Process Name/Title:    Model code/Part number:   311D/400D   75S834-7051   Customer:   TRJ   Car Model:   TOYOTA-RAV 4/BZ4X   Document No.:   WI-ENG-PDE-1	1 of 18
Purpose:	1 of 18
PARTS:  1. Assy parts (GR/B wire with White SV tube, Sky blue tape); Connector PBVP-06V-S (W); Black SV tube (Vinyl) Ø7 L= 131±3mm; Black SV tube (Vinyl) Ø5.5 L=122±3mm; Connector PBVP-10V-S (W); Connector 4A1230-0000 (W); AVSS 0.3 R L=166±2mm; W/G L=168±2mm; BR L=172±2mm; LG  2. Steering Navigation	
PARTS: Ø5.5 L=122±3mm; Connector PBVP-10V-S (W); Connector 4A1230-0000 (W); AVSS 0.3 R L=166±2mm; W/G L=168±2mm; BR L=172±2mm; LG  L=289±2mm; G L=285±2mm; V L=285±2mm; V L=285±2mm; V L=285±2mm; V L=285±2mm	TERS
NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POIN	TERS
Table Lay-out  Connector PBVP-06V-S (W)/ Box  Black SV tube (Vinyl) Ø5.5 L=122±3mm  Assy parts (GR/B wire with White SV tube, Sky blue tape)  Assy parts (GR/B wire with White SV tube, Sky blue tape)  2 Layer Navigation  Safety Instruction  Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)  2. Refer to WI-PRO-CNC-total assembly process (Pre-assembly process (Pre-assembly process (Pre-assembly process (Pre-assembly process))	117 for Wire e 151 for Taping
Master sample    Master sample   Housekeeping	
Insertion Jig B  Insertion Jig A  Connector PBVP-10V-S (W)/ Box  Connector 4A1230-0000 (W)/ Box  Connector 4A1230-0000 (W)/ Box  Connector 4A1230-0000 (W)/ Box	
Revision History Prepared by Checked by Reviewed by	Approved by
03/04/25 2 Additional model code "400D" and car model "Toyota-BZ4X" due to new project. Update Measurement due to wrong facing. D.Castillo J. Loterte C. Villanueva A. Arañes	
12/06/24 1 Changr from Pre-launch to Masspro.  D.Castillo n/a C. Villanueva A. Arañes	SHOW
11/15/24 0 Initial issue.  D.Castillo n/a C. Villanueva A. Arañes D. Castillo J. Loterte C. Villanueva	A. Arañes
Eff. Date Rev. No Details of Change Revised Checked Reviewed Approved Est. Date: November 15, 2024	

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			WORK INS	TRUCTION		Effectivity Date:		March 04, 2025	i
		Process Name/Title:	TAPIN	G ASSEMBLY PRO	CESS	Validity Date:		n/a	
		Model code/Part number:	311D/400D / 75S834-7051	Customer: TRJ	Car Model: TOYOTA-RAV 4/BZ4X	Document No.:		WI-ENG-PDE-11	52
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	■ MASSPRO	Revision No.:	2	Page No.:	2 of 18
PARTS:	1. Conne	ector 4A1230-0000 (W) ector PBVP-10V-S (W)				JIG:	Insertion     Steering		
NO.	Р	ROCESS NAME	WORK P	ROCEDURE/ ILLUST	RATION	TOOLS/PPE	(	QUALITY POINT	ΓERS
2	P1	Connector setting to insertion jig 4A1230-0000 (W) and PBVP-10V-S (W)	Insertion Jig  Vis reference  Upper 9  1  2  Lower guide  755744-7051 J1-A	guide Cor	nnector orientation  1 2  R  1230-0000 (W) using left hand and 1 M connector using right hand then enector orientation.  Press  2. Press the upper and lower guide using both hands in same timing. Holes that need to be insert are only open.	STEERING NAVIGATION (2 layer)  CONTROLLER	<ol><li>No wron</li><li>No wron</li></ol>	provided jig per mo g usage of parts g orientation of cor aged connector	

