NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS Safety Instruction Be suit to tweat prescribed personal protective equipment duing operation (gloves, equipment duing operation duing operation duing operation (gloves, equipment duing operation (gloves, equipment duing operation					WORK IN	STRUCTION			Effectivity Date:		September 12, 2	024	
Page 1. Connector PRVP-10V-S (W) [2]stal. Connector 1746072-1 (B): AVSS 0.3 R, Y, V, B, GRIB L-170-Zmm, AVSS 0.3 W, G, BR, G, G, P, I-170-Zmm, AVSS 0.3 W, G, BR, G, GR, P, I-170-Zmm, AVSS 0.3 W, G, BR, G, GR, P, I-170-Zmm, AVSS 0.3 W, G, BR, G, GR, P, I-170-Zmm, AVSS 0.3 W, G, BR, G, GR, P, I-170-Zmm, AVSS 0.3 W, G, BR, G, GR, P, I-170-Zmm, AVSS 0.3 W, G, BR, G, GR, P, I-170-Zmm, AVSS 0.3 W, G, BR, G, GR, P, I-170-Zmm, AVSS 0.3 W, G, BR, G, GR, P, I-170-Zmm, AVSS 0.3 W, G, BR, G, GR, P, I-170-Zmm, AVSS 0.3 W, G, BR, G, GR, P, I-170-Zmm, AVSS 0.3 W, G, BR, G, GR, P, I-170-Zmm, AVSS 0.3 W, G, BR, G, GR, P, I-170-Zmm, AVSS 0.3 W, G, BR, GR, BR,			Pro	cess Name/Title:					Validity Date:		n/a		
PARTS: 1. Connector PByP-10VS (W) 2pcs.): Connector 1748872-1 (8): AVSS 0.3 R. Y. V. B. QNB 1=176:2mm; AVSS 0.3 W.C. BR. C. GR, P. L=176:2mm; JG: 2. Selecting Recognition (2): Selecti			Mo	del code/Part number:	300D / 75Q697-0351	Customer: TRJ	Car Model: TOYO	TA-CROWN	Document No.:		WI-ENG-PDE-3	49	
AVS 0.3 LO, PL, EW, RWI, OR L-521 ±2mm; Black VM tube (Supprene) at L=134±2mm 2. Steering Nivingation NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS TABLE LAY-OUT Safety Instruction Res size to Weety (By 6x x			Pur	pose:	PROTOTYPE	PRE-LAUNCH	MASSPRO		Revision No.:	6	Page No.:	1 of 18	
TABLE LAY-OUT Safety Instruction Be sure to wear prescribed personal protective equipment, during operation (gloves, finger cots, etc.) I Table lay-out Master Safety Instruction Be sure to wear prescribed personal protective equipment, during operation (gloves, finger cots, etc.) I Table lay-out Master Safety Instruction Be sure to wear prescribed personal protective equipment, during operation (gloves, finger cots, etc.) I No deformed terminal No wrong usage of parts Revision History Revision Histor	PARTS:								JIG:				
Safety Instruction Be sure to wear prescribed personal protective equipment (gloves, finger cots, finder cots, finder cots, finger cots, finder cots, finder cots, finder cots, finder cots, finger cots, finder cots, finder cots, finder cots, finder cots, finder cots	N	0.	PRC	CESS NAME	WORK	PROCEDURE/ ILLUSTR	ATION		TOOLS/PPE	(QUALITY POIN	TERS	
Master sample 1			6			Dark Brown VM tube (Sunprene)			Be sure to wear prescribed person protective equipme during operation (gloves, finger cots	Docume 1. Refer to	WI-PRO-CNC-0		
Revision History Revision Lineader for immediate corrective action. Prepared by Revised by Approved by Noted by Villanus A. Arañes Proprieta History His	1	I	P1	Table lay-out	sample 12000 15000	K (X K O X K)	(Sui	nprene)	Maintain and alwa practice 5's. Personal things the workplace is prohibited. Keep it	1. No defor 2. No wron			
Improved insertion jig; Change connector (PBVP-10V-S) orientation, terminal orientation and color sequence as customer claim countermeasure. Inclusion of Table lay-out. Improved Wire arrangement, Measurement and Visual inspection/Quality checkpoints. Change document number of Steering Electrical test (WI-QAD-QAC-252). Improve work procedure/Illustration; Change VM tube (Sunprene) from Brown VM tube (Sunprene) to Dark Brown VM tube (Sunprene) to Dark Brown VM tube (Sunprene); Standardize tube description: VM tube (Sunprene); Inclusion of Quality checkpoints. D.Castillo C. Villanueva A. Arañes Villanueva		Insertion Jig B Insertion Insertion Jig B Inse											
claim countermeasure. Inclusion of Table lay-out. Improved Wire arrangement, Measurement and Visual inspection/Quality checkpoints. Change document number of Steering Electrical test (WI-QAD-QAC-252). D2/25/23 5 Improve work procedure/Illustration; Change VM tube (Sunprene) from Brown VM tube (Sunprene) to Dark Brown VM tube (Sunprene) to Dark Brown VM tube (Sunprene); Standardize tube description: VM tube (Sunprene); Inclusion of Quality checkpoints. D.Castillo Villanueva A. Arañes Vi					Revision History				Prepared by	Reviewed by	Approved by	Noted by	
5 (Sunprene); Standardize tube description: VM tube (Sunprene); Inclusion of Quality checkpoints. D.Castillo	09/12/24	6	claim counter	measure. Inclusion of Table	lay-out. Improved Wire arrangement, Measurem			A. Arañes n	/a				
09/30/22 4 Improved the insertion jig and procedure. D.Castillo J. Loterte C. Villanueva A. Arañes D. Castillo C. Villanueva A. Arañes D.	02/25/23	5					M. Ariola J. Loterte		rañes	1/4:4	ALEX		
	09/30/22	4		·		•	D.Castillo J. Loterte		rañes D. Castillo	C. Villanueva	A. Aranes	n/a	
									3				



