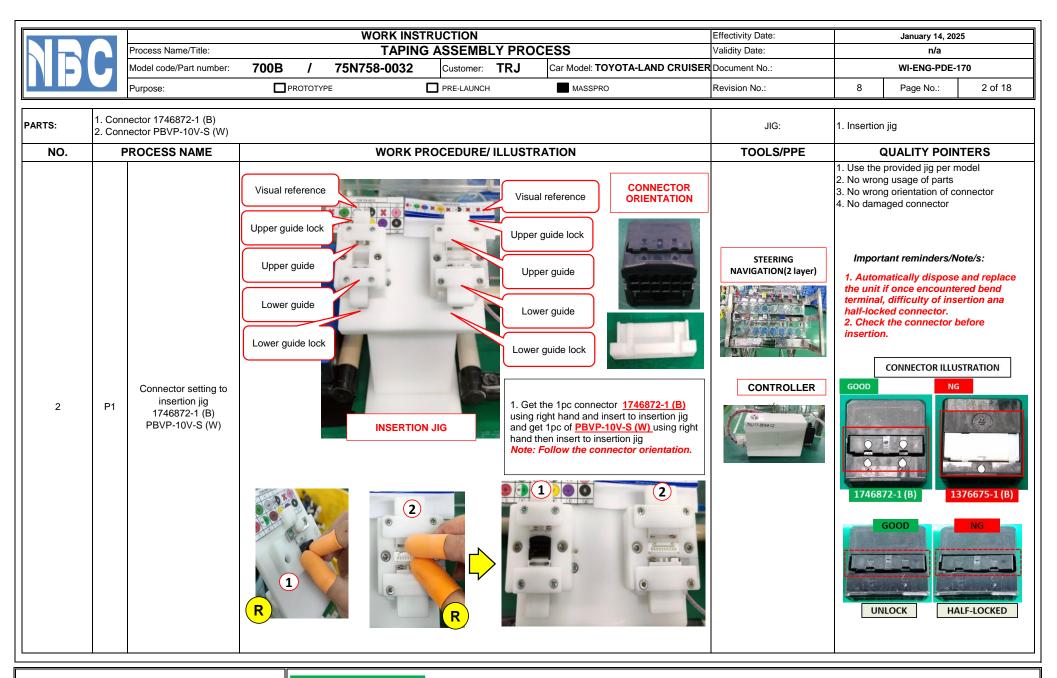
7						WORK INST						Effec	ctivity Date:		January 14, 20	25
			Process Name/Title:			TAPING	<b>ASSEME</b>	<b>3LY PROC</b>	CESS			Valid	lity Date:		n/a	
			Model code/Part number:	700B	/	75N758-0032	Customer:	TRJ	Car Model	:TOYOTA-	LAND CRU	ISER Docu	ument No.:		WI-ENG-PDE-1	70
			Purpose:	☐ PR	ROTOTYP	PE	PRE-LAUNC	:H	MASS	SPRO		Revi	sion No.:	8	Page No.:	1 of 18
		Į	<u>'</u>													
PARTS:		L=124± L=89±3	ector 1746872-1 (B); Coni 1mm; B L=124±2mm; G L mm; AVSS 0.3 B/W L=262 26±3mm; Connector PBVF	=344±2mm; 0 2±2mm; OR l	GR L=3	344±2mm; GR/B L=124 2mm; R/L L=262±2mm	1±2mm; P L=3 n; LG L=262±2	344±2mm; 1. I 2mm; R/W L=	Black VM tu 262±2mm;	be (Sunpre	ne) Ø8		JIG:		g Navigator	
N	Ο.	Р	ROCESS NAME			WORK PI	ROCEDURE	/ ILLUSTR	ATION				TOOLS/PPE		QUALITY POIN	TERS
				PBVP-10	ector OV-S (W	Black VM (Sunpre Ø8 L=89±	I tube	Lay-out			2 Layer Navigation	bi k	Safety Instruction Be sure to wear or escribed person rotective equipment of during operation (gloves, finger cotter)	al ent s, <b>Docum</b> 1. Refer	nent reference/s to WI-PRO-CNC-L ngth Tolerance	
1	l	P1	Table lay-out	Master sample						🎒 (Sı	e VM tube unprene) = 226±3mm	2 p	Housekeeping Maintain and alw practice 5's. Personal things the workplace is prohibited. Keep it your locker.	on 1. No defo	rmed terminal ng usage of parts	
					Insertic Jig B	Jig A		Conne		A SA	nnector	the	Alert level or any trouble, info e Assembly Assis Supervisor or Lin- eader for immedia corrective action	tant e ate		
						Empty box		1746872	·1 (B)/		-10V-S (W)/	,				
							<u> </u>	Box	·		Box					
		! 				Revision History							Prepared by	Reviewed by	Approved by	Noted by
01/14/25	8		of table lay-out and inclusion of Work procedure of Measureme		location	of assy parts as counterme	asure to custome	er claim.	D. Castillo	C. Villanueva	A. Arañes	n/a				
08/15/23	7	1pc conn	vork procedure of process 1, prector 1746872-1 (B) using right to white color controller.						A.Hernandez	J. Loterte	C. Villanueva	A. Arañes		.// ."	AMP	
07/29/23	6		onnector, terminal orientation a /ork procedue/Illustration and q			roved the insertion jig as co	ostumer claim cou	untermeasure.	D. Castillo	J. Loterte	C. Villanueva	A. Arañes	D. Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No			De	etails of 0	Change			Revised	Reviewed	Approved	Noted	Est. Date:	September 21, 202	0	