				WORK INSTR				Effectivity Date:	T	March 04, 202	25
		Process Name/Title:			ASSEMBLY PR	OCESS		Validity Date:		n/a	
		Model code/Part number:	311D/400D /	75S834-7051	Customer: TRJ	Car Model:	TOYOTA-RAV 4/BZ4X	Document No.:		WI-ENG-PDE-1	152
		Purpose:	☐ PROTOTYPE		PRE-LAUNCH	■ MASSP	'RO	Revision No.:	2	Page No.:	3 of 18
PARTS:	1. AVSS	6 0.3 R L=166±2mm; W/G L=1	168±2mm; BR L=172±2r	nm				JIG:	Insertion     Steering		
NO.	P	PROCESS NAME		WORK PR	ROCEDURE/ ILLUS	TRATION		TOOLS/PPE	(	QUALITY POIN	ITERS
3	P1	Wire insertion to Connector 4A1230-0000 (W)	1. Get the R wire uprocess for W/G ar	nd BR wires. Check the		w/G 168  X X X  An insert to connect to conn	TERMINAL FACING  I ILLUSTRATION  BR 172  X X X  Actor. Repeat the	STEERING NAVIGATION (2 layer)  CONTROLLER	2. No wron 3. One by 4. No wron 5. No defo 6. No stuci  Importa  1. Make inserted Push aft Do not e 2. Pleast terminal 3. Auton replace e encount difficulty locked c 4. Insert left to rig  Docume  1. Refer a 2. Refer a Steering procedur 3. Refer a	ent reference/s: to WI-PRO-CNC- d Strip Length To to WI-ENG-PDE-( ) Navigation Cont	te/s:  properly push-Pull-  near n. e and nal, d half- at be from  017 for plerance. 044 for troller

							_
			WORK INSTRU	JCTION		Effectivity Date:	
	Process Name/Title:		TAPING A	SSEMBLY PROC	ESS	Validity Date:	Γ
	Model code/Part number:	311D/400D / 7	75S834-7051	Customer: TRJ	Car Model: TOYOTA-RAV 4/BZ4X	Document No.:	
	Purpose:	☐ PROTOTYPE		PRE-LAUNCH	MASSPRO	Revision No.:	

2 Page No.: 4 of 18 1. 4A1230-0000 (W) 1. Insertion jig PARTS: JIG: 2. Connector PBVP-10V-S (W)/ 2. Steering Navigation TOOLS/PPE **QUALITY POINTERS** NO. PROCESS NAME **WORK PROCEDURE/ ILLUSTRATION** 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 **STEERING** NAVIGATION (2 layer) Important reminders/Note/s: 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. 2. Press the Upper and lower button using both hands. Remove the 1st connector with inserted wires Do not exert extra force. using right hand. 2. Please hold the wires near terminal during insertion. Wire insertion to 3. Automatically dispose and Connector 4 P1 replace the unit if once 4A1230-0000 (W) encountered bend terminal, CONTROLLER (Continuation) 3. After removal to insertion jig, difficulty of insertion and halfput the assy parts to empty locked connector. box. 4. Insertion of wires must be from Note: Follow the illustration. 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.

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March 04, 2025 n/a WI-ENG-PDE-1152

