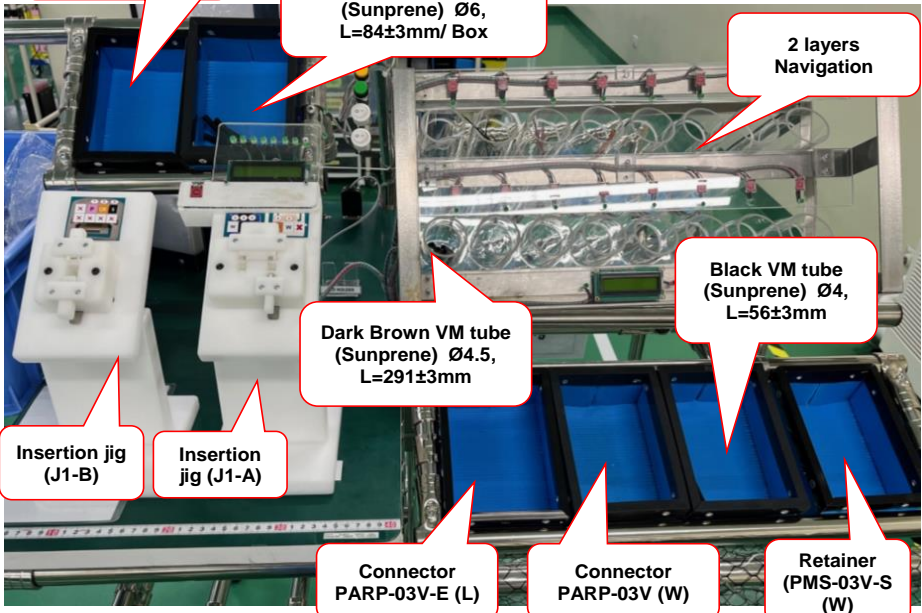
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	Process Name/Title:				Validity Date: n/a	
	Model code/Part number: 310D / 628126-0000A		Customer: TRJ	Car Model: TOYOTA-RAV4	Document No.: WI-ENG-PDE-1167A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: 1		Page No.:	1 of 13

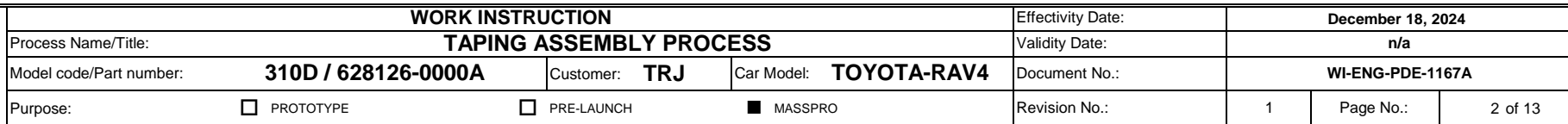
PARTS: 1. Connector PARP-03V-E (L); Connector PARP-03V (W); AVSS 0.3 W wire L=399±2mm; AVSS 0.3 P-B wires L=412±2mm; Dark Brown VM tube (Sunprene) Ø4.5, L=291±3mm; Black VM tube (Sunprene) Ø4, L=56±3mm; Retainer (PMS-03V-S (W)); AVSS 0.3 OR wire L=177±2mm; Connector 4A1330-0000 (W); Black VM tube (Sunprene) Ø6, L=84±3mm		JIG: 1. Insertion jig 2. Navigation	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
1	P1 Table lay-out		<div> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>
		QUALITY POINTERS	
		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				Prepared by	Reviewed by	Approved by	Noted by
12/18/24	1	Change Purpose from Pre-launch to Masspro. Update the Work Procedure/illustration, provide insertion jigs and Steering Navigation; Additional table lay-out.	D.Castillo	C. Villanueva	A.Arañes	n/a	
11/22/24	0	Initial issue.	D.Castillo	C. Villanueva	A.Arañes	n/a	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: November 22, 2024

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

December 18, 2024

Model code/Part number:

310D / 628126-0000A

Customer: TRJ

Car Model: TOYOTA-RAV4

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1167A

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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1

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PARTS:

1. AVSS 0.3 W wire L=399±2mm
2. AVSS 0.3 P-B wires L=412±2mm

JIG:

1. Insertion jig
2. Navigation

NO.

