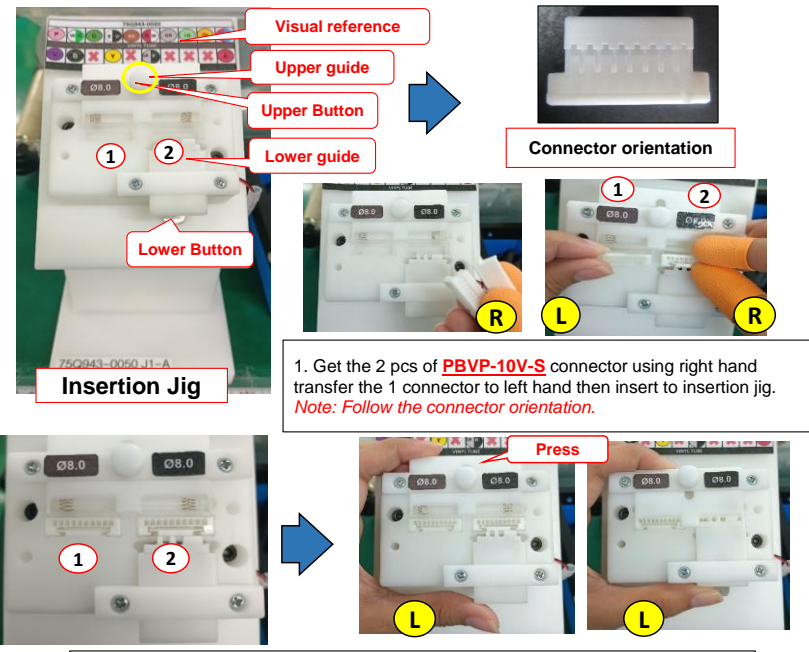


	WORK INSTRUCTION				Effectivity Date:		May 10, 2024	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: 840B / 75Q943-0050		Customer: TRJ	Car Model: TOYOTA SIENTA	Document No.: WI-ENG-PDE-336	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		5	Page No.: 1 of 13

PARTS:	1. Connector PBVP-10V-S (W) [2pcs]			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1 Connector setting to insertion jig PBVP-10V-S (W)	 <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>2. Press the upper and lower guide using left hand in same timing. Holes that need to be insert are only open.</p>		<div style="border: 1px dashed 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 dashed 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 dashed red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>	1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector

Revision History					Prepared by		Reviewed by		Approved by		Noted by	
05/10/24	5	Change the folding facing due to improvement of abnormality. Update the Work procedure/Illustration of Process 5,7, 11-13. Update Quality pointers. Change hand method (Process 3). Change Electrical test document number due to transfer process from Production to QC. Inclusion of Car model "TOYOTA-SIENTA"	D.Castillo	C.Villanueva	A. Arañes	n/a						n/a
8/15/23	4	Improve work procedure of process 2 procedure 1, from "Get the wire using left hand and transfer to right hand" to "Get the wire using right hand and process 3 procedure 1 from "Get the VM tube (Sunprene) using left hand transfer to the right hand" to "Get the VM tube (Sunprene) using right hand". Change the steering navigation to 2 layers navigation, and gray color	A. Hernandez	J. Loterte	C. Villanueva	A. Arañes						
2/10/23	3	Improved the insertion jig and procedure. Changed the term of Sunprene tube to VM tube (Sunprene). Improved work procedure/illustration. Include quality checkpoints (Page 14).	D.Castillo	J. Loterte	C. Villanueva	A. Arañes						
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 10, 2021				

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**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 10, 2024

Model code/Part number:

840B / 75Q943-0050

Customer:

TRJ

Car Model:

TOYOTA SIENTA

Document No.:

WI-ENG-PDE-336

Purpose:


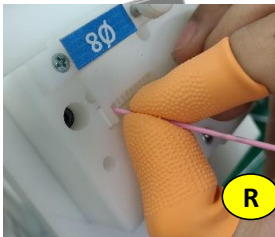





☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. AVSS 0.3 P L=130±2mm; W/G L=130±2mm; G L=130±2mm; B/W L=208±2mm; BR L=130±2mm; R/W L=208±2m; GR L=130±2mm; LG L=208±2mm; OR L=208±2mm; R/L L=208±2mm 2. Dark Gray VM tube (Sunprene) Ø8 L=85±2mm								JIG:	1. Insertion jig																														
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION								TOOLS/PPE	QUALITY POINTERS																														
2	Wire insertion to Connector PBVP-10V-S (W) P1	<div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div> <div></div> <div></div> <div></div> <table><tr><td>1</td><td>2</td><td>3</td><td>4</td><td>5</td><td>6</td><td>7</td><td>8</td><td>9</td><td>10</td></tr><tr><td>P</td><td>W/G</td><td>G</td><td>B/W</td><td>BR</td><td>R/W</td><td>GR</td><td>LG</td><td>OR</td><td>R/L</td></tr><tr><td>130</td><td>130</td><td>130</td><td>208</td><td>130</td><td>208</td><td>130</td><td>208</td><td>208</td><td>208</td></tr></table> <div>1. Get the P wire using left hand and transfer to right hand then insert to connector. Repeat the process for W/G-G-B/W-BR-R/W-GR-LG-OR-R/L. Check the wire after insertion. <i>Note: Follow the insertion sequence based on the illustration.</i></div>								1	2	3	4	5	6	7	8	9	10	P	W/G	G	B/W	BR	R/W	GR	LG	OR	R/L	130	130	130	208	130	208	130	208	208	208	<div>Wire facing</div> <div>STEERING NAVIGATION(2 layer)</div> <div></div> <div>CONTROLLER</div> <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</div> <div>Important reminders/Note/s: 1. Please hold the wire near terminal during insertion. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>Document References: 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-028 for Pull-Push procedure.</div>
1	2	3	4	5	6	7	8	9	10																																
P	W/G	G	B/W	BR	R/W	GR	LG	OR	R/L																																
130	130	130	208	130	208	130	208	208	208																																
3	Wire insertion to Dark Gray VM tube (Sunprene) Ø8 L=85±2mm	<div></div> <div></div> <div>1. Get the Dark Gray VM tuber (Sunprene) Ø8 L=85±2mm using right hand. Hold the wires using left hand and insert the wires using right hand.</div>								N/A	<div>1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires</div>																														

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model code/Part number:

840B / 75Q943-0050

Customer:

TRJ

Car Model:

TOYOTA SIENTA

Purpose:

☐ PROTOTYPE

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Effectivity Date:

May 10, 2024

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PARTS:

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

JIG:

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

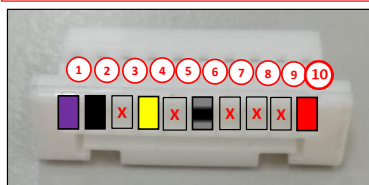
QUALITY POINTERS

4

P1

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

INSERTION SEQUENCE FROM LEFT TO RIGHT

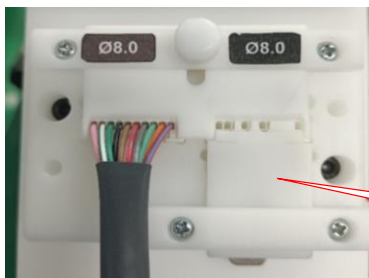


Wire facing

1	2	3	4	5	6	7	8	9	10
V	B	X	Y	X	GR/B	X	X	X	R
130	130	X	130	X	130	X	X	X	130

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

Lower guide



1. Get the **V** wire using right hand and insert to connector. Repeat the process for **B-Y-GR/B-R**. 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. Please hold the wire near terminal during insertion.

2. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion.

Do not exert extra force.

Document References:

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.