			WORK INS	STRUCTION		Effectivity Date:		September 12, 20	024
		Process Name/Title:	TAPIN	CESS	Validity Date:		n/a		
		Model code/Part number:	300D / 75Q697-0351	Customer: TRJ	Car Model: TOYOTA-CROWN	Document No.:		WI-ENG-PDE-3	49
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	6	Page No.:	2 of 18
PARTS:	1. Connector PBVP-10V-S (W) [2pcs] PROCESS NAME 6 WORK PROCEDURE/ ILLUSTRATION					JIG:	1. Insertion	jig	
NO.	F	PROCESS NAME	6 WORK	PROCEDURE/ ILLUSTI	RATION	TOOLS/PPE		QUALITY POIN	TERS
2	P1	Connector setting to insertion jig PBVP-10V-S (W)	Insertion Jig Upper guide 1 2	Visual reference 1. Get the 2 pcs of PBVF transfer the 1 connector Note: Follow the connector Note: Follow the connector Note: Pollow the connector Note: P	Connector orientation R L P-10V-S connector using right hand to left hand then insert to insertion jig. ctor orientation. Press er guide using left hand in same	n/a	1. Use the 2. No wror 3. No wror	provided jig per m ng usage of parts ng orientation of co naged connector	odel



		WORK INSTRUCTION Process Name/Title: TAPING ASSEMBLY PROCESS								Effectivity Date:		September 12, 2	2024
		Process Name/Title:		TAPING ASS	EMBL'	Y PROCE	ESS			Validity Date:		n/a	
		Model code/Part number:	300D / 75Q697-03	551 Cus	omer:	TRJ	Car Model:	TOYOTA-0	CROWN	Document No.:		WI-ENG-PDE-3	349
		Purpose:	PROTOTYPE	☐ PRE-	AUNCH		MASSPR	२०		Revision No.:	6	Page No.:	3 of 18
PARTS:	OR L=3	21±2mm; B/W L=321±2mm;	176±2mm; R/L L=321±2mm; BR L=	·				±2mm; GR L=1	76±2mm;	JIG:	Insertion Steering	Navigation	7500
NO.	ŀ	PROCESS NAME	<u> </u>	ORK PROCE	URE/ I	LLUSTRA	TION			TOOLS/PPE		QUALITY POIN	TERS
			1 2 3 4 5 6 W/G G R/L BR R/W P	7890		WIRE IN		WIRE FACING		STEERING NAVIGATION (2 layer)	2. No wron 3. One by 4. No wron 5. No defo 6. No stuck	vided jig per mode ng usage of parts one insertion ng insertion rmed terminal k of terminal tip	
	1 2 3 4 5 6 7 8 9						10		_				
3	P1	Wire insertion to Connector PBVP-10V-S (W)	W/G G R/L 176 176 321 1. Get the W/G wire using left process for G-R/L-BR-R/W-P-Note: Follow the insertion sequence of the s	BR R/W 176 321 R R hand and transfe LG-GR-OR-B/W	to right vires. Ch	LG 76 321	GR 176	OR 321 Ø8	B/W 321	CONTROLLER	inserted Push aft Do not e 2. Pleas during ir 3. Insert to right. Import 1. Refer Steering procedur 2. Refer and Strip	ant reminders/No to WI-ENG-PDE-C Navigation Contro re. to WI-PRO-CNC-C D Length Tolerance to GL-PRO-ASY fo	ar terminal e from left ote/s: 044 for coller 017 for Wire



