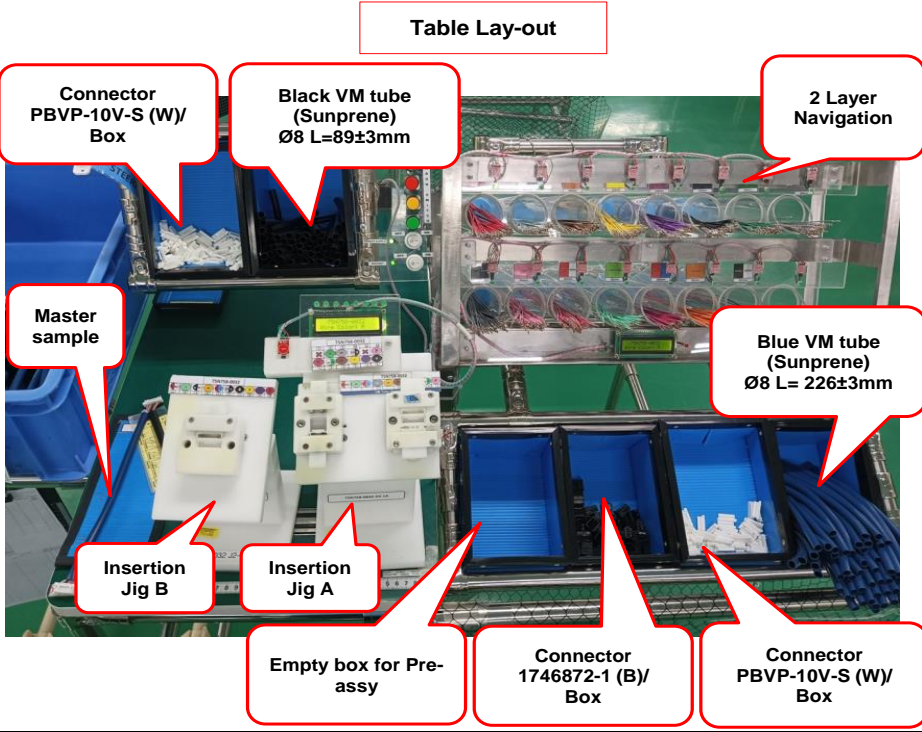
	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>January 14, 2025</b>		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>700B / 75N758-0032</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-LAND CRUISER</b>	Document No.:	<b>WI-ENG-PDE-170</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	8	Page No.:	1 of 18

<b>PARTS:</b>	1. Connector 1746872-1 (B); Connector PBVP-10V-S (W); AVSS 0.3 R L=124±2mm; W/G L=344±2mm; BR L=344±2mm; Y L=124±1mm; V L=124±1mm; B L=124±2mm; G L=344±2mm; GR L=344±2mm; GR/B L=124±2mm; P L=344±2mm; 1. Black VM tube (Sunprene) Ø8 L=89±3mm; AVSS 0.3 B/W L=262±2mm; OR L=262±2mm; R/L L=262±2mm; LG L=262±2mm; R/W L=262±2mm; Blue VM tube (Sunprene) Ø8 L=226±3mm; Connector PBVP-10V-S (W)				JIG:	1. Insertion jig 2. Steering Navigator	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
1	P1 Table lay-out			<p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p><b>Document reference/s:</b> 1. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length Tolerance</p> <p>1. No deformed terminal 2. No wrong usage of parts</p>		
Revision History							
01/14/25	8	Inclusion of table lay-out and inclusion of empty box for location of assy parts as countermeasure to customer claim. Improved Work procedure of Measurement.		D. Castillo	C. Villanueva	A. Arañes	n/a
08/15/23	7	Improve work procedure of process 1, procedure 1, from "Get the 1pc connector 1746872-1 (B) using left hand" to "Get the 1pc connector 1746872-1 (B) using right hand ". Change the steering navigation to 2 layers navigation, and gray color controller to white color controller.		A.Hernandez	J. Loterte	C. Villanueva	A. Arañes
07/29/23	6	Change connector, terminal orientation and color sequence, improved the insertion jig as costumer claim countermeasure. Update Work procedue/illustration and quality checkpoints.		D. Castillo	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved	Noted
				Prepared by	Reviewed by	Approved by	Noted by
				D. Castillo	C. Villanueva	A. Arañes	n/a
				Est. Date:	September 21, 2020		

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

January 14, 2025

Validity Date:

n/a

Model code/Part number:

700B / 75N758-0032

Customer:

TRJ

Car Model: TOYOTA-LAND CRUISER

Document No.:

