

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 21, 2023

Model code/Part number:

930B / 75S136-0020Customer: **TRJ**Car Model: **TOYOTA 4RUNNER**

Document No.:

WI-ENG-PD-719

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1. Connector PBVP-10V-S (W) [2pcs.]; Connector 1746872-1 (B); AVSS 0.3 R L=154±2mm; V L=154±2mm; Y L=154±2mm; B L=154±2mm; GR/B L=154±2mm; LG L=285±2mm; R/W L=285±2mm; B/W L=285±2mm; OR L=285±2mm; R/L L=285±2mm; AVSS 0.3 P L=156±2mm; W/G L=156±2mm; G L=156±2mm; BR L=156±2mm; GR L=156±2mm; Black VM tube(sunprene) ø8 L=112±3mm; Green VM tube (sunprene) ø8 L=114±3mm

JIG:

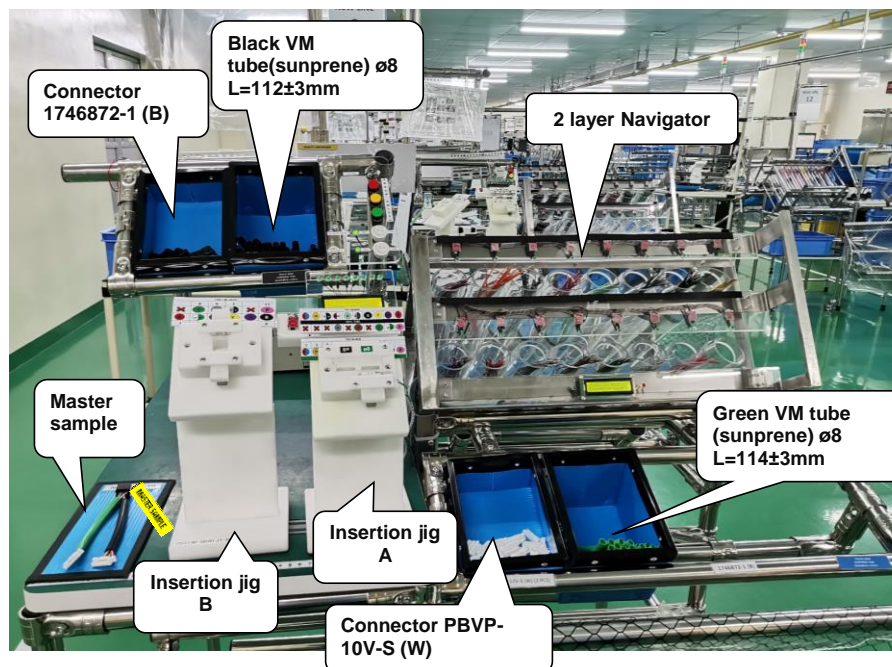
1. Insertion jig

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
10/21/2023	1	Change pre launch to mass pro and inclusion of table lay-out.	A.Hernandez	J.Loterte	C. Villanueva	A. Arañes	A.Hernandez	J.Loterte	C. Villanueva	A. Arañes
09/02/2023	0	Initial issue	A.Hernandez	J.Loterte	C. Villanueva	A. Arañes	A.Hernandez	J.Loterte	C. Villanueva	A. Arañes

