

**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

January 23, 2025

Model code/Part number:

**920B / 75S321-0081**

Customer:

**TRMX**

Car Model:

**TOYOTA-TACOMA**

Document No.:

**WI-ENG-PDE-1185**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

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**PARTS:**

1. Connector PBVP-10V-S (W); Connector 1746872-1 (B); AVSS 0.3 R L=160±2mm; V L=160±2mm; Y L=160±2mm; B L=160±2mm; GR/B L=160±2mm; LG L=297±2mm; R/W L=297±2mm; B/W L=297±2mm; OR L=297±2mm; R/L L=297±2mm; AVSS 0.3 P L=162±2mm; W/G L=162±2mm; G L=162±2mm; BR L=162±2mm; GR L=162±2mm; Black VM tube (Sunprene) ø8 L=118±3mm; Green VM tube (Sunprene) ø8 L=120±3mm.

JIG:

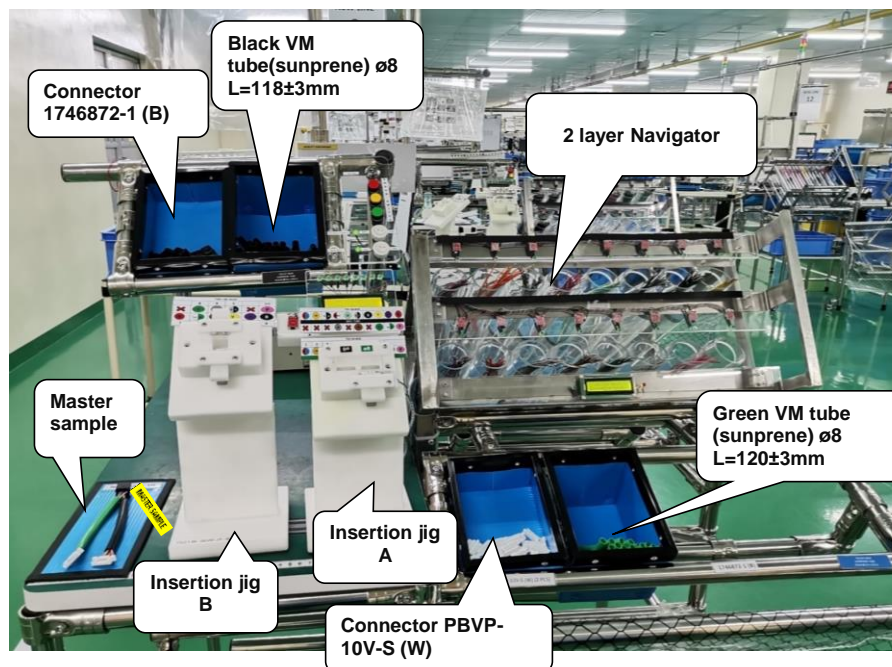
1. Insertion jig
2. Steering Navigation

**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

1

P1

Table Lay-out

**TABLE LAY-OUT****Safety Instruction**

Be sure to wear required 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 deformed terminal
2. No wrong usage of parts

## Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
01/23/25	1	Change document purpose from pre-launch to mass pro.	A. Buban	C. Villanueva	A. Arañes	n/a	Alexandra A. Buban	C. Villanueva	A. Arañes	n/a
01/14/25	0	Initial issue.	A. Buban	C. Villanueva	A. Arañes	n/a	A. Buban	C. Villanueva	A. Arañes	n/a