					WORK INST		_						Effectivity Date:		January 14, 202	25
		Process Name/Title:				3 ASSEME							Validity Date:		n/a	
		Model code/Part number:	700B	1	75N758-0032	Customer:	TR	J	Car Model:	ГОҮОТА	-LAND CR	RUISER	Document No.:		WI-ENG-PDE-	70
		Purpose:	PR	ОТОТҮР	PE	PRE-LAUNC	:н		MASSP	RO			Revision No.:	8	Page No.:	3 of 18
PARTS:	L=344±	S 0.3 R L=124±2mm; W/G £2mm; GR/B L=124±2mm;								L=344±2	mm; GR		JIG:		Navigator	
NO.	F	PROCESS NAME			WORK PI	ROCEDURE	/ ILLU	USTRAT	ΓΙΟΝ				TOOLS/PPE	(	QUALITY POIN	TERS
2		Connector setting to insertion jig 1746872-1 (B) PBVP-12V-S (W) (Continuation)	L 2. Press the open.	<b>6</b>	and lower guide using	R both hands s	L ame tir	ming. Hold	es that nee	•		R	n/a	2. No wron 3. No wron	provided jig per n ng usage of parts ng orientation of co aged connector	
3	P1	Wire insertion to connector 1746872-1 (B)	2ND ROW 1ST ROW	BLAG	3 9 10 11 (  3 9 10 11 (  3 3 4 5 (  CK VM TUBE (SUNPREDUENCE	12	7 X 1 R 124	8 G 344 2 W/0 4 344 344	3 G BR 344	10 GR/B 124 4 Y 124 IRE FAC	11 X 5 V 124 SING gright har or. Repeat (-V-B wire pertion)	12 P 344 6 B 124	STEERING NAVIGATION(2 layer)  CONTROLLER	<ol> <li>No wrong</li> <li>No wrong</li> <li>No deform</li> <li>No stuck</li> </ol>	rided jig per model g usage of parts g insertion med terminal of terminal tip one insertion.	