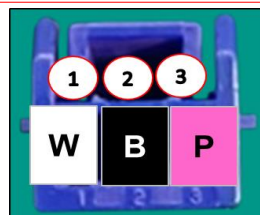
PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

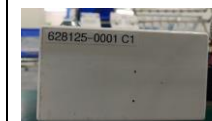
INSERTION SEQUENCE FROM LEFT
TO RIGHTTERMINAL
FACING

WIRE INSERTION ILLUSTRATION

1	2	3
W	B	P
399	412	412

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.

Conduct Pull-Push-Pull-Push after insertion.

Do not exert extra force.

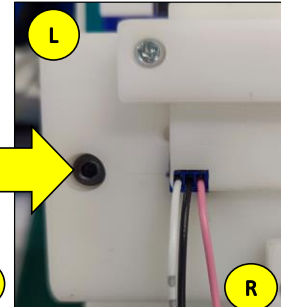
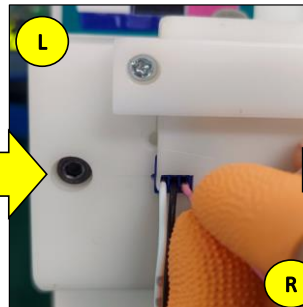
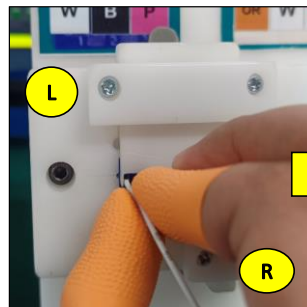
3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.
4. Insertion of wires must be from left to right.

Document references:

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

3

P1


Wire insertion to
Connector PARP-03V (W)



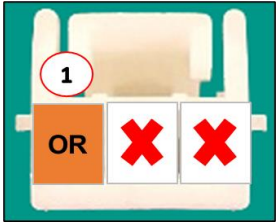

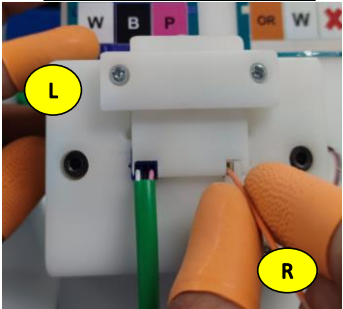


1. Get the **W wire** using **left hand** and transfer to the right hand then insert to connector Conduct **2x** push pull after wire insertion. Repeat the process to **B and Pink wire**.
Note: Follow the insertion sequence based on the illustration.

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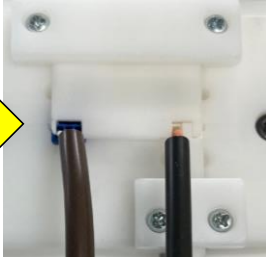
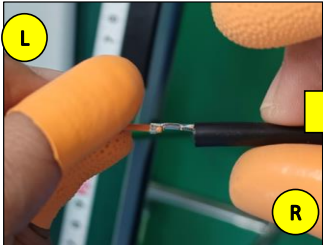
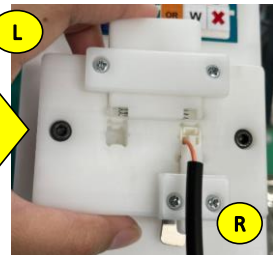
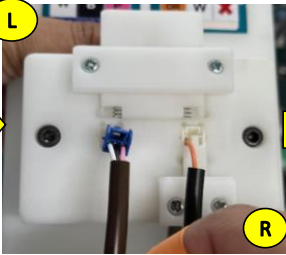
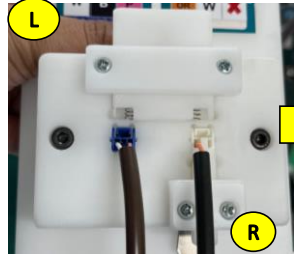
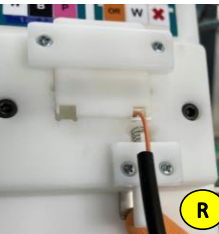
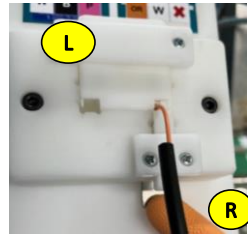
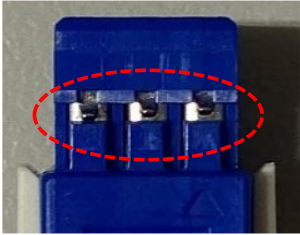
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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	4 of 13