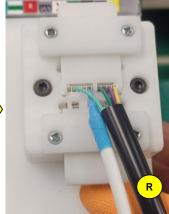
			W	ORK INSTRUCTION				Effectivity Date:		March 04, 202	.5
		Process Name/Title:		TAPING ASSEM	BLY PROC	CESS		Validity Date:		n/a	
		Model code/Part number:	311D/400D / 75S8	834-7051 Customer	TRJ	Car Model:	TOYOTA-RAV 4/BZ4X	Document No.:		WI-ENG-PDE-11	152
		Purpose:	☐ PROTOTYPE	☐ PRE-LAUNG	СН	MASSPI	RO	Revision No.:	2	Page No.:	5 of 18
PARTS:	2. Assy	parts (GR/B with tube taping)		,					Insertion     Steering	Navigation	
NO.	I	PROCESS NAME		WORK PROCEDURI	E/ ILLUSTR	ATION		TOOLS/PPE		QUALITY POIN	
			INSERTION SEQUENCE F	3 4 6 6	WIDE	INSERTION	TERMINAL FACING		2. No wron 3. One by 6 4. No wron 5. No defor 6. No stuck	vided jig per mode ng usage of parts one insertion ng insertion rmed terminal k of terminal tip nt reminders/Note sure wires are pr	e/s:
5	P1	Wire insertion to Connector PBVP-10V-S (W)	1. Get the LG wire using rigt taping) using right hand. Pot to connector. Repeat the pinote: Follow the insertion of	osition the finger in the mi rocess for G,B,V and Y w	R  Innector. Get the ddle of wire a sires. Check the	3 4 G B 285 285	5 6 V Y 5 285 285  (GR/B with White tube by pinch while inserting)	STEERING NAVIGATION (2 layer)  CONTROLLER	inserted. Push afte Do not ex 2. Please during in 3. Autom the unit i terminal, half-lock 4. Inserti to right.  Docume 1. Refer t and Strip 2. Refer t Steering procedum 3. Refer t Push pro 4. Refer t	Conduct Pull-Puer insertion. xert extra force. e hold the wires nesertion. varies antically dispose a fif once encounter difficulty of insertion of wires must on of wires must on the reference/s: to WI-PRO-CNC-00 Length Tolerand to WI-ENG-PDE-00 Navigation Continue. Telegical Continues of the Continues of the CI-PRO-ASY-00 Continues of CI-PRO-ASY-00 Standard for continues of the CI-PRO-ASY-00 Standard for continues	ear terminal and replace red bend rtion and be from left 017 for Wire ce. 44 for roller 029 for Pull-

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Terminal tip must be visible

				WORK INSTR	RUCTION			Effectivity Date:		March 04, 202	25
		Process Name/Title:		TAPING	<b>ASSEMBLY PRO</b>	CESS		Validity Date:		n/a	
		Model code/Part number:	311D/400D / 7	75S834-7051	Customer: TRJ	Car Model: TOYOTA-R	AV 4/BZ4X	Document No.:		WI-ENG-PDE-1	152
		Purpose:	☐ PROTOTYPE		PRE-LAUNCH	■ MASSPRO		Revision No.:	2	Page No.:	6 of 18
PARTS:		6 0.3 LG L=289±2mm; G L=28 parts (GR/B with tube taping)		L=285±2mm; Y L=28	85±2mm			JIG:	1. Insertion 2. Steering		
NO.	F	PROCESS NAME		WORK PRO	OCEDURE/ ILLUST	RATION		TOOLS/PPE	(	QUALITY POIN	ITERS
5	P1	Wire insertion to Connector PBVP-10V-S (W) (Continuation)	BACK VIEW OF TERMING GOOD Terminal condit  Note: *Make sure the tell *Avoid hitting the	tion Terr	GOOD minal condition	BACK VIEW OF TERMINA  Damaged terminal  NO GOOD  Terminal condition	L FR.		2. No wron 3. One by 6 4. No wron 5. No defoi 6. No stuck  Importan 1. Make inserted Push aft Do not e 2. Please terminal 3. Auton replace a encount difficulty locked c 4. Insert left to rig  Docume. 1. Refer a Wire and 2. Refer a Steering procedu 3. Refer a Pull-Push 4. Refer a Inspection	med terminal k of terminal tip k of terminal tip met reminders/Norware wires are pure insertion. Exert extra force, a hold the wires during insertion natically dispose the unit if once were doend terminy of insertion and connector, ion of wires musight.  Interference/s:  to WI-PRO-CNC-I Strip Length To to WI-ENG-PDE-I Navigation Control in the control of the wigation Control in the control of the wigation Control in the control of the wigation Control in the control	te/s:  properly push-Pull-  near n. e and nal, d half- st be from  017 for olerance. 044 for troller

