PARTS: 1. Connector 1746872-1 (B); BlueVM tube (Supprene) Ø8 L=152±3mm; Black VM tube (Supprene) Ø8 L=162±3mm; Connector PBVP-10V-S (W); AVSS 0.3 Wires OR L=206±2mm; CR/B L=398±2mm; CR/B L	TY POINTERS Perence/s: 10-CNC-017 for Wire and										
PARTS: D. Connector 1746872-1 (B); BlueVM tube (Supprene) Ø8 L=152±3mm; Black VM tube (Supprene) Ø8 L=162±3mm; Connector PBVP-10V-S (W); AVSS 0.3 Wires OR L=206±2mm; WL=202±2mm; GR/B L=398±2mm; CR/B L=398±2mm; CR/B L=398±2mm; CR/B L=398±2mm; VL=190±2mm; VL=1	TY POINTERS Perence/s: 10-CNC-017 for Wire and										
1. Connector 1746872-1 (B); BlueVM tube (Sunprene) Ø8 L=152±3mm; Black VM tube (Sunprene) Ø8 L=146±3mm; Connector PBVP-10V-S (W); AVSS 0.3 Wires OR L=206±2mm; MC L=237±2mm; RV L=237±2mm; RV L=237±2mm; RV L=237±2mm; RV L=237±2mm; RV L=192±2mm; RV L=192±2m	Y POINTERS erence/s: O-CNC-017 for Wire and										
PARTS: Wires OR L=206±2mm; W L=202±2mm; G L=369±2mm; G L=369±2mm; W L=369±2mm; W L=369±2mm; W L=369±2mm; B L=204±2mm; B L=204±2mm NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION Table Lay-out BlueVM tube (Sunprene) (Master sample) Table lay-out Table lay-out Table lay-out Table lay-out P1 Table lay-out Table lay	TY POINTERS Perence/s: 10-CNC-017 for Wire and										
Table Lay-out Connector 1746872-1 (B)/ Box BlueVM tube (Sunprene) Ø8 L=152±3mm Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)	erence/s: O-CNC-017 for Wire and										
Connector 1746872-1 (B)/ Box BlueVM tube (Sunprene) Ø8 L=152±3mm BlueVM tube (Sunprene) Ø8 L=152±3mm Connector 1746872-1 (B)/ Box BlueVM tube (Sunprene) Ø8 L=152±3mm Connector 1746872-1 (B)/ Box BlueVM tube (Sunprene) Ø8 L=152±3mm Connector 1746872-1 (B)/ Box BlueVM tube (Sunprene) Ø8 L=152±3mm Document refer 1. Refer to WI-PR Strip Length Toles (In Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in 1. No deformed termination of the workplace is prohibited. Keep it in 1. No deformed termination of the workplace is prohibited. Keep it in 1. No deformed termination of the workplace is prohibited. Keep it in 1. No deformed termination of the workplace is prohibited. Keep it in 1. No deformed termination of the workplace is prohibited. Keep it in 1. No deformed termination of the workplace is prohibited. Keep it in 1. No deformed termination of the workplace is prohibited. Keep it in 1. No deformed termination of the workplace is prohibited. Keep it in 1. No deformed termination of the workplace is prohibited.	O-CNC-017 for Wire and										
1 P1 Table lay-out Master sample Master sample 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in 1. No deformed termi											
	P1 Table lay-out Master sample Table lay-out 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in 1. No deformed terminal										
Black VM tube (Sunprene) Ø8 L= 146±3mm Insertion Jig A Connector PBVP-10V-S (W)/ Box Relative For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.											
Revision History Prepared by Reviewed by Approved by Noted by											
lmproved insertion jig; Change connector (PBVP-10V-S) orientation, terminal orientation and color sequence as customer claim countermeasure. Inclusion of Table lay-out. Additional method to Wire folding 1 process as countermeasure to damage lance. Improved Measurement and Visual inspection/Quality checkpoints. Change document number of Steering Electrical test (WI-QAD-QAC-252). A. Arañes via lance. Improved Measurement and Visual inspection/Quality checkpoints. Change document number of Steering Electrical villanueva											
02/08/23 2 Standarized the tube descriptions: VM tube (Sunprene). Improve work procedure/illustration. Inclusion of Quality checkpoints M. Ariola J. Loterte C. Villanueva A. Arañes											
03/15/22 1 Change from Pre-launch to Masspro. Merge P1 and P2 due to the process Improvement. Improve work Procedure/Illustration. M. Ariola J. Loterte C. Villanueva A. Arañes D. Castillo C. Villanueva A. A											
Eff. Date Rev. No Details of Change Revised Reviewed Approved Noted st. Date: November 11, 2021	rañes n/a										

