			I	11125						1				
					K INSTRUCTION	11/ 85 6 6	\=0C				tivity Date:		February 10, 2	
			Process Name/Title:		APING ASSEMB	LY PROC	ESS				ity Date:		February 17, 2	025
			Model code/Part number:	920B / 75S321-008	Customer:	TRMX	Car Model:	TOYOT	A-TACO	MA Docu	ment No.:		WI-ENG-PDE-	556
'			Purpose:	PROTOTYPE	PRE-LAUNCH	1	MASSI	PRO		Revis	sion No.:	2	Page No.:	1 of 18
PARTS	:	L=154± L=112± L=114±	:2mm; LG L=285±2mm; R/ :3mm; AVSS 0.3 P L=156±	onnector 1746872-1 (B); AVSS 0. W L=285±2mm; B/W L=285±2mm; -2mm; W/G L=156±2mm; G L=156	n; OR L=285±2mm; R/L	L=285±2mr m; GR L=15	m; Black VM 6±2mm;Gree	tube (Sunp	orene) ø8		JIG:		n jig g Navigation	ITEDS
- 14	0.		ROCESS NAME	***	OKK PROCEDUKE	/ ILLUSTIK	ATION				TOOLS/FFL		QUALITITOIN	IILKO
	1	P1	Table Lay-out	Connector 1746872-1 (B) Master sample Insertion jig B	Insertion jig A Connector PBVF 10V-S (W)	2 la	yer Navigat	Green VM (sunpren L=114±3r	e) ø8	pr ((Bafety Instruction Be sure to wear required persona otective equipme during operation gloves, finger cotetc.) Housekeeping Maintain and alw. practice 5's. Personal things the workplace is rohibited. Keep it your locker. Alert level and the same of the same by Assist Supervisor or Line ander for immedia corrective action.	ays 1. No defo 2. No wror 2. No wror	rmed terminal ng usage of parts	
				Revision H	listory						Prepared by	Reviewed by	Approved by	Noted by
		lmm rou · - ·	dinaartian iigi Changa at-	r (DD)/D 40\/ C) evientation toin-li-	untation and color acc	an quatem					-			
02/10/25	2	claim co	untermeasure. Inclusion of Table	r (PBVP-10V-S) orientation, terminal orie e lay-out. Change document number of S	Steering Electrical test (WI-C	QAD-QAC-252)		C. Villanueva	A. Arañes	n/a				
11/15/22	1	Improve quality pointers: Reminders/notes, work procedure/illustration ands references in process in all process as document improvement. Work procedure/illustration in process no.12 - visual/by two's inspection					M. Catapang	J. Loterte	C. Villanueva	A. Arañes	0			
07/06/22		Initial issue.					M. Catapang	C. Villanueva	A. Arañes	n/a	D. Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No		Details of Change					Reviewed	Approved	Noted '	Est. Date:	July 06, 2022		



	WORK INSTRUCTION Effectivity Date: February 10, 2025 Process Name/Title: TAPING ASSEMBLY PROCESS Validity Date: February 17, 2025											
		Process Name/Title:	TAPING ASSEMBLY PROCESS	Validity Date:								
	H	Model code/Part number:	920B / 75S321-0080 Customer: TRMX Car Model: TOYOTA-TACOMA	Document No.:		WI-ENG-PDE-5						
		Purpose:	□ PROTOTYPE □ PRE-LAUNCH ■ MASSPRO	Revision No.:	2	Page No.:	2 of 18					
PARTS:	1. Coni	nector PBVP-10V-S (W) [2	pcs.]	JIG:	1. Insertion	n jig						
NO.	F	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	-	QUALITY POIN	TERS					
2	P1	Connector setting to insertion jig PBVP-10V-S (W)	LCD Connector Visual reference Upper guide 1. Get the 2 pcs of PBVP-10V-S (W) connector using right hand then transfer the 1 connector to left hand then insert to insertion jig. Note: Follow the connector orientation. Press 2. Press the upper and lower guide using left hand in same timing. Holes that need to be insert are only open.	N/A	2. No wror 3. No wror	provided jig per m ig usage of parts ig orientation of co aged connector						



