3; t=0.5; L=64±3mm n/a Taping Vinyl to Wire near terminal	Model code/Part number: Purpose: 1. AVSS 0.3 GR/B L=113±2mm; 2. Light Blue tape (19mm) 3. White SIV tube (Vinyl) ø3; t=0.5; L=64±3mm	Model code/Part number: Sand Purpose PROTOTYPE PRE-LAUNCH	Model code/Part number: Purpose:	Model code/Part number: 310D / 75S744-7050A	Model code/Part number: 310D / 75S744-7050A Customer: TRJ Car Model: RAV4 Document of the property of the prop	Model code/Part number: 310D / 75S744-7050A Customer: TRJ Carr Model: RAV4 Document No.: Puppose: □PROTOTYPE ■ PRE-LAUNCH □ MASSPRO Revision No.: 1. AVSS 0.3 GR/B L=113±2mm; 2. Light Blue tape (19mm) 3. White SV tube (Vinyl) e3; t=0.5; L=64±3mm PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE Wire Insention of GR/B to White SV tube (Vinyl) e3; t=0.5; L=64±3mm using protective equipment during operation (gloves, finger cost, etc.) 1. Get the GR/B wire using left hand. Get 1 pc of White SV tube (Vinyl) a3; t=0.5; L=64±3mm using protective equipment for the GR/B wire. (Based on the Illustration above) 1. Get the GR/B wire using left hand. Get 1 pc of White SV tube (Vinyl) a3; t=0.5; L=64±3mm using protective equipment during operation (gloves, finger cost, etc.) 1. Alentain and alway protective equipment of the protective e	Model code Part number: Purpose: PREADNCH MASSPRO Revision No.: 0	Note Code Part number: 310D / 75S744-7050A Customer: TRJ Car Model: RAV4 Document No: WIFENS-PDE-8	

	WORK INSTRUCTION Effectivity Date: July 4, 2024											
		Process Name/Title:		NG ASSEMBLY P	ROCESS	Validity Date:		n/a				
		Model code/Part number:	310D / 75S744-7050A	Customer: TR.		Document No.:		WI-ENG-PDE-8	368			
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO MASSPRO	Revision No.:	0	Page No.:	2 of 7			
PARTS:		ector 4A1230-0000 (W); 5 0.3 R L=166±2mm; WG L=	168±2mm; BR L=172±2mm;			JIG:	n/a					
NO.	F	ROCESS NAME	WORK	PROCEDURE/ ILLU	STRATION	TOOLS/PPE	(QUALITY POIN	TERS			
3	n/a	Wire insertion to connector PBVP-10V-S (W)	VISUAL REFERENCE 4. Hold the connector PBVP-10V-S (wire and insert to terminal slot 1 of chand. Conduct 2x push pull after wire process to WG wire in terminal Slot 2 terminal Slot 5. Note: Follow the insertion sequence illustration.	1 R 166 X	WIRE INSERTION ILLUSTRATION 2 3 4 5 WG BR 172 X 5. After insertion, check the wire condition. NOTE: SET ASIDE THE ASSY PARTS	n/a	2. No wron 3. No dam. 4. No wron 5. No loose 6. No wron 7. One by 8. No defo 9. No wron In 1. Make inserted 2. Condu insertiol 3.Do not 4.Please 1. Refer Strip len 2. Refer	g insertion one insertion rmed terminal g wire facing nportant reminde sure wires are pi tot Pull-Push-Pul	or's/Note: roperly I-Push after e. ear terminal. ences: 017 for Wire 029 for pull-			

			WORK INS	Effectivity Date:	July 4, 2024						
		Process Name/Title:		IG ASSEMBLY PRO			Validity Date:	n/a			
		Model code/Part number:	310D / 75S744-7050A	Customer: TRJ	Car Model:	RAV4	Document No.:		WI-ENG-PDE-86	i8	
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO		Revision No.:	0	Page No.:	3 of 7	
PARTS:		parts ector PBVP-10V-S (W) SV tube (Vinyl) Ø7; t=0.5; L=	L=285±2mm; V L=28	.=113±1mm; R L=166±2mm; V 35±2mm; Y L=285±2mm; G L=			JIG:	n/a			
NO.	PROCESS NAME WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	(QUALITY POINT	ERS			
4	n/a	Wire insertion to connector PBVP-10V-S (W)	6. Hold the connector PBVP-10V-S (M to terminal slot 1 of connector using riwire insertion. Repeat the process to terminal slot 6. Insert LG wires to Slot Note: Follow the insertion sequence.	1 2 3 4 Y V B G 285 285 285 285 V) then get the Yellow wire ght hand. Conduct 2x push V-B-G. Get the GR/B wire that 9.	and insert pull after nen insert to	N 8 9 10 LG 289 er insertion, the terminal tip tion, must be	n/a	2. No wron 3. No dama 4. No wron 5. No loose 6. No wron 7. One by o 8. No defor 9. No wron Im, 1. Make s inserted. 2. Condu insertion 3. Do not	g insertion one insertion rmed terminal g wire facing portant reminder's sure wires are project Pull-Push-Pull-	s/Note: perly Push after	
5		Y-V-B-G-GR/B-LG Wire insertion to Black SV tube (Vinyl) Ø7; t=0.5; L=131±3mm PBVP-10V-S (W)	8. Hold the wires using left hand, get the Black SV tube (Vinyl) ø7; t=0.5; L=131±3mm using right hand then institute long wires.	Black SV tub	sure the GR/B wire is the (Vinyl) ø7; t=0.5;	e on top of		1. Refer to Strip leng 2. Refer to	Document referen to WI-PRO-CNC-01 ght tolerance. to GL PRO-ASY-02 Il-push procedure	17 for Wire	