			WORK IN		Effectivity Date:		February 13, 202	25	
		Process Name/Title:	TAPIN	NG ASSEMBLY PROC		Validity Date:		n/a	
		Model code/Part number:	177D / 75S137-0050	Customer: TRJ	Car Model: TOYOTA-COROLLA	Document No.:		WI-ENG-PDE-3	69
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	3	Page No.:	2 of 18
PARTS:	1. Conn	ector PBVP-10V-S (W) [2pcs]			JIG:	Insertion Steering	jig Navigation	
NO.	F	PROCESS NAME	WORK	PROCEDURE/ ILLUSTR	ATION	TOOLS/PPE	(QUALITY POIN	TERS
2	P1	Connector setting to insertion jig PBVP-10V-S (W)	1 2 Lower guide INSERTION JIG	1. Get the 2pcs of PBVP-	2. Press the upper and lower guide lock (same timing) using left hands	STEERING NAVIGATION (2 layer) CONTROLLER	No wronNo wron	provided jig per m ig usage of parts ig orientation of co aged connector	

					WOF	RK INSTE	RUCTION	1					Effectivity Date:		February 13, 202	25
		Process Name/Title:			7	APING	ASSEN	IBLY P	ROCES	S			Validity Date:		n/a	
		Model code/Part number:	17	7D / 759	3137-00	50	Custom	er: TR	J Ca	ır Model: 1	ОҮОТА-	COROLLA	Document No.:		WI-ENG-PDE-3	69
		Purpose:	☐ PRO	TOTYPE] PRE-LAU	NCH		MASSPR)		Revision No.:	3	Page No.:	3 of 18
PARTS:		S 0.3 Wires OR L=206±2mm; 2mm; R/W L=365±2mm; BR L		nm; GR/B L=	=369±2mm	; G L=200±2	2mm; R/L l	.=371±2mr	n; GR L=19	96±2mm; W	//G L=373±2	2mm; L	JIG:	Insertion Steering		
NO.	F	PROCESS NAME			W	ORK PR	OCEDUI	RE/ ILLU	STRATI	ON			TOOLS/PPE	(QUALITY POIN	TERS
		3	1	ON SEQUE	5 6	78	9 10 W OR	Monne	IRE INS	ERTION		MINAL	STEERING NAVIGATION (2 layer)	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 wires near terminal		operly
			1	2	3	4	5	6	7	8	9	10		2. Please hold the wires near termina		
			BR R/W L 371 365 192			W/G	GR	R/L	G	GR/B	W	OR		during insertion. 3. Automatically dispose and replace		
3	P1	Wire insertion to Connector PBVP-10V-S (W)	1. Get the R/L, G, G	BR wire unitable. When the installation in the	sing right	. Check th	insert to c	er insertio	n	a 369	202	206 W/G, GR,	CONTROLLER	the unit iterminal, half-lock 4. Insertito right. Documed 1. Refer and Strip 2. Refer Steering procedul 3. Refer units pecticinsertion	if once encounter, difficulty of inselect connector. If on of wires must not reference/s: to WI-PRO-CNC-00 Length Tolerance to WI-ENG-PDE-0. Navigation Contres. to GL-PRO-ASY-00 ocedure. to GL-PRO-ASY-0 on Standard for ce	ed bend tion and be from left 17 for Wire e. 44 for oller 29 for Pull- 25 for onnector