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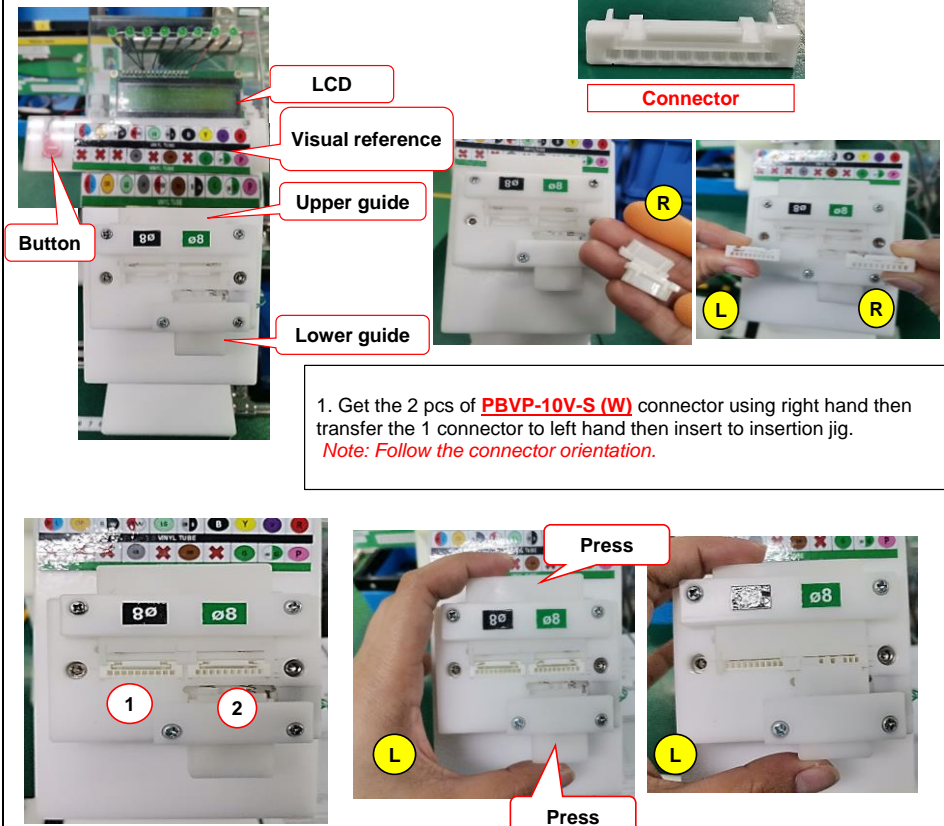
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PARTS:		1. Connector PBVP-10V-S (W) [2pcs.]		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<div><p>1. Get the 2 pcs of PBVP-10V-S (W) connector using right hand then transfer the 1 connector to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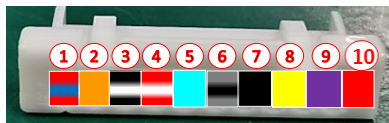






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PARTS:		1. AVSS 0.3 R L=154±2mm; V L=154±2mm; Y L=154±2mm; B L=154±2mm; GR/B L=154±2mm; LG L=285±2mm; R/W L=285±2mm; B/W L=285±2mm; OR L=285±2mm; R/L L=285±2mm; 2. Black VM tube(sunprene) ø8 L=112±3mm		JIG:	1. Insertion jig																														
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS																														
3	P1	<div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div> <div>Wire facing</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>R/L</td><td>OR</td><td>B/W</td><td>R/W</td><td>LG</td><td>GR/B</td><td>B</td><td>Y</td><td>V</td><td>R</td></tr><tr><td>285</td><td>285</td><td>285</td><td>285</td><td>285</td><td>154</td><td>154</td><td>154</td><td>154</td><td>154</td></tr></table> <div></div> <div>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.</div>		1	2	3	4	5	6	7	8	9	10	R/L	OR	B/W	R/W	LG	GR/B	B	Y	V	R	285	285	285	285	285	154	154	154	154	154	<div>STEERING NAVIGATION(2 layer)</div> <div></div> <div>CONTROLLER</div> <div></div>	<div>Important reminders/Note/s:</div> <div>1. Please hold the wire near terminal during insertion.</div> <div>2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion.</div> <div>Do not exert extra force.</div> <div>Document References:</div> <div>1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.</div> <div>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div> <div>3. Refer to GL-PRO-ASY-028 for Pull-Push procedure.</div>
		1	2	3	4	5	6	7	8	9	10																								
R/L	OR	B/W	R/W	LG	GR/B	B	Y	V	R																										
285	285	285	285	285	154	154	154	154	154																										
4	Wire insertion to Black VM tube (sunprene) ø8 L=112±3mm	<div></div> <div>1. Get the Black VM tube (Sunprene) ø8 L=112±3mm using left hand and transfer to 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</div> <div>2. No deformed terminal</div> <div>3. No tangled wires</div>																														

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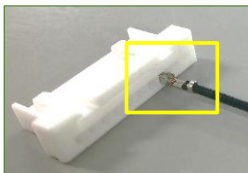