PARTS: 1. Assy parts 2. Dark Brown VM tube (Sunprene) Ø4.5, L=291±3mm 3. Connector PARP-03V (W)		JIG: 1. Insertion jig 2. Navigation										
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE									
4	Wire insertion to Green VM tube (Sunprene) Ø4.5, L=291±3mm	  <p>1. Hold the wires using left hand, get the Dark Brown VM tube (Sunprene) Ø4.5, L=291±3mm using right hand then insert the wires using left hands</p>	n/a									
5	Wire insertion to Connector PARP-03V (W)	<div> <div> INSERTION SEQUENCE FROM LEFT TO RIGHT  </div> <div>  TERMINAL FACING </div> <div> WIRE INSERTION ILLUSTRATION <table border="1"> <tr> <td>1</td> <td></td> <td></td> </tr> <tr> <td>OR</td> <td>X</td> <td>X</td> </tr> <tr> <td>177</td> <td></td> <td></td> </tr> </table> </div> <div> <p>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.</p> </div> </div> 	1			OR	X	X	177			<div> STEERING NAVIGATION (2 layers)  </div> <div> CONTROLLER  </div>
1												
OR	X	X										
177												
		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.										

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	TAPING ASSEMBLY PROCESS			Validity Date:	n/a							
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	Purpose:		<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	1	Page No.:	5 of 13			


PARTS:		1. Assy parts 2. Black VM tube (Sunprene) Ø4, L=56±3mm			JIG:	1. Insertion jig 2. Navigation		
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
6	P1 Wire insertion to Black VM tube (Sunprene) Ø4, L=56±3mm	<div><div>1. Hold the wires using left hand, get the Black VM tube (Sunprene) Ø4, L=56±3mm using right hand then insert the wires using left hands</div></div> <div><div>2. Press the upper 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.</div></div> <div><div>3. Press the lower button using right hand. Check the terminal tip condition, must be visible.</div></div>			n/a	<div>1. No wrong orientation of connector 2. No wrong use of parts 3. No deformed terminal 4. No wrong wire facing</div> <div><div>Terminal tip must be visible.</div></div>		

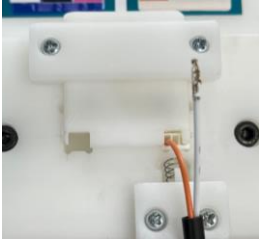
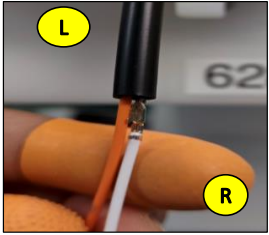


