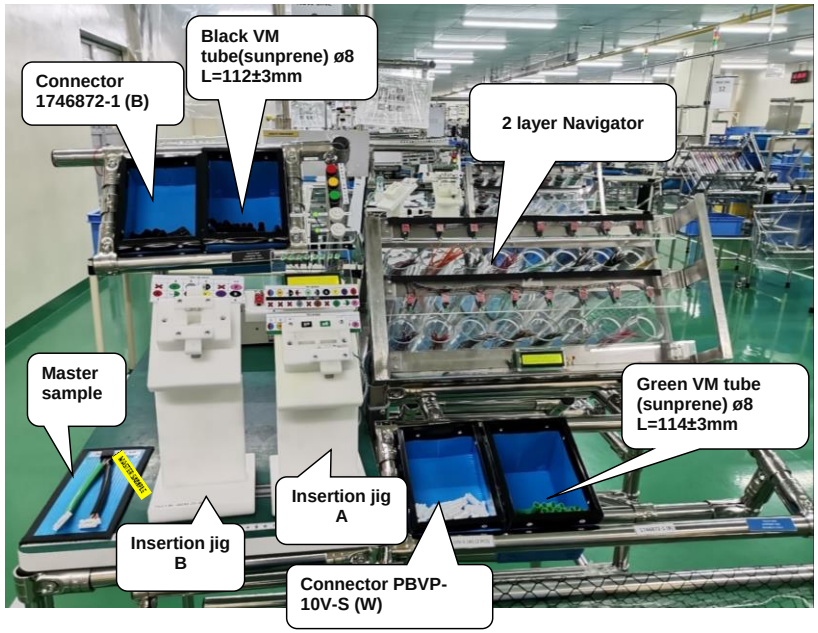
	WORK INSTRUCTION			Effectivity Date:	February 10, 2025	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	February 17, 2025	
	Model code/Part number: 920B / 75S321-0080	Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:	WI-ENG-PDE-556	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	2	Page No.: 1 of 18

PARTS:	1. Connector PBVP-10V-S (W); 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; Black VM tube (Sunprene) ø8 L=112±3mm; AVSS 0.3 P L=156±2mm; W/G L=156±2mm; G L=156±2mm; BR L=156±2mm; GR L=156±2mm;Green VM tube (sunprene) ø8 L=114±3mm	JIG:	1. Insertion jig 2. Steering Navigation

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	Table Lay-out	**TABLE LAY-OUT**  	**Safety Instruction** Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) **Housekeeping** 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. **Alert level** For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	1. No deformed terminal 2. No wrong usage of parts

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
02/10/25	2	Improved insertion jig; Change connector (PBVP-10V-S) orientation, terminal orientation and color sequence as customer claim countermeasure. Inclusion of Table lay-out. Change document number of Steering Electrical test (WI-QAD-QAC-252).	D. Castillo	C. Villanueva	A. Arañes	n/a
11/15/22	1	Improve quality pointers: Reminders/notes, work procedure/illustration ands references in process in all process as document improvement. Work procedure/illustration in process no.12 - visual/by two's inspection	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
07/06/22	0	Initial issue.	M. Catapang	C. Villanueva	A. Arañes	n/a

Prepared by	Reviewed by	Approved by	Noted by
D. Castillo	C. Villanueva	A. Arañes	n/a
Est. Date:	July 06, 2022		

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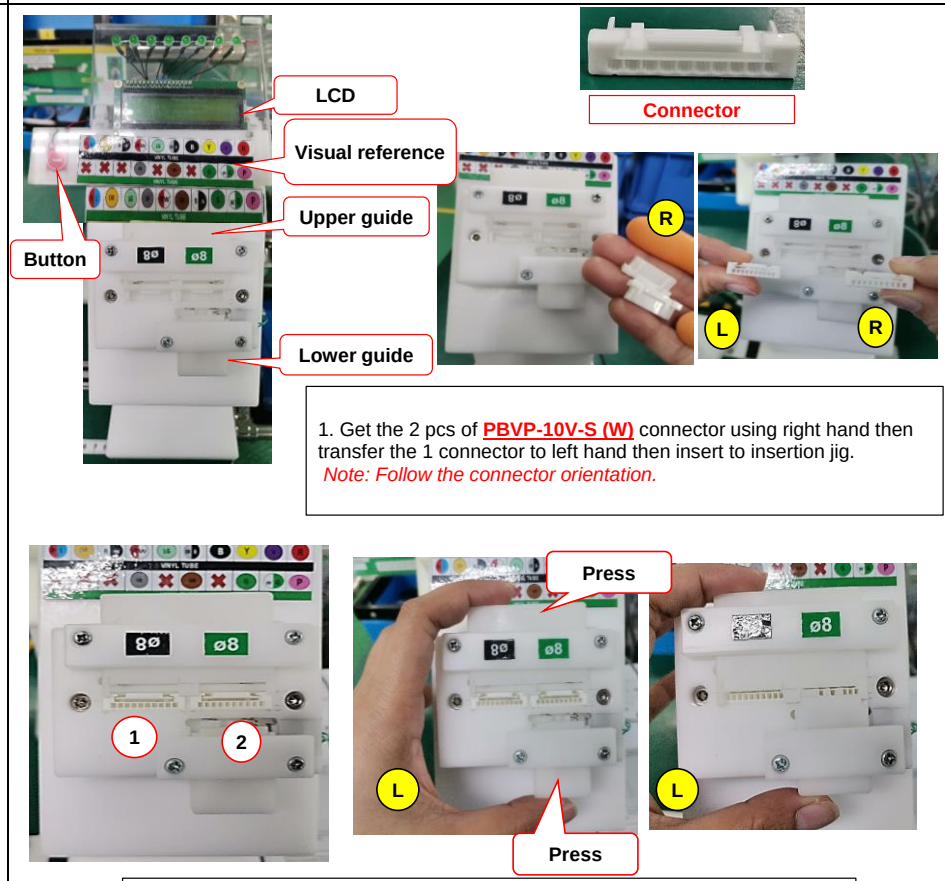
	WORK INSTRUCTION			Effectivity Date:	February 10, 2025	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	February 17, 2025	
	Model code/Part number: 920B / 75S321-0080	Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:	WI-ENG-PDE-556	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	2	Page No.: 2 of 18