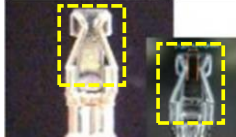

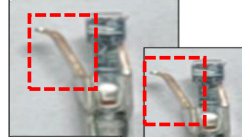

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PARTS:	1. AVSS 0.3 R L=154±2mm; V L=154±2mm; Y L=154±2mm; B L=154±2mm; GR/B L=154±2mm; LG L=285±2mm; R/W L=285±2mm; B/W L=285±2mm; OR L=285±2mm; R/L L=285±2mm;			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY 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>1. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force. 2. Please hold the wires near terminal during insertion. 3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector. 4. Insertion of wires must be from left to right.</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance. 2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.. 3. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</div>

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PARTS:	1. AVSS 0.3 P L=156±2mm; W/G L=156±2mm; G L=156±2mm; BR L=156±2mm; GR L=156±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)	<div><div>INSERTION SEQUENCE FROM LEFT TO</div><div></div></div> <div><div>Wire facing</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>X</td><td>X</td><td>X</td><td>GR</td><td>X</td><td>BR</td><td>X</td><td>G</td><td>W/G</td><td>P</td></tr><tr><td>156</td><td>156</td><td>156</td><td>156</td><td>156</td><td>156</td><td>156</td><td>156</td><td>156</td><td>156</td></tr></table></div> <div><div>Note: Holes that need to be insert are only open.</div></div> <div><div>Lower guide</div><div></div><div></div></div> <div><div>1. Get the GR wire using right hand and insert to connector. Repeat the process for BR-G-W/G-P wires.</div><div>Note: Follow the insertion sequence based on the illustration.</div></div>	1	2	3	4	5	6	7	8	9	10	X	X	X	GR	X	BR	X	G	W/G	P	156	156	156	156	156	156	156	156	156	156	<div><div>STEERING NAVIGATION(2 layer)</div><div></div></div> <div><div>CONTROLLER</div><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																									
X	X	X	GR	X	BR	X	G	W/G	P																									
156	156	156	156	156	156	156	156	156	156																									

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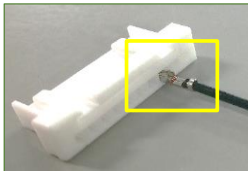

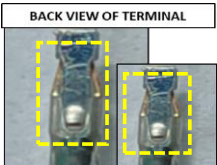
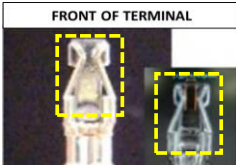
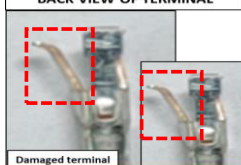

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PARTS:	1. AVSS 0.3 P L=156±2mm; W/G L=156±2mm; G L=156±2mm; BR L=156±2mm; GR L=156±2mm			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1 Wire insertion to connector PBVP-10V-S (W) (Continuation)	<div>Proper alignment of terminal to connector</div>  <div>Improper alignment of terminal to connector</div>  <div>BACK VIEW OF TERMINAL</div>  <div>GOOD Terminal condition</div> <div>FRONT OF TERMINAL</div>  <div>GOOD Terminal condition</div> <div>BACK VIEW OF TERMINAL</div>  <div>Damaged terminal</div> <div>NO GOOD Terminal condition</div> <div>FRONT VIEW OF TERMINAL</div>  <div>NO GOOD Terminal condition</div> <div>Note: *Make sure the terminal was in proper alignment before insert. *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.</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. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force. 2. Please hold the wires near terminal during insertion. 3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector. 4. Insertion of wires must be from left to right.</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance. 2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.. 3. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</div>

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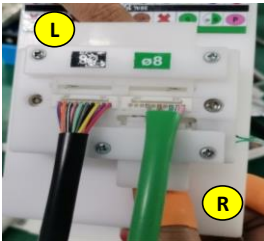

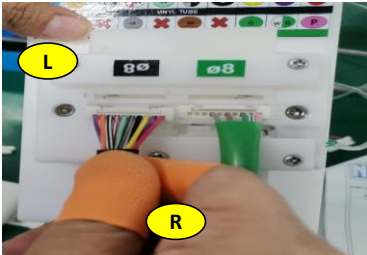
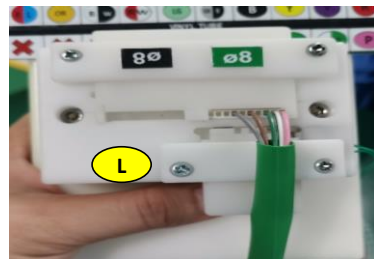


☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Green VM tube (sunprene) ø8 L=114±3mm		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1	<div><div><p>1. Get the Green VM tube (Sunprene) ø8 L=114±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> <div><div></div><p>3. Remove the 1st connector with inserted wires and Black VM tube (Sunprene) using right hand then press the upper guide using left hand. Check the wire insertion condition. Note: Second connector with inserted wire and Black VM tube (Sunprene) will stay in the jig.</p></div> <div><div></div><p>4. Press the lower button using left hand. Holes that need to be inserted are only open.</p></div>		N/A	<div><p>1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires</p><p>Terminal tip must be visible</p><p>Document References: 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></div>
		N/A	<div><p>1. No wrong use of parts 2. No deformed terminal 3. No tangled wires</p></div>		

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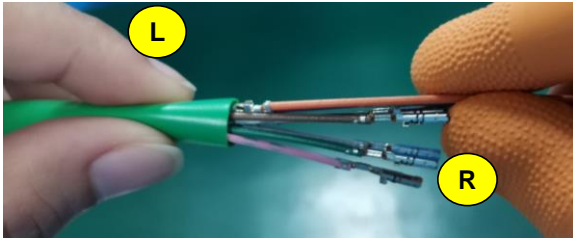


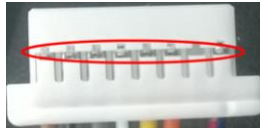
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PARTS:		1. Assy parts 2. Green VM tube (sunprene) ø8 L=114±3mm		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1 Wire insertion to assy parts	<div></div> <div></div> <div></div> <div>1. Hold the Green VM tube (Sunprene) using left hand and insert the wires from Black VM tube (Sunprene) using right hand.</div>		N/A	<div>1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires</div> <div></div> <div>Terminal tip must be visible</div> <div>Document References: 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.</div>

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PARTS: 1. Assy parts

JIG:

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

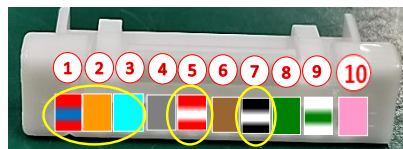
TOOLS/PPE

QUALITY POINTERS

10

P1

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

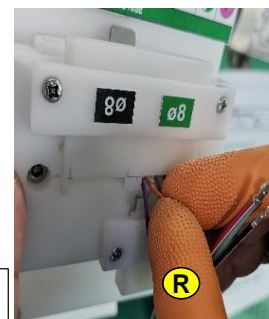


WIRE INSERTION ILLUSTRATION

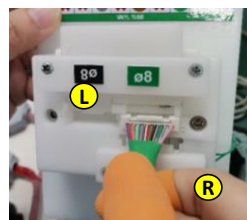
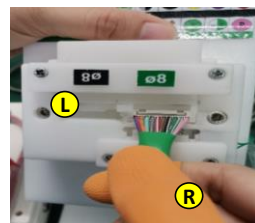
1	2	3	4	5	6	7	8	9	10
R/L	OR	LG	GR	R/W	BR	B/W	G	W/G	P
285	285	285	156	285	156	285	156	156	156



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**

Effectivity Date:

October 21, 2023

Process Name/Title:

Model code/Part number:

930B / 75S136-0020

Customer: TRJ

Car Model: TOYOTA 4RUNNER

Document No.:

WI-ENG-PD-719

Purpose:


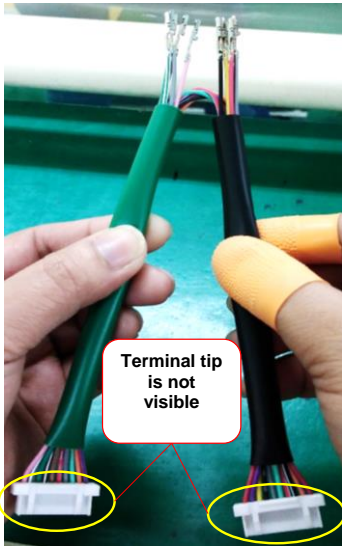
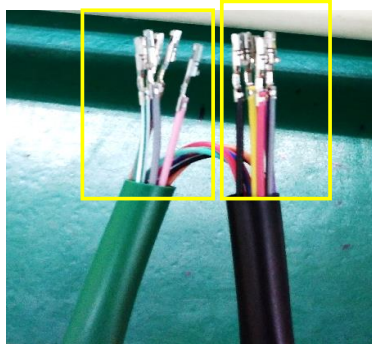

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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
11	P1	<div>Wire arrangement</div> <div><p>BEFORE FOLDING</p><div><p>Terminal tip is not visible</p><p>1. Hold the assy parts using both hands then conduct wire arrangement.</p></div></div>	N/A	<div>1. No deformed terminals</div> <div>2. No tangled wires</div> <div>3. No wrong facing</div>

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☐ PRE-LAUNCH


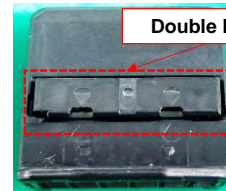
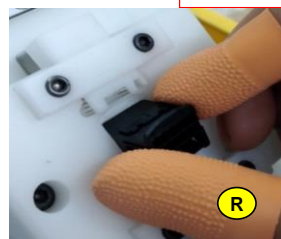
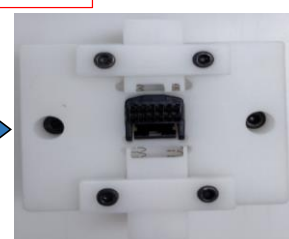
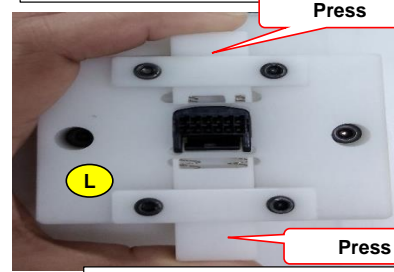
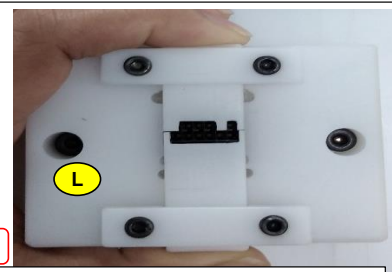
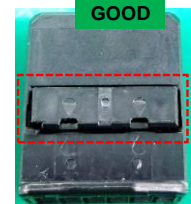

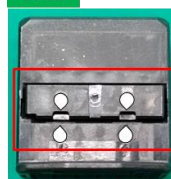

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PARTS:		1. Connector 1746872-1 (B)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
12	P1	<div><div><div>INSERTION JIG</div><div></div></div><div><div>Double lock</div><div></div><div>Note: Check the connector before insertion.</div></div><div><div>CONNECTOR</div><div></div><div></div></div><div><div>1. Get the connector 1746872-1 (B) and insert to insertion jig using right hand. <i>Note: Follow the connector orientation</i></div><div><div><div>Press</div><div></div><div>Press</div><div></div></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><div>CONNECTOR LOCK APPEARANCE CHECK</div><div><div>GOOD</div><div>NG</div><div></div><div></div><div>UNLOCK</div><div>HALF-LOCKED</div></div><div><div>CONNECTOR ILLUSTRATION</div><div><div>GOOD</div><div>NG</div><div></div><div></div><div>1746872-1 (B)</div><div>1376675-1 (B)</div></div><div><div>Important reminders/Note/s:</div><div>1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</div></div></div></div>

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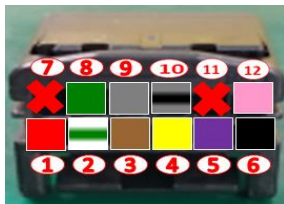