	WORK INSTRUCTION Effectivity Process Name/Title: TAPING ASSEMBLY PROCESS Validity D							September 12, 20	024
								n/a	
		Model code/Part number:	300D / 75Q697-0351	Customer: TRJ	Car Model: TOYOTA-CROWN	Document No.:		WI-ENG-PDE-3	49
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	6	Page No.:	4 of 18
PARTS:		6 0.3 W/G L=176±2mm; G L= 21±2mm; B/W L=321±2mm;	176±2mm; R/L L=321±2mm; BR L=176±2n	nm; R/W L=321±2m; P L=176±	-2mm; LG L=321±2mm; GR L=176±2mm;	JIG:	Insertion Steering		
NO.	F	ROCESS NAME	<u> </u>	PROCEDURE/ ILLUST	RATION	TOOLS/PPE	(QUALITY POIN	TERS
3	P1	Wire insertion to Connector PBVP-10V-S (W) (Continuation)	GOOD Terminal condition Note: *Make sure the terminal was *Avoid hitting the terminal in	FRONT OF TERMINAL GOOD Terminal condition in proper alignment be to the connector during	Damaged terminal NO GOOD Terminal condition	NO GOOD Terminal codition	2. No wror 3. One by 4. No wror 5. No defo 6. No stuce Importa 1. Make inserted Push aft Do not e 2. Pleass terminal 3. Auton replace encount difficulty locked of 4. Insert left to rig Docume 1. Refer Wire and 2. Refer Steering procedu 3. Refer Pull-Pus 4. Refer Inspection	ent reference/s: to WI-PRO-CNC-0 I Strip Length Tole to WI-ENG-PDE-0 Navigation Contr	e/s: roperly rsh-Pull- ear and al, half- be from 17 for erance. 44 for oller

	WORK INSTRUCTION Effectivity Date: September 12, 2024 Process Name/Title: TAPING ASSEMBLY PROCESS Validity Date: n/a										
		Process Name/Title:				Validity Date:		n/a			
		Model code/Part number:	300D / 75Q697-0351	Customer: TR	J Car Model: TOYOTA-CROWN	Document No.:		WI-ENG-PDE-3	49		
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	6	Page No.:	5 of 18		
	1. Assy										
PARTS:		Brown VM tube (Sunprene) &	08 L=134±2mm			JIG:	1. Insertion	jig			
NO.	1	PROCESS NAME	WORK F	PROCEDURE/ ILLU	ISTRATION	TOOLS/PPE	(QUALITY POIN	TERS		
4	P1	Wire insertion to Dark Brown VM tube (Sunprene) Ø8 L=134±2mm		(Sur	Get the Dark Brown VM tube nprene) Ø8 L=134±2mm using right d. Hold the wires using left hand and art the wires using right hand.	n/a	1. No wron 2. No defo 3. No tang	ig usage of parts rmed terminal led wires			