PARTS:	1. Connector PBVP-10V-S (W) [2pcs.]			JIG:	1. Insertion jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
2	P1	Connector setting to insertion jig PBVP-10V-S (W)		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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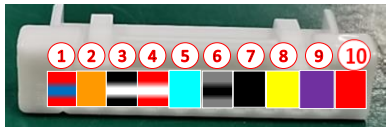
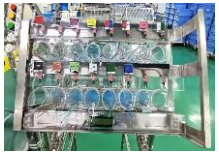
	WORK INSTRUCTION			Effectivity Date:	February 10, 2025	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	February 17, 2025	
	Model code/Part number: 920B / 75S321-0080	Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:	WI-ENG-PDE-556	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	2	Page No.: 3 of 18

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 (2)	Wire insertion to Connector PBVP-10V-S (W)	**INSERTION SEQUENCE FROM LEFT TO RIGHT** **Wire facing**  1 R/L 285; 2 OR 285; 3 B/W 285; 4 R/W 285; 5 LG 285; 6 GR/B 154; 7 B 154; 8 Y 154; 9 V 154; 10 R 154 1. Get the **R/L wire** using right hand and insert to connector. Repeat the process for **OR-B/W-R/W-LG-GR/B-B-Y-V-R wires.** ***Note: Follow the insertion sequence based on the illustration.***	**STEERING NAVIGATION(2 layer)**  **CONTROLLER** 	1. Use provided jig per model 2. No wrong usage of parts 3. One by one insertion 4. No wrong insertion 5. No deformed terminal 6. No stuck of terminal tip ***Important reminders/Note/s:*** *1. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion.* *Do not exert extra force.* *2. Please hold the wire near terminal during insertion.* *3. Follow the insertion sequence based on the illustration.* ***Document references:*** *1. Refer to **GL-PRO-ASY-029** for Pull-Push procedure.* *2. Refer to **WI-ENG-PDE-044** for Steering Navigation Controller procedure.*
4		Wire insertion to Black VM tube (sunprene) ø8 L=112±3mm	 1. Get the **Black VM tube (Sunprene) ø8 L=112±3mm** using right hand. Hold the wires using left hand and insert the wires using right hand.	N/A	1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires

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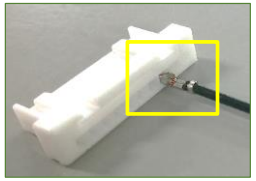
PARTS:	1. AVSS 0.3 R L=154±2mm; V L=154±2mm; Y L=154±2mm; B L=154±2mm; GR/B L=154±2mm; LG L=285±2mm; R/W L=285±2mm; B/W L=285±2mm; OR L=285±2mm; R/L L=285±2mm;	JIG:	1. Insertion jig

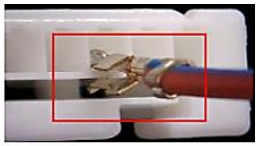
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1	Wire insertion to connector PBVP-10V-S (W) (Continuation)			1. Use provided jig per model 2. No wrong usage of parts 3. No wrong insertion 4. No deformed terminal 5. No stuck of terminal tip 6. One by one insertion

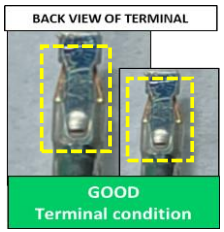
2

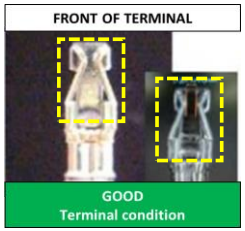
Proper alignment of terminal to connector

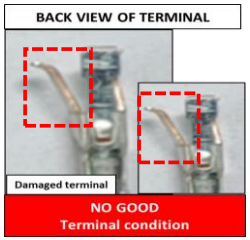


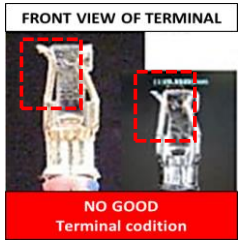
Improper alignment of terminal to connector











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.