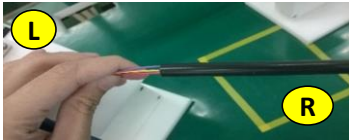
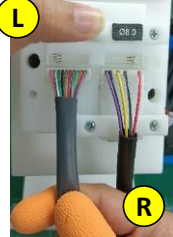
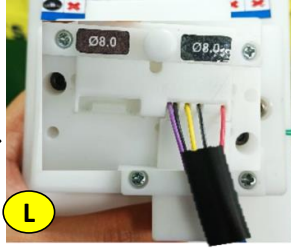
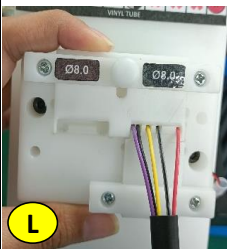
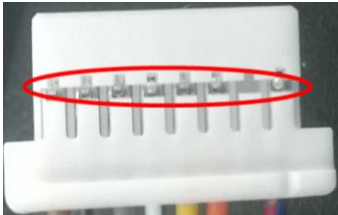
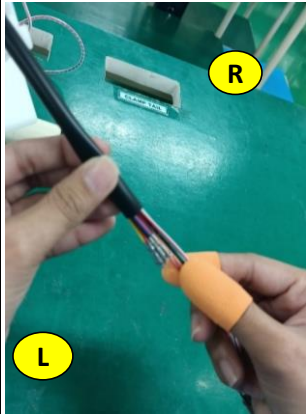
3. Refer to **GL-PRO-ASY-028** for Pull-Push procedure.

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	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 840B / 75Q943-0050		Customer: TRJ	Car Model: TOYOTA SIENTA	Document No.:	WI-ENG-PDE-336		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	5	Page No.:	4 of 13

PARTS:	1. Black VM tube (Sunprene) Ø8 L=85±2mm			JIG:	1. Insertion jig
NO.	PROCESS NAME	5	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1	Wire insertion to Black VM tube (Sunprene) Ø8 L=85±2mm	<div><p>1. Get the Black VM tube (Sunprene) Ø8 L=85±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 Gray VM tube (Sunprene) using right hand</p></div> <div><p>3. Press the upper guide using left hand and press the lower button using left hand. Holes that need to be insert are only open. Check the wire insertion condition.</p><p>Note: Second connector with inserted wire and Black Sunprene tube will stay in the jig.</p></div>	N/A	<div><p>Terminal tip must be visible</p></div> <p>Document References: 1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.</p>
6		Wire insertion to assy parts	<div><p>1. Hold the Black VM tube (Sunprene) using left hand and insert the wires from Dark Gray VM tube (Sunprene) using right hand.</p></div>		<div><p>1. No wrong use of parts 2. No deformed terminal 3. No tangled wires</p></div>

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 10, 2024

Model code/Part number:

840B / 75Q943-0050

Customer:

TRJ

Car Model:

TOYOTA SIENTA

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Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:

1. Assy parts

JIG:

1. Insertion jig

NO.

PROCESS NAME

5

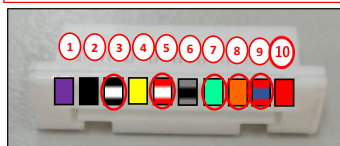
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

7

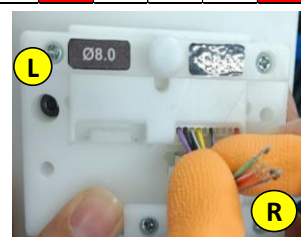
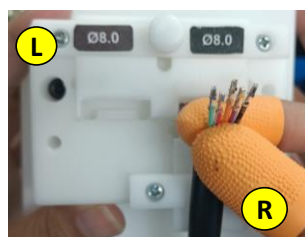
P1