					WORK INS	STRUCTION							Effectivity Date:	T	January 14, 20	25
		Process Name/Title:				IG ASSEM		ROCES	SS				Validity Date:	+	n/a	23
		Model code/Part number:	700B	7	75N758-0032					: TOYOT	A-LAND	CRUISER	R Document No.:	+	WI-ENG-PDE-1	170
		Purpose:		ОТОТҮР		PRE-LAUN			MASS				Revision No.:	8	Page No.:	4 of 18
PARTS:		S 0.3 R L=124±2mm; W/G ±2mm; GR/B L=124±2mm;			=344±2mm; Y L=124	±1mm; V L=12	4±1mm;	B L=124±	±2mm; 0	3 L=344±	-2mm; Gí	R	JIG:	Insertion     Steering	n jig g Navigator	
NO.	ı	PROCESS NAME			WORK	PROCEDUR	E/ ILLU	JSTRAT	ION				TOOLS/PPE	(	QUALITY POIN	ITERS
3	P1	Wire insertion to connector 1746872-1 (B) (Continuation)	2ND ROW  1ST ROW  SECONII  2. Get wires.	BLAC DROW	TO SEQUENCE  V SEQUENCE  Wire using right hand of the insertion sequence	RENE)	7 X 1 R 124	8 G 344 2 W/G 344	9 GR 344 3 BR 344	ON ILLUS  10 GR/B 124 4 Y 124  VIRE FAC	11 X 5 V 124 CING	12 P 344 6 B 124	STEERING NAVIGATION(2 layer)  CONTROLLER	2. No wror 3. No wror 4. No defo 5. No stuci 6. One by Impoi 1. Pleas during 2. Make insertic Do not 3. Auto the uni termina and has Docume 1. Refer Pull-Pus 2. Refer Wire an 3. Refer	ct Pull-Push-Pullon. exert extra force omatically disposit if once encount al and difficulty of locked connection of the	Note/s: near terminal properly I-Push after a. se and replace tered bend of insertion tor.  G-029 for -017 for olerance -044 for



			W	ORK INSTRUCTION		Effectivity Date:		January 14, 2025	
		Process Name/Title:		TAPING ASSEMBLY PRO	OCESS	Validity Date:		n/a	
		Model code/Part number:	700B / 75N758	8-0032 Customer: TRJ	Car Model: TOYOTA-LAND CRUISER	Document No.:		WI-ENG-PDE-1	70
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	8	Page No.:	5 of 18
PARTS:	1. Blacl	« VM tube (Sunprene) Ø8 I	_=89±3mm			JIG:	1. Insertior	n jig	
NO.	F	ROCESS NAME		WORK PROCEDURE/ ILLUS	TRATION	TOOLS/PPE		QUALITY POIN	TERS
4	P1	Wire insertion to Black VM tube (Sunprene) Ø8 L=89±3mm	2. Press the upper and lower both hands (same timing). It right hand and gently pull ou jig then set aside.  Note: Please see above illustrations.	Hold the wires using ut the connector from ustration  o insertion jig, put the assy	1. Hold the wires using left hand, get the Black VM tube (Sunprene) Ø8 L=89±3mm using right hand then insert the long wires using left hand.	N/A	2. No dam	ng use of parts aged connector	

				WOR	K INSTRU	CTION				Effectivity Date:		January 14, 202	5
		Process Name/Title:			APING A		LY PROC	CESS		Validity Date:	-	n/a	<u>′</u>
		Model code/Part number:	700B /	75N758-0		Customer:		1	OYOTA-LAND CRUISE	· ·	1	WI-ENG-PDE-1	70
		Purpose:	PROTOTYF	E		PRE-LAUNCH		MASSPRO	)	Revision No.:	8	Page No.:	6 of 18
PARTS:		S 0.3 B/W L=262±2mm; OF	R L=262±2mm; R/L							JIG:	Insertior     Steering	Navigator	
NO.	F	PROCESS NAME		W	ORK PRO	CEDURE/	ILLUSTR	ATION		TOOLS/PPE	(	QUALITY POIN	ΓERS
			123	QUENCE FRO			[	WIRE FA			2. No wron 3. No wron 4. No defo 5. No stucl 6. One by	rmed terminal k of terminal tip one insertion ant reminders/Note	e/s:
5	P1	Wire insertion to connector PBVP-10V-S (W)		W wire using a		en insert to	6 X	Repeat the proabove illustrate	9 10 X X	STEERING NAVIGATION(2 layer)  CONTROLLER	inserted Push aft Do not e 2. Please terminal 3. Auton replace o bend terf and half 4. Insert left to rig  Docum 1. Refer Wire and 2. Refer Steering procedu 3. Refer Pull-Pus 4 Refer	ent reference/s: to WI-PRO-CNC-0 d Strip Length Tol to WI-ENG-PDE-0 Navigation Conti re to GL-PRO-ASY-0 th procedure. r to GL-PRO-ASY-0 on Standard for c	near and ncountered finsertion r. be from  017 for lerance. 144 for roller 029 for -025 for