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.

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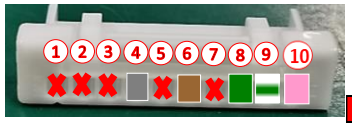
PARTS:	1. AVSS 0.3 P L=156±2mm; W/G L=156±2mm; G L=156±2mm; BR L=156±2mm; GR L=156±2mm;	JIG:	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	2 P1	Wire insertion to Connector PBVP-10V-S (W)			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

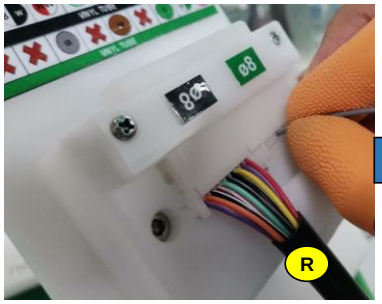
INSERTION SEQUENCE FROM LEFT

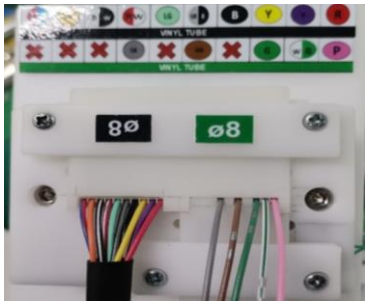


Wire facing

1	2	3	4	5	6	7	8	9	10
X	X	X	GR 156	X	BR 156	X	G 156	W/G 156	P 156

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





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

Note: Follow the insertion sequence based on the illustration.

STEERING NAVIGATION(2 layer)

CONTROLLER

Important reminders/Note/s:

1. Please hold the wire near terminal during insertion.

*2. Refer to **GL-PRO-ASY-029** for Pull-Push procedure.*

*3. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion.*
Do not exert extra force.

4. Follow the insertion sequence based on the above illustration.

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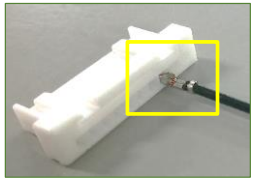
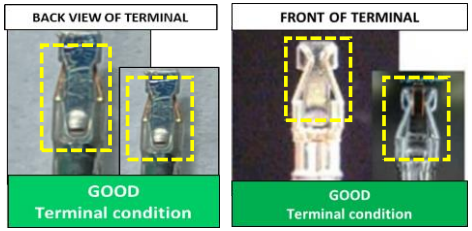
PARTS:	1. AVSS 0.3 P L=156±2mm; W/G L=156±2mm; G L=156±2mm; BR L=156±2mm; GR L=156±2mm;	JIG:	1. Insertion jig

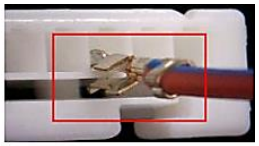
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	△2 P1	Wire insertion to connector PBVP-10V-S (W) (Continuation)			1. Use provided jig per model 2. No wrong usage of parts 3. No wrong insertion 4. No deformed terminal 5. No stuck of terminal tip 6. One by one insertion

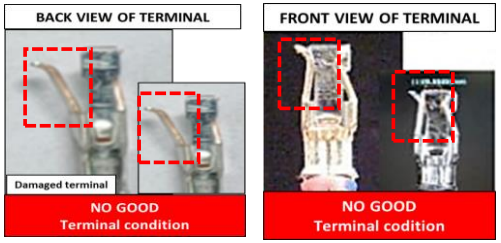
Proper alignment of terminal to connector





Improper alignment of terminal to connector





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.

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.

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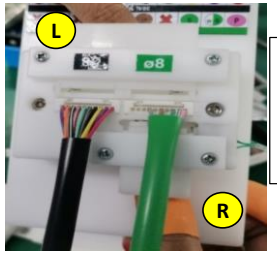
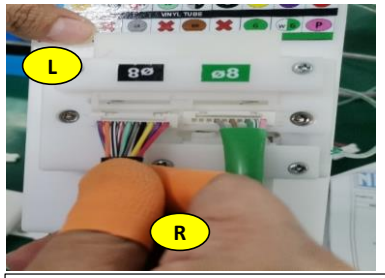
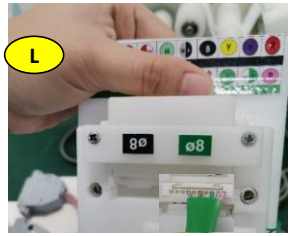
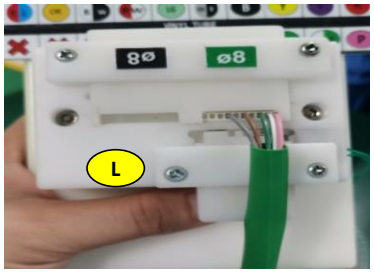
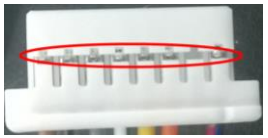
	WORK INSTRUCTION			Effectivity Date:	February 10, 2025	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	February 17, 2025	
	Model code/Part number: 920B / 75S321-0080	Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:	WI-ENG-PDE-556	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	2	Page No.: 7 of 18