			WORK INS	STRUCTION			Effectivity Date:		February 10, 20)25
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		Model code/Part number:	920B / 75S321-0080	Customer: TRMX	Car Model:	TOYOTA-TACOMA	Document No.:		WI-ENG-PDE-5	56
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPR	RO	Revision No.:	2	Page No.:	3 of 18
PARTS:	L=285:	S 0.3 R L=154±2mm; V L= -2mm; OR L=285±2mm; R/ k VM tube (Sunprene) ø8 L		m; GR/B L=154±2mm; LG L=2		V L=285±2mm; B/W	JIG:	1. Insertion	ijg	
NO.	F	PROCESS NAME	WORK	PROCEDURE/ ILLUSTR	ATION		TOOLS/PPE		QUALITY POIN	
3	P1	Wire insertion to Connector PBVP-10V-S (W)	1. Get the R/L wire using right hand a LG-GR/B-B-Y-V-R wires. Note: Follow the insertion sequence	9 10 2 3 R/L OR B/W 285 285 285 285 285 285 285 285	4 5 6 R/W LG GR/t 285 285 154	4 154 154 154 154	STEERING NAVIGATION(2 layer) CONTROLLER	2. No wron 3. One by 0 4. No wron 5. No defot 6. No stuck Importal 1. Make st Conduct P insertion. Do not exe 2. Please during inset 3. Follow t the illustra Docume 1. Refer t procedure 2. Refer t	med terminal to of terminal to of terminal to of terminal tip on the reminders/Nure wires are propertial-Push-Pull-Push-Push-Push-Push-Push-Push-Push-Push	lote/s: erly inserted. sh after terminal ence based on : 129 for Pull-Push
4		Wire insertion to Black VM tube (sunprene) ø8 L=112±3mm	L	S) S) R	tu L= ha us in:	. Get the Black VM ube (Sunprene) ø8 =112±3mm using right and Hold the wires sing left hand and isert the wires using ght hand.	N/A		g usage of parts med terminal ed wires	



			WORK IN	NSTRUCTION		Effectivity Date:		February 10, 20)25
		Process Name/Title:	TAP	ING ASSEMBLY PROC	CESS	Validity Date:		February 17, 20)25
		Model code/Part number:	920B / 75S321-0080	Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:		WI-ENG-PDE-5	56
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	2	Page No.:	4 of 18
PARTS:		S 0.3 R L=154±2mm; V L= -2mm; OR L=285±2mm; R/	154±2mm; Y L=154±2mm; B L=154±2i L L=285±2mm;	mm; GR/B L=154±2mm; LG L=	285±2mm; R/W L=285±2mm; B/W	JIG:	1. Insertion	jig	
NO.	F	PROCESS NAME	WORK	(PROCEDURE/ ILLUSTR	ATION	TOOLS/PPE	(QUALITY POIN	TERS
5	P1	Wire insertion to connector PBVP-10V-S (W) (Continuation)	BACK VIEW OF TERMINAL GOOD Terminal condition Note: *Make sure the terminal w *Avoid hitting the terminal	FRONT OF TERMINAL GOOD Terminal condition ras in proper alignment before into the connector during well and the connector d	BACK VIEW OF TERMINAL Damaged terminal NO GOOD Terminal condition	nal to connector NT VIEW OF TERMINAL NO GOOD Terminal codition	1. Use prov 2. No wrong 3. No wrong 4. No defor 5. No stuck 6. One by c Impo 1. Mainser Push Do na 2. Ple termi 3. Au replat enco diffic locke 4. Ins left to Docu 1. Ref Wire a 2. Ref Steeri proce 3. Ref Pull-F 4. Ref	ided jig per model g usage of parts	lote/s: e properly -Push-Pull- ee. es near on. se and eninal, end half- ust be from : C-017 for Tolerance. E-044 for entroller Y-029 for