			We	ORK INSTRUCTION	1		E	Effectivity Date:		March 04, 202	5
		Process Name/Title:		TAPING ASSEM	IBLY PRO	CESS	\	Validity Date:		n/a	
		Model code/Part number:	311D/400D / 75S8	334-7051 Custome	er: <b>TRJ</b>	Car Model: TOYOTA-RAV 4/I	BZ4X	Document No.:		WI-ENG-PDE-11	152
		Purpose:	☐ PROTOTYPE	☐ PRE-LAU	NCH	■ MASSPRO	F	Revision No.:	2	Page No.:	7 of 18
PARTS:	1. Black	SV tube (Vinyl) Ø7 L=131±3	mm					JIG:	1. Insertion	jig	
NO.	Р	ROCESS NAME		WORK PROCEDUR	RE/ ILLUST	RATION		TOOLS/PPE	(	QUALITY POIN	TERS
6	P1	Wire insertion to Black SV tube (Vinyl) Ø7 L=131±3mm	1. Get the Black SV tube ('L=131±3mm using right ha using left hand then insert the Note: Make sure that the as with tube taping) is under the after insertion.	nd. Hold the wire he wires.				n/a		ng usage of parts rmed terminal led wires	



2. Press the lower

guide using right hand. Holes that need to be inserted are only open.

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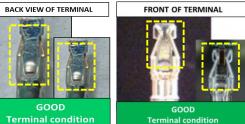
	W	ORK INSTRUCTI	ON			Effectivity Date:		March 04, 202	25
Process Name/Title:		Validity Date:		n/a					
Model code/Part number:	311D/400D / 75S	834-7051 Custo	omer: TR	Car Model:	TOYOTA-RAV 4/BZ4X	Document No.:		WI-ENG-PDE-1	152
Purpose:	☐ PROTOTYPE	☐ PRE-L	AUNCH	MASSP	RO	Revision No.:	2	Page No.:	8 of 18
						<u>'</u>			

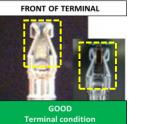
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO	Revision No.:	2 Page No.: 8 of 18
RTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1 Wire insertion to assy parts	1. Hold the Black VM tube (Sunprene) using left hand and insert the wires of assy parts (Connector with wire) using right hand.	n/a	No wrong usage of parts     No deformed terminal     No tangled wires

					WORK	INSTRU	JCTION						Effectivity Date:	$\overline{\Box}$	March 04, 202	5
		Process Name/Title:			TA	PING A	SSEME	LY PRO	OCESS				Validity Date:		n/a	
		Model code/Part number:	311D/400E	) / 7	'5S834-7	7051	Customer:	TRJ	Car N	/lodel: 1	ОҮОТА-І	RAV 4/BZ4X	Document No.:		WI-ENG-PDE-1	152
		Purpose:	☐ PROTOTY	PE			PRE-LAUNC	Н		MASSPRO	)		Revision No.:	2	Page No.:	9 of 18
PARTS:	1. Assy				14/05		050110		FD 4 T10				JIG:	1. Insertion 2. Steering	Navigation	
NO.	F	ROCESS NAME			WOF	RK PRO	CEDURE	/ ILLUS	RATIO	N			TOOLS/PPE		QUALITY POIN	
				2 3		1	V.		RE INSE	RTION II		MINAL CING	STEERING	2. No wron 3. One by c 4. No wron 5. No defor 6. No stuck Important 1. Make inserted.	vided jig per mode g usage of parts one insertion ig insertion rmed terminal c of terminal tip nt reminders/Note sure wires are pr Conduct <u>Pull-Pu</u> er insertion.	v/s: operly
8	P1	Wire insertion to Connector PBVP-10V-S (W)	1 BR 172  1. Hold the BR connector slot Note: Follow th	1 using i	right hand.	Repeat th	ne process	on W/G a	nd R wire	B 285	V 285	Y 285	NAVIGATION (2 layer)  CONTROLLER	Do not example 2. Please during in 3. Autom the unit it terminal, half-lock 4. Insertito right.  Documer 1. Refer than 3. Refer than 3. Refer than 3. Refer than 3. Refer than 4. Refer than 5.	xert extra force.  A hold the wires no sertion.  A totally dispose of fonce encounter difficulty of insection of wires must not reference/s:  A WI-PRO-CNC-CO Length Tolerand to WI-ENG-PDE-O Navigation Contine.  A to GL-PRO-ASY-CO COCUPY of COCUPY COCUPY COCUPY CONTINUED TO STANDARD FOR CONTINUED TO STANDARD FOR COCUPY CONTINUED TO STANDARD FOR CONTINUED TO STANDARD FOR CONTINUED TO STANDARD FOR COCUPY CONTINUED TO STANDARD FOR CON	and replace ed bend rtion and be from left  17 for Wire ee. 44 for coller 129 for Pull-