			WORK INS	STRUCTION			Effectivity Date:		July 4, 2024	
		Process Name/Title:	TAPIN	Validity Date:		n/a				
		Model code/Part number:	310D / 75S744-7050A	Customer: TRJ	Car Model:	RAV4	Document No.:		WI-ENG-PDE-8	68
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO		Revision No.:	0	Page No.:	4 of 7
PARTS:	1. Assy						JIG:	n/a		
NO.	F	PROCESS NAME	WORK P	PROCEDURE/ ILLUSTF	RATION		TOOLS/PPE	(QUALITY POIN	ΓERS
6		Wire insertion of assy part (Connector 4A1230- 0000 (W) with inserted wires) to Black SV tube (Vinyl) Ø7; t=0.5; L=131±3mm with assy part	9. Hold the assy part (Connector PBVf first assy part (Connector 4A1230-000 SV tube (Vinyl) Ø7; t=0.5; L=131±3mi	00 (W) with inserted wires)	wires) using left ha using right hand th	nd then get the en insert to Black				
7	n/a	Wire insertion to Connector PBVP-10V-S (W) with inserted wires		WIRE II 1 2 3 4 Y V B G 285 285 285 285 285	NSERTION ILLUSTRATION 5 6 7 GR/B R	8 9 10 WG LG BR	N/A	1. No wron 2. No defor	g insertion rmed terminal	

10. Hold the Connector PBVP-10V-S (W) with inserted wires then get the Red wire and insert to terminal slot 7 of connector using right hand. Conduct 2x push pull after wire insertion. Repeat the process to W/G wire to Slot 8 and BR wire to Slot 10.

Note: Follow the insertion sequence based on the illustration.

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			WORK INS	TRUCTION			Effectivity Date:		July 4, 2024	1
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		Model code/Part number:	310D / 75S744-7050A	Customer:	TRJ Car Model:	RAV4	Document No.:		WI-ENG-PDE-8	368
		Purpose:	PROTOTYPE	SASSEMBLY PROCESS Oustomer: TRJ Car Model: RAV4 Document No.: WI-ENG-PDE-868 PRE-LAUNCH MASSPRO Revision No.: 0 Page No.: 5 of 7						
PARTS:		parts ector PBVP-06V-S (W); SV tube (Vinyl) ø5.5; t=0.5;	L=122±3mm	JIG:	n/a					
NO.	F	PROCESS NAME	WORK I	PROCEDURE/ I	ILLUSTRATION		TOOLS/PPE QUALITY POINTERS			ITERS
8		Wire insertion of Assy part to Black SV tube (Vinyl) ø5.5; t=0.5; L=122±3mm	L	11. Hold the a ø5.5; t=0.5; L	_=122±3mm then insert the B-\	tube (Vinyl) /-Y-G and LG		2. No wrong use of connector3. No damaged connector4. No wrong insertion of wires5. No loose insertion		
9	n/a	Wire insertion of Assy part to Connector PBVP-06V-S (W)	12. Hold the connector PBVP-06V-S (Black wire then insert to terminal slot using right hand. Conduct 2x push pull insertion. Repeat the process to V-Y-G	U) then get the of connector after wire after wires.	WIRE INSERTION ILLUSTRAL 2 3 4 V Y G 285 285 285 13. After insertion, check th condition, must be visible.	TION 5 6 LG 289 e terminal tip	N/A	7. One by 8. No defo 9. No wron 1. Make s inserted. 2. Conduinsertion 3. Do not 4. Please	portant remindersure wires are protect Pull-Push-Pull. exert exert extra force hold the wire needs to be procument references.	operly II-Push after e. ear terminal. ences: 9 for pull-
			Note: Follow the insertion sequence illustration.	e based on the		ent using both		push-pul	I-push procedure	95

	WORK INSTRUCTION Effectivity Date:										
		Process Name/Title:		IG ASSEMBLY PR	OCESS		Validity Date:	n/a			
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		Purpose:	PROTOTYPE	PRE-LAUNCH	☐ MASSPRO		Revision No.:	0	Page No.:	6 of 7	
PARTS:	1. Assy	/ parts					JIG:	n/a			
NO.	F	PROCESS NAME	WORK	PROCEDURE/ ILLUS	TRATION		TOOLS/PPE	QUALITY POINTERS			
10	n/a	Measurement	White Vinyl Tube (B) 2) 122 ±3	White	Vinyl Tube (W) ø3 (7) 15 ±5	(a) 131 ±3 Vinyl Tube (B) Ø7 Vinyl Tape (Sky B) (b) 64 ±3 (c) 109 ±	white	2. No wron 3. No dama 4. No wron 5. No loose 6. No wron 7. One by 6 8. No wron 6. 7 8 Note: Please measu	g insertion one insertion g wire facing MEASURING TAI	6789	

ir .		WODI	ZINCTRUCTION			Ing. at the Date.	1		
	Process Name/Title:		KINSTRUCTION APING ASSEMBLY PRO	0500		Effectivity Date:		July 4, 2024 n/a	
						Validity Date:			
	Model code/Part number:		1-7050A Customer: TRJ	Car Model:	RAV4	Document No.:		WI-ENG-PDE-8	
	Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO		Revision No.:	0	Page No.:	7 of 7
							<u> </u>		
PARTS: n/a						JIG:	n/a		
			VISUAL INS	PECTION					
			VIOUAL ING	PECHON					
			75S744 -	-7050A					
	2. Check the wire all no tangled wires. 4. Check the orientation	lignment. Make sure	3. Check the is included to		6. Check	the terminal if with backing erted) or deformed terminal.	out (not		