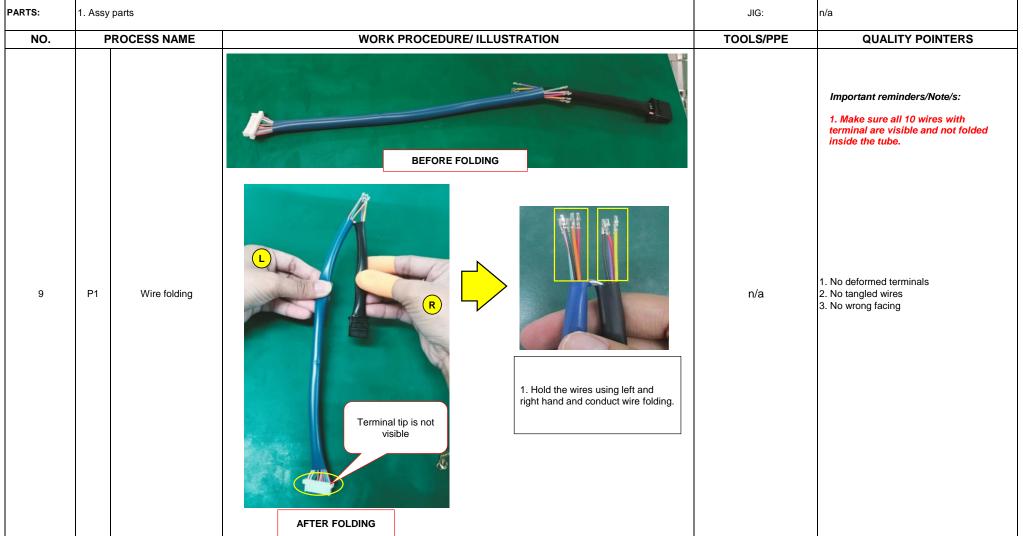
	_				WORK INS	TRUCTION		Effectivity Date:		January 14, 2025	
	lacksquare	Process Name/Title:				G ASSEMBLY PRO	CESS	Validity Date:	+	n/a	
		Model code/Part number:	700B	1	75N758-0032	Customer: TRJ	Car Model: TOYOTA-LAND CRUISER	Document No.:		WI-ENG-PDE-17	70
		Purpose:	□PR	ОТОТУРЕ	:	PRE-LAUNCH	MASSPRO	Revision No.:	8	Page No.:	7 of 18
PARTS:	1. AVSS	6 0.3 B/W L=262±2mm; OR L:	=262±2mm; R	/L L=262	2±2mm; LG L=262±2mi	ım; R/W L=262±2mm		JIG:	Insertion     Steering		
NO.	F	ROCESS NAME			WORK P	PROCEDURE/ ILLUST	RATION	TOOLS/PPE	(	QUALITY POINT	TERS
5	P1	Wire insertion to connector PBVP-10V-S (W) (Continuation)	*/\ */-	Term ote: Make su	Deper alignment of te	FRONT OF TERMINAL  GOOD Terminal condition  sin proper alignment before the connector during	BACK VIEW OF TERMINAL  Damaged terminal  NO GOOD  Terminal condition	NT VIEW OF TERMINAL  NO GOOD Terminal codition	1. Use provi 2. No wrong 3. No wrong 4. No deforr 5. No stuck 6. One by or  Import 1. Mainsert Push Do no 2. Plet termin 3. Aut replace encou difficul locket 4. Inst left to  Docur 1. Refe Wire a 2. Refe Steeri proce 3. Refe Pull-P 4. Refe Inspec	rided jig per model g usage of parts g insertion med terminal of terminal tip one insertion  retant reminders/No ake sure wires are ted. Conduct Pull- after insertion. of exert extra force ase hold the wires nal during insertio tomatically dispose the unit if once untered bend term ulty of insertion ar de connector. ertion of wires mu o right.  ment reference/s: fer to WI-PRO-CNO and Strip Length T fer to WI-ENG-PDE ing Navigation Coi	properly Push-Pull-  a. a. b.