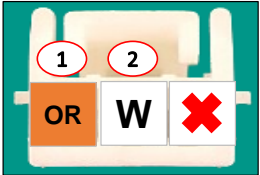
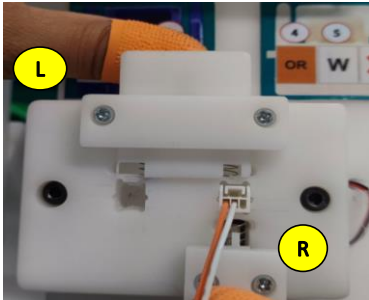
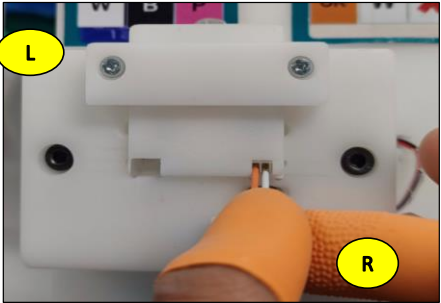
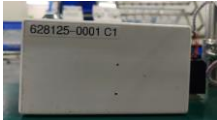
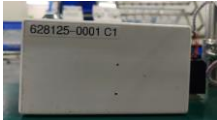
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	Model code/Part number: 310D / 628126-0000A		Customer: TRJ	Car Model: TOYOTA-RAV4	Document No.:	WI-ENG-PDE-1167A		
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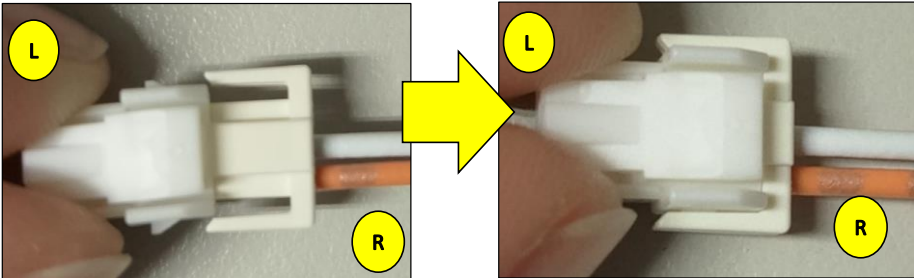
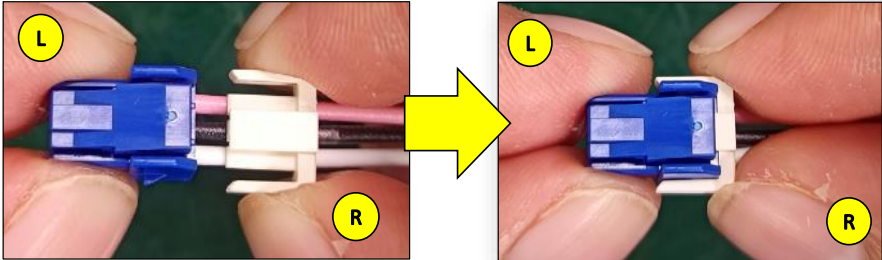
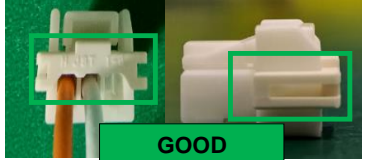
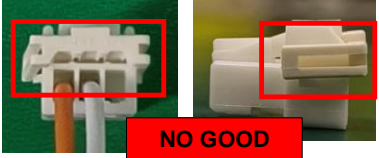
PARTS:	1. Assy parts			JIG:	1. Insertion jig 2. Navigation		
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS		
7	Wire insertion to Assy parts	<div><div>1. Hold the Black VM tube (Sunprene) using left hand and insert the wire of assy parts using right hand.</div></div>		<div>STEERING NAVIGATION (2 layers)</div> 	<div>1. No wrong usage of parts. 2. No deformed terminal. 3. No tangled wires.</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.</div>		
8	Wire insertion to Connector PARP-03V (W)	<div><div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div><div>1 2 3 OR W X 177 399</div><div>TERMINAL FACING</div><div>WIRE INSERTION ILLUSTRATION</div><div></div><div>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.</div><div>2. Press the upper button using left hand. Remove the 2nd connector with inserted wires using right hand. Check the terminal tip condition, must be visible.</div></div> <td><div>CONTROLLER</div></td>		<div>CONTROLLER</div> 			

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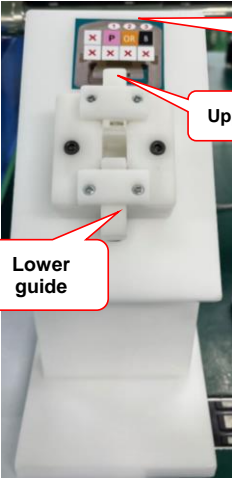
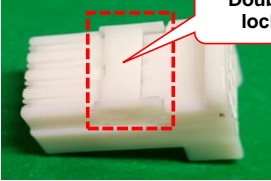
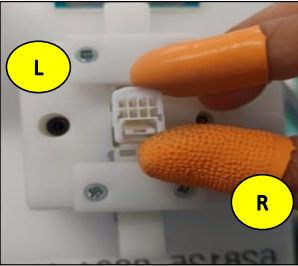
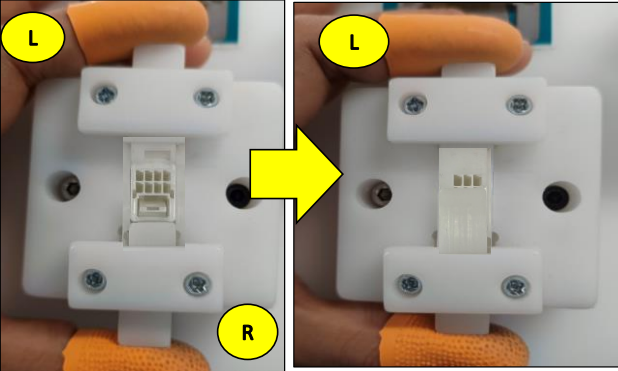
PARTS:		1. Retainer (PMS-03V-S (W)) [2pcs] 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
9	P1 Retainer attachment (PMS-03V-S (W))	<div></div> <div>1. Hold the Connector using left hand, get the Retainer PMS-03V-S (W) then insert the clamp using right 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>	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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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	8 of 13