Wire insertion to
Connector
PBVP-10V-S (W)INSERTION SEQUENCE FROM
LEFT TO RIGHT

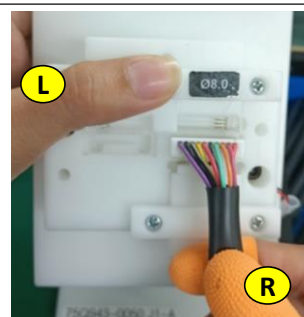
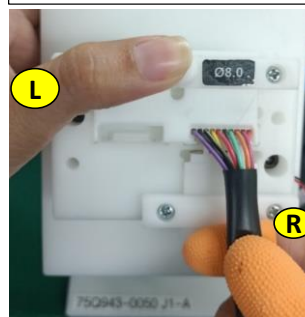
Wire facing



1	2	3	4	5	6	7	8	9	10
V	B	B/W	Y	R/W	GR/B	LG	OR	R/L	R
130	130	208	130	208	130	208	208	208	130



1. Hold the **B/W** wire using right hand and support the wire by left index finger then insert to connector using right hand. Repeat the process on **R/W-LG-OR-R/L** wires. Check the wire after insertion
Note: Follow the insertion sequence based on the above illustration.



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

STEERING
NAVIGATION(2 layer)

CONTROLLER



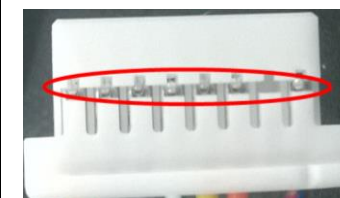
1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip
7. No tangled wires
8. No wrong facing

Important reminders/Note/s:

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

Document References:

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-028** for Pull-Push procedure.
4. Refer to **GL-PRO-ASY-025** for Inspection Standard for Coupler Insertion.




Terminal tip must be visible


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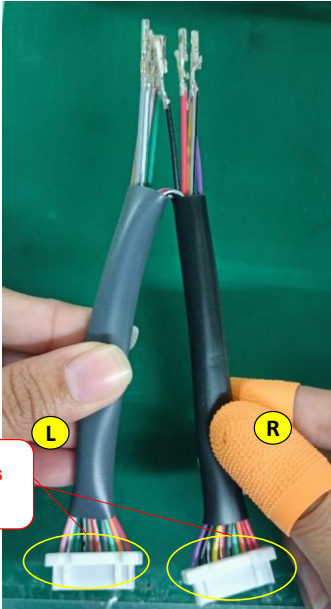
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	WORK INSTRUCTION				Effectivity Date:		May 10, 2024	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 840B / 75Q943-0050		Customer: TRJ	Car Model: TOYOTA SIENTA	Document No.:		WI-ENG-PDE-336	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		5	Page No.:

PARTS:		1. Assy parts		JIG:	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1	Wire arrangement		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.

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Car Model:

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Document No.:

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PARTS:	1. Connector 1746872-1 (B)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P1	<div><div>Connector setting to insertion jig 1746872-1 (B)</div><div><div><div><div><div><div>Visual reference</div><div>Upper guide</div><div>Upper button</div></div><div><div>Visual reference</div><div>Upper guide</div><div>Upper button</div></div></div><div><div>Visual reference</div><div>Upper guide</div><div>Upper button</div></div><div><div>Visual reference</div><div>Upper guide</div><div>Upper button</div></div></div><div><div>Visual reference</div><div>Upper guide</div><div>Upper button</div></div><div><div>Visual reference</div><div>Upper guide</div><div>Upper button</div></div></div><div><div>Visual reference</div><div>Upper guide</div><div>Upper button</div></div><div><div>Visual reference</div><div>Upper guide</div><div>Upper button</div></div></div><div><div>Visual reference</div><div>Upper guide</div><div>Upper button</div></div><div><div>Visual reference</div><div>Upper guide</div><div>Upper button</div></div></div> <div><div>Visual reference</div><div>Upper 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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 10, 2024

Model code/Part number:

840B / 75Q943-0050

Customer:

TRJ

Car Model:

TOYOTA SIENTA

Document No.:

WI-ENG-PDE-336

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

5

Page No.:

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PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	P1	<div>Wire insertion to Connector 1746872-1 (B)</div> <div><div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div><div><div>2ND ROW</div><div>1ST ROW</div><div><div><div>8</div><div>9</div><div>5</div><div>1</div></div><div><div><div><div>X</div><div></div><div></div><div></div><div>X</div><div></div></div><div><div><div>1</div><div>6</div><div>7</div><div>2</div><div>3</div><div>4</div></div></div></div></div><div>BLACK VM TUBE (SUNPRENE)</div><div><div>5</div><div><div><div>X</div><div>X</div><div>X</div><div>X</div><div>X</div><div>X</div></div><div><div><div>1</div><div>2</div><div>3</div><div>4</div></div></div></div></div><div><div>FIRST ROW (LEFT TO RIGHT)</div><div>SECOND ROW (LEFT TO RIGHT)</div></div><div><div><div><div><div><div><div></div><div></div><div></div><div></div><div></div><div></div></div><div><div><div>R</div></div></div></div><div><div><div></div><div></div><div></div><div></div><div></div><div></div></div><div><div><div>R</div></div></div></div></div><div><div><div><div><div></div><div></div><div></div><div></div><div></div><div></div></div><div><div><div>R</div></div></div></div><div><div><div></div><div></div><div></div><div></div><div></div><div></div></div><div><div><div>R</div></div></div></div></div></div><div><div>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. <i>Note: Follow the insertion sequence based on the illustration stated above.</i></div><div>2. Hold the GR/B wire and insert to terminal slot 5. <i>Note: Follow the insertion sequence based on the illustration stated above.</i></div></div></div><div>N/A</div><td><div>1. Use provided jig per model</div><div>2. No wrong usage of parts</div><div>3. One by one insertion</div><div>4. No wrong insertion</div><div>5. No deformed terminal</div><div>6. No stuck of terminal tip</div><div>Important reminders/note/s: <i>1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</i> <i>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.</i> <i>Do not exert extra force.</i> <i>3. Please hold the wire near terminal during insertion.</i></div><div>Document reference/s: <i>1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.</i> <i>2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.</i> <i>3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i></div></td></div></div></div></div></div>	<div>1. Use provided jig per model</div> <div>2. No wrong usage of parts</div> <div>3. One by one insertion</div> <div>4. No wrong insertion</div> <div>5. No deformed terminal</div> <div>6. No stuck of terminal tip</div> <div>Important reminders/note/s: <i>1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</i> <i>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.</i> <i>Do not exert extra force.</i> <i>3. Please hold the wire near terminal during insertion.</i></div> <div>Document reference/s: <i>1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.</i> <i>2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.</i> <i>3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i></div>	

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

May 10, 2024

Validity Date:

n/a

Model code/Part number:

840B / 75Q943-0050

Customer:

TRJ

Car Model:

TOYOTA SIENTA

Document No.:

WI-ENG-PDE-336

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
10	P1 Wire insertion to Connector 1746872-1 (B) (Continuation)	<div><div><div>DARK GRAY VM TUBE (SUNPRENE)</div><div></div></div><div><p>3. Hold the W/G wire using right hand and support the wire by left index finger then insert to terminal slot 6 using right hand. Repeat the process for BR wire. <i>Note: Follow the insertion sequence based on the above illustration.</i></p><p>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></p><p>5. Press the Upper button using left hand then remove the assy part using right hand.</p></div></div>	N/A	<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>1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</p> <p>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.</p> <p>Do not exert extra force.</p> <p>3. Please hold the wire near terminal during insertion.</p> <p>Document reference/s:</p> <p>1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.</p> <p>2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.</p> <p>3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>

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TAPING ASSEMBLY PROCESS

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840B / 75Q943-0050

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Car Model:

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Document No.:

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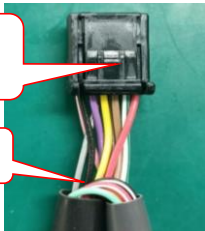
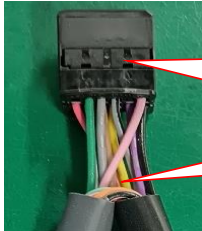
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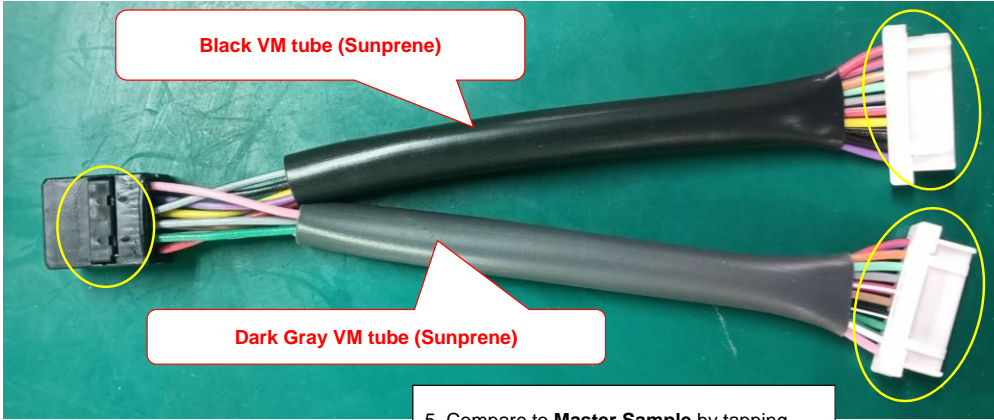
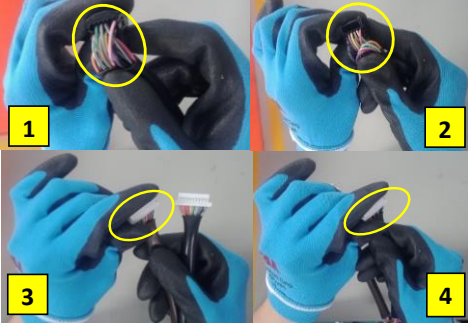
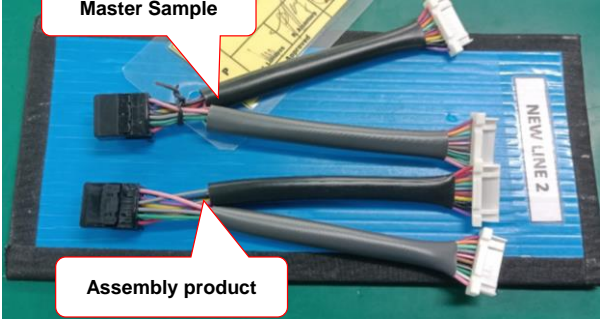
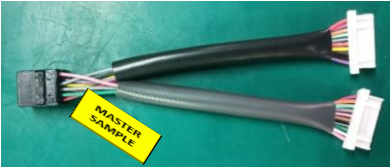
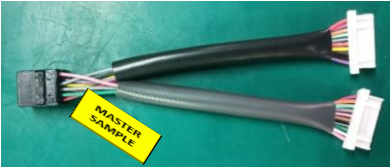
PARTS:	1. Assy parts			JIG:	N/A
NO.	PROCESS NAME	5 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1	Wire Arrangement	<div>1. Hold the harness using both hands. Arrange the wire properly to avoid tangled wires.</div> <div><div><div>Folding in the back</div><div>CORRECT FACING</div></div><div><div>Folding in the front</div><div>WRONG</div></div><div><div>GOOD FACING</div><div>Connector lock</div><div>Folding</div></div><div><div>NG FACING</div><div>Double lock</div><div>Folding</div></div></div> <div><div>Terminal tip is not visible</div><div>Terminal tip is not visible</div><div>Terminal tip is visible</div><div>Terminal tip is visible</div></div>	n/a	1. No wrong orientation of connector 2. No tangled wires 3. No wrong harness facing

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	WORK INSTRUCTION				Effectivity Date:	May 10, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 840B / 75Q943-0050		Customer: TRJ	Car Model: TOYOTA SIENTA	Document No.:	WI-ENG-PDE-336		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	5	Page No.:	11 of 13