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	2 P1	Wire insertion to Green VM tube (sunprene) ø8 L=114±3mm	 1. Get the **Green VM tube (Sunprene) ø8 L=114±3mm** using right hand. Hold the wire using left hand then insert the wires.  2. Press the Upper and lower guide button using left and right hand.   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.  4. Press the lower button using left hand. Holes that need to be inserted are only open.	N/A	1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires  **Terminal tip must be visible** ***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.*

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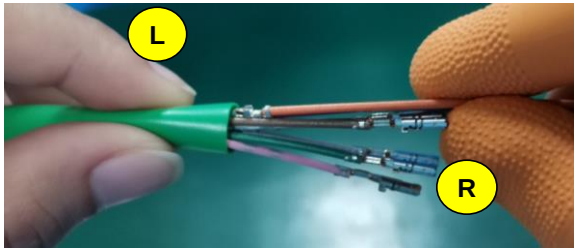
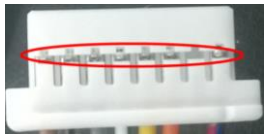
PARTS:	1. Assy parts 2. Green VM tube (sunprene) ø8 L=114±3mm	JIG:	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P1	Wire insertion to assy parts	 1. Hold the **Green VM tube (Sunprene)** using left hand and insert the wires from **Black VM tube (Sunprene)** using right hand. 	N/A	1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires  **Terminal tip must be visible** ***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.*

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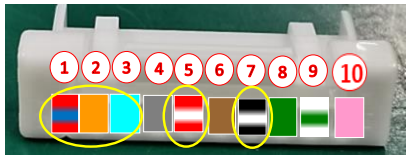
PARTS:	1. Assy parts	JIG:	1. Insertion jig

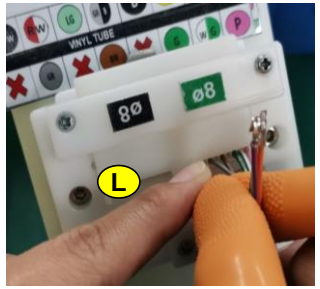
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	P1	Wire insertion to Connector PBVP-10V-S (W)			

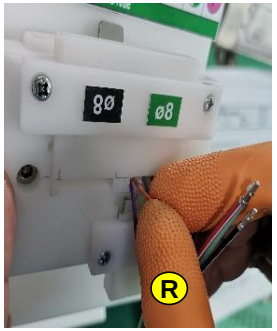
WIRE INSERTION ILLUSTRATION



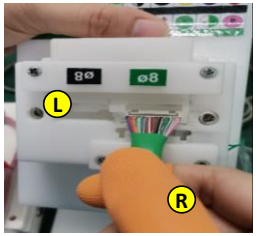
1	2	3	4	5	6	7	8	9	10
R/L	OR	LG	GR	R/W	BR	B/W	G	W/G	P
285	285	285	156	285	156	285	156	156	156

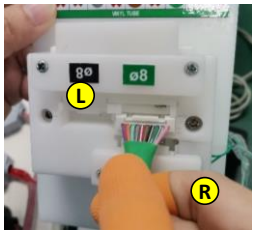
Wire facing





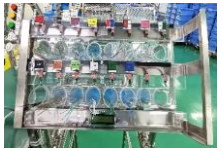
2. Hold the **R/L wire** using right hand and support the wire by left index finger then insert to connector using right hand. Repeat the process on **OR-LG-R/W-B/W wires**. Check the wire after insertion
Note: Follow the insertion sequence based on the above illustration.





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

STEERING NAVIGATION(2 layer)