	WORK INSTRUCTION Process Name/Title: TAPING ASSEMBLY PROCESS							Effectivity Date:		September 12, 2	024
		Process Name/Title:	TAPIN		Validity Date:		n/a				
		Model code/Part number:	300D / 75Q697-0351	Customer:		_	TOYOTA-CROWN	Document No.:		WI-ENG-PDE-3	49
		Purpose:	PROTOTYPE	PRE-LAUNCH	ı	MASSP	'RO	Revision No.:	6	Page No.:	6 of 18
PARTS:	1. AVS	S 0.3 B L=170±2mm; V L=	170±2mm; GR/B L=170±2mm; Y L=170)±2mm; R L=170±	-2mm			JIG:	Insertion Steering		
NO.	F	PROCESS NAME	<u>∕</u> 6\ WORK	PROCEDURE/	LLUSTF	RATION		TOOLS/PPE		QUALITY POIN	TERS
5	P1	Wire insertion to Connector PBVP-10V-S (W)	INSERTION SEQUENCE FROM 1 2 3 4 X B V X ST/B Y X	5 R X X 3 GR/B	WI 4 Y 170	TIRE INSERTION 5 R 170		STEERING NAVIGATION(2 layer) CONTROLLER	1. Use pro 2. No wror 3. One by 4. No wror 5. No defo 6. No stuc Impo 1. Mainser Push Do n 2. Platerm 3. Insert to the proce 1. Resistee. proce 2. Resident to the proce 3. Resident to the proce 3. Resident to the proce	ovided jig per mode ng usage of parts one insertion one insertion or med terminal k of terminal tip or tant reminders/leake sure wires are ted. Conduct Pullar after insertion. To exert extra force ease hold the wire inial during insertion of wire musto right. Selfer to WI-ENG-PE ring Navigation Coedure. Selfer to WI-PRO-CN and Strip Length Telefer to GL-PRO-ASP ush-Push proceed.	properly Push-Pull- e. near n. et be from S: DE-044 for introller UC-017 for Tolerance SY-029 for



			Effectivity Date:		September 12, 20	024			
	Process Name/Title: TAPING ASSEMBLY PROCESS Validity Date:							n/a	
		Model code/Part number:	300D / 75Q697-0351	Customer: TRJ		Document No.:		WI-ENG-PDE-3	49
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	6	Page No.:	7 of 18
PARTS:	1. AVS	S 0.3 B L=170±2mm; V L=	70±2mm; GR/B L=170±2mm; Y L=17	0±2mm; R L=170±2mm		JIG:	Insertion Steering		
NO.	F	ROCESS NAME	√6\ WORK	PROCEDURE/ ILLUST	RATION	TOOLS/PPE	(QUALITY POIN	ΓERS
5	P1	Wire insertion to Connector PBVP-10V-S (W) (Continuation)		FRONT OF TERMINAL GOOD Terminal condition in proper alignment be not the connector during	Damaged terminal NO GOOD Terminal condition	NO GOOD Terminal codition	2. No wror 3. One by 4. No wror 5. No defo 6. No studing 1. Make inserted Push aft Do not e 2. Please terminal 3. Auton replace encount difficulty locked of 4. Insert left to rig Docume 1. Refer in Steering procedur 3. Refer in Steering procedur 4. Refer in Steering procedur 4. Refer in Steering procedur 5. Refer in Steering procedur 6. Refer in Steering procedur 6. Refer in Steering procedur 7. Refer in Steering procedur 8. Refer in Steering procedur 9. Refer in Steering procedur	nt reference/s: to WI-PRO-CNC-0 I Strip Length Tole to WI-ENG-PDE-0 Navigation Contr	e/s: roperly ush-Pull- near and al, half- be from 117 for terance. 44 for roller

			WORK I		Effectivity Date:		September 12, 20	124	
	Process Name/Title: TAPING ASSEMBLY PROCESS Model code/Part number: 300D / 75Q697-0351 Customer: TRJ Car Model: TOYOTA-					Validity Date:		n/a	
		Model code/Part number:	300D / 75Q697-0351	Customer: TRJ	Car Model: TOYOTA-CROWN	Document No.:		WI-ENG-PDE-34	19
	Purpose: PROTOTYPE PRE-LAUNCH MASSPRO 1. Assy parts 2. Black VM tube (Sunprene) Ø8 L=128±2mm						6	Page No.:	8 of 18
PARTS:			\wedge			JIG:	1. Insertion	jig	
NO.	F	PROCESS NAME	∠6 WOR	K PROCEDURE/ ILLUSTF	RATION	TOOLS/PPE	(QUALITY POINT	TERS
6	P1	Wire insertion to Black VM tube (Sunprene) Ø8 L=128±2mm	using left hand. Remove the 1st connector with inserted wires and Dark Brown VM tube	L=128±2mm using hand then insert the	eft hand and press the lower button to be inserted are only open.	N/A	1. Refer Inspection Insertion 1. No wron 2. No defo 3. No tang	ng usage of parts rmed terminal	25 for upler
7		Wire insertion to assy parts		R	1. Hold the Black VM tube (Sunprene) using left hand and insert the wires from Dark Brown VM tube (Sunpene) using right hand.	N/A		ng use of parts rmed terminal led wires	