				WORK INS	TRUCTION		Effectivity Date:		January 14, 202	<u>.</u> 5
		Process Name/Title:		TAPIN	G ASSEMBLY PR	OCESS	Validity Date:		n/a	
		Model code/Part number:	700B /	75N758-0032	Customer: TRJ	Car Model: TOYOTA-LAND CRUISER	Document No.:		WI-ENG-PDE-1	70
		Purpose:	PROTOTYF	PE	PRE-LAUNCH	MASSPRO	Revision No.:	8	Page No.:	8 of 18
PARTS:	1. Blue 2. Assy	VM tube (Sunprene) Ø8 L=22 parts	6±3mm				JIG:	1. Insertion	n jig	
NO.	F	ROCESS NAME		WORK P	PROCEDURE/ ILLUS	STRATION	TOOLS/PPE	(	QUALITY POIN	TERS
6	P1	Wire insertion to Blue VM tube (Sunprene) Ø8 L=226±3mm	1. Hold the wires (Sunprene) Ø8 wires using left h	s using left hand, get the L=226±3mm using right	ght hand then insert the	Press the lower guide lock using right d. Holes that need to be insert are only in.	N/A	2. No defo	ng usage of parts ormed terminal tant reminders/No es must be offset	
7		Wire insertion to Assy parts		/M tube (Sunprene) us the wires from assy pa	position s sid	nector facing and should be on the left de of harness.	N/A		ng usage of parts irmed terminal	

					WORK	INSTR	RUCTION						Effectivity Date:		January 14, 202	5
		Process Name/Title:			TA	PING	ASSEN	IBLY P	ROCES	S			Validity Date:		n/a	
		Model code/Part number:	700B	/ 75	N758-00	032	Custome	r: TR	<b>J</b> Ca	r Model: <b>T</b> (	YOTA-LA	ND CRUISEF	Document No.:		WI-ENG-PDE-1	70
		Purpose:	PROT	OTYPE			PRE-LAU	NCH		MASSPR	)		Revision No.:	8	Page No.:	9 of 18
PARTS:	1. Assy	parts											JIG:	Insertion     Steering		
NO.	F	PROCESS NAME			WO	RK PR	OCEDUF	RE/ ILLU	ISTRATI	ON			TOOLS/PPE	(	QUALITY POIN	ΓERS
8	P1	Wire insertion to connector PBVP-10V-S (W)	1 R/W	2 LG 262	en insert to ess for LG	WIRE  4 GR 344  hand and connecte-R/L-OR:	8 9 (1) 5 OR 262 d support to or at slot 1 -B/W wire	ON ILLUGATION on			9 W/G 344	10 P 344	STEERING NAVIGATION(2 layer)  CONTROLLER	2. No wron 3. No wron 4. No defo 5. No stuck 6. One by Importa 1. Make inserted Push aft Do not e 2. Pleass terminal 3. Auton replace bend ter and half 4. Insert left to rig  Docum 1. Refer Wire and 2. Refer Steering procedu 3. Refer Pull-Pus 4 Refer	ent reference/s: to WI-PRO-CNC-0 I Strip Length Tol to WI-ENG-PDE-0 Navigation Conti re to GL-PRO-ASY-0 h procedure. r to GL-PRO-ASY-0 on Standard for c	e/s: coperly sh-Pull- ear and acountered finsertion r. be from 117 for erance. 44 for coller 129 for