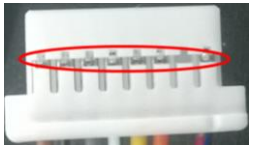


CONTROLLER

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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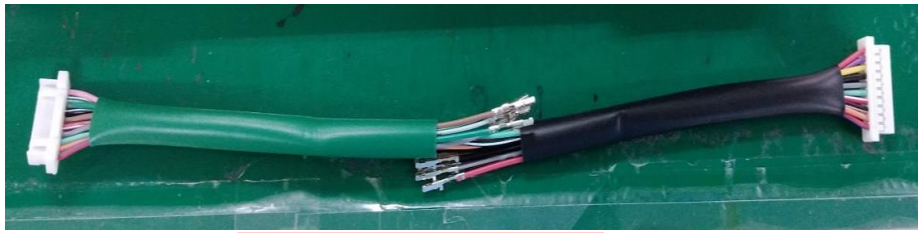
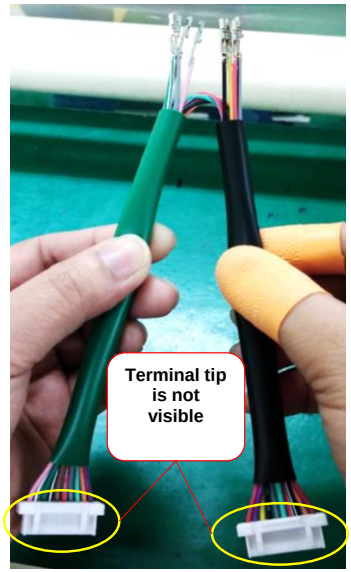
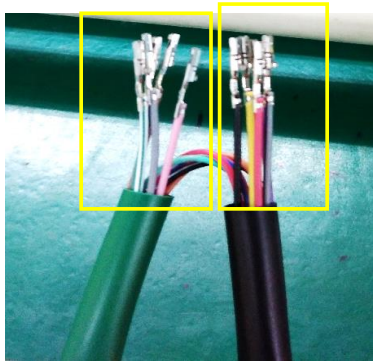
PARTS:	1. Assy parts	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
11	P1	Wire arrangement	 BEFORE FOLDING   1. Hold the assy parts using both hands then conduct wire arrangement.	N/A	1. No deformed terminals 2. No tangled wires 3. No wrong facing

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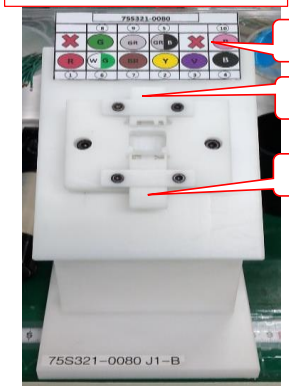
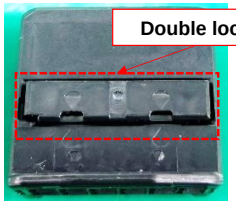
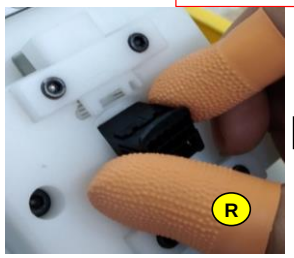
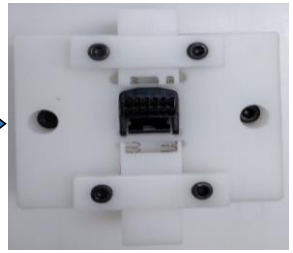
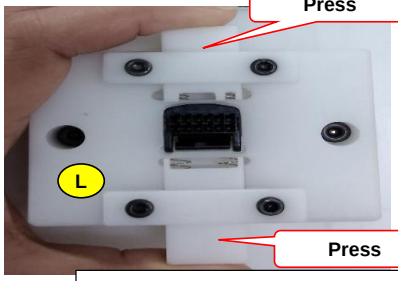
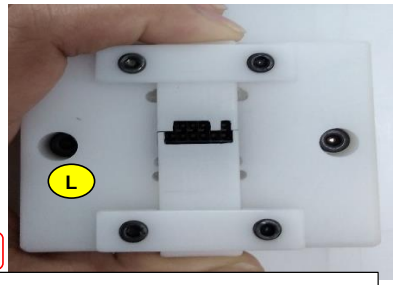
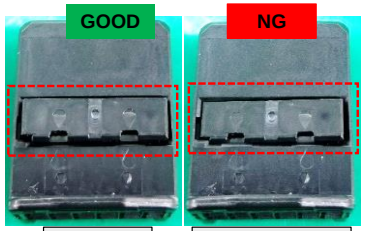
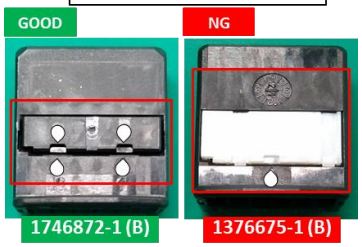
	WORK INSTRUCTION			Effectivity Date:	February 10, 2025	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	February 17, 2025	
	Model code/Part number: 920B / 75S321-0080	Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:	WI-ENG-PDE-556	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	2	Page No.: 11 of 18

PARTS:	1. Connector 1746872-1 (B)	JIG:	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
12	P1	Connector setting to insertion jig 1746872-1 (B)	INSERTION JIG   Note: Check the connector before insertion. CONNECTOR   1. Get the connector **1746872-1 (B)** and insert to insertion jig using right hand. *Note: Follow the connector orientation*   2. Press the upper and lower guide (same timing) using left hand. Holes that need to be insert are only open.	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 CONNECTOR LOCK APPEARANCE CHECK  UNLOCK HALF-LOCKED CONNECTOR ILLUSTRATION  ***Important reminders/Note/s:*** *1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.* *2. Follow the connector orientation* *3. Check the connector before insertion.*