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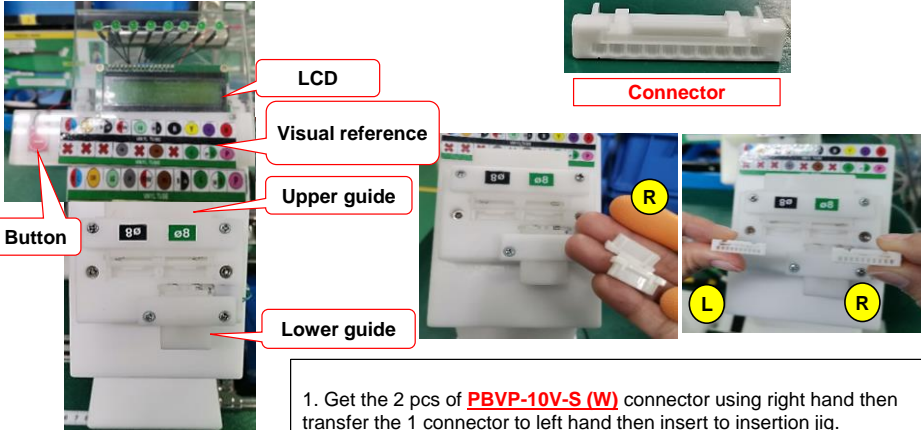
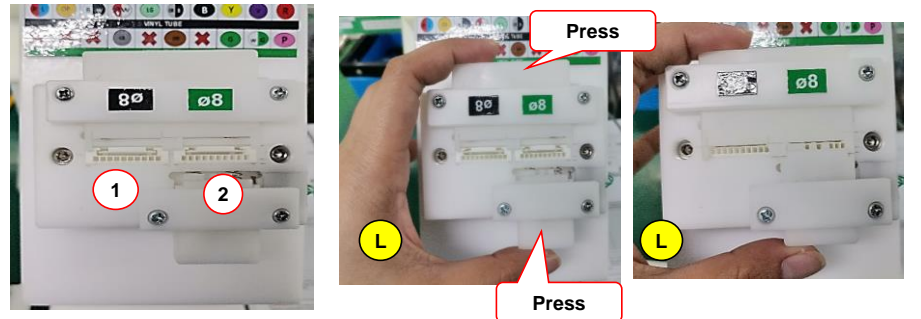
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PARTS:	1. Connector PBVP-10V-S (W) [2pcs.]		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1  Connector setting to insertion jig PBVP-10V-S (W)	<div><p>1. Get the 2 pcs of <b>PBVP-10V-S (W)</b> connector using right hand then transfer the 1 connector to left hand then insert to insertion jig. <i>Note: Follow the connector orientation.</i></p></div> <div><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>	N/A	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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**3 of 18****PARTS:**

1. AVSS 0.3 R L=160±2mm; V L=160±2mm; Y L=160±2mm; B L=160±2mm; GR/B L=160±2mm; LG L=297±2mm; R/W L=297±2mm; B/W L=297±2mm; OR L=297±2mm; R/L L=297±2mm;
2. Black VM tube (Sunprene) ø8 L=118±3mm

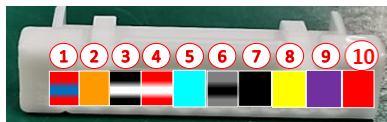
JIG:

1. Insertion jig

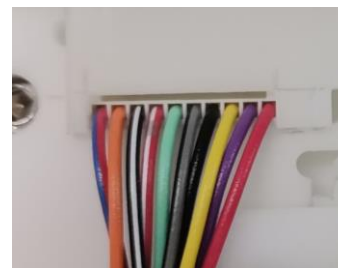
**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

3

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
R/L	OR	B/W	R/W	LG	GR/B	B	Y	V	R
297	297	297	297	297	160	160	160	160	160



1. Get the **R/L wire** using right hand and insert to connector. Repeat the process for **OR-B/W-R/W-LG-GR/B-B-Y-V-R wires**.

**Note: Follow the insertion sequence based on the 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. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion. Do not exert extra force.
2. Please hold the wire near terminal during insertion.
3. Follow the insertion sequence based on the illustration.

**Document references:**

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

N/A

1. No wrong usage of parts
2. No deformed terminal
3. No tangled wires

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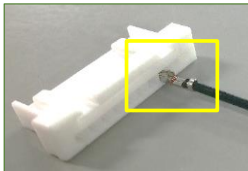
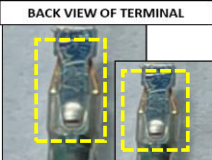
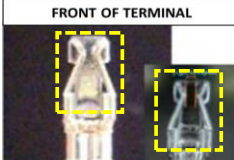