WI-ENG-PDE-170

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


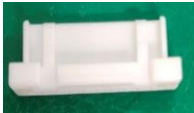


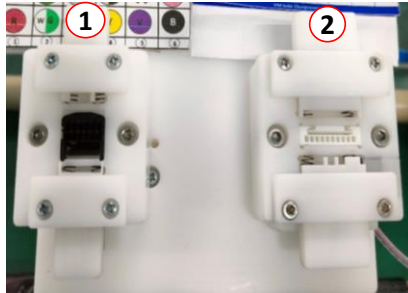


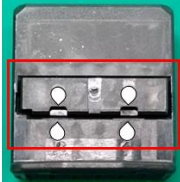


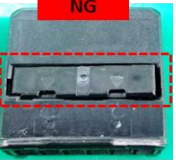
☒ MASSPRO

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PARTS:		1. Connector 1746872-1 (B) 2. Connector PBVP-10V-S (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<div>Connector setting to insertion jig 1746872-1 (B) PBVP-10V-S (W)</div> <div><div><div>Visual reference</div><div>Upper guide lock</div><div>Upper guide</div><div>Lower guide</div><div>Lower guide lock</div></div><div><div>Visual reference</div><div>Upper guide lock</div><div>Upper guide</div><div>Lower guide</div><div>Lower guide lock</div></div><div><div>CONNECTOR ORIENTATION</div><div></div><div></div></div><div><div>1. Get the 1pc connector <b>1746872-1 (B)</b> using right hand and insert to insertion jig and get 1pc of <b>PBVP-10V-S (W)</b> using right hand then insert to insertion jig <i>Note: Follow the connector orientation.</i></div></div><div><div><div><div><div>1</div><div>R</div></div><div><div><div>2</div><div>R</div></div></div><div><div><div>1</div><div>2</div></div></div></div><div><div>INSERTION JIG</div></div></div></div></div>		<div><div>STEERING NAVIGATION(2 layer)</div><div></div></div> <div><div>CONTROLLER</div><div></div></div>	<div><div>1. Use the provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div></div> <div><div><b>Important reminders/Note/s:</b></div><div>1. <b>Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</b></div><div>2. <b>Check the connector before insertion.</b></div></div> <div><div>CONNECTOR ILLUSTRATION</div><div><div><div>GOOD</div><div><div>1746872-1 (B)</div></div><div><div>NG</div><div><div>1376675-1 (B)</div></div></div><div><div><div>GOOD</div><div><div>UNLOCK</div></div><div><div>NG</div><div><div>HALF-LOCKED</div></div></div></div></div></div></div></div>

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**700B / 75N758-0032**

Customer:

**TRJ**Car Model: **TOYOTA-LAND CRUISER**

Document No.:

**WI-ENG-PDE-170**

Purpose:


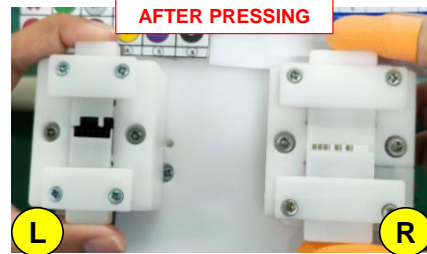
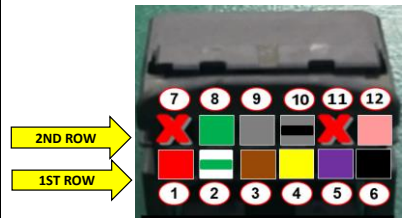




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PARTS:		1. AVSS 0.3 R L=124±2mm; W/G L=344±2mm; BR L=344±2mm; Y L=124±1mm; V L=124±1mm; B L=124±2mm; G L=344±2mm; GR L=344±2mm; GR/B L=124±2mm; P L=344±2mm		JIG:	1. Insertion jig 2. Steering Navigator																													
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS																													
2	P1  Connector setting to insertion jig 1746872-1 (B) PBVP-12V-S (W) (Continuation)	<div><div>BEFORE PRESSING</div><div></div><div>AFTER PRESSING</div><div></div></div> <div>2. Press the upper and lower guide using both hands same timing. Holes that need to be insert are only open.</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																													
3		<div><div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div><div></div><div>BLACK VM TUBE (SUNPRENE)</div><div>FIRST ROW SEQUENCE</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>124</td><td>344</td><td>344</td><td>124</td><td>124</td><td>124</td></tr></table><div></div><div>WIRE FACING</div><div>1. Get the <b>R wire</b> using right hand and insert to connector. Repeat the process for <b>W/G-BR-Y-V-B wires</b>. <b>Note: Follow the insertion sequence based on the illustration.</b></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	124	344	344	124	124	124	<div><div>STEERING NAVIGATION(2 layer)</div><div></div><div>CONTROLLER</div><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																													
124	344	344	124	124	124																													

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## WORK INSTRUCTION

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## TAPING ASSEMBLY PROCESS

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Model code/Part number:

700B / 75N758-0032

Customer: TRJ

Car Model: TOYOTA-LAND CRUISER

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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## PARTS:

1. AVSS 0.3 R L=124±2mm; W/G L=344±2mm; BR L=344±2mm; Y L=124±1mm; V L=124±1mm; B L=124±2mm; G L=344±2mm; GR L=344±2mm; GR/B L=124±2mm; P L=344±2mm

JIG:

1. Insertion jig
2. Steering Navigator

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

## TOOLS/PPE

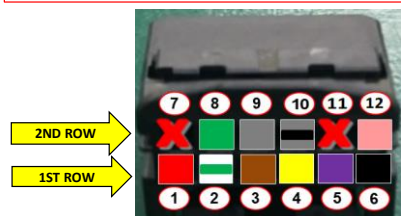
## QUALITY POINTERS

3

P1

Wire insertion to connector 1746872-1 (B) (Continuation)

## INSERTION SEQUENCE FROM LEFT TO RIGHT



BLACK VM TUBE (SUNPRENE)

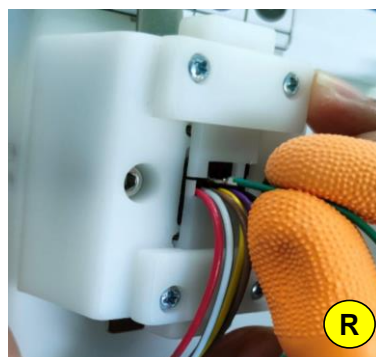
## WIRE INSERTION ILLUSTRATION

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
124	344	344	124	124	124



WIRE FACING

## SECOND ROW SEQUENCE



2. Get the **G** wire using right hand and insert to connector. Repeat the process for **GR-GR/B-P** 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. No wrong insertion
4. No deformed terminal
5. No stuck of terminal tip
6. One by one insertion.

## 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.
3. Automatically dispose and replace the unit if once encountered bend terminal and difficulty of insertion and half locked connector.

## 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
3. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.

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	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>700B / 75N758-0032</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-LAND CRUISER</b>	Document No.:	<b>WI-ENG-PDE-170</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	8	Page No.:	5 of 18

<b>PARTS:</b>	1. Black VM tube (Sunprene) Ø8 L=89±3mm			JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
4	P1	<div><div><p>1. Hold the wires using left hand, get the <b>Black VM tube (Sunprene) Ø8 L=89±3mm</b> using right hand then insert the long wires using left hand.</p></div><div><div><p><b>BEFORE PRESSING</b> <b>AFTER PRESSING</b></p><p>2. Press the upper and lower guide lock with both hands (<b>same timing</b>). Hold the wires using right hand and gently pull out the connector from jig then set aside. <b>Note: Please see above illustration</b></p><p>3. After removal to insertion jig, put the assy parts to empty box. <b>Note: Follow the illustration.</b></p></div><div><p>8</p><p>Assy parts</p></div></div></div>		N/A	<div>1. No wrong use of parts 2. No damaged connector</div> <div><b>Important reminders/Note/s:</b> <b>1. Wires must be offset with each other.</b></div> <div><p>GOOD</p><p>NG</p></div>

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## PARTS:

1. AVSS 0.3 B/W L=262±2mm; OR L=262±2mm; R/L L=262±2mm; LG L=262±2mm; R/W L=262±2mm

JIG:

1. Insertion jig
2. Steering Navigator

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

## TOOLS/PPE

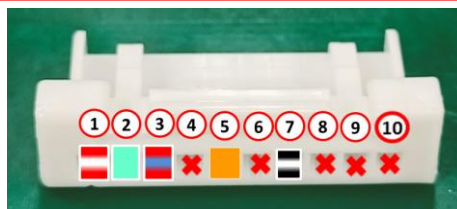
## QUALITY POINTERS

5

P1

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

## INSERTION SEQUENCE FROM LEFT TO RIGHT

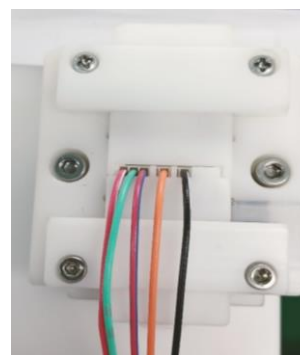
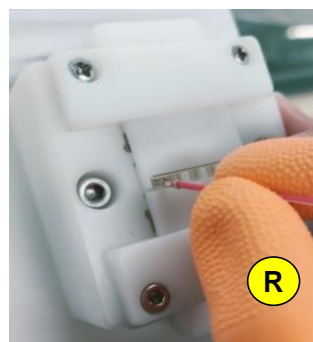