1 Insertion iir			WORK INSTRUCTION		Effectivity Date:	Ma	rch 04, 2025
PARTS: 1. Assy parts    Description   Proper alignment of terminal to connector		Process Name/Title:	TAPING ASSEMBLY P	ROCESS	Validity Date:		n/a
PARTS: 1. Assy parts    NO.   PROCESS NAME   WORK PROCEDURE/ ILLUSTRATION   TOOLS/PPE   QUALITY POINTER:		Model code/Part number:	311D/400D / 75S834-7051 Customer: TR	Car Model: TOYOTA-RAV 4/BZ4X	Document No.:	WI-E	ENG-PDE-1152
NO. PROCESS NAME  WORK PROCEDURE/ ILLUSTRATION  TOOLS/PPE  Proper alignment of terminal to connector  Improper alignment of terminal to connector		Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	2 Pag	ge No.: 10 of 18
Proper alignment of terminal to connector  Improper alignment of terminal to connector  In 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:	PARTS:	1. Assy parts			JIG:		ion
Proper alignment of terminal to connector  Improper alignment of t	NO.	PROCESS NAME	WORK PROCEDURE/ ILLU	ISTRATION	TOOLS/PPE	QUALI	TY POINTERS
5. No deformed terminal 6. No stuck of terminal tip  Important reminders/Note/s:			Proper alignment of terminal to connector	Improper alignment of tern	ninal to connector	No wrong usage     One by one insertions	e of parts ertion
				8.00		5. No deformed te	erminal
						_	

Wire insertion to Connector P1 8 PBVP-10V-S (W) (Continuation)









- 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.