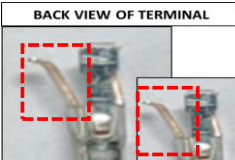
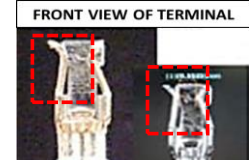
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PARTS:		1. AVSS 0.3 R L=160±2mm; V L=160±2mm; Y L=160±2mm; B L=160±2mm; GR/B L=160±2mm; LG L=297±2mm; R/W L=297±2mm; B/W L=297±2mm; OR L=297±2mm; R/L L=297±2mm;		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1  Wire insertion to connector PBVP-10V-S (W) (Continuation)	<div><div>Proper alignment of terminal to connector</div><div></div><div><div>BACK VIEW OF TERMINAL</div><div></div><div>GOOD Terminal condition</div></div><div><div>FRONT OF TERMINAL</div><div></div><div>GOOD Terminal condition</div></div></div> <div><div>Improper alignment of terminal to connector</div><div></div><div><div>BACK VIEW OF TERMINAL</div><div></div><div>Damaged terminal NO GOOD Terminal condition</div></div><div><div>FRONT VIEW OF TERMINAL</div><div></div><div>NO GOOD Terminal condition</div></div></div> <div>Note: <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></div>			<div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong insertion 4. No deformed terminal 5. No stuck of terminal tip 6. One by one insertion</div> <div>Important reminders/Note/s:</div> <div><div>1. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</div><div>2. Please hold the wires near terminal during insertion.</div><div>3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</div><div>4. Insertion of wires must be from left to right.</div></div> <div>Document reference/s:</div> <div><div>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</div><div>2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..</div><div>3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div><div>4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</div></div>

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☐ PRE-LAUNCH

☒ MASSPRO

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**PARTS:** 1. AVSS 0.3 P L=162±2mm; W/G L=162±2mm; G L=162±2mm; BR L=162±2mm; GR L=162±2mm;

JIG:

1. Insertion jig

**NO.**

**PROCESS NAME**

**WORK PROCEDURE/ ILLUSTRATION**

**TOOLS/PPE**

**QUALITY POINTERS**

6

P1

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

INSERTION SEQUENCE FROM LEFT TO



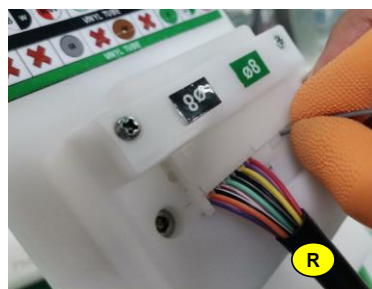
Wire facing



1	2	3	4	5	6	7	8	9	10
X	X	X	GR	X	BR	X	G	W/G	P
162	162	162	162	162	162	162	162	162	162

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

Lower guide



1. Get the **GR wire** using right hand and insert to connector. Repeat the process for **BR-G-W/G-P wires**.

**Note: Follow the insertion sequence based on the 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. Refer to **GL-PRO-ASY-029** for Pull-Push procedure.
3. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion. Do not exert extra force.
4. Follow the insertion sequence based on the above illustration.

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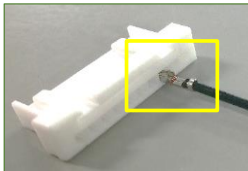
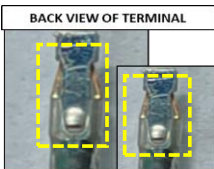
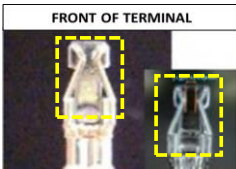