## WIRE FACING



## WIRE INSERTION ILLUSTRATION

1	2	3	4	5	6	7	8	9	10
R/W	LG	R/L	X	OR	X	B/W	X	X	X
262	262	262		262		262			



1. Get the **R/W** wire using right hand then insert to connector. Repeat the process for **LG-R/L-OR-B/W** wires. **Note: Follow the insertion sequence based on above illustration.**

STEERING  
NAVIGATION(2 layer)

## CONTROLLER



## 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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**TAPING ASSEMBLY PROCESS**

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**700B****/ 75N758-0032**Customer: **TRJ**Car Model: **TOYOTA-LAND CRUISER**

Document No.:

**WI-ENG-PDE-170**

Purpose:

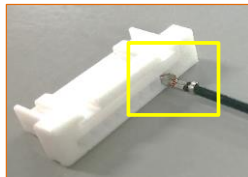
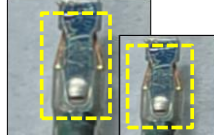

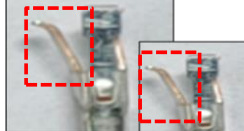


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PARTS:		1. AVSS 0.3 B/W L=262±2mm; OR L=262±2mm; R/L L=262±2mm; LG L=262±2mm; R/W L=262±2mm		JIG:	1. Insertion jig 2. Steering Navigator	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
5	P1	<div>Wire insertion to connector PBVP-10V-S (W) (Continuation)</div> <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>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>Improper alignment of terminal to connector</div><div></div></div><div><div>Note:</div><div><i>*Make sure the terminal was in proper alignment before insert.</i></div><div><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></div> <td></td> <td><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><b>Important reminders/Note/s:</b>  <div>1. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</div><div>2. Please hold the wires near terminal during insertion.</div><div>3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</div><div>4. Insertion of wires must be from left to right.</div></div><div><b>Document reference/s:</b>  <div>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</div><div>2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..</div><div>3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div><div>4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</div></div></td>				<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><b>Important reminders/Note/s:</b>  <div>1. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</div><div>2. Please hold the wires near terminal during insertion.</div><div>3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</div><div>4. Insertion of wires must be from left to right.</div></div> <div><b>Document reference/s:</b>  <div>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</div><div>2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..</div><div>3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div><div>4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</div></div>


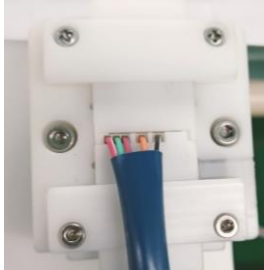
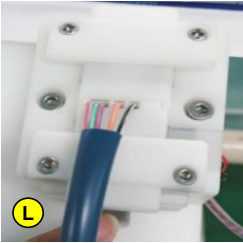
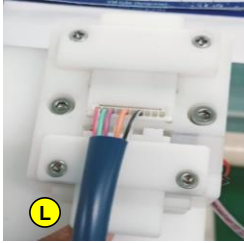
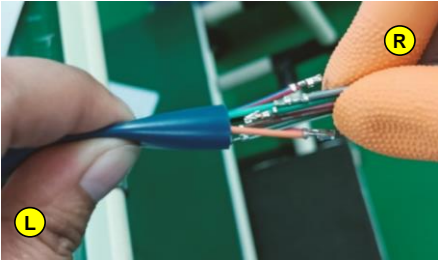

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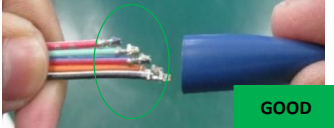
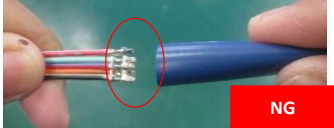
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	<b>WORK INSTRUCTION</b>				Effectivity Date:	January 14, 2025		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>700B / 75N758-0032</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-LAND CRUISER</b>	Document No.:	<b>WI-ENG-PDE-170</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	8	Page No.:	8 of 18


  

<b>PARTS:</b> 1. Blue VM tube (Sunprene) Ø8 L=226±3mm 2. Assy parts		JIG: 1. Insertion jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>
6	Wire insertion to Blue VM tube (Sunprene) Ø8 L=226±3mm	<div>   </div> <p>1. Hold the wires using left hand, get the <b>Blue VM tube (Sunprene) Ø8 L=226±3mm</b> using right hand then insert the wires using left hand.</p> <div>   </div> <p>2. Press the lower guide lock using right hand. Holes that need to be insert are only open.</p>	N/A
7	Wire insertion to Assy parts	<div>   </div> <p>1. Hold the Blue VM tube (Sunprene) using left hand then insert the wires from assembly parts using right hand.</p> <p>Connector facing and position should be on the left side of harness.</p>	N/A