WORK INSTRUCTION Effectivity Date: February 13, 2025										
		Process Name/Title:		NG ASSEMBLY PRO	CESS	Validity Date:		n/a	<u> </u>	
		Model code/Part number:	177D / 75S137-0050	Customer: TRJ	Car Model: TOYOTA-COROLLA	Document No.:		WI-ENG-PDE-36	69	
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	■ MASSPRO	Revision No.:	3	Page No.:	4 of 18	
PARTS:		S 0.3 Wires OR L=206±2mm; 2mm; R/W L=365±2mm; BR L	W L=202±2mm; GR/B L=369±2mm; G L=2 =371±2mm	200±2mm; R/L L=371±2mm; GF	R L=196±2mm; W/G L=373±2mm; L	JIG:	Insertion Steering			
NO.	ı	PROCESS NAME	WORK	PROCEDURE/ ILLUSTE	RATION	TOOLS/PPE	(QUALITY POINT	ſERS	
3	P1	Wire insertion to Connector PBVP-10V-S (W) (Continuation)		FRONT OF TERMINAL GOOD Terminal condition in proper alignment be to the connector during	Damaged terminal NO GOOD Terminal condition	NO GOOD Terminal codition	2. No wron 3. One by 4. No wron 5. No defo 6. No stuck 1. Make inserted Push aft Do not e 2. Please terminal 3. Auton replace e encount difficulty locked c 4. Insert left to rig Docume 1. Refer i Wire and 2. Refer i Steering procedu 3. Refer i 9. Vill-Pus 4. Refer i Inspectic	rmed terminal k of terminal tip of terminal ti	e/s: coperly csh-Pull- ear and al, half- be from 17 for erance. 44 for oller	

		Т	WORK ING	TELIATION		I	1		
		D. M. TWI		STRUCTION	0500	Effectivity Date:		February 13, 202	25
		Process Name/Title:		IG ASSEMBLY PRO		Validity Date:		n/a	
		Model code/Part number:	177D / 75S137-0050	Customer: TRJ	Car Model: TOYOTA-COROLLA	Document No.:		WI-ENG-PDE-3	69
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	3	Page No.:	5 of 18
PARTS:		VM tube (Sunprene) Ø8 L=15				JIG:	1. Insertion		
NO.	I	PROCESS NAME	WORK	PROCEDURE/ ILLUST	RATION	TOOLS/PPE	(QUALITY POIN	TERS
4	P1	Wire insertion to Blue VM tube (Sunprene) Ø8 L=152±3mm	1. Get the Blue VM tube (Sunprene) & using left hand and transfer to right hawires using left hand and insert the whands.	and. Hold the vires using right	755137-0050 (a) (b) (c) (c) (c) (c) (c) (c) (c) (c) (c) (c	n/a	1. No wror 2. No defo 3. No tang	ng usage of parts rmed terminal led wires	

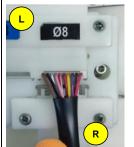
			WORK IN	STRUCTION			Effectivity Date:		February 13, 202	5
		Process Name/Title:	TAPI	NG ASSEMBLY	PROCESS		Validity Date:		n/a	
		Model code/Part number:	177D / 75S137-0050	Customer: 1	Car Model:	TOYOTA-COROLLA	Document No.:		WI-ENG-PDE-36	69
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	MASSP	PRO	Revision No.:	3	Page No.:	6 of 18
PARTS:	1. AVS	S 0.3 Wires R L=186±2mm; V	L=190±2mm; Y L=192±2mm; P L=198±2m	m; B L=204±2mm			JIG:	Insertion Steering		
NO.	F	PROCESS NAME	WORK	PROCEDURE/ IL	LUSTRATION		TOOLS/PPE	(QUALITY POINT	ΓERS
5		Wire insertion to Connector PBVP-10V-S (W)	INSERTION SEQUENCE FROM LE 1 2 3 4 X B X P X Y 1 1 V B	FT TO RIGHT 2 P 198 An insert to connector	WIRE INSERTION 3 Y 192 19 r. Repeat the process	1 5 R 90 X 186		1. Use pro 2. No wron 3. One by 4. No wron 5. No defo 6. No stuck Importan 1. Make inserted. Push afte Do not ex 2. Please during in 3. Autom the unit it terminal, half-lock 4. Inserti to right. Docume 1. Refer i and Strip 2. Refer i Steering procedur 3. Refer i Push pro 4. Refer i Inspectic insertion	vided jig per model gusage of parts one insertion in insertion in insertion in insertion in insertion in insertion. A conduct Pull-Puster insertion. A conduct puster insertion in insertion of wires must interference/s: A conduct puster insertion in ins	/s: pperly sh-Pull- ear terminal and replace ed bend tion and be from left 17 for Wire e. 44 for coller 29 for Pull- 25 for connector