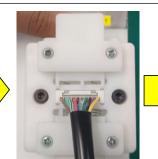
Terminal tip must be visible

## 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.





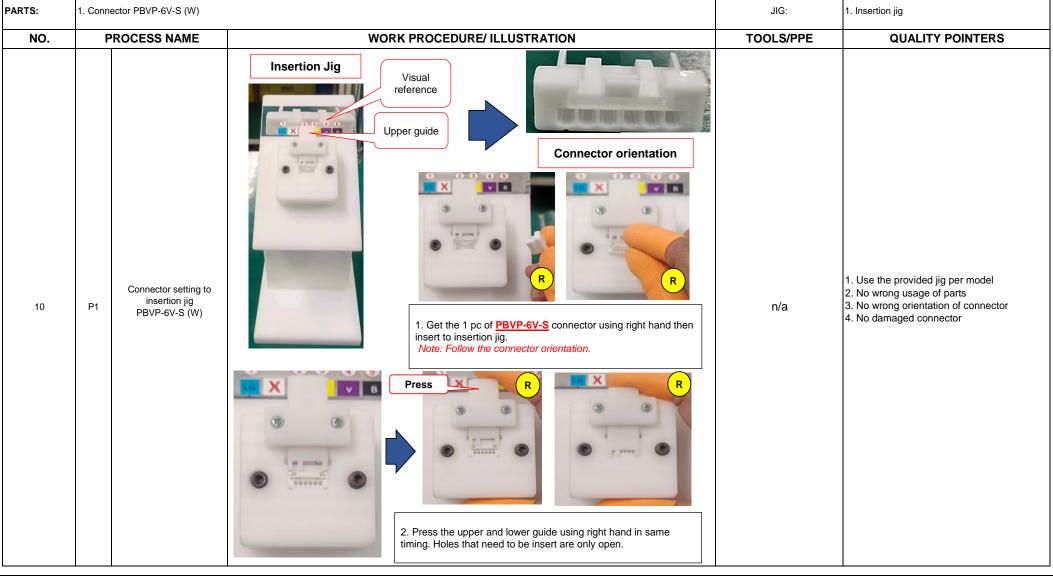


2. Press the upper lock by left hand and hold the assy part by right hand. Check the wire after insertion

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			WORK INSTRUCTION		Effectivity Date:		March 04, 2025	j
		Process Name/Title:	TAPING ASSEMBLY PROC	CESS	Validity Date:		n/a	
		Model code/Part number:	311D/400D / 75S834-7051 Customer: TRJ	Car Model: TOYOTA-RAV 4/BZ4X	Document No.:		WI-ENG-PDE-115	52
		Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH	MASSPRO	Revision No.:	2	Page No.:	11 of 18
	l					T		
PARTS:	1. Black	SV tube (Vinyl) Ø5.5 L=122±	£3mm		JIG:	n/a		
NO.	F	PROCESS NAME	WORK PROCEDURE/ ILLUSTR	ATION	TOOLS/PPE	(	QUALITY POINT	ERS
9	P1	Wire insertion to Black SV tube (Vinyl) Ø5.5 L=122±3mm		1. Get the Black SV tube (Vinyl) Ø5.5 L=122±3mm using right hand. Hold the wire of assy parts using left hand then insert the wires.		1. No wron 2. No defor 3. No tangl	ng usage of parts rmed terminal led wires	

NB				WORK INSTR	Effectivity Date:	March 04, 2025				
		Process Name/Title: TAPING ASSEMBLY PROCESS					Validity Date:	n/a		
	J	Model code/Part number:	311D/400D /	75S834-7051	Customer: TRJ	Car Model: TOYOTA-RAV 4/BZ4X	Document No.:	WI-ENG-PDE-1152		
		Purpose:	☐ PROTOTYPE		PRE-LAUNCH	■ MASSPRO	Revision No.:	2 Page No.: 12 of 18		
PARTS: 1. Connector PBVP-6V-S (W)						JIG:	1. Insertion jig			
NO.	F	PROCESS NAME WORK PROCEDURE/ ILLUSTRATION					TOOLS/PPE	QUALITY POINTERS		



			WORK INSTRUCTION							March 04, 2025		
		Process Name/Title:		TAPING	<b>ASSEMBLY</b>	PROCESS		Validity Date:	n/a			
		Model code/Part number:	311D/400D /	75\$834-7051	Customer:	Car Model:	TOYOTA-RAV 4/BZ4X	Document No.:		WI-ENG-PDE-1	152	
		Purpose:	☐ PROTOTYPE		PRE-LAUNCH	■ MASSF	PRO	Revision No.:	2	Page No.:	13 of 18	
PARTS: 1. Assy								JIG:	1. Insertion jig			
NO.	P	ROCESS NAME		WORK PR	OCEDURE/ IL	LUSTRATION		TOOLS/PPE	QUALITY POINTERS			
11	P1	Wire insertion to Connector PBVP-6V-S (W)	1. Hold the LG wire connector slot 1 usin	G Y V	support the wire the process on	G 285 2  R  by left index finger the G, Y, V and B wires.	TERMINAL FACING  NILLUSTRATION  3 4 5 Y V B 85 285 285  en insert to	n/a	2. No wron 3. One by 4. No wron 5. No defo 6. No stuck  Importar 1. Make inserted. Push afte Do not e: 2. Please during in 3. Autom the unit i terminal, half-lock 4. Inserti to right.  Docume 1. Refer a and Strip 2. Refer i Push pro 3. Refer i	rmed terminal k of terminal tip at reminders/Note sure wires are properties. Conduct Pull-Puer insertion.  Exert extra force.  In the hold the wires an esertion.  In the hold the wires and the hold the	e/s: operly sh-Pull- ear terminal and replace ed bend rtion and be from left 17 for Wire ee. 129 for Pull-	