<b>QUALITY POINTERS</b>  1. No wrong usage of parts 2. No deformed terminal  <b>Important reminders/Note/s:</b> <b>1. Wires must be offset with each other.</b>	 
1. No wrong usage of parts 2. No deformed terminal	

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## WORK INSTRUCTION

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## TAPING ASSEMBLY PROCESS

Effectivity Date:

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Model code/Part number:

700B / 75N758-0032

Customer: TRJ

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## PARTS:

1. Assy parts

JIG:

1. Insertion jig
2. Steering Navigator

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

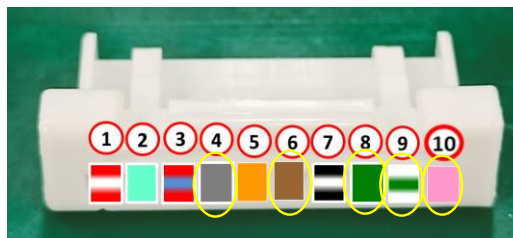
QUALITY POINTERS

8

P1

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

INSERTION SEQUENCE FROM LEFT TO RIGHT

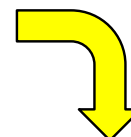
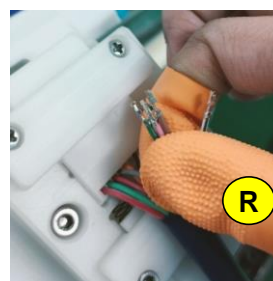
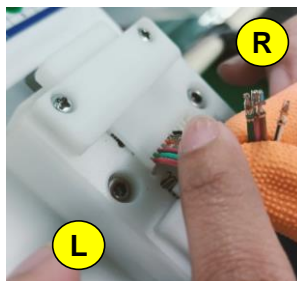


WIRE FACING



WIRE INSERTION ILLUSTRATION

1	2	3	4	5	6	7	8	9	10
R/W	LG	R/L	GR	OR	BR	B/W	G	W/G	P
262	262	262	344	262	344	262	344	344	344



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-R/L-OR-B/W** 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. 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.

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Customer: TRJ

Car Model: TOYOTA-LAND CRUISER

Document No.:

WI-ENG-PDE-170

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

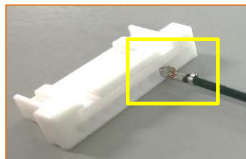
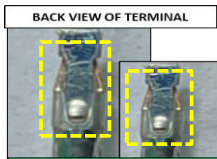
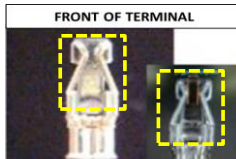

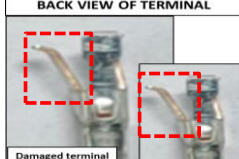
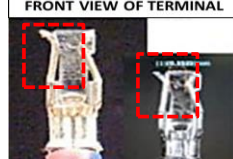
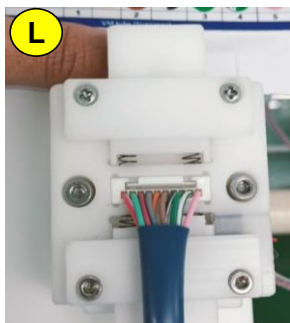
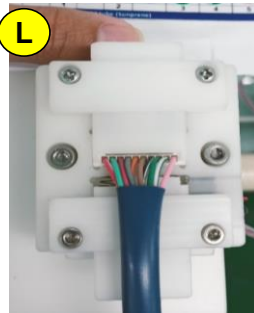


