



## WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

June 6, 2024

Model code/Part number:

011B / 75L177-0020A

Customer: TRJ

Car Model: TOYOTA-CAMRY

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

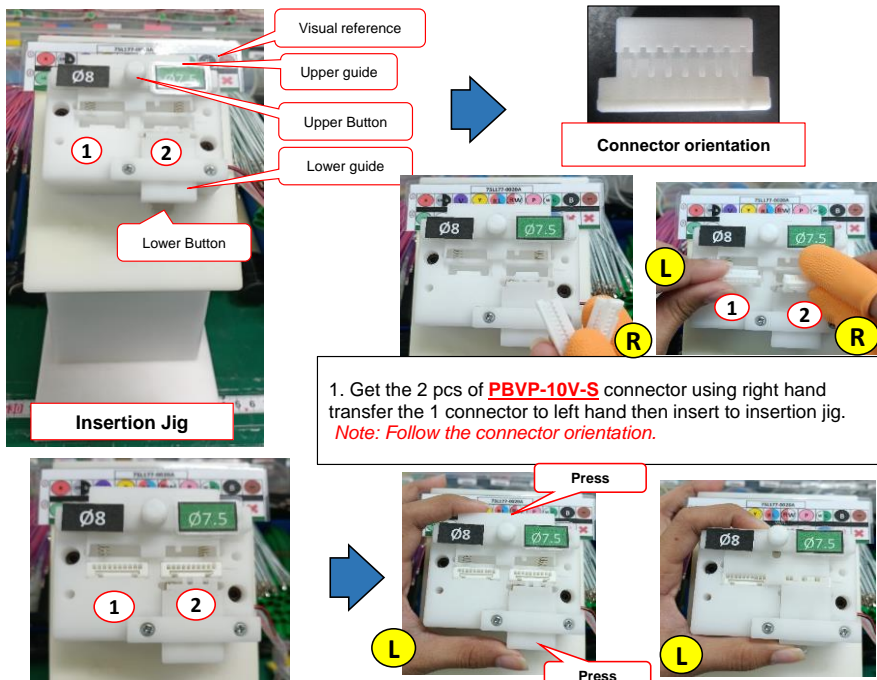



WI-ENG-PDE-189

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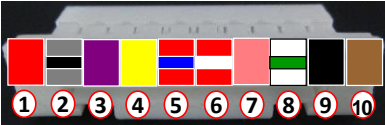







|                  |              |  |   |               |               |           |  |  |  |  |          |
|------------------|--------------|--|---|---------------|---------------|-----------|--|--|--|--|----------|
| PARTS:           |              | 1. Connector PBVP-10V-S (W) [2pcs]   |   |               |               | JIG:      | 1. Insertion jig   |  |  |  |          |
| NO.              | PROCESS NAME |  | WORK PROCEDURE/ ILLUSTRATION  |               |               |           | TOOLS/PPE  | QUALITY POINTERS   |  |  |          |
| 1                | P1           | Connector setting to insertion jig<br>PBVP-10V-S (W)   | <div><p>1. Get the 2 pcs of <b>PBVP-10V-S</b> connector using right hand transfer the 1 connector to left hand then insert to insertion jig.<br/><i>Note: Follow the connector orientation.</i></p><p>2. Press the upper and lower guide using left hand in same timing. Holes that need to be insert are only open.</p></div> |               |               |           | <div><b>Safety Instruction</b><br/>Be sure to wear prescribe personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b><br/>1. Maintain and always practice 5's.<br/>2. Personal things on the workplace is prohibited.<br/>Keep it in your locker.</div> <div><b>Alert level</b><br/>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div> |  | <div>1. Use the provided jig per model<br/>2. No wrong usage of parts<br/>3. No wrong orientation of connector<br/>4. No damaged connector</div> |  |          |
| Revision History |              |  |   |               |               |           |  |  |  |  |          |
| 06/06/24         | 6            | Update Process 4 and 6. Inclusion of Quality checkpoint.   | D.Castillo  | C. Villanueva | A. Arañes     | n/a       | Prepared by  | Reviewed by  |  | Approved by  | Noted by |
| 08/15/23         | 5            | Improve work procedure of process 3, procedure 1, from "get the Black VM tube (Sunprene) usinf left hand to Get the Black VM tube (Sunpere) 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 | <br>D. Castillo   | <br>C. Villanueva |  | <br>A. Arañes | n/a      |
| 09/29/22         | 4            | Improved the insertion jig and procedure. Improved visual/by two's inspection.   | D.Castillo  | J. Loterte    | C. Villanueva | A. Arañes |  |  |  |  |          |
| Eff. Date        | Rev. No      | Details of Change  | Revised   | Reviewed      | Approved      | Noted     | Est. Date:   | July 10, 2017  |  |  |          |