			WORK II		Effectivity Date:		September 12, 2	024			
		Process Name/Title:	TAP		Validity Date:		n/a				
		Model code/Part number:	300D / 75Q697-0351	Customer:	TRJ	Car Model:	OYOTA-CROWN	Document No.:		WI-ENG-PDE-3	49
		Purpose:	PROTOTYPE	PRE-LAUNCH		MASSPR	0	Revision No.:	6	Page No.:	9 of 18
PARTS:	1. Assy	parts						JIG:	Insertion Steering	jig Navigation	
NO.	F	ROCESS NAME	<u>∕6</u> \ WOR	K PROCEDURE/ I	ILLUSTRA	TION		TOOLS/PPE		QUALITY POIN	TERS
			INSERTION SEQUENCE FROM 1 2 B/W B V LG 58/8 Y R/	3 4 5	WIDI	WIRE F		STEERING NAVIGATION(2 layer)	2. No wron 3. One by 4. No wron 5. No defo 6. No stuc	ovided jig per mode ng usage of parts one insertion ng insertion irmed terminal k of terminal tip	
8	P1	Wire insertion to Connector PBVP-10V-S (W)	B/W B V LO 321 170 170 32 L R 2. Hold the B/W wire using right hand connector slot 1 using right hand. R after insertion Note: Follow the insertion sequence.	G GR/B 1 170 17	R/L R/L R R R R R R R R R R R R R	L R 1 170 L dex finger the R-R/W wires.	OR R/W 321 321 Ren insert to Check the wire	CONTROLLER	1. Make inserted after ins Do not & 2. Pleas during in 3. Insertight. Doct 1. Refe Inspect Insertic 2. Refe Steerin proced 3. Refe	exert extra force. se hold the wire nearsertion. tion of wire must be ument reference/s r to GL-PRO-ASY- ion Standard for Coin. r to WI-ENG-PDE- g Navigation Contr	operly sh-Pull-Push ar terminal e from left to :: :: :: :: :: :: :: :: :: :: :: :: :



	WORK INSTRUCTION Effectivity Date: September 12, 2024 Process Name/Title: TAPING ASSEMBLY PROCESS Validity Date: n/a										
		Process Name/Title:	Validity Date:		n/a						
		Model code/Part number:	300D / 75Q697-0351	Customer: TRJ	Car Model: TOYOTA-CROWN	Document No.:		WI-ENG-PDE-3	49		
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	6	Page No.:	10 of 18		
PARTS:	1. Assy	parts	^			JIG:	Insertion Steering				
NO.	F	PROCESS NAME	6 WORK	(PROCEDURE/ ILLUSTI	RATION	TOOLS/PPE	(QUALITY POIN	TERS		
NO. 8	P1	Wire insertion to Connector PBVP-10V-S (W) (Continuation)	Proper alignment of term BACK VIEW OF TERMINAL GOOD Terminal condition Note: *Make sure the terminal was *Avoid hitting the terminal in	FRONT OF TERMINAL GOOD Terminal condition in proper alignment befato the connector during	BACK VIEW OF TERMINAL Damaged terminal NO GOOD Terminal condition No Good Terminal condition Terminal condition 3. Press the Upper button using left hand then remove the assy part using right hand. Check	Inal to connector ONT VIEW OF TERMINAL NO GOOD Terminal codition	1. Use pro 2. No wror 3. One by 4. No wror 5. No defo 6. No stuc Importa 1. Make inserted Push af Do not & 2. Pleas termina 3. Autor replace encoundifficult locked & 4. Insert left to ri Docume 1. Refer Wire and 2. Refer Steering procedu 3. Refer Pull-Pus 4. Refer Inspecti	vided jig per mode ig usage of parts one insertion ag insertion ing insertion ing insertion in the same wire are part of the wires are part of the wires in during insertion insertion in the unit if once the during insertion and connector. If the wires mustically dispose the unit if once the unit if once it is of insertion and connector. If the wires mustically dispose the unit if once it is of the wires mustically dispose the unit if once it is of wires mustically dispose the unit if once it is of wires mustically dispose the unit if once it is of wires mustically dispose the unit if once it is of wires mustically dispose the wires mustically dispose the wires mustically dispose the wires must be wires.	te/s: roperly ush-Pull- near and nal, I half- t be from 017 for lerance. 144 for roller		
				R	the wire insertion condition.	ninal tip must be visible					