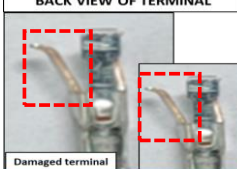
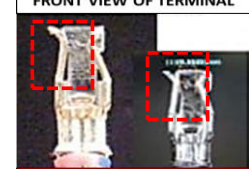
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. AVSS 0.3 P L=162±2mm; W/G L=162±2mm; G L=162±2mm; BR L=162±2mm; GR L=162±2mm;		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1  Wire insertion to connector PBVP-10V-S (W) (Continuation)	<div><div>Proper alignment of terminal to connector</div><div></div><div><div>BACK VIEW OF TERMINAL</div><div></div><div>GOOD Terminal condition</div></div><div><div>FRONT OF TERMINAL</div><div></div><div>GOOD Terminal condition</div></div></div> <div><div>Improper alignment of terminal to connector</div><div></div><div><div>BACK VIEW OF TERMINAL</div><div></div><div>Damaged terminal NO GOOD Terminal condition</div></div><div><div>FRONT VIEW OF TERMINAL</div><div></div><div>NO GOOD Terminal condition</div></div></div> <div>Note: <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></div>			<div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong insertion 4. No deformed terminal 5. No stuck of terminal tip 6. One by one insertion</div> <div>Important reminders/Note/s:</div> <div>1. <i>Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</i> 2. <i>Please hold the wires near terminal during insertion.</i> 3. <i>Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</i> 4. <i>Insertion of wires must be from left to right.</i></div> <div>Document reference/s:</div> <div>1. <i>Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</i> 2. <i>Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..</i> 3. <i>Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i> 4. <i>Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</i></div>

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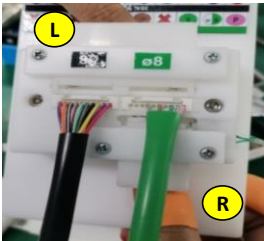
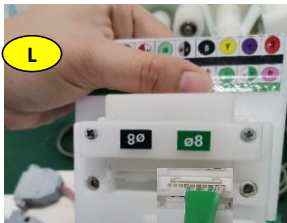
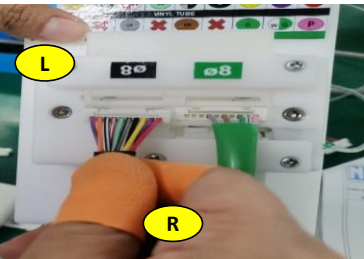
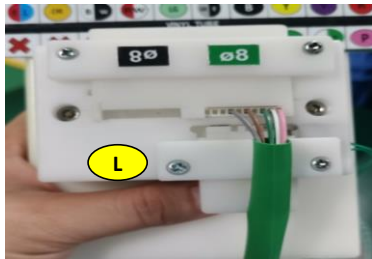


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PARTS:		1. Assy parts 2. Green VM tube (sunprene) $\varnothing 8$ L=120 $\pm$ 3mm		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1	<div><div><p>1. Get the <b>Green VM tube (Sunprene)</b> <math>\varnothing 8</math> L=120<math>\pm</math>3mm using right hand. Hold the wire using left hand then insert the wires.</p></div><div><p>2. Press the Upper and lower guide button using left and right hand.</p></div><div><p>3. Remove the 1st connector with inserted wires and <b>Black VM tube (Sunprene)</b> using right hand then press the upper guide using left hand. Check the wire insertion condition. <b>Note:</b> Second connector with inserted wire and <b>Black VM tube (Sunprene)</b> will stay in the jig.</p></div><div><p>4. Press the lower button using left hand. Holes that need to be inserted are only open.</p></div></div>		N/A	<div><p><b>Terminal tip must be visible</b></p></div> <p><b>Document References:</b> 1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion. 2. Refer to GL-PRO-ASY-043 for Verification of Fully Inserted Wires.</p>
		N/A	<div>1. No wrong use of parts 2. No deformed terminal 3. No tangled wires</div>		

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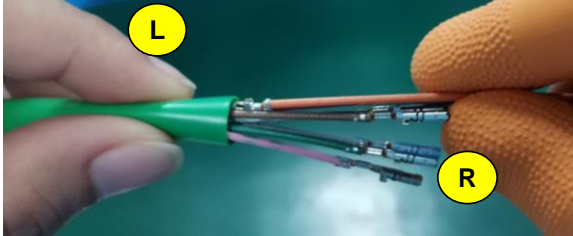


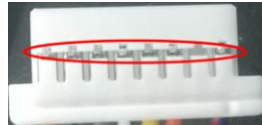
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PARTS:		1. Assy parts 2. Green VM tube (sunprene) ø8 L=120±3mm		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1 Wire insertion to assy parts	<div></div> <div><p>1. Hold the <b>Green VM tube (Sunprene)</b> using left hand and insert the wires from <b>Black VM tube (Sunprene)</b> using right hand.</p></div> <div></div> <div></div>		N/A	<div></div> <div><p><b>Terminal tip must be visible</b></p></div> <div><p><b>Document References:</b></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: 1. Assy parts