WORK INSTRUCTION Effectivity Date: February 10, 2 Process Name/Title: TAPING ASSEMBLY PROCESS Validity Date: February 17, 2										
		Process Name/Title:	TAPIN	G ASSEMBLY PROC	CESS		Validity Date:		February 17, 20	25
		Model code/Part number:	920B / 75S321-0080	Customer: TRMX	Car Model:	ГОҮОТА-ТАСОМА	Document No.:		WI-ENG-PDE-5	56
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO)	Revision No.:	2	Page No.:	5 of 18
PARTS:		·	L=156±2mm; G L=156±2mm; BR L=156±				JIG:	1. Insertior		
NO.	F	ROCESS NAME	WORK P	PROCEDURE/ ILLUSTR	ATION		TOOLS/PPE	(QUALITY POIN	TERS
6	<u>/:</u>	Wire insertion to Connector PBVP-10V-S (W)	BR-G-W/G-P wires.	Note: Holes that need open. Lower guide Lower guide ight hand and insert to connect t	ed to be insert a	7 8 9 10 G W/G P 156 156 156 are only		2. No wron 3. One by 4. No wron 5. No defo 6. No stuci Importa 1. Please during in 2. Refer Push pro 3. Make Conduct insertion. Do not e. 4. Follow	ant reminders/le hold the wire neasertion. to GL-PRO-ASY-Cocedure. sure wires are properly and the properly and the properly and the properly are properly and the properly an	Note/s: or terminal 029 for Pull- perly inserted. ush after

			WORK IN	ISTRUCTION		Effectivity Date:		February 10, 20	125
		Process Name/Title:		NG ASSEMBLY PROC	CESS	Validity Date:		February 17, 20	
		Model code/Part number:	920B / 75S321-0080	Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:		WI-ENG-PDE-5	556
		Purpose:	PROTOTYPE	☐ PRE-LAUNCH	MASSPRO	Revision No.:	2	Page No.:	6 of 18
PARTS:	1. AVS	S 0.3 P L=156±2mm; W/G	L=156±2mm; G L=156±2mm; BR L=15	6±2mm; GR L=156±2mm;		JIG:	1. Insertion	jig	
NO.	ı	PROCESS NAME	WORK	PROCEDURE/ ILLUSTR	ATION	TOOLS/PPE		QUALITY POIN	TERS
7	<i>/</i> 3		BACK VIEW OF TERMINAL GOOD Terminal condition Note: *Make sure the terminal w. *Avoid hitting the terminal	FRONT OF TERMINAL GOOD Terminal condition as in proper alignment before the connector during we	BACK VIEW OF TERMINAL Damaged terminal NO GOOD Terminal condition	nal to connector NT VIEW OF TERMINAL NO GOOD Terminal codition	1. Use prov 2. No wrong 3. No wrong 4. No defort 5. No stuck 6. One by o Impo 1. Mainsert Push Do no 2. Ple termin 3. Aut replat encoi diffici locke 4. Ins left to Docum 1. Ref Wire a 2. Ref Steeri proce 3. Ref Pull-P 4. Ref Inspec	ided jig per model g usage of parts g insertion med terminal of terminal tip ne insertion retant reminders/l ake sure wires are ded. Conduct Pull after insertion. In texert extra force ase hold the wire mal during insertio ce the unit if once untered bend terr ulty of insertion a d connector. ertion of wires m oright. ment reference/s er to WI-PRO-CN and Strip Length or Navigation Co	Note/s: e properly I-Push-Pull- ee. es near ion. ese and e minal, end half- ust be from : C-017 for Tolerance. E-044 for ontroller ey-029 for