PARTS:		1. Connector 4A1330-0000 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	P1 Connector setting to insertion jig 4A1330-0000 (W)	<div><div>INSERTION JIG</div><div></div><div></div><div>CONNECTOR ORIENTATION</div><div></div><div><p>1. Get the Connector 4A1330-0000 (W) and insert to insertion jig using right hand. Note: Follow the connector orientation.</p></div><div></div><div><p>2. Press the upper and lower guide (same timing) using left hand. Holes to be insert are only open.</p></div></div> <td>n/a</td> <td><p>1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector.</p><p>Important reminders/Note/s: 1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector. 2. Follow the connector orientation 3. Check the Connector before insertion.</p></td>		n/a	<p>1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector.</p> <p>Important reminders/Note/s: 1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector. 2. Follow the connector orientation 3. Check the Connector before insertion.</p>

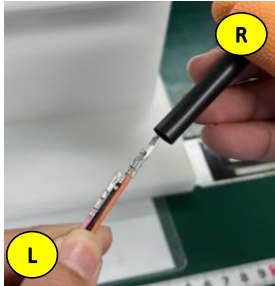


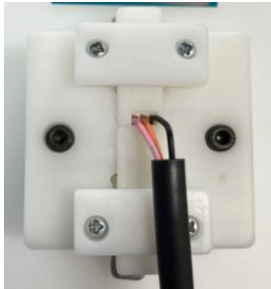

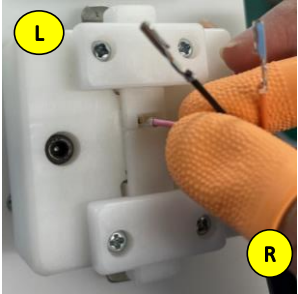
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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	1	Page No.:	9 of 13

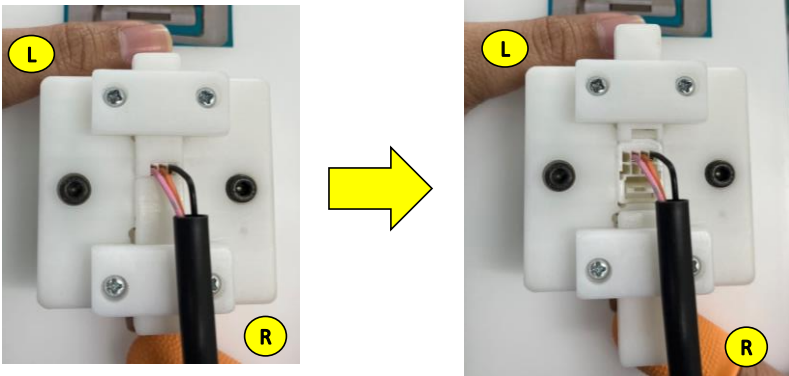
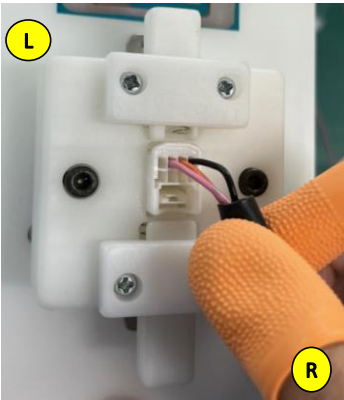
PARTS:	1. Assy parts 2. Black VM tube (Sunprene) Ø6, L=84±3mm			JIG:	1. Insertion jig												
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS												
11	Wire insertion Black VM tube (Sunprene) Ø6, L=84±3mm	 <div>1. Hold the wires of assy parts using right hand, get the Black VM tube (Sunprene) Ø6, L=84±3mm using left hand then insert the wires (Assy parts) using both hands.</div>		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.												
12	Wire insertion to Connector 4A1330-0000 (W)	<div>INSERTION SEQUENCE FROM LEFT TO RIGHT </div> <div>WIRE INSERTION ILLUSTRATION<table><tr><td>X</td><td>1 P</td><td>2 OR</td><td>3 B</td></tr><tr><td>X</td><td>412</td><td>177</td><td>412</td></tr><tr><td>X</td><td>X</td><td>X</td><td>X</td></tr></table></div> <div>TERMINAL FACING </div> <div></div> <div>1. Insert the wires from Black VM tube (Sunprene). Hold the R wire and insert to terminal slot no.1 using right hand. Repeat the process for OR and B wires.</div>		X	1 P	2 OR	3 B	X	412	177	412	X	X	X	X	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. 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 GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.
X	1 P	2 OR	3 B														
X	412	177	412														
X	X	X	X														