JIG:

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

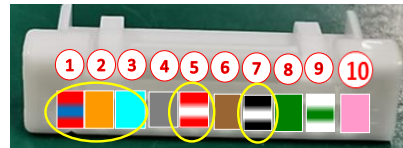
TOOLS/PPE

QUALITY POINTERS

10

P1

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

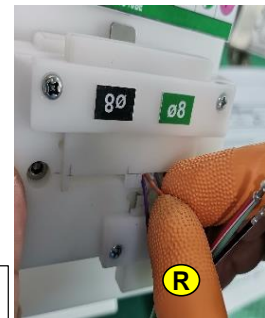


### WIRE INSERTION ILLUSTRATION

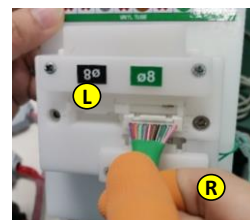
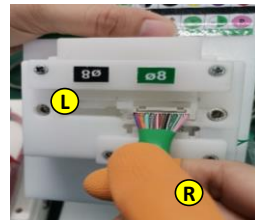
1	2	3	4	5	6	7	8	9	10
R/L	OR	LG	GR	R/W	BR	B/W	G	W/G	P
297	297	297	162	297	162	297	162	162	162



Wire facing



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



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

### STEERING NAVIGATION(2 layer)



### CONTROLLER



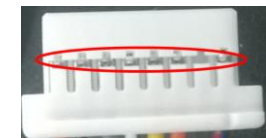
1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip
7. No deformed terminals
8. No tangled wires
9. No wrong facing

### 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.



Terminal tip must be visible

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Process Name/Title:

Model code/Part number:

**920B / 75S321-0081**

Customer:

**TRMX**

Car Model:

**TOYOTA-TACOMA**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

**January 23, 2025**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-1185**


Revision No.:

**1**

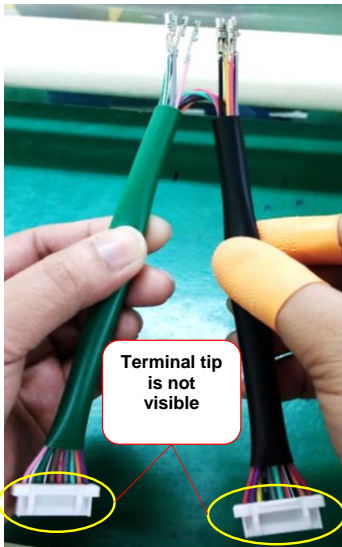
Page No.:

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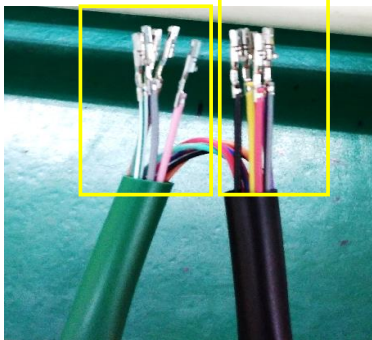
PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1	Wire arrangement		N/A	1. No deformed terminals 2. No tangled wires 3. No wrong facing