PARTS:	N/A				JIG:	N/A		
NO.	PROCESS NAME	<div>5</div> WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
12	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. Make sure no tangled wires.</div> <div>3. Check the terminal if with backing out (not fully inserted) or deformed terminal.</div> <div>4. Check the orientation of harness.</div> <div></div> <div><div>3</div><div></div><div></div></div> <td></td> <td><div>1. No wrong facing of harness</div><div>2. No Tangled wires</div><div>3. No missing parts</div><div><div>MASTER SAMPLE</div><div></div><div><div>5</div><div>Document reference/s:</div><div>1. Refer to WI-ENG-PDE-252 for Steering Electrical Test after assembly.</div></div></div></td>		<div>1. No wrong facing of harness</div> <div>2. No Tangled wires</div> <div>3. No missing parts</div> <div><div>MASTER SAMPLE</div><div></div><div><div>5</div><div>Document reference/s:</div><div>1. Refer to WI-ENG-PDE-252 for Steering Electrical Test after assembly.</div></div></div>			


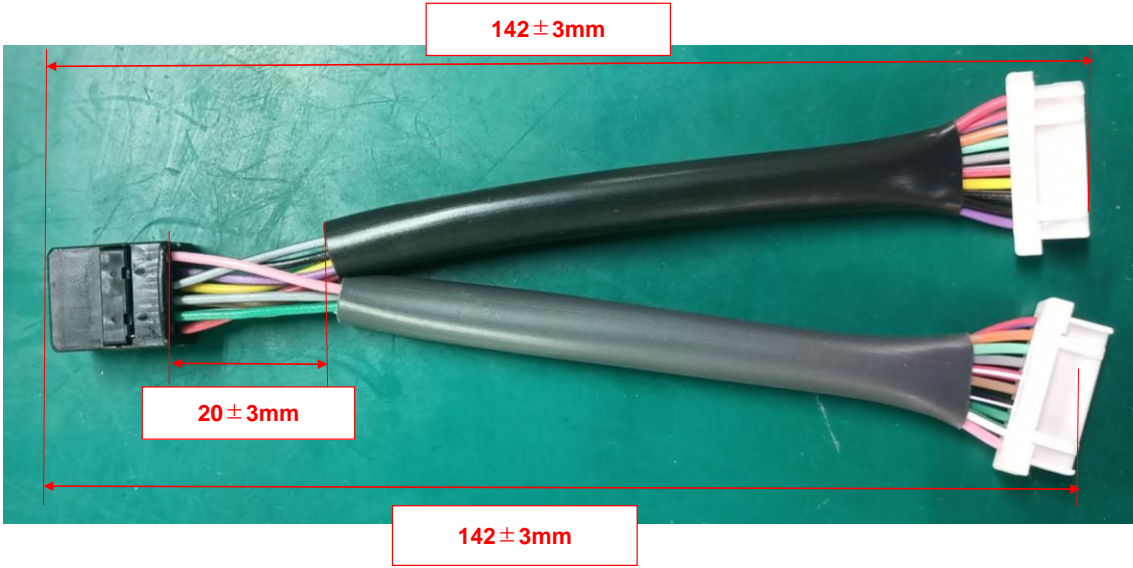
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	Model code/Part number: 840B / 75Q943-0050		Customer: TRJ	Car Model: TOYOTA SIENTA	Document No.:	WI-ENG-PDE-336		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	5	Page No.:	12 of 13

PARTS:	N/A			JIG:	N/A			
NO.	PROCESS NAME	5 WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS		
13	P1	Measurement	<div><p>MEASURING TAPE</p></div> <div></div>			<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified 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 Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension</p>		

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Revision No.:

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PARTS:

N/A

JIG:

N/A



QUALITY CHECKPOINTS

75Q943-0050

1. Check the connector lock, should be unlock.

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

Black VM Tube (Sunprene)

Dark Gray VM Tube (Sunprene)

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

4. Check the orientation of harness.

5. Check if no missing parts.

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