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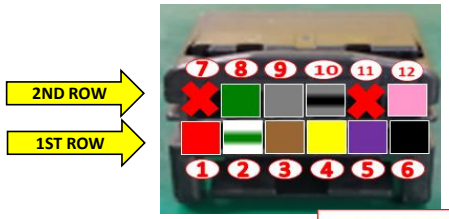
PARTS:	1. Assy parts	JIG:	Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
13	P1	Connector setting to insertion jig 1746872-1 (B)		N/A	

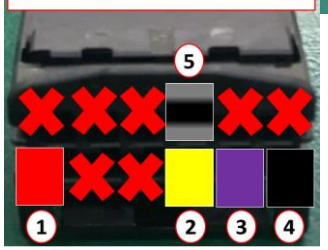
INSERTION SEQUENCE FROM LEFT TO RIGHT



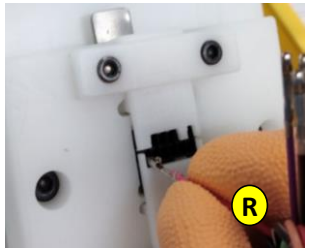
WIRE INSERTION ILLUSTRATION

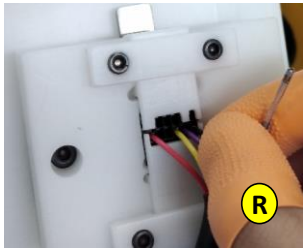
7	8	9	10	11	12
X	G	GR	GR/B	X	P
	156	156	154		156
1	2	3	4	5	6
R	W/G	BR	Y	V	B
154	156	156	154	154	154

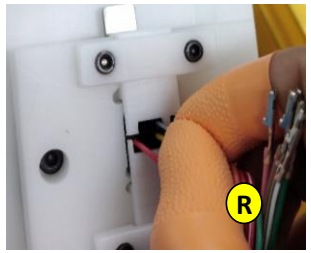
BLACK SUNPRENE TUBE



Wire facing







1. Insert first the wires from **Black Sunprene tube.** Hold the **R wire** and insert to terminal slot 1 using right hand. Repeat the process for **V-Y-B wires**.
Note: Follow the insertion sequence based on the illustration stated above.

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

QUALITY POINTERS

1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

Important reminders/Note/s:

1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.

*2. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push after insertion.***
Do not exert extra force.

3. Please hold the wire near terminal during insertion.

4. Follow the insertion sequence based on the illustration stated above.

Document references:

*1. Refer to **GL-PRO-ASY-029** for Pull-Push procedure.*

*2. Refer to **WI-PRO-CNC-017** for Wire and Strip Length Tolerance*

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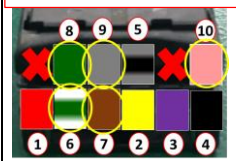
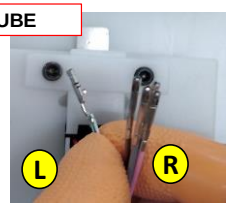
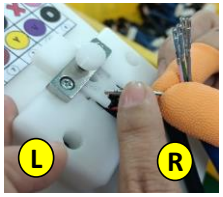
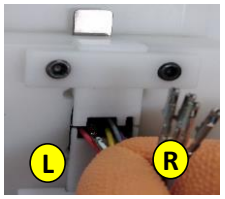
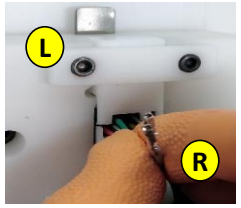
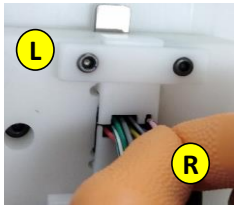
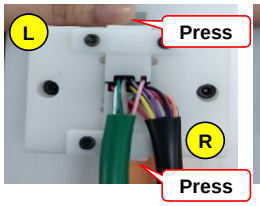
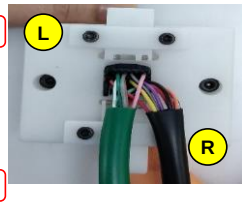
PARTS:	1. Assy parts	JIG:	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
14	P1	Wire insertion to Connector 1746872-1 (B) (Continuation)	GREEN SUNPRENE TUBE     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.** *Note: Follow the insertion sequence based on the above illustration.*   4. Hold the **G wire** and insert to terminal slot 8 using right hand. Repeat the process for **GR-P wire**. *Note: Follow the insertion sequence based on the illustration.*   5. Press the upper and lower lever guide (same timing) using both hands. 6. Remove the assy parts using right hand.	N/A	1. Use provided jig per model 2. No wrong usage of parts 3. One by one insertion 4. No wrong insertion 5. No deformed terminal 6. No stuck of terminal tip ***Important reminders/Note/s:*** *1. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push after insertion.** Do not exert extra force.* *2. Please hold the wire near terminal during insertion.* *3. Follow the insertion sequence based on the above illustration.* ***Document references:*** *1. Refer to **GL-PRO-ASY-029** for Pull-Push procedure.*