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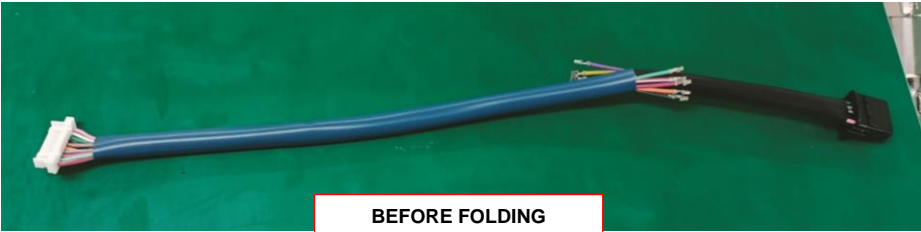
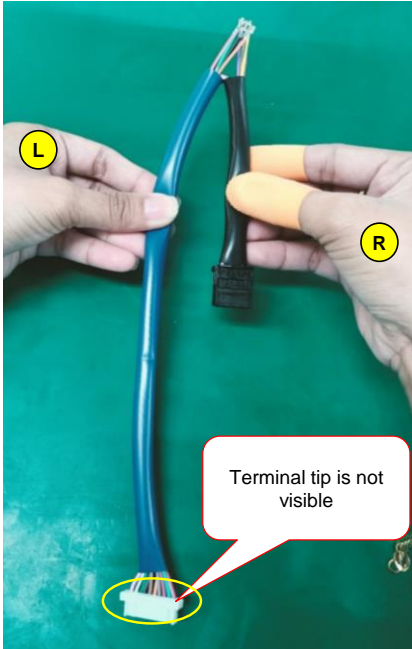
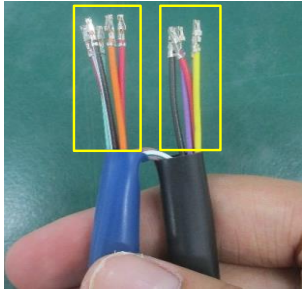
PARTS:	1. Assy parts		JIG:	1. Insertion jig 2. Steering Navigator
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P1  Wire insertion to connector PBVP-10V-S (W) (Continuation)	<div><div>Proper alignment of terminal to connector</div><div></div><div><div>BACK VIEW OF TERMINAL</div><div></div><div>GOOD Terminal condition</div><div>FRONT OF TERMINAL</div><div></div><div>GOOD Terminal condition</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>FRONT VIEW OF TERMINAL</div><div></div><div>NO GOOD Terminal condition</div></div><div>Note: <i>*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.</i></div><div><div><div></div><div>2. Hold the wires using right hand and then press the unlock button using left thumb.</div></div><div><div></div><div>3. Gently pull out the connector from jig then check the terminal tip condition.</div></div></div><div><div></div><div>Terminal tip must be visible.</div></div></div></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 <b>Pull-Push-Pull-Push</b> 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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	WORK INSTRUCTION				Effectivity Date:	January 14, 2025		
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	Model code/Part number: 700B / 75N758-0032		Customer: TRJ	Car Model: TOYOTA-LAND CRUISER	Document No.:	WI-ENG-PDE-170		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	8	Page No.:	11 of 18

PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
9	P1	Wire folding <div><p>BEFORE FOLDING</p><p>AFTER FOLDING</p><p>1. Hold the wires using left and right hand and conduct wire folding.</p></div>	n/a	<p><b>Important reminders/Note/s:</b></p> <p>1. Make sure all 10 wires with terminal are visible and not folded inside the tube.</p> <p>1. No deformed terminals 2. No tangled wires 3. No wrong facing</p>	

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PARTS:	1. Connector PBVP-10V-S (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	P1  Connector setting to insertion jig PVBVP-10V-S (W)	<div><div>Visual reference</div><div>Upper guide lock</div><div>Upper guide</div><div>INSERTION JIG</div></div> <div><div>1. Get the connector <b>PBVP-10V-S (W)</b> and insert to insertion jig using right hand. <i>Note: Follow the connector orientation.</i></div></div> <div><div>BEFORE PRESSING</div></div> <div><div>AFTER PRESSING</div><div>2. Press the upper guide using left hand. You will notice the holes that needs to be inserted are only open.</div></div>	N/A	1. No deformed terminals 2. No tangled wires 3. No wrong facing

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## PARTS:

1. Assy parts

JIG:

1. Insertion jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

## TOOLS/PPE

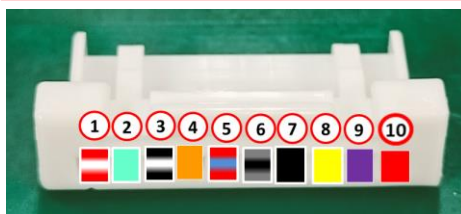
## QUALITY POINTERS

11

P1

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

## INSERTION SEQUENCE FROM LEFT TO RIGHT

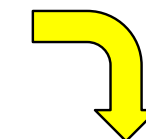
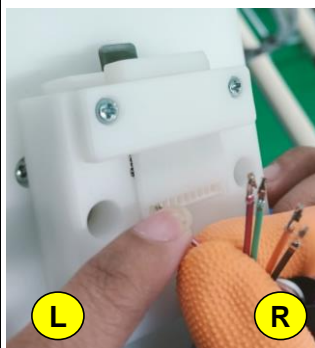


## WIRE FACING



## WIRE INSERTION ILLUSTRATION

1	2	3	4	5	6	7	8	9	10
R/W	LG	B/W	OR	R/L	GR/B	B	Y	V	R
262	262	262	262	262	124	124	124	124	124



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.**

N/A

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:

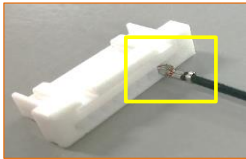
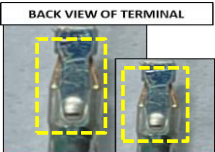
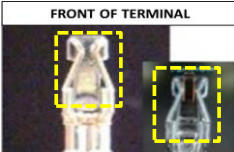

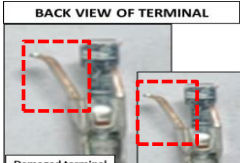
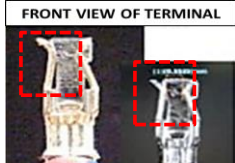

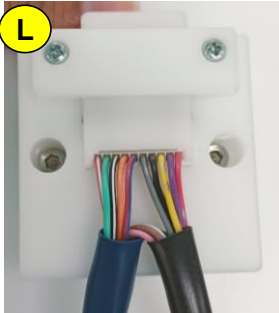

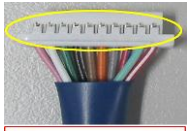
1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
4. . Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.