BEFORE FOLDING



Terminal tip is not visible



1. Hold the assy parts using both hands then conduct wire arrangement.

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# WORK INSTRUCTION

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TOYOTA-TACOMA

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


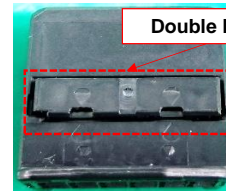
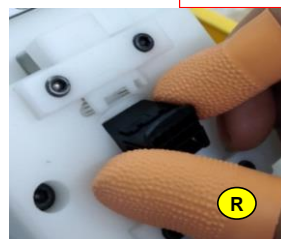
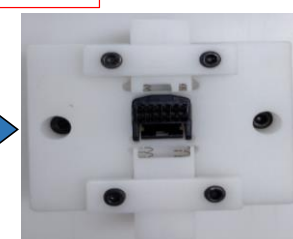
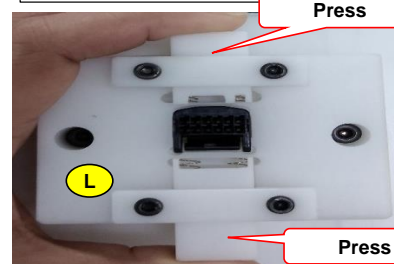
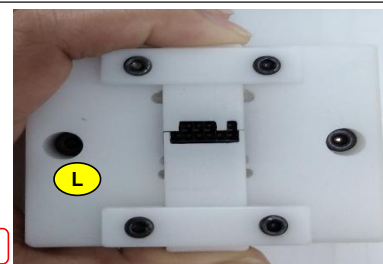




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PARTS:		1. Connector 1746872-1 (B)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
12	P1  Connector setting to insertion jig 1746872-1 (B)	<div><div><div>INSERTION JIG</div><div></div><div>Visual</div><div>Upper guide</div><div>Lower guide</div></div><div><div></div><div>Double lock</div><div>Note: Check the connector before insertion.</div><div>CONNECTOR</div><div></div><div></div></div><div><div>1. Get the connector <b>1746872-1 (B)</b> and insert to insertion jig using right hand. <i>Note: Follow the connector orientation</i></div><div><div></div><div>Press</div><div></div><div>Press</div><div>2. Press the upper and lower guide (same timing) using left hand. Holes that need to be insert are only open.</div></div></div></div>		N/A	<div>1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</div> <div>CONNECTOR LOCK APPEARANCE CHECK</div> <div><div>GOOD</div><div></div><div>UNLOCK</div></div> <div><div>NG</div><div></div><div>HALF-LOCKED</div></div> <div>CONNECTOR ILLUSTRATION</div> <div><div>GOOD</div><div></div><div>1746872-1 (B)</div></div> <div><div>NG</div><div></div><div>1376675-1 (B)</div></div> <div><b>Important reminders/Note/s:</b> <i>1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</i> <i>2. Follow the connector orientation</i> <i>3. Check the connector before insertion.</i></div>

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## WORK INSTRUCTION

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Model code/Part number:

920B / 75S321-0081

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

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PARTS: 1. Assy parts

JIG:

Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

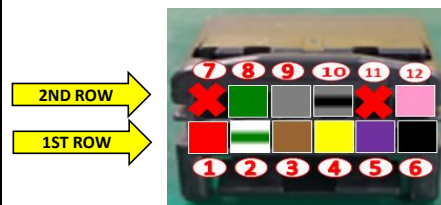
QUALITY POINTERS

13

P1

Connector setting to  
insertion jig  
1746872-1 (B)

## INSERTION SEQUENCE FROM LEFT TO RIGHT



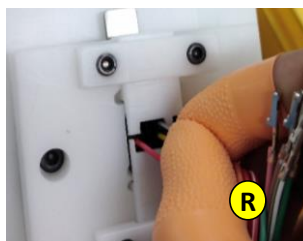
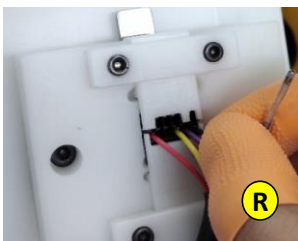
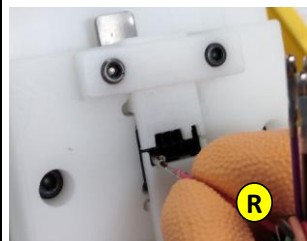
## WIRE INSERTION ILLUSTRATION

7	8	9	10	11	12
X	G	GR	GR/B	X	P
1	2	3	4	5	6
R	W/G	BR	Y	V	B
160	162	162	160	160	160

## BLACK SUNPRENE TUBE



## Wire facing



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.*

2. Hold the **GR/B wire** and insert to terminal slot 5.  
*Note: Follow the insertion sequence based on the illustration stated above.*

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. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.
2. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push after insertion**. Do not exert extra force.
3. Please hold the wire near terminal during insertion.
4. Follow the insertion sequence based on the illustration stated above.