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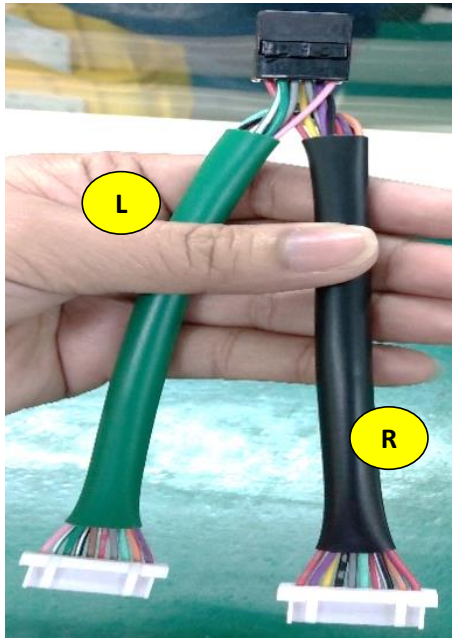
PARTS:	1. Assy parts	JIG:	n/a

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

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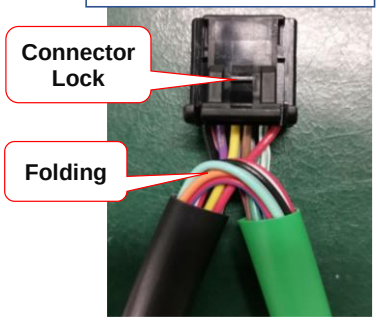
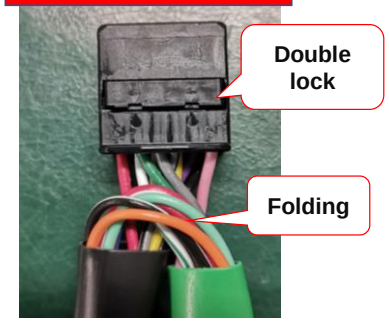
PARTS:	1. Assy parts	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
15	P1	Harness arrangement (Continuation)	 GOOD FACING  NG FACING 	n/a	1. No wrong orientation of connector 2. No tangled wires 3. No wrong wire folding

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PARTS:	1. Assy parts 2. Master sample	JIG:	n/a

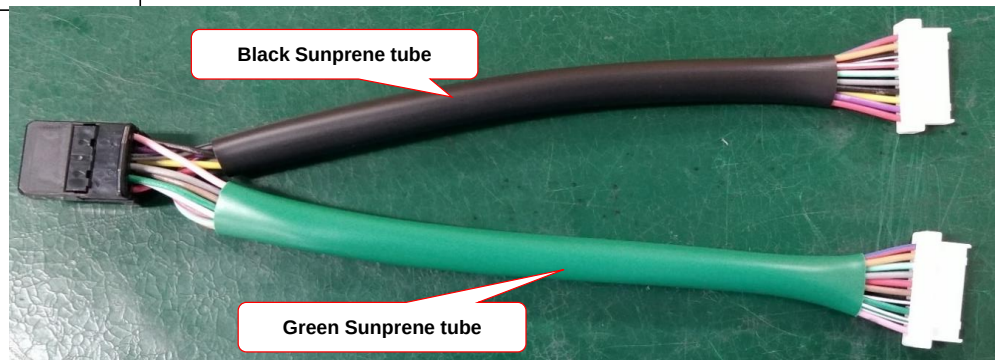
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
16	P1	Visual/By Two's Inspection			

1. Check the connector lock, locking of connector is included in Steering electrical test.

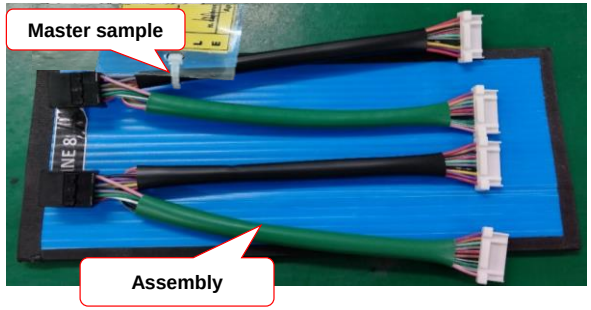
2. Check the wire alignment. Make dure no tangled wires.