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	WORK INSTRUCTION			Effectivity Date:	December 18, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 310D / 628126-0000A		Customer: TRJ	Car Model: TOYOTA-RAV4	Document No.: WI-ENG-PDE-1167A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	10 of 13


PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
12	P1 Wire insertion to Connector 4A1330-0000 (W) (Continuation)	<div></div> <div>2. Press the upper and lower button (same timing) using both hands.</div> <div></div> <div>3. Remove the assy parts using right hand and check if the connector is totally locked.</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. 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.</div> <div>Document reference/s: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</div>

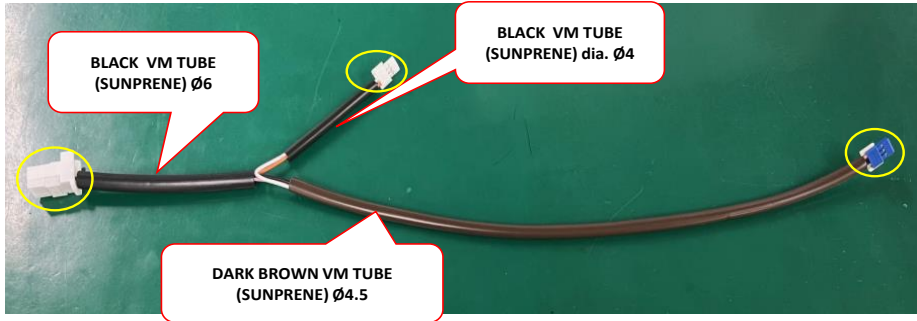
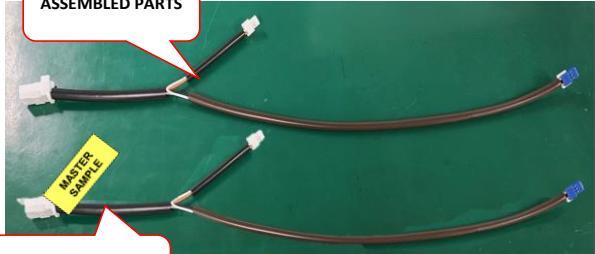


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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		1	Page No.:	11 of 13	


PARTS:	1. Assembled parts 2. Master sample			JIG:	n/a	
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS		
13	P1 Visual/By two's Inspection	<div>1. Check the connector lock. Locking of connector is included in Steering Electrical test.</div> <div>2. Check the wire alignment. Must be no tangled wires.</div> <div>3. Check the Terminal if with Backing out (Not fully inserted) or no deformed terminal.</div> <div></div> <div><div>4. Check the orientation of harness.</div><div>5. Compare to Master sample by tapping</div><div></div></div> <td>n/a</td> <td colspan="3"><div>1. No skip process during inspection.</div><div>Document refence/s: 1. Refer to <i>WI-QAD-QAC-252 Steering Electrical Test</i></div><div>MASTER SAMPLE</div><div></div></td>	n/a	<div>1. No skip process during inspection.</div> <div>Document refence/s: 1. Refer to <i>WI-QAD-QAC-252 Steering Electrical Test</i></div> <div>MASTER SAMPLE</div> <div></div>		