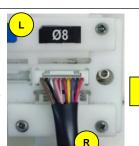
		Effectivity Date:		February 13, 202	5				
		Process Name/Title:	TAPII	NG ASSEMBLY PRO	CESS	Validity Date:		n/a	
		Model code/Part number:	177D / 75S137-0050	Customer: TRJ	Car Model: TOYOTA-COROLLA	Document No.:		WI-ENG-PDE-3	69
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	3	Page No.:	7 of 18
PARTS:		8 0.3 Wires OR L=206±2mm; 2mm; R/W L=365±2mm; BR L	W L=202±2mm; GR/B L=369±2mm; G L=2 =371±2mm	200±2mm; R/L L=371±2mm; GR	L=196±2mm; W/G L=373±2mm; L	JIG:	Insertion Steering		
NO.	F	PROCESS NAME	WORK	PROCEDURE/ ILLUSTR	RATION	TOOLS/PPE	(QUALITY POIN	TERS
5	P1	Wire insertion to Connector PBVP-10V-S (W) (Continuation)	GOOD Terminal condition Note: *Make sure the terminal was *Avoid hitting the terminal in	FRONT OF TERMINAL GOOD Terminal condition in proper alignment being to the connector during	Damaged terminal NO GOOD Terminal condition	NO GOOD Terminal codition	2. No wron 3. One by 4. No wron 5. No defo 6. No stuck 1. Make inserted Push aft Do not e 2. Please terminal 3. Auton replace e encount difficulty locked c 4. Insert left to rig Docume 1. Refer i Wire and 2. Refer i Steering procedu 4. Refer i Inspection	rmed terminal c of terminal tip nt reminders/Note sure wires are pr Conduct <u>Pull-Pu</u> er insertion. exert extra force. e hold the wires n during insertion. attically dispose the unit if once ered bend termina of insertion and onnector. ion of wires must ight. to WI-PRO-CNC-0 I Strip Length Tole to WI-PIG-PDE-0 Navigation Contr	e/s: coperly csh-Pull- ear and al, half- be from 17 for erance. 44 for oller

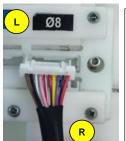
			WORK IN	STRUCTION			Effectivity Date:		February 13, 202	25
		Process Name/Title:		NG ASSEMBLY	PROCE	SS	Validity Date:		n/a	
		Model code/Part number:	177D / 75S137-0050	Customer: T	RJ C	Car Model: TOYOTA-COROLLA	Document No.:		WI-ENG-PDE-3	69
		Purpose:	PROTOTYPE	PRE-LAUNCH	•	MASSPRO	Revision No.:	3	Page No.:	8 of 18
PARTS:	1. Assy 2. Black	parts VM tube (Sunprene) Ø8 L= 1	46±3mm ∧				JIG:	1. Insertion j	ig	
NO.	F	PROCESS NAME	√3\ WORK	PROCEDURE/ ILL	LUSTRAT	TION	TOOLS/PPE	C	UALITY POIN	ΓERS
6	P1	Wire insertion to Black VM tube (Sunprene) Ø8 L=146±3mm	L Ø8 Ø8	R R	L= 146±3	2. Press the upper lock using left thumb. Remove the 1st connector with inserted wires with Blue VM tube (Sunprene) using right hand. Press the lower lock. Check the wire insertion condition. Note: The 2nd connector with inserted wires (With Black VM tube (Sunprene) remains on the jig.	n/a		g usage of parts med terminal ed wires	
7		Wire insertion to assy parts		us	sing left han	lack VM tube (Sunprene) Id and insert the wires from Id (Sunprene) using right hand.	n/a		g usage of parts med terminal ed wires	