			WORK IN	Effectivity Date: March 04, 2025  Validity Date: n/a			25		
		Process Name/Title:	TAPI						
		Model code/Part number:	311D/400D / 75S834-70	51 Customer: TRJ	Car Model: TOYOTA-RAV 4/BZ4X	Document No.:	WI-ENG-PDE-1152		
		Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	2	Page No.:	14 of 18
NO.	I	PROCESS NAME	WORK	TOOLS/PPE	TOOLS/PPE QUALITY POINTE  1. Use provided jig per model				
PARTS:	1. Assy	·	work		JIG:	1. Insertion jig			
			Proper alignment of terr	ninal to connector	Improper alignment of term	ninal to connector	<ul><li>2. No wrong usage of parts</li><li>3. One by one insertion</li></ul>		
				4. No wrong insertion 5. No deformed terminal 6. No stuck of terminal tip  Important reminders/Note/s:		e/s:			

Note:

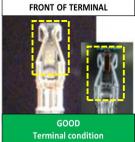
Wire insertion to Connector PBVP-6V-S (W) (Continuation)

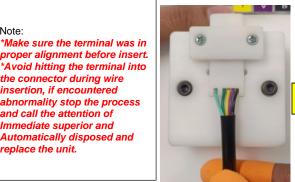
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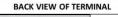
P1



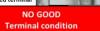














FRONT VIEW OF TERMINAL



**Terminal codition** 

2. Press the upper lock by left hand and hold the assy part by right hand. Check the wire after insertion

- 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 riaht.

## Document reference/s:

- 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.
- 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
- 3. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.



Terminal tip must be visible

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.

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				March 04, 2025					
		Process Name/Title:		TAPING ASSEMBLY PR	Validity Date:	n/a			
	7	Model code/Part number:		5S834-7051 Customer: TRJ	Car Model: TOYOTA-RAV 4/BZ4)	Document No.:		WI-ENG-PDE-1	152
		Purpose:	PROTOTYPE	☐ PRE-LAUNCH	MASSPRO	Revision No.:	2	Page No.:	15 of 18
PARTS:	1. Assy				JIG:	n/a			
NO.	F	PROCESS NAME		WORK PROCEDURE/ ILLUS	TOOLS/PPE	QUALITY POINTERS			
12	P1	Wire folding/ Wire arrangement	Double lock Term	BEFORE FOLDING  Terminal tip is visible  D FACING	Terminal tip is visible	Terminal tip is visible	2. No wror	ng orientation of co ng use of connecto ng terminal facing	nnector

			WORK INS					Effectivity Date:	March 04, 2025				
		Process Name/Title:			MBLY PROC	ESS		Validity Date:	n/a				
		Model code/Part number:	311D/400D / 75S834-705	1 Custom	ner: TRJ	Car Model: TOYO	TA-RAV 4/BZ4X	Document No.:		WI-ENG-PDE-1	152		
		Purpose:	☐ PROTOTYPE	PRE-LAU	JNCH	MASSPRO		Revision No.:	2	Page No.:	16 of 18		
PARTS:	1. Assy 2. Mast	parts er sample						JIG:	n/a				
NO.	F	PROCESS NAME	WORK F	PROCEDU	RE/ ILLUSTRA	ATION		TOOLS/PPE	(	QUALITY POINTERS			
<b>NO.</b>	P1	Visual/By Two's Inspection	1. Check the connector lock. Locking of is included to Steering electrical test.  Black SV to ACTUAL PRODUCT	connector  ube (Vinyl)	2. Check the w Make sure no to	wire alignment. tangled wires  White SV to	(not fully inserte terminal.	minal if with backing out d) or no deformed	Docu 1. Refi Steerii	QUALITY POIN  ument reference er to WI-QAD-QA ng Electrical Test  MASTER SAMP	ce/s: C-252		
			Check the orientation of harness.      Compare to <b>Master sample</b> by tapping.		Engineering S	ample							