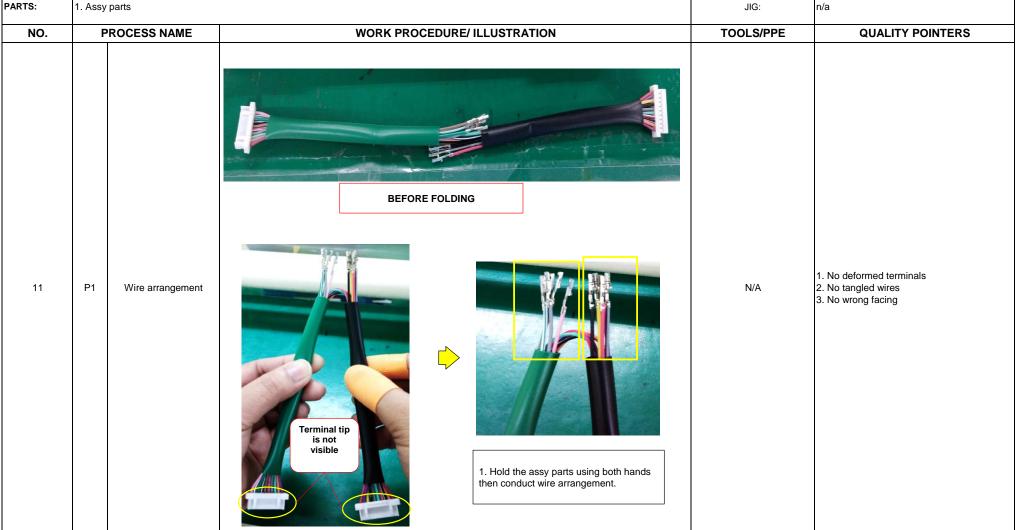
			WORK INS	STRUCTION		Effectivity Date: February 10, 2029)25		
		Process Name/Title:	TAPIN	NG ASSEMBLY PRO	CESS		Validity Date:		February 17, 20)25
		Model code/Part number:	920B / 75S321-0080	Customer: TRMX	Car Model:	TOYOTA-TACOMA	Document No.:		WI-ENG-PDE-5	56
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPE	RO	Revision No.:	2	Page No.:	7 of 18
PARTS:	1. Assy 2. Gree	parts n VM tube (sunprene) ø8 L	=114±3mm				JIG:	1. Insertio	n jig	
NO.	F	PROCESS NAME	WORK	PROCEDURE/ ILLUSTR	ATION		TOOLS/PPE		QUALITY POIN	TERS
8	P1	Wire insertion to Green VM tube (sunprene) Ø8 L=114±3mm	1. Get the Green VM tube (Sunprene) ø8 using right hand. Hold the wire using left hat the wires. 3. Remove the 1st connector with inseruper guide using left hand. Check the Note: Second connector with inserted v	and then insert L L L L L L L L L L L L L	e) will stay in the ji		N/A	Z. No defc 3. No tang Teri Docum 1. Rei Inspectinspectinsertic 2. Refe	minal tip must be ment References: fer to GL-PRO-AS\tion Standard for C	7-025 for Coupler -043 for



	WORK INSTRUCTION Effectivity Date: February 10, 2025 Process Name/Title: TAPING ASSEMBLY PROCESS Validity Date: February 17, 2025										
		Process Name/Title:			FSS						
		Model code/Part number:	920B / 75S321-0080	Customer: TRMX	Car Model: TOYOTA-TACOM			WI-ENG-PDE-55			
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	2	Page No.:	8 of 18		
PARTS:	1. Assy 2. Gree	parts n VM tube (sunprene) ø8 I	_=114±3mm			JIG:	1. Insertion	n jig			
NO.	F	ROCESS NAME	WORK I	PROCEDURE/ ILLUSTR	ATION	TOOLS/PPE	QUALITY POINTERS				
9	P1	Wire insertion to assy parts	755126-00 ;	R	1. Hold the Green VM tube (Sunprene) using left hand and insert the wires from Black VM tube (Sunprene) using right hand.	N/A	Z. No defo 3. No tang Term Docum 1. Ref. Inspect. 2. Refe 2. Refe	ninal tip must be v	-025 for oupler 043 for		

	WORK INSTRUCTION Effectivity Date: February 10, 2025 Process Name/Title: TAPING ASSEMBLY PROCESS Validity Date: February 17, 2025										
		Process Name/Title:	TAPIN	NG ASSEMBLY PROC	CESS		Validity Date:		February 17, 20	25	
		Model code/Part number:	920B / 75S321-0080	Customer: TRMX	Car Model:	TOYOTA-TACOMA	Document No.:		WI-ENG-PDE-5	56	
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPE	RO	Revision No.:	2	Page No.:	9 of 18	
PARTS:	1. Ass	y parts					JIG:	1. Insertion	n jig		
NO.		PROCESS NAME	WORK	PROCEDURE/ ILLUSTR	ATION		TOOLS/PPE	(QUALITY POIN	TERS	
10	P1	Wire insertion to Connector PBVP-10V-S (W)	2. Hold the R/L wire using right hand a finger then insert to connector using right Note: Follow the insertion sequence by	WIRE 1 2 3 4 R/L OR LG 6 285 285 285 11 and support the wire by left in ght hand. Repeat the processire after insertion passed on the above illustration as	INSERTION II 4 5 6 IR R/W BR IS 285 156 Wir Addex s on n.		STEERING NAVIGATION(2 layer) CONTROLLER	1. Use pro 2. No wror 3. One by 4. No wror 5. No defo 6. No stuc 7. No defo 8. No tang 9. No wror Importa 1. Pleass during in 2. Make Conduct insertion Do not e Docume 1. Refer Steering procedur 2. Refer and Strip 3. Refer Push pro	vided jig per mode ig usage of parts one insertion ig insertion immed terminal it of of terminal it of terminals it of the wire near sertion. Sure wires are propull-Push-Push-Pull-Push-Push-Push-Push-Push-Push-Push-Push	e/s: r terminal perly inserted. sh after 044 for ller 17 for Wire 28 for Pull-	