				STRUCTION		Effectivity Date:		September 12, 2	024
		Process Name/Title:		IG ASSEMBLY PRO		Validity Date:		n/a	
	57	Model code/Part number:	300D / 75Q697-0351	Customer: TRJ	Car Model: TOYOTA-CROWN	Document No.:		WI-ENG-PDE-3	49
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	6	Page No.:	11 of 18
PARTS:	1. Assy	parts				JIG:	n/a		
NO.	F	PROCESS NAME	WORK	PROCEDURE/ ILLUSTI	RATION	TOOLS/PPE	(QUALITY POIN	TERS
9	P1	Wire folding	AFTER FOLDING L	1. Hold the ass then conduct w	by parts using both hands rire arrangement.	N/A	1. No defo 2. No tang 3. No wror	rmed terminals led wires g facing	



				INSTRUCTION		Effectivity Date:		September 12, 20	124
		Process Name/Title:		APING ASSEMBLY PROC		Validity Date:		n/a	
		Model code/Part number:	300D / 75Q697-035	1 Customer: TRJ	Car Model: TOYOTA-CROWN	Document No.:		WI-ENG-PDE-34	19
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	6	Page No.:	12 of 18
PARTS:	1. Con	nector 1746872-1 (B)				JIG:	1. Insertior	ı jig	
NO.	F	ROCESS NAME	WO	RK PROCEDURE/ ILLUSTR	ATION	TOOLS/PPE	(QUALITY POINT	ERS
10	P1	Connector setting to insertion jig 1746872-1 (B)	INSERTION JIG	Upper guide Upper button CONNECTOR ORIEN	B) and insert to insertion jig uisng right		2. No wron 3. No wron 4. No dam: CG API UNL Importa 1. Auto the unit termina half-loc	ant reminders/Not matically dispose a t if once encounter al, difficulty of inser ked connector. ck the connector be	NG F-LOCKED e/s: and replace ed bend tion and



			WORK INSTRUCTION					Effectivity Date:	September 12, 2024		
		Process Name/Title:	TAPING ASSEMBLY PROCESS					Validity Date: n/a			
		Model code/Part number:	300D / 75Q697-0351	Customer:	TRJ	Car Model:	TOYOTA-CROWN	Document No.:		WI-ENG-PDE-3	149
		Purpose:	PROTOTYPE	PRE-LAUNCH	l	MASSP	PRO	Revision No.:	6	Page No.:	13 of 18
PARTS:	1. Assy							JIG:	1. Insertion		
NO.	F	PROCESS NAME WORK PROCEDURE/ ILLUSTRATION					TOOLS/PPE	(QUALITY POIN	TERS	
11	P1	Wire insertion to Connector 1746872-1 (B)	INSERTION SEQUENCE FRORIGHT 3 9 5 2ND ROW 1ST ROW 1 6 7 2 1. Insert first the wires from Black V Hold the R wire and insert to termin hand. Repeat the process for Y-V-B Note: Follow the insertion sequence stated above.	M tube (Sunpreral slot 1 using righwires.	I R 170 BLACE R ne).	8 9 G GR 176 176 6 7 W/G BR 176 176 K VM TUBE 2 3 6 SECOND R 2. Hold the to terminal s Note: Follow	w the insertion pased on the illustration		2. No wron 3. One by 4. No wron 5. No defo 6. No studi Impo 1. Auto the unitermini half-loo 2. Make inserte Push a Do not 3. Plea during Do 1. Refe Inspect Insertic 2. Refe Steerin proced 3. Refe Steerin	er to WI-ENG-PDE ng Navigation Cont	and replace red bend rtion and replace red bend rtion and roperly ush-Pull-ear terminal