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	Model code/Part number: <b>700B / 75N758-0032</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-LAND CRUISER</b>	Document No.:	<b>WI-ENG-PDE-170</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	8	Page No.:	14 of 18


<b>PARTS:</b>	1. Assy parts		JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
11	P1  Wire insertion to connector PBVP-10V-S (W) (Continuation)	<div><div>Proper 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> <div><div>Improper alignment of terminal to connector</div><div>BACK VIEW OF TERMINAL</div><div>Damaged terminal NO GOOD Terminal condition</div><div>FRONT VIEW OF TERMINAL</div><div>NO GOOD Terminal condition</div></div> <div><div>Note:</div><div>*Make sure the terminal was in proper alignment before insert.</div><div>*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> <div><div></div><div>2. Hold the wires using right hand and then press the unlock button using left thumb.</div></div> <div><div></div><div>3. Gently pull out the connector from jig then check the terminal tip condition.</div></div>		<div>1. Use provided jig per model</div> <div>2. No wrong usage of parts</div> <div>3. No wrong insertion</div> <div>4. No deformed terminal</div> <div>5. No stuck of terminal tip</div> <div>6. One by one insertion</div> <div>Important reminders/Note/s:</div> <div>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>2. Please hold the wires near terminal during insertion.</div> <div>3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</div> <div>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.</div> <div>2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..</div> <div>3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div> <div>4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</div> <div><div>Terminal tip must be visible.</div></div>


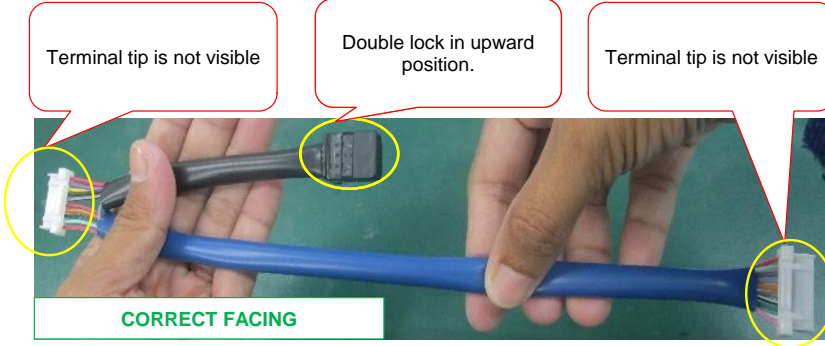
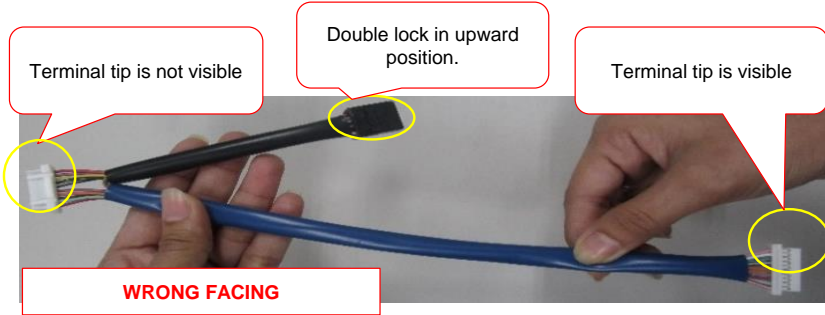
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	Model code/Part number: <b>700B / 75N758-0032</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-LAND CRUISER</b>	Document No.:	<b>WI-ENG-PDE-170</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	8	Page No.:	15 of 18

<b>PARTS:</b>	1. Assy parts			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
12	P1 Wire facing arrangement	<div><div>1. Hold the harness using left and right hand then start to conduct the correct facing.</div><div>CORRECT FACING</div><div>WRONG FACING</div></div>	N/A	<p><b>Important reminders/Note/s:</b></p> <p><b>1. Harness must be straight and not folded.</b></p> <p>1. No wrong facing 2. No tangled wires</p>	

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**700B / 75N758-0032**Customer: **TRJ**Car Model: **TOYOTA-LAND CRUISER**

Document No.:

**WI-ENG-PDE-170**

Purpose:

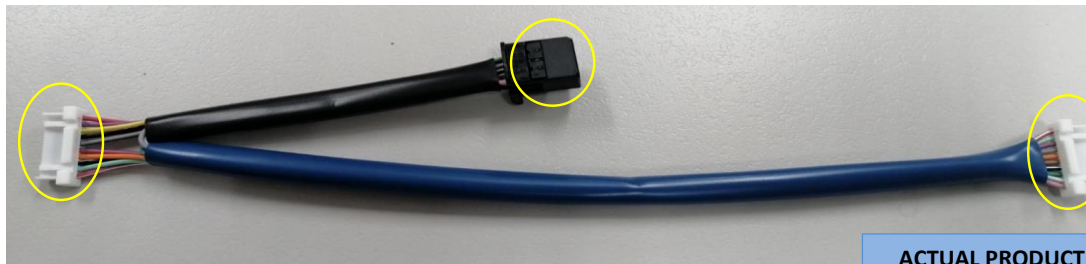

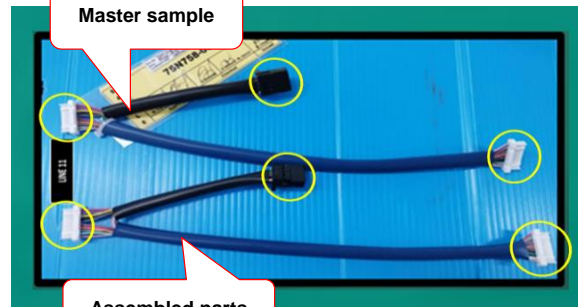

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Master sample		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
13	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 sure no tangled wires.</div> <div>3. Check the terminal if with backing out (not fully inserted) or deformed terminal.</div> <div><div>ACTUAL PRODUCT</div></div> <div><div>4. Check the orientation of harness.</div><div>5. Compare to Master sample by tapping..</div><div><div><div>Master sample</div><div><div>Assembled parts</div></div></div></div></div>	<div>MASTER SAMPLE</div> <div></div> <div>Document reference/s: 1. Refer to <b>WI-QAD-QAC-252</b> Steering Electrical Test</div> <div>1. No wrong facing of harness 2. No Tangled wires 3. No missing parts</div>	

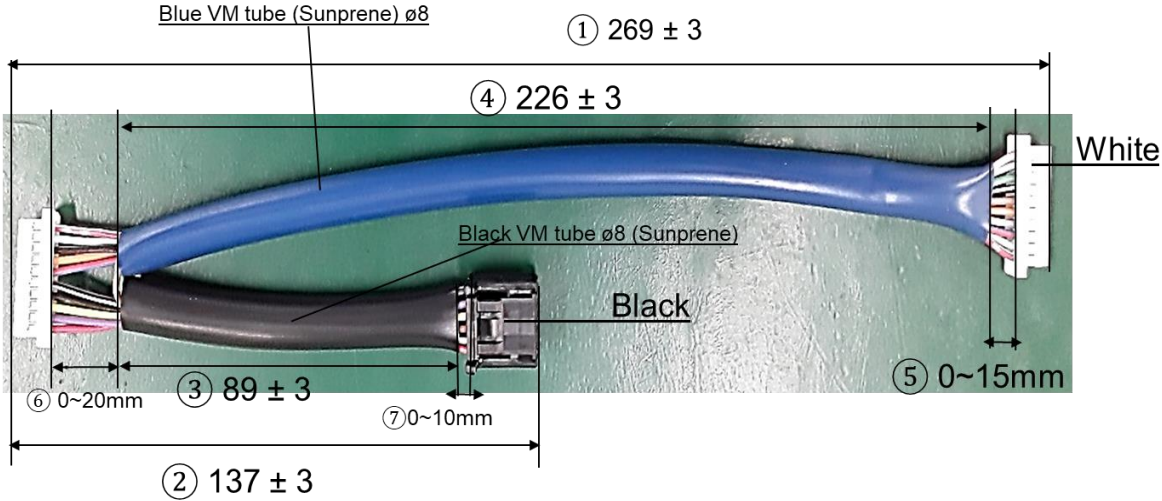

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	<b>WORK INSTRUCTION</b>				Effectivity Date:	January 14, 2025		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>700B / 75N758-0032</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-LAND CRUISER</b>	Document No.:	<b>WI-ENG-PDE-170</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	8	Page No.:	17 of 18

<b>PARTS:</b>	1. Assy parts			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>8</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
14	P1	Measurement	<div><div>MEASURING TAPE</div></div> <div>NOTE: *Unit of dimension is in millimeter (mm)</div>		<p><b>Important reminders and note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono, Nakamono and Owarimono.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</p> <p>1. No wrong dimension.</p>

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Document No.:

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Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

8

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**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

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