					WORK INST	PUCTION		Effectivity Date:			1
		Process Name/Title:				S ASSEMBLY PRO	CESS	Effectivity Date: Validity Date:		January 14, 20 n/a	25
		Model code/Part number:	700B		75N758-0032	Customer: TRJ	Car Model: TOYOTA-LAND CRUISER	,		WI-ENG-PDE-1	70
									_	1	
		Purpose:	<b>□</b> PF	ROTOTYPE		PRE-LAUNCH	MASSPRO	Revision No.:	8	Page No.:	10 of 18
PARTS:	1. Assy	parts						JIG:	Insertior     Steering	ı jig ı Navigator	
NO.	F	PROCESS NAME			WORK PI	ROCEDURE/ ILLUSTR	RATION	TOOLS/PPE	(	QUALITY POIN	TERS
8	P1	Wire insertion to connector PBVP-10V-S (W)		BACK Term	GOOD ninal condition	FRONT OF TERMINAL  GOOD Terminal condition  er alignment before inser- connector during wire inser-	Damaged terminal  NO GOOD  Terminal condition	NT VIEW OF TERMINAL  NO GOOD  Terminal codition	2. No wron 3. No wron 4. No defo 5. No stuck 6. One by Impo 1. Ma inser Push Do no 2. Ple termi 3. Au repla enco diffic locke 4. Ins	vided jig per mode ig usage of parts ig insertion rmed terminal to of terminal tip one insertion vitant reminders/lake sure wires and ted. Conduct Pullafter insertion. To exert extra force as hold the wire nal during insertitomatically disponentially disponenti	Note/s: e properly -Push-Pull- ee. es near on. se and eminal, ind half-
		(Continuation)	L	ne wires u	using right hand and ti		sposed and replace the unit.	3. Gently pull out the connector from jig then check the terminal tip condition.	1. Rei Wire a 2. Rei Steern proce 3. Rei Pull-F 4. Rei Inspe	ment reference/s: fer to WI-PRO-CN and Strip Length fer to WI-ENG-PD fing Navigation Co dure fer to GL-PRO-AS cutor to GL-PRO-AS cutor Standard for fector insertion.	C-017 for Tolerance. E-044 for ontroller Y-029 for Y-025 for

					WORK INST	RUCTION				Effectivity Date:		January 14, 20	25
		Process Name/Title:			TAPING	S ASSEMI	BLY P	ROCE	SS	Validity Date:		n/a	-
		Model code/Part number:	700B	1	75N758-0032	Customer	TRJ	J	Car Model: TOYOTA-LAND CRUISER	Document No.:		WI-ENG-PDE-1	70
		Purpose:	□PR	OTOTYF	E	PRE-LAUNG	СН		MASSPRO	Revision No.:	8	Page No.:	11 of 18
PARTS:	1. Assy	/ parts								JIG:	n/a		
NO.	F	PROCESS NAME			WORK PI	ROCEDUR	TION	TOOLS/PPE	(	QUALITY POIN	TERS		





			WORK INS	STRUCTION		Effectivity Date:		January 14, 202	25
		Process Name/Title:		IG ASSEMBLY PRO	CESS	Validity Date:		n/a	
		Model code/Part number:	700B / 75N758-0032	Customer: TRJ	Car Model: TOYOTA-LAND CRUISER	Document No.:		WI-ENG-PDE-1	70
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	8	Page No.:	12 of 18
PARTS:	1. Conr	nector PBVP-10V-S (W)				JIG:	1. Insertior	n jig	
NO.	F	PROCESS NAME	WORK I	PROCEDURE/ ILLUSTR	RATION	TOOLS/PPE	(	QUALITY POIN	ΓERS
10	P1	Connector setting to insertion jig PVBVP-10V-S (W)	Upp Upp Upp Upp INSERTION JIG	oper guide lock  per guide	OV-S (W) and insert to insertion jig	N/A		rmed terminals led wires	