	_		WORK	INSTRUCTION		Effectivity Date:		September 12, 2	024	
		Process Name/Title:		Validity Date:	n/a					
		Model code/Part number:						WI-ENG-PDE-3	ENG-PDE-349	
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	6	Page No.:	14 of 18	
PARTS:	1. Assy	parts				JIG:	1. Insertior	n jig		
NO.	PROCESS NAME		WOR	K PROCEDURE/ ILL	LUSTRATION	TOOLS/PPE	(QUALITY POIN	TERS	
11	P1	Wire insertion to Connector 1746872-1 (B) (Continuation)	DARK BROWN VM TUBE 3. Hold the W/G wire using right I terminal slot 2 using right hand. R Note: Follow the insertion sequents. R	R R A si pi	e by left index finger then insert to R wire. Illustration. Hold the G wire and insert to terminal lot 8 using right hand. Repeat the rocess for GR-P wires. Note: Follow the insertion sequence based on the illustration.		2. No wron 3. One by 6 4. No wron 5. No defoi 6. No stuck Importa 1. Autor the unit terminal locked c 2. Make inserted after ins Do not e 3. Pleas during ir Docui 1. Refer Inspecti Insertiol 2. Refer Steering procedu 3. Refer	ant reminal tip ant reminders/No matically dispose a if once encountered, difficulty of insert connector. In a conduct Pull-Pust ertion. In a conduct Pull	ante/s: and replace ed bend tion and half- operly sh-Pull-Push ear terminal : -025 for oupler -044 for roller	

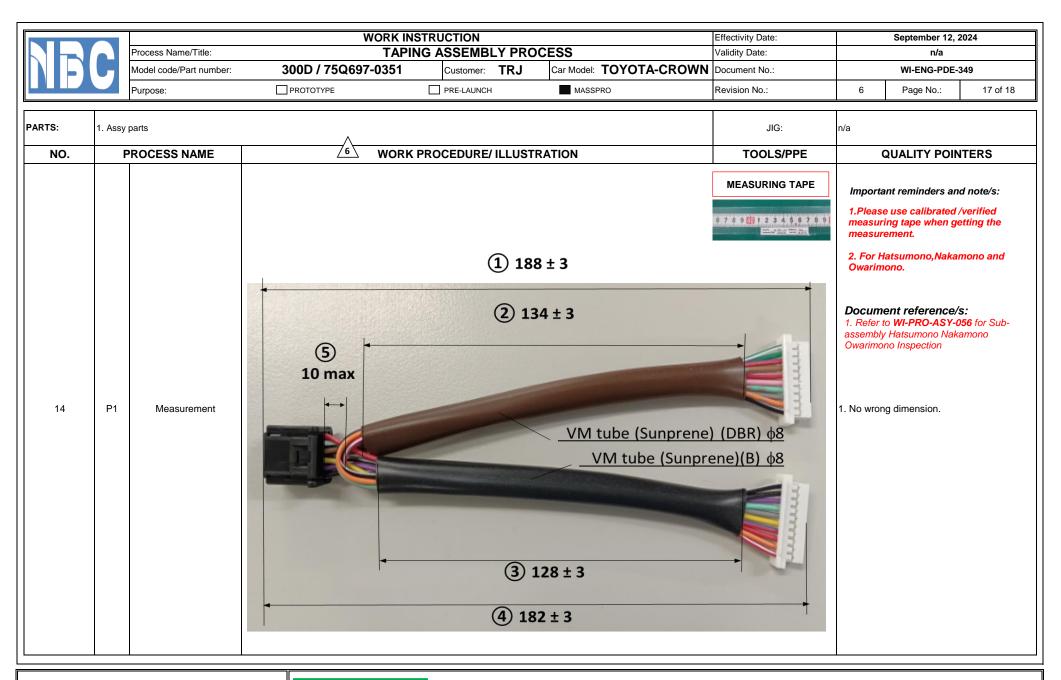


			WORK IN	STRUCTION		Effectivity Date:		September 12, 2	024
		Process Name/Title:		NG ASSEMBLY PRO	CESS	Validity Date:		n/a	
		Model code/Part number:			Document No.:		WI-ENG-PDE-349		
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	6	Page No.:	15 of 18
PARTS:	1. Assy	parts	^			JIG:	1. Insertion	n jig	
NO.	P	ROCESS NAME	<u>∕</u> 6\ WORK	TOOLS/PPE	(QUALITY POINTERS			
12	P1	Wire Arrangement	GOOD FACING NG FACING 1. Hold the harness using both hands. Arrange the wire properly to avoid tangled wires. Folding	GOOD FACING	NG FACING Pouble lock Folding	N/A	2. No tang	ng orientation of co led wires ng facing of wire fol	