			WORK IN	STRUCTION		Effectivity Date:		February 10, 2	025	
		Process Name/Title:	TAPII	NG ASSEMBLY PR	OCESS	Validity Date:		February 17, 2	025	
		Model code/Part number:	920B / 75S321-0080	Customer: TRM	X Car Model: TOYOTA-TACOM	A Document No.:		WI-ENG-PDE-556		
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PARTS:	1. Assy	parts				JIG:	n/a			





			WORK IN	STRUCTION			Effectivity Date:		February 10, 20	25
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		Model code/Part number:	920B / 75S321-0080	Customer: TRMX		YOTA-TACOMA	Document No.:		WI-ENG-PDE-5	56
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO		Revision No.:	2	Page No.:	11 of 18
PARTS:	1. Conr	nector 1746872-1 (B)					JIG:	1. Insertior	n jig	
NO.	F	ROCESS NAME	WORK	PROCEDURE/ ILLUSTRA	ATION		TOOLS/PPE	(QUALITY POINT	ΓERS
12	P1	Connector setting to insertion jig 1746872-1 (B)	1. Get the connector 1746872-1 Note: Follow the connector orien	Press Ower guide (same timing) using	using right hand.	lote: Check the onnector before esertion.		2. No wron 3. No wron 4. No dam CAF Import 1. Autor unit if or difficulty connect 2. Follow	CONNECTOR ILLUST NG NG 1372-1 (B) 137 tant reminders/ matically dispose an once encountered by of insertion and he	RATION RATION Mote/s: nd replace the end terminal, alf-locked entation

			WORK INSTRUCTION			Effectivity Date:		February 10, 20	25
		Process Name/Title:	TAPING ASSEMBL	Y PROCESS		Validity Date:		February 17, 20	25
		Model code/Part number:	920B / 75S321-0080 Customer:	TRMX Car Model:	TOYOTA-TACOMA	Document No.:		WI-ENG-PDE-5	56
		Purpose:	PROTOTYPE PRE-LAUNCH	MASS	PRO	Revision No.:	2	Page No.:	12 of 18
PARTS:	1. Assy	parts				JIG:	Insertion ji	9	
NO.	F	PROCESS NAME	WORK PROCEDURE/ I	ILLUSTRATION		TOOLS/PPE	(QUALITY POIN	ΓERS
NO.	P1	Connector setting to insertion jig 1746872-1 (B)	INSERTION SEQUENCE FROM LEFT TO RIGHT 2ND ROW 1ST ROW BLACK SUNPREI 1 2 2 2	WIRE INSERTION	ON ILLUSTRATION 10		1. Use pro 2. No wror 3. One by 4. No wror 5. No defo 6. No stuck Import 1. Auton unit if or difficulty connect 2. Make Conduct insertio Do not e 3. Pleas during ir 4. Follow	evided jig per mode ing usage of parts one insertion insertion in the part of	Note/s: and replace the end terminal, alf-locked perly inserted. ush after ar terminal
			1. Insert first the wires from Black Sunprene tube. Hold the R wire and insert to terminal slot 1 using right hand. Repeat the process for V-Y-B wires. Note: Follow the insertion sequence based on the illustration stated above.	terminal slot 5. Note: Follow the	/B wire and insert to the insertion sequence dustration stated above.		1. Refer Push pro 2. Refer	to GL-PRO-ASY-C cocedure. to WI-PRO-CNC-C co Length Tolerance	129 for Pull- 17 for Wire