			WORK INS		Effectivity Date:		February 13, 202	25					
		Process Name/Title:	TAPIN	IG ASSEMB	LY PRO	CESS			Validity Date:		n/a		
		Model code/Part number:	177D / 75S137-0050	Customer:	TRJ	Car Model:	TOYOTA	A-COROLLA	Document No.:		WI-ENG-PDE-3	69	
		Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH		■ MASSE	PRO		Revision No.:	3	Page No.:	9 of 18	
PARTS:	1. Assy	parts							JIG:	Insertion Steering			
NO.	F	PROCESS NAME	WORK	PROCEDURE/	ILLUSTR	RATION			TOOLS/PPE		QUALITY POINT		
		7	1 2 3 4 BR B P R/W R/L Y	TERMINAL FACING WIRE INSERTION ILLUSTRATION 3 4 5					STEERING	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.			
8	P1	Wire insertion to Connector PBVP-10V-S (W)	1. Hold the BR wire using right hand slot 1 using right hand. Repeat the pro Note: Follow the insertion sequence is	P R/W 198 365 Ø8 and support the works on W/G, R/	R/L 371	192 1 ndex finger the GR/B wires.	V GR 90 36	R 186	CONTROLLER	Do not e. 2. Please during ir 3. Autom the unit i terminal, half-lock 4. Inserti to right. Docume. 1. Refer and Strip 2. Refer Steering procedum 3. Refer y Push pro 4. Refer of	xert extra force. e hold the wires no sertion. natically dispose a if once encounter, difficulty of inserted connector. ion of wires must ant reference/s: to WI-PRO-CNC-0 to WI-PRO-CNC-0 Navigation Contries. to GL-PRO-ASY-0 cocedure. to GL-PRO-ASY-0 on Standard for co	and replace ed bend rition and be from left 17 for Wire e. 44 for oller 29 for Pull-	

NB		Process Name/Title:		G ASSEMBLY PRO		Effectivity Date: Validity Date:	February 13, 2025 n/a		
	U	Model code/Part number: Purpose:	177D / 75S137-0050	Customer: TRJ PRE-LAUNCH	Car Model: TOYOTA-COROLLA MASSPRO	Revision No.:	WI-ENG-PDE-369 3 Page No.: 10 of 1		
PARTS:	1. Assy	y parts				JIG:	Insertion Steering	jig Navigation	
NO.		PROCESS NAME	WORK P	ROCEDURE/ ILLUST	RATION	TOOLS/PPE	QUALITY POINTERS		
			Proper alignment of termi	inal to connector	2. No wroi 3. One by	ovided jig per mode ng usage of parts one insertion ng insertion	I		
8		Wire insertion to Connector PBVP-10V-S (W) (Continuation)	GOOD	GOOD GOOD Terminal condition	BACK VIEW OF TERMINAL FR Damaged terminal NO GOOD Terminal condition	ONT VIEW OF TERMINAL NO GOOD Terminal codition	5. No defo 6. No stud Importa 1. Make inserted Push aft Do not e 2. Please during in 3. Auton the unit terminal half-lock 4. Insert to right.	ormed terminal tip or terminal	operly sh-Pull- ear terminal and replace ed bend rtion and
			Note: *Make sure the terminal was in prop *Avoid hitting the terminal into the the attention of Immediate superior	connector during wire in	sertion, if encountered abnormality st	op the process and call	and Strij 2. Refer Steering procedu 3. Refer Push pro	to WI-PRO-CNC-(o b Length Tolerand to WI-ENG-PDE-(i l Navigation Conti re to GL-PRO-ASY-(ocedure. to GL-PRO-ASY-(ce. 44 for roller 029 for Pull-







2. Press the upper lock by left hand and hold the assy part by right hand. Check the wire after insertion 4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.