Process Name/Title: TAPING ASSEMBLY PROCESS Validity Date: n/a Model code/Part number: 300D / 75Q697-0351 Customer: TRJ Car Model: TOYOTA-CROWN Document No.: WI-ENG-PDE-349		WORK INSTRUCTION							Effectivity Date: September 12, 2024					
PARTS: 1. Assembled parts 2. Master sample NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS 1. Check the connector lock. Locking of connector is included to Steering electrical test. Silack VM tube (Sunprene) 1. Rofer in W-QAD-QAC-252 Steering Electrical Test MASTER SAMPLE 1. Visual/By Two's Inspection Visual/By Two's Inspection Visual/By Two's Inspection MEASURING TAPE PROTOTYPE PROTOTYPE PROTOTYPE Master sample More parts Master sample Master sam			Process Name/Title:		-									
PARTS: 1. Assembled parts 2. Master sample NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS 1. Check the connector lock, Locking of connector is included to Steering electrical test. 2. Check the wire alignment. Make sure no alignment. Make sure no deformed terminal. Document reference/s: 1. Refer to Wi-QAD-QAC-252 Steering Electrical Test MASTER SAMPLE Visual/By Two's Inspection Visual/By Two's Inspection Visual/By Two's Inspection MASTER SAMPLE 5. Compare to Master sample by tapping							Document No.:		WI-ENG-PDE-349					
NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS 1. Check the connector lock, Locking of connector is included to Steering electrical test. Slack VM tube (Sunprene) ACTUAL PRODUCT Dark Brown VM tube (Sunprene) Visual/By Two's Inspection Visual/By Two's Inspection 4. Check the orientation of harness. 5. Compare to Master sample by tapping MEASURING TAPE			Purpose:	PROTOTYPE	☐ PRE-LA	UNCH	MASSPRO	Revision No.:	6	Page No.:	16 of 18			
1. Check the connector lock. Locking of connector is included to Steering electrical test. 1. Check the wire alignment. Make sure no tangled wires	PARTS:	1. Asse 2. Mas	embled parts er sample					JIG:	n/a					
Locking of connector is included to Steering electrical test. ACTUAL PRODUCT Dark Brown VM tube (Sunprene)	NO.	F	PROCESS NAME WORK PROCEDURE/ ILLUSTRATION					TOOLS/PPE	(QUALITY POINTERS				
Assembly product 4 5 6 7 8 9 20 1 3			Visual/By Two's	1. Check the connector lock. Locking of connector is included to Steering electrical test. Black VM tube (Sunprene) ACTUAL PRODUCT	2. Check the walignment. Mak tangled wires Dark E	Brown VM tube Sunprene) 5. Compare t tapping Master Sa	3. Check the terminal if with backing out (not fully inserted) or no deformed terminal. to Master sample by Assembly	MEASURING TAPE	Docu 1. Refu Steerii	ument reference er to WI-QAD-QAC ng Electrical Test MASTER SAMF	9/s: 252			





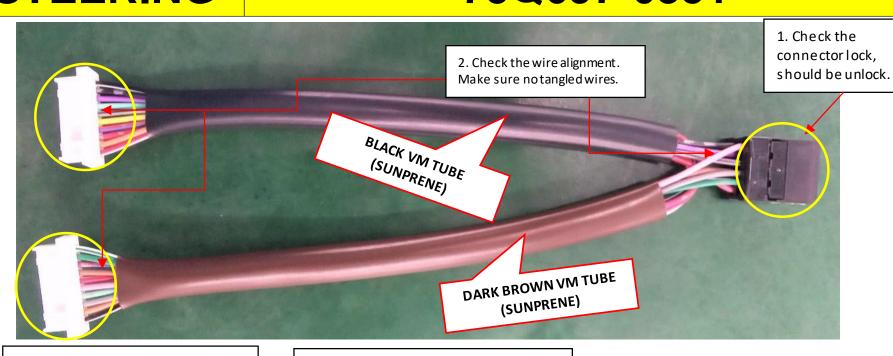


			Effectivity Date:	September 12, 2024					
		Process Name/Title:	TAPI	NG ASSEMBLY PROC	Validity Date:	n/a			
		Model code/Part number:	300D / 75Q697-0351	Customer: TRJ	Car Model: TOYOTA-CROWN	Document No.:		WI-ENG-PDE-3	49
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	6	Page No.:	18 of 18
PARTS:	1. Assy	parts				JIG:	n/a		

VISUAL INSPECTION/ QUALITY CHECKPOINTS

STEERING

75Q697-0351



3. Check the orientation of harness.

4. Check if no missing parts.

- ness. 5. Check the terminal if with backing out (no fully inserted) or deformed terminal
- 6. Compare to master sample.

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