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		Process Name/Title:		Validity Date:	February 17, 2025					
	H	Model code/Part number:	TAPING ASSEMBLY PROCESS 920B / 75S321-0080				Document No.:	WI-ENG-PDE-5		
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO		Revision No.:	2	Page No.:	13 of 18
PARTS:	1. Assy	parts					JIG:	1. Insertior	n jig	
NO.	F	PROCESS NAME	WORK	PROCEDURE/ ILLUSTR	RATION		TOOLS/PPE	TOOLS/PPE QUALITY POINTI		
14	P1	Wire insertion to Connector 1746872-1 (B) (Continuation)	3. Insert the wires from Green sunprewire by left index finger then insert to to Note: Follow the insertion sequence between the Reference of	erminal slot 6 using right han ased on the above illustration 4. Hold the using right P wire. Note: Foll the illustration 5. Press t (same time)	e G wire and insert to terminate hand. Repeat the process for BR on.	al slot 8 or GR-ased on		2. No wron 3. One by 4. No wron 5. No defo 6. No studi Import 1. Make Conduct insertio Do not e 2. Pleas terminal 3. Follow the abou	exert extra force. The hold the wire near during insertion. The insertion sequence illustration. The insertion sequence illustration.	Note/s: perly inserted. push after ar uence based on



			WORK INS					Effectivity Date:		February 10, 20	
		Process Name/Title: TAPING ASSEMBLY PROCESS						Validity Date:		February 17, 20	025
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	1										
PARTS:	1. Assy							JIG:	n/a		
NO.	F	PROCESS NAME	WORK P	PROCEDURE	/ ILLUSTR	RATION		TOOLS/PPE	QUALITY POINTERS		
15	P1	Harness arrangement	L	R	1. Hold th then cond	ne assy parts usir duct harness facii	ng both hands ng arrangement.	n/a	No tang	ng orientation of co gled wires ng wire folding	onnector



				fectivity Date: February 10, 2025						
		rocess Name/Title: TAPING ASSEMBLY PROCESS					ty Date:		February 17, 202	25
		Model code/Part number: 920B / 75S321-0080 Customer: TRMX Car Model: TOYOTA-TACOMA					ment No.:	6		
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revisi	ion No.:	2	Page No.:	15 of 18
<u> </u>										
PARTS:	1. Assy	/ parts					JIG:	n/a		
NO.			WORK F	PROCEDURE/ ILLUSTR/	ATION		TOOLS/PPE	(QUALITY POINT	ERS
15	P1	Harness arrangement (Continuation)	GOOD FACING Folding in the front NG FACING GOOD FACIN Connector Lock Folding	NG .	Terminal tip is Not visible Terminal tip is visible NG FACING Double lock		n/a	2. No tang	g orientation of cor led wires g wire folding	nector



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		Process Name/Title:	Validity Date:	February 17, 2025						
		Model code/Part number:	920B / 75S321-008	APING ASSEMBLY P Customer: TR		YOTA-TACOMA	Document No.:		WI-ENG-PDE-5	56
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO		Revision No.:	2	Page No.:	16 of 18
PARTS:	1. Assy 2. Mas	/ parts ter sample					JIG:	n/a		
NO.	F	PROCESS NAME	WO	RK PROCEDURE/ ILLU	ISTRATION		TOOLS/PPE	QUALITY POINTERS		
			lock, locking of ali	Check the wire gnment. Make dure no gled wires.	3. Check the terminal -out(Or not fully insert deformed terminal.	if with backing ed) no	4. Check the orientation of harness.	Docum 1. Refer	ent Reference: to WI-QAD-QAC- ering Electrical Te ly.	252
16	P1	Visual/By Two's Inspection		Green Sunprene to Master s	Master sample	embly		The state of the s	MASTER SAMI	ALL THE STATE OF T

				RK INSTRUCTION TAPING ASSEMBLY PRO		Effectivity Date:		February 10, 20	25
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		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	2	Page No.:	17 of 18
PARTS:	1. Assy	parts				JIG:	n/a		
NO.	P	ROCESS NAME	V	VORK PROCEDURE/ ILLUSTF	RATION	TOOLS/PPE	(QUALITY POINT	TERS
17	P1	Measurement	Note: Please use calibrated/verified measuring tape when getting the measurement.		166±3mm 168±3mm		1. Please measurir measure 2. For He Owarimo Docume 1. Refer t assembly Owarimo	atsumono, Nakamo	rified rig the rino and rig for Sub-



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PARTS: n/a					JIG:	n/a						
			QUALITY CHE	CKPOINTS								
P1	P1 75S321-0080											
3. Check f	the connector lock. The orientation of harnes if no missing parts.	sure no tangled		Black Sunprene Tube Green Sunprene Tube nal if with backing out (not all terminal).			FOLDE WIRES MUST IN BAC POSIT	BE K				