Terminal tip must be visible

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		WORK IN		Effectivity Date:		February 13, 2025	5	
	Process Name/Title:		NG ASSEMBLY PRO	CESS	Validity Date:		n/a	
	Model code/Part number:	177D / 75S137-0050	Customer: TRJ	Car Model: TOYOTA-COROLLA	Document No.:		WI-ENG-PDE-36	9
	Purpose:	☐ PROTOTYPE	PRE-LAUNCH	■ MASSPRO	Revision No.:	3	Page No.:	11 of 18
PARTS: 1. Ass	ssy parts	^			JIG:	n/a		
NO.	PROCESS NAME	3 WORK	PROCEDURE/ ILLUST	RATION	TOOLS/PPE	(QUALITY POINT	ERS
9 P1		Terminal tip is visible R Terminal tip is visible	1. Hold to gently for R Terminal tip is visible 2. tut the tut coordinate of the total coordinate of	he Assy parts using both hands and ld it.	n/a	1. No wron 2. No defor 3. No wron 4. No dam	g orientation of cor rmed terminal g terminal facing	nector
9 P1	21 Wire folding 1	is visible Terminal tip	Terminal tip is visible 2. tul the tul co	Hold the connector with Blue VM be and slightly bend the wire. Reapet e process to connector with Black VM be. Check the facing of both innector	n/a	 No deformant No wrong No damant 	rmed terminal ig terminal facing age lance	

	_		WORK INS		Effectivity Date:		February 13, 202	5	
		Process Name/Title:		NG ASSEMBLY PROC	CESS	Validity Date:		n/a	
		Model code/Part number:	177D / 75S137-0050	Customer: TRJ	Car Model: TOYOTA-COROLLA	Document No.:		WI-ENG-PDE-36	39
		Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	3	Page No.:	12 of 18
PARTS:	1. Conr	ector 1746872-1 (B)				JIG:	1. Insertion	jig	
NO.	F	PROCESS NAME	WORK	PROCEDURE/ ILLUSTR	RATION	TOOLS/PPE	(QUALITY POINT	ERS
10	P1	Connector setting to insertion jig 1746872-1 (B)	Upper Guide Unlock INSERTION JIG Press R	EButton CONNECTO 1. Get the connector then insert to insert.	Note: Check the connector before insertion. OR OR OR 1746872-1 (B) using right hand	n/a	1. Use the 2. No wron 3. No wron 4. No dam. Impo 1. Che insertic 2. Auto the uni termina locked.	provided jig per mog usage of parts ig orientation of coraged connector rtant reminders ck the connector be on. matically dispose a strict once encounter al, difficulty of inserval, difficulty of inserval. CONNECTOR L APPEARANCE C CONNECTOR ILLUS ON NG	odel nnector s/Note/s: efore and replace ed bend tion and half- COCK CHECK NG LF-LOCKED STRATION

		WORK INSTRUCTION								Effectivity Date:	February 13, 2025			
		Process Name/Title: TAPING ASSEMBLY PROCESS							Validity Date: n/a					
		Model code/Part number:	177D / 75S137-0050	Customer: 7	TRJ	Car Model: TOYOTA-COROLLA		ROLLA	Document No.:	WI-ENG-PDE-369				
		Purpose:	PROTOTYPE	PRE-LAUNCH		MAS	SSPRO			Revision No.:	3	Page No.:	13 of 18	
PARTS: 1. Ass		y parts						JIG:	1. Insertion jig					
NO.	PROCESS NAME WORK PROCEDURE/ ILLUSTRATION					TOOLS/PPE		QUALITY POIN	TERS					
NO.	P1	Wire insertion to Connector 1746872-1 (B)	INSERTION SEQUENCE FROM LE 2ND ROW R OR G V Y T T T T T T T T T T T T T T T T T T	TO RIGHT TO RIGHT TO RIGHT R 186 BLACK VM T	WIRI 8 W 202 6 OR 206 TUBE (SI	9 L 192 7 G 200 UNPREN	5 P 198 2 V 190	3 Y 192	10 GR 196 4 B 204	n/a	1. Use pro 2. No wror 3. One by 4. No wror 5. No defo 6. No stuci Importan 1. Make Inserted. Push aft Do not e. 2. Please during ir 3. Autom terminal, half-lock 4. Inserti to right. Docume 1. Refer and Strip 2. Refer Inspection	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. 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 GL-PRO-ASY-029 for Pull-Push procedure. 3. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.		
			1. Insert first the wires from Black VN the R wire and insert to terminal slot Repeat the process for V-Y-B wires. Note: Follow the insertion sequence stated above.	M tube (Sunprene). H	Hold 2 to 1 to	2. Hold the terminal slo Note: Follo based on to above.	ot 10. ow the ins	e and inse	ert to					