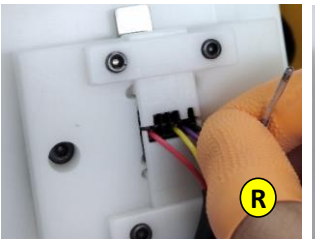
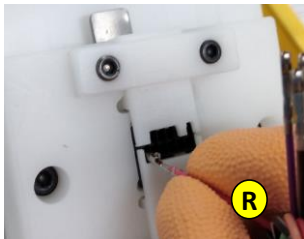
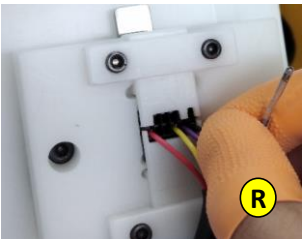
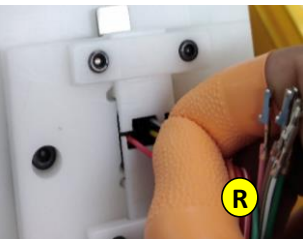
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PARTS:	1. Assy parts		JIG:	Insertion jig																														
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS																														
13	P1 Connector setting to insertion jig 1746872-1 (B)	<div><div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div><div><div>2ND ROW</div><div>1ST ROW</div><div></div></div><div><div>WIRE INSERTION ILLUSTRATION</div><table><tr><td>7</td><td>8</td><td>9</td><td>10</td><td>11</td><td>12</td></tr><tr><td>X</td><td>G</td><td>GR</td><td>GR/B</td><td>X</td><td>P</td></tr><tr><td>1</td><td>2</td><td>3</td><td>4</td><td>5</td><td>6</td></tr><tr><td>R</td><td>W/G</td><td>BR</td><td>Y</td><td>V</td><td>B</td></tr><tr><td>154</td><td>156</td><td>156</td><td>154</td><td>154</td><td>154</td></tr></table></div><div><div>BLACK SUNPRENE TUBE</div><div></div></div><div><div>Wire facing</div><div></div></div><div><div></div><div></div><div></div></div><div><div>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. <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>	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	154	156	156	154	154	154	N/A	<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:</div> <div>1. Please hold the wire near terminal during insertion.</div> <div>2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion.</div> <div>Do not exert extra force.</div> <div>3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</div> <div>Document References:</div> <div>1. Refer to GL-PRO-ASY-028 for Pull-Push procedure.</div>
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																													
154	156	156	154	154	154																													

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930B / 75S136-0020

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Car Model: TOYOTA 4RUNNER

Document No.:

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Purpose:


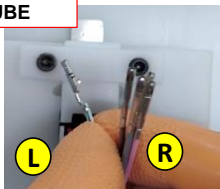
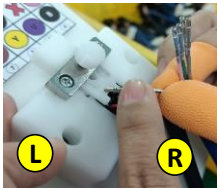
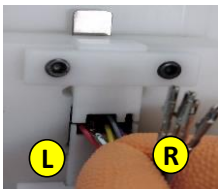
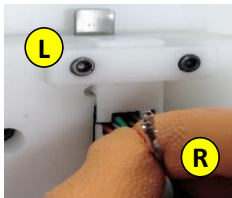
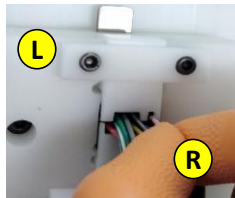
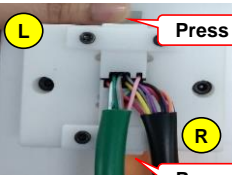
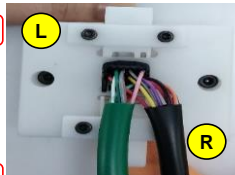

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PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
14	P1 Wire insertion to Connector 1746872-1 (B) (Continuation)	<div><div>GREEN SUNPRENE TUBE</div><div></div><div></div><div></div><div></div><div><p>3. Insert the wires from Green sunprene tube, 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></div><div></div><div></div><div><p>4. Hold the G wire and insert to terminal slot 8 using right hand. Repeat the process for GR-P wire. <i>Note: Follow the insertion sequence based on the illustration.</i></p></div><div></div><div></div><div><p>5. Press the upper and lower lever guide (same timing) using both hands.</p></div><div></div><div><p>6. Remove the assy parts using right hand.</p></div></div> <div>N/A</div> <td><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. Please hold the wire near terminal during insertion. 2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force. 3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</p><p>Document References:</p><p>1. Refer to GL-PRO-ASY-028 for Pull-Push procedure.</p></td>	<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. Please hold the wire near terminal during insertion. 2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force. 3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</p> <p>Document References:</p> <p>1. Refer to GL-PRO-ASY-028 for Pull-Push procedure.</p>	