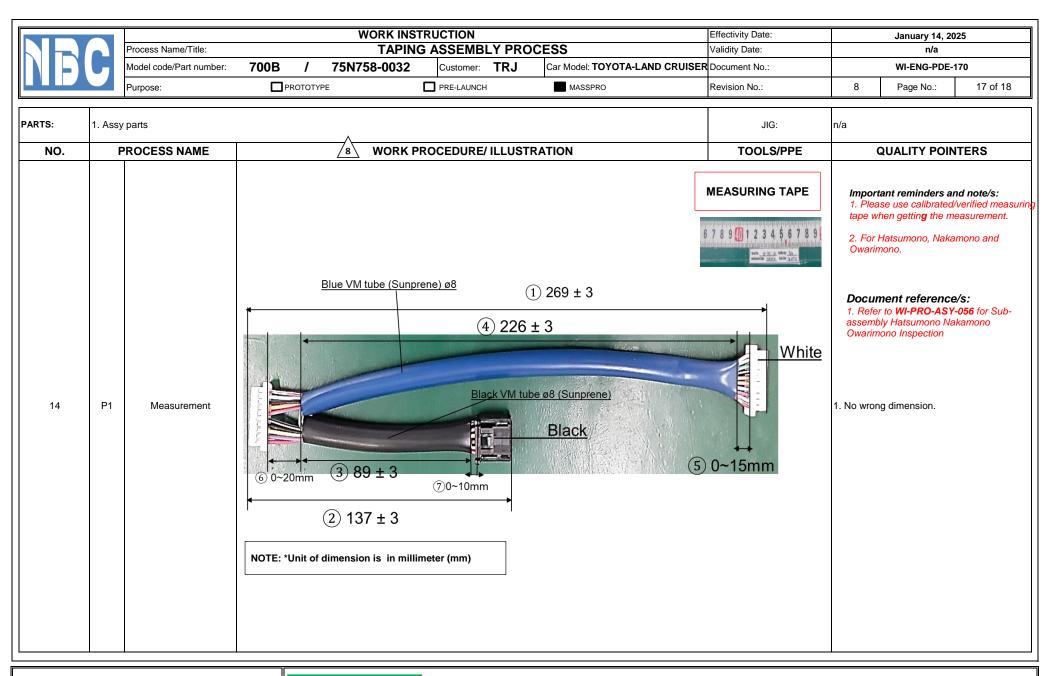
WORK INSTRUCTION Effectivity Date:  Process Name/Title: TAPING ASSEMBLY PROCESS Validity Date:  Model code/Part number: 700B / 75N758-0032 Customer: TRJ Car Model: TOYOTA-LAND CRUISER Document No.:  Purpose: PROTOTYPE PRE-LAUNCH MASSPRO Revision No.:  PARTS: 1. Assy parts  NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE  INSERTION SEQUENCE FROM LEFT TO RIGHT WIRE FACING  WIRE FACING	January 14, 2025
Purpose: PROTOTYPE PRE-LAUNCH MASSPRO Revision No.:  PARTS: 1. Assy parts  NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE	n/a
PARTS: 1. Assy parts  NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE	WI-ENG-PDE-170
NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE	8 Page No.: 13 of 18
	1. Insertion jig
INSERTION SEQUENCE FROM LEFT TO RIGHT  WIRE FACING	QUALITY POINTERS
Wire insertion to connector PBVP-10V-S (W)  1. Hold the R/W wire using right hand and support the wire by the left index finger then insert to connector at slot 1 using right hand. Repeat the process for LG-B/W-OR-R/L-GR/B-B-Y-V-R wires Note: Follow the insertion sequence based on the illustration.	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  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 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.  Document reference/s: 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.