			WORK IN	Effectivity Date:	February 13, 2025				
		Process Name/Title:	TAPI	ROCESS	Validity Date:		n/a		
		Model code/Part number:	177D / 75S137-0050	Customer: TRJ	Car Model: TOYOTA-COROLLA	Document No.:	WI-ENG-PDE-369		
		Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	3	Page No.:	14 of 18
PARTS: 1. Assy		parts				JIG:	1. Insertion jig		
NO.	PROCESS NAME		WORK	TOOLS/PPE	QUALITY POINTERS				
11	P1	Wire insertion to Connector 1746872-1 (B) (Continutaion)	BLUE VM TUBE (SUNPRENE) R OR G V Y B 4. Hold the W wire and insert to termi Note: Follow the insertion sequence to	inal slot 8, repeat the procedure on the above illustrated based on the above illustrated bab		n/a	2. No wror 3. One by 4. No wror 5. No defo 6. No stuc Importan 1. Make inserted. Push aft Do not e 2. Please during in 3. Auton the unit terminal, half-lock 4. Inserti to right. Docume 1. Refer and Strip 2. Refer Push pro 3. Refer	natically dispose a if once encounterd difficulty of inser- ed connector. ion of wires must on treference/s: to WI-PRO-CNC-0 to GL-PRO-ASY-0 pocedure. to GL-PRO-ASY-0 on Standard for co	e/s: operly sh-Pull- ear terminal and replace ed bend rtion and be from left 117 for Wire e.e. 129 for Pull-

			Effectivity Date:	February 13, 2025							
		Process Name/Title:	WORK IN: TAPII	Validity Date:	n/a						
		Model code/Part number:	177D / 75S137-0050	Customer: TRJ Car Model: TOYOTA-COROLLA		Document No.:	WI-ENG-PDE-369				
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH		■ MASSPRO		Revision No.:	3	Page No.:	15 of 18
PARTS:	1. Assy	parts						JIG:	n/a		
NO.	P	ROCESS NAME	WORK PROCEDURE/ ILLUSTRATION					TOOLS/PPE	QUALITY POINTERS		
12	P1	Wire folding 2	BLUE VM TUBE (SUI	NPRENE)	R 3. Aft	1. Hold the 10V-S (W) slightly fold Blue VM tul shown in ill using right 1	process for Black sunprene	n/a	1. No wror 2. No wror	ng orientation of cong use of connectong terminal facing	onnector

			WORK INS					Effectivity Date:	February 13, 2025		
		Process Name/Title:	TAPIN	IG ASSEN	IBLY PROC	ESS		Validity Date:	n/a		
		Model code/Part number:	177D / 75S137-0050	Custom	er: TRJ	Car Model: TOYC	TA-COROLLA	Document No.:		WI-ENG-PDE-3	69
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH		MASSPRO		Revision No.:	3	Page No.:	16 of 18
PARTS:	Assy parts Master sample						JIG:	n/a			
NO.	F	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION					TOOLS/PPE	QUALITY POINTERS		
			Check the connector lock. Locking of is included to Steering electrical test.	connector	2. Check the Make sure no	wire alignment. tangled wires	3. Check the ter (not fully inserte terminal.	minal if with backing out d) or no deformed	Document reference/s: 1. Refer to WI-QAD-QAC-252 Steering Electrical Test		
13	P1	Visual/By Two's Inspection	ACTUAL PRODUCT		MASTER SAMPLE 1. No skip checking during inspection						
			4. Check the orientation of harness.	5. C tapp	ompare to Mast	er sample by		MASTER SAMPLE			
						ASSEMBLI	ED PRODUCTS				