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930B / 75S136-0020Customer: **TRJ**Car Model: **TOYOTA 4RUNNER**

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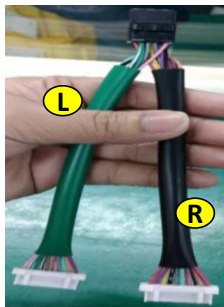

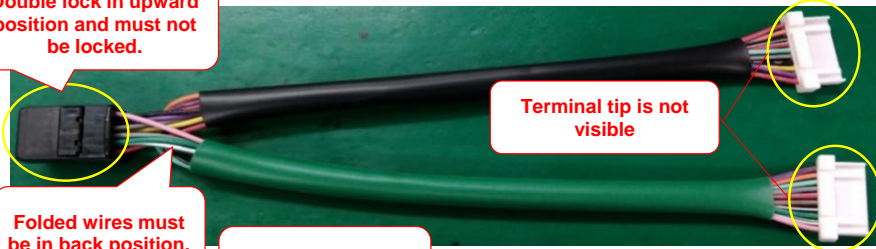
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
15	P1	<div><div>1. Hold the assy parts using both hands then conduct harness facing arrangement.</div></div> <div></div>	n/a	1. No wrong orientation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

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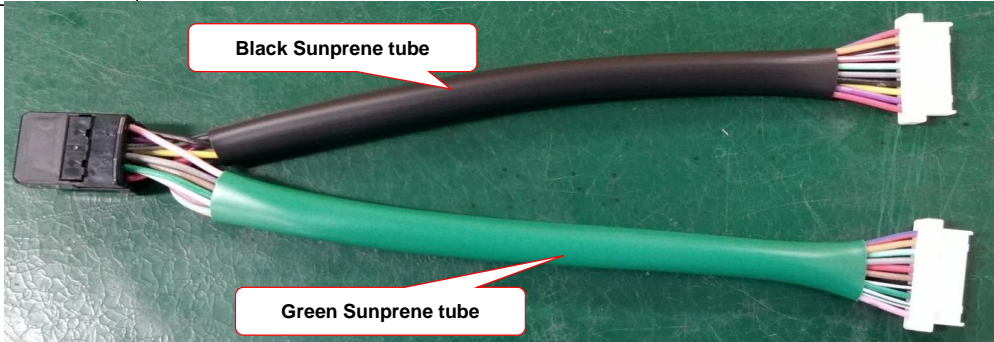


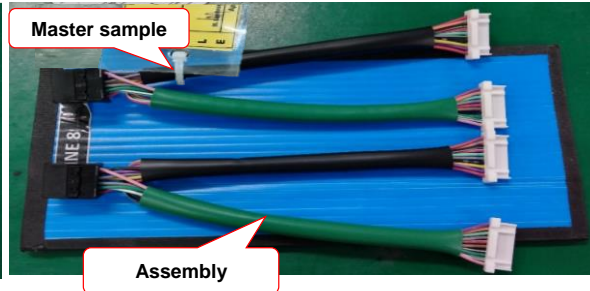
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PARTS:		1. Assy parts 2. Master sample		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
16	P1	Visual/By Two's Inspection	<div>1. Check the connector lock, locking of connector is included in Steering electrical test.</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> <div>5. Compare to Master sample by tapping.</div>		<div>Document References: 1. Refer to WI-ENG-PDE-431 for Steering Electrical Test after assembly.</div> <div><div>MASTER SAMPLE</div></div> <div>1. No wrong facing of harness 2. No Tangled wires 3. No missing parts</div>
			<div></div> <div><div>Master sample</div></div> <div>Assembly</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>			<div>NOTE: FOR HATSUMONO AND OWARIMONO</div> 1. No wrong dimension

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PARTS:

n/a

JIG:

n/a

QUALITY CHECKPOINTS

75S136-0020

1. Check the connector lock.

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

Black Sunprene Tube

Green Sunprene Tube

CORRECT FACING

FOLDED WIRES MUST BE IN BACK POSITION

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.

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