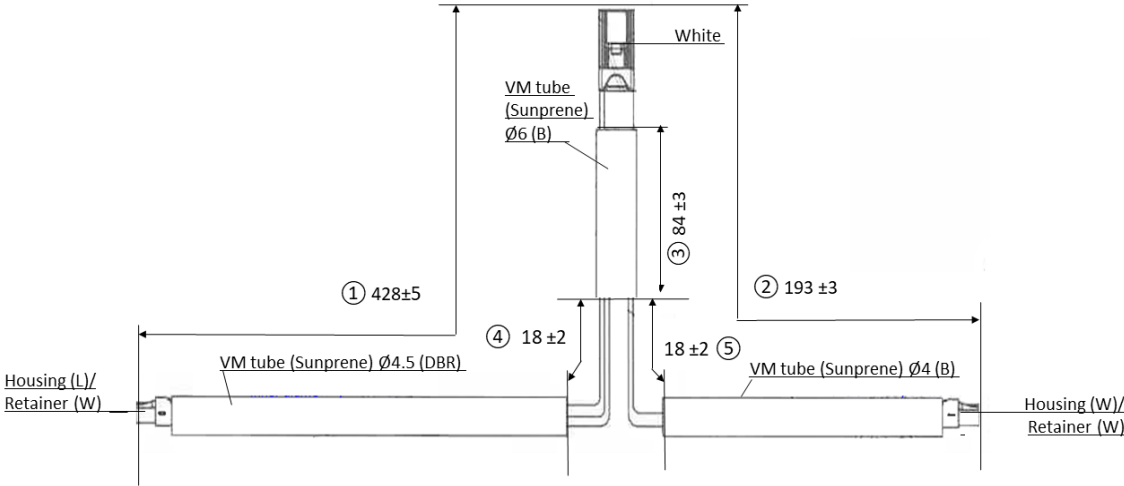
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	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 310D / 628126-0000A		Customer: TRJ	Car Model: TOYOTA-RAV4	Document No.: WI-ENG-PDE-1167A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	1	Page No.:	12 of 13

PARTS:	1. Assy parts			JIG:	n/a		
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
14	P1	Measurement	<div>MEASURING TAPE</div>  	<p>1. No wrong dimension</p> <p>Important Reminder/s and Note/s:</p> <p>1. Please use calibrated measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p>Document reference/s:</p> <p>1. Refer to WI-PRO-ASY-056 For assembly Hatsumono, Nakamono and Owarimono Inspection.</p>			

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

December 18, 2024

Validity Date:

n/a

Model code/Part number:

310D / 628126-0000A

Customer: TRJ

Car Model: TOYOTA-RAV4

Document No.:

WI-ENG-PDE-1167A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

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PARTS:

1. Assy parts

JIG:

n/a



VISUAL INSPECTION/ QUALITY CHECKPOINTS

PADDLE SWITCH

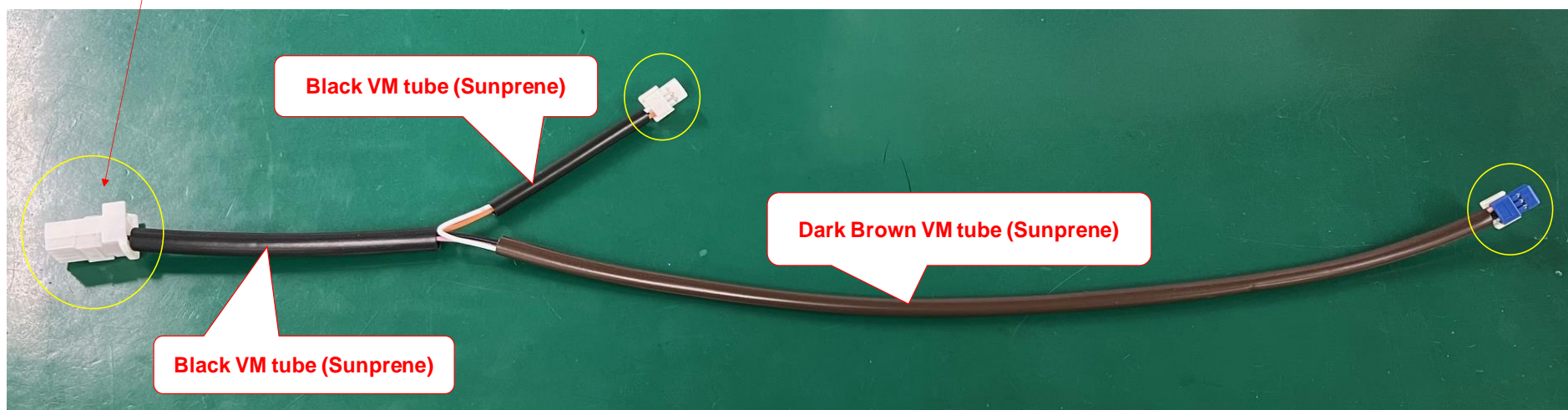
628126-0000A

1. Check the Connector lock, should be unlock.

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

3. Check the terminal if with backing out (not fully inserted) or deformed terminal.

4. Check the orientation of harness.



5. Check if no missing parts. Check the presence and position of retainer (2 connectors).

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