3. Check the terminal if with backing -out(Or not fully inserted) no deformed terminal.

4. Check the orientation of harness.



5. Compare to **Master sample** by tapping.



2

Document References:

1. Refer to WI-QAD-QAC-252 for Steering Electrical Test after assembly.

MASTER SAMPLE

1. No wrong facing of harness
2. No Tangled wires
3. No missing parts

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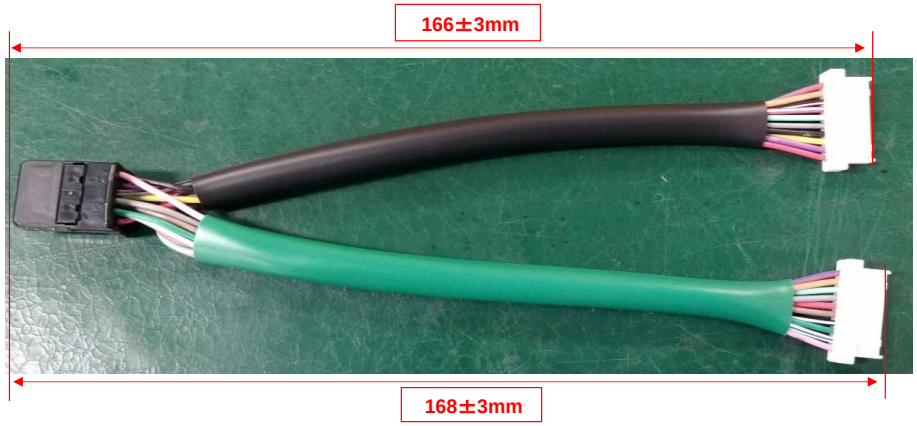
PARTS:	1. Assy parts	JIG:	n/a

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

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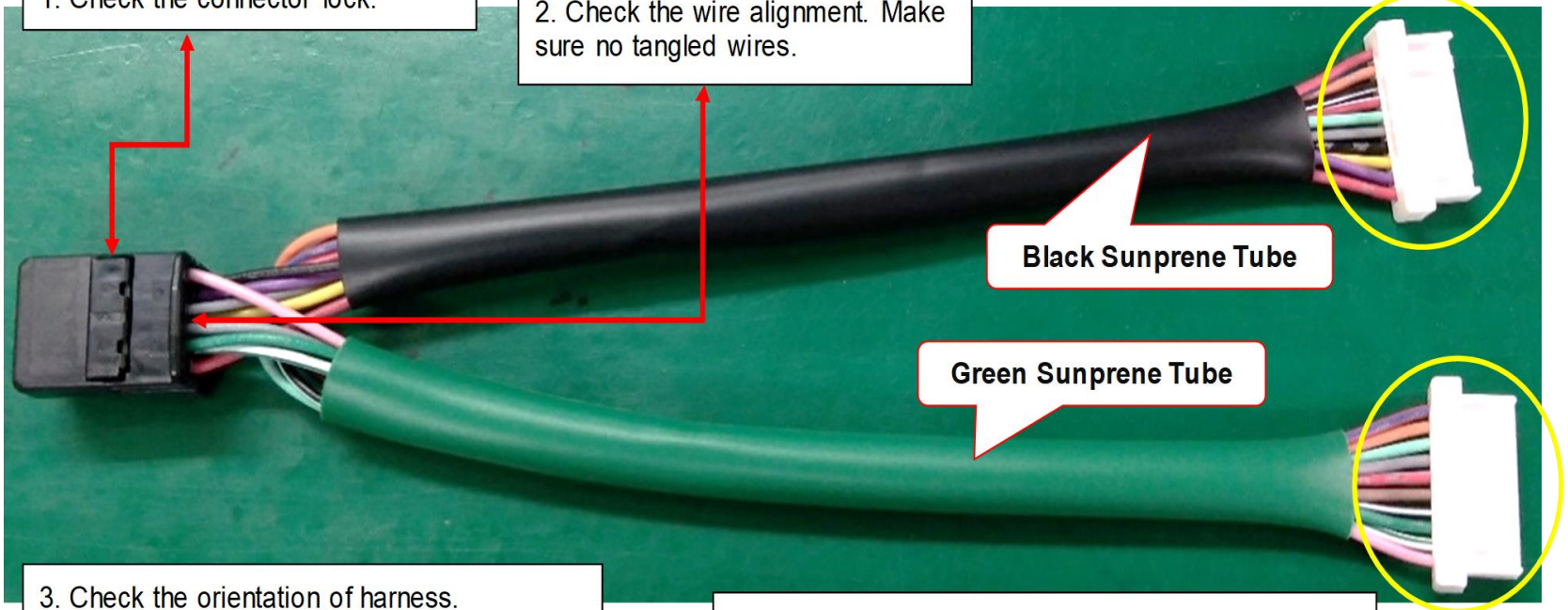
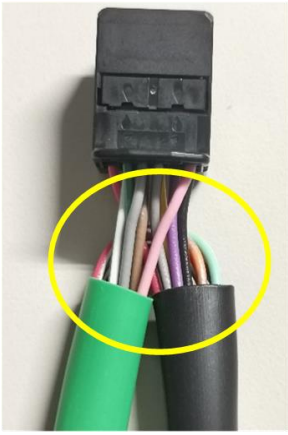
PARTS:	n/a	JIG:	n/a

QUALITY CHECKPOINTS

P1 — 75S321-0080





FOLDED WIRES MUST BE IN BACK POSITION

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