WORK INSTRUCTION Effectivity Date: January 14, 2025												
		Process Name/Title:			Validity Date:	+	n/a					
		Model code/Part number:	700B / 75N758-0032		G ASSEMBLY PROCESS  Customer: TRJ Car Model: TOYOTA-LAND CRUISE			WI-ENG-PDE-170				
			PROTOTY		PRE-LAUNCH	MASSPRO	Revision No.:	8	Page No.:	14 of 18		
		Purpose:	PROTOTY	PE	PRE-LAUNCH	MASSPRO	Revision No.:	0	Page No.:	14 01 16		
PARTS:	1. Assy	parts			JIG:	1. Insertion	1. Insertion jig					
NO.	F	PROCESS NAME		TOOLS/PPE		QUALITY POIN	TERS					
11	P1	Wire insertion to connector PBVP-10V-S (W)	Proper alignment of terminal to connector  BACK VIEW OF TERMINAL  FRONT OF TERMINAL  FRONT OF TERMINAL  GOOD  Terminal condition  Note:  *Make sure the terminal was in proper alignment before in			BACK VIEW OF TERMINAL  FROM  Damaged terminal  NO GOOD  Terminal condition	Damaged terminal  NO GOOD  Terminal condition  NO GOOD  Terminal condition			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  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 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.		
		(Continuation)	Call the attenti	on of Immediate super	erior and Automatically of	isposed and replace the unit.		1. Rei Wire a 2. Rei Steern proce 3. Rei Pull-F 4. Rei Inspe	ment reference/s: fer to WI-PRO-CN and Strip Length fer to WI-ENG-PD ing Navigation Co edure fer to GL-PRO-AS Push procedure. fer to GL-PRO-AS action Standard fo ector insertion.	C-017 for Tolerance. E-044 for ontroller Y-029 for Y-025 for		

				WORK INS	Effectivity Date:	January 14, 2025					
		Process Name/Title:						n/a			
		Model code/Part number:	700B /	75N758-0032	Customer: TRJ	Car Model: TOYOTA-LAND CRUISER	Document No.:		WI-ENG-PDE-1	70	
		Purpose:	PROTOTY	PE	PRE-LAUNCH	MASSPRO	Revision No.:	8	Page No.:	15 of 18	
PARTS:	1. Assy parts							n/a			
NO.	F	ROCESS NAME		WORK P	TOOLS/PPE	QUALITY POINTERS					
12	P1	Wire facing arrangement		correct facing tip is not visible  WRONG FACING	Double lock in upward position.  Double lock in upward position.	1. Hold the harness using left and right hand then start to conduct the correct facing.  Terminal tip is not visible  Terminal tip is visible	N/A		ng facing		

WORK INSTRUCTION Effectivity Date: January									January 14, 202	25		
		Process Name/Title:			NG ASSEMBLY PROC	CESS		Validity Date:		n/a		
		Model code/Part number:	700B /	75N758-0032		_	A-LAND CRUISER			WI-ENG-PDE-1	70	
		Purpose:	PROTO		PRE-LAUNCH	MASSPRO		Revision No.:	8	Page No.:	16 of 18	
PARTS:	1. Assy parts 2. Master sample						JIG:	n/a				
NO.	PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE							TOOLS/PPE	(	QUALITY POIN	TERS	
NO.	P1	Visual/By Two's Inspection	of  2. Check the wire align no tangled wires.	Check the wire alignment. Make sure  3. Check the termination of the control			Docum  1. Refer Steering	MASTER SAM  15HT58-003  Pent reference/s:  to WI-QAD-QAC- Electrical Test  g facing of harnes pled wires	MPLE 2 252			



WORK INSTRUCTION								Effectivity Date:	January 14, 20	anuary 14, 2025		
		Process Name/Title: TAPING ASSEMBLY PROCESS						Validity Date: n/a				
		Model code/Part number:	700B	/ 75	N758-0032	Customer: TRJ	Car Model: TOYOTA-LAND CRUISER	Document No.:		WI-ENG-PDE-	170	
		Purpose:	PRO	ОТОТҮРЕ		PRE-LAUNCH	MASSPRO	Revision No.:	8	Page No.:	18 of 18	
PARTS:	1. Assy	parts						JIG:	n/a			
	VISUAL INSPECTION/ QUALITY CHECKPOINT											
	75N758-0032											
	Black VM Tube (Sunprene)  1. Check the connector lock, Should be unlock.  Blue VM Tube (Sunprene)  CORRECT FACING											
		ck the wire nent.Make su	ire no 1	tangle	ll ha	Check the o arness.	5.Check the ter backing out (no nserted)or defo		fully			
W L	ires.	res.		4.	Check if no	terminal.						