**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

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Model code/Part number:

920B / 75S321-0081

Customer:

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Car Model:

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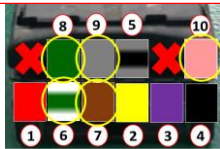
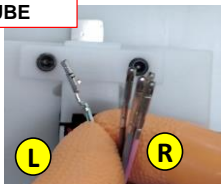
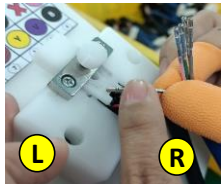
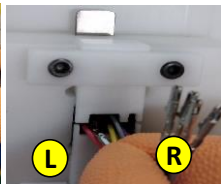
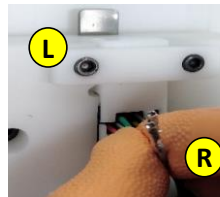
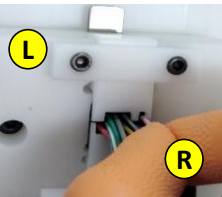
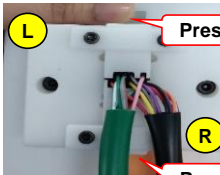
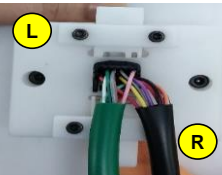

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
14	P1 Wire insertion to Connector 1746872-1 (B) (Continuation)	<p><b>GREEN SUNPRENE TUBE</b></p>     <p>3. Insert the wires from <b>Green sunprene tube</b>, hold the <b>W/G wire</b> using right hand and support the wire by left index finger then insert to terminal <b>slot 6</b> using right hand. Repeat the process for <b>BR wire</b>. <i>Note: Follow the insertion sequence based on the above illustration.</i></p>   <p>4. Hold the <b>G wire</b> and insert to terminal <b>slot 8</b> using right hand. Repeat the process for <b>GR-P wire</b>. <i>Note: Follow the insertion sequence based on the illustration.</i></p>   <p>5. Press the upper and lower lever guide (same timing) using both hands.</p>  <p>6. Remove the assy parts using right hand.</p>		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><b>Important reminders/Note/s:</b></p> <p>1. Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push after insertion</b>. <i>Do not exert extra force.</i></p> <p>2. Please hold the wire near terminal during insertion.</p> <p>3. Follow the insertion sequence based on the above illustration.</p> <p><b>Document references:</b></p> <p>1. Refer to <b>GL-PRO-ASY-029</b> for Pull-Push procedure.</p>

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Effectivity Date:

January 23, 2025

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

920B / 75S321-0081

Customer:

TRMX

Car Model:

TOYOTA-TACOMA

Document No.:

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Purpose:

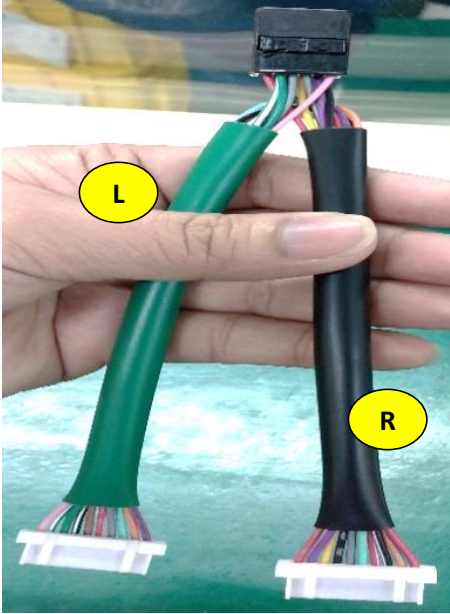
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PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
15	P1	Harness arrangement	<div><div>1. Hold the assy parts using both hands then conduct harness facing arrangement.</div></div>	n/a	1. No wrong orientation of connector 2. No tangled wires 3. No wrong wire folding

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**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Process Name/Title:

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**920B / 75S321-0081**

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**TOYOTA-TACOMA**

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
15	P1 Harness arrangement (Continuation)	<div><div><p>Folding at the back</p></div><div><p>Terminal tip is Not visible</p></div><div>GOOD FACING</div></div> <div><div><p>Folding in the front</p></div><div><p>Terminal tip is visible</p></div><div>NG FACING</div></div> <div><div><p>GOOD FACING</p></div><div><p>Connector Lock</p></div><div><p>Folding</p></div></div> <div><div><p>NG FACING</p></div><div><p>Double lock</p></div><div><p>Folding</p></div></div>	n/a	1. No wrong orientation of connector 2. No tangled wires 3. No wrong wire folding

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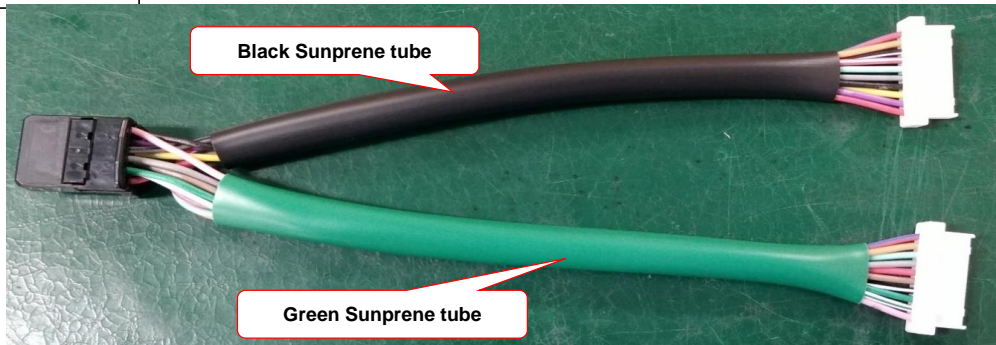
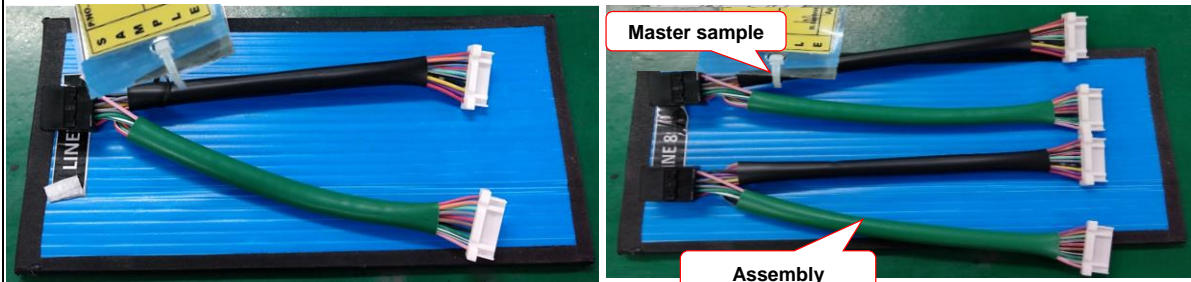

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PARTS:		1. Assy parts 2. Master sample		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
16	P1	Visual/By Two's Inspection	<div>1. Check the connector lock, locking of connector is included in Steering electrical test.</div> <div>2. Check the wire alignment. Make dure no tangled wires.</div> <div>3. Check the terminal if with backing - out(Or not fully inserted) no deformed terminal.</div> <div>4. Check the orientation of harness.</div> <div><div>Black Sunprene tube</div><div>Green Sunprene tube</div><div>5. Compare to Master sample by tapping.</div><div><div>Master sample</div><div>Assembly</div></div></div>		<div>Document References:</div> <div>1. Refer to WI-QAD-QAC-252 for Steering Electrical Test after assembly.</div> <div><div>MASTER SAMPLE</div><div></div><div>1. No wrong facing of harness 2. No Tangled wires 3. No missing parts</div></div>

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

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# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number: **920B / 75S321-0081**

Customer: **TRMX**

Car Model: **TOYOTA-TACOMA**

Purpose:

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PARTS:

n/a

JIG:

n/a

### QUALITY CHECKPOINTS

**P1**

**75S321-0081**

1. Check the connector lock.

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

Black Sunprene Tube

Green Sunprene Tube

3. Check the orientation of harness.

4. Check if no missing parts.

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

**FOLDED WIRES MUST BE IN BACK POSITION**

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