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|---|---|--|----------------------|--------------------------------|-------------------|-----------------------|-----------|----------------|
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|   | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO |  |                      |                                | Revision No.:     | <b>6</b>              | Page No.: | <b>2 of 14</b> |

|               |  |   |     |     |      |  |   |     |     |   |   |   |   |   |   |    |   |      |   |   |     |     |   |     |   |    |     |     |     |     |     |     |     |     |     |     |  |
|---------------|--|---|-----|-----|------|--|---|-----|-----|---|---|---|---|---|---|----|---|------|---|---|-----|-----|---|-----|---|----|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|--|
| <b>PARTS:</b> | 1. AVSS 0.3 R L=191±2mm; GR/B L=380±2mm; V L=195±2mm; Y L=197±2mm; R/L L=382±2mm; R/W L=378±2mm; P L=203±2mm; W/G L=386±2mm; B L=207±2mm; BR L=384±2mm<br>2. Black VM tube (Sunprene) Ø8 L=151±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>   |     |     |   |   |   |   |   |   |    |   |      |   |   |     |     |   |     |   |    |     |     |     |     |     |     |     |     |     |     |  |
| 2             | P1<br><br>Wire insertion to Connector PBVP-10V-S (W)   | <div><div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div><div></div><div></div><div></div><div>1. Get the <b>R wire</b> using right hand and insert to connector. Repeat the process for <b>GR/B-V-Y-R/L-R/W-P-W/G-B-BR wires</b>.<br/><b>Note: Follow the insertion sequence based on the illustration.</b></div></div> |     |     |      | <div>Wire facing</div>  <table><tr><td>1</td><td>2</td><td>3</td><td>4</td><td>5</td><td>6</td><td>7</td><td>8</td><td>9</td><td>10</td></tr><tr><td>R</td><td>GR/B</td><td>V</td><td>Y</td><td>R/L</td><td>R/W</td><td>P</td><td>W/G</td><td>B</td><td>BR</td></tr><tr><td>191</td><td>380</td><td>195</td><td>197</td><td>382</td><td>378</td><td>203</td><td>386</td><td>207</td><td>384</td></tr></table> <div>STEERING NAVIGATION(2 layer)</div>  <div>CONTROLLER</div>  | 1   | 2   | 3   | 4 | 5 | 6 | 7 | 8 | 9 | 10 | R | GR/B | V | Y | R/L | R/W | P | W/G | B | BR | 191 | 380 | 195 | 197 | 382 | 378 | 203 | 386 | 207 | 384 | <div>1. Use provided jig per model</div> <div>2. No wrong usage of parts</div> <div>3. One by one insertion</div> <div>4. No wrong insertion</div> <div>5. No deformed terminal</div> <div>6. No stuck of terminal tip</div> <div><b>Important reminders/Note/s:</b></div> <div>1. Please hold the wire near terminal during insertion.</div> <div>2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</div> <div><b>Document References:</b></div> <div>1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.</div> <div>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div> <div>3. Refer to GL-PRO-ASY-028 for Pull-Push procedure.</div> |
| 1             | 2  | 3   | 4   | 5   | 6    | 7  | 8   | 9   | 10  |   |   |   |   |   |   |    |   |      |   |   |     |     |   |     |   |    |     |     |     |     |     |     |     |     |     |     |  |
| R             | GR/B   | V   | Y   | R/L | R/W  | P  | W/G   | B   | BR  |   |   |   |   |   |   |    |   |      |   |   |     |     |   |     |   |    |     |     |     |     |     |     |     |     |     |     |  |
| 191           | 380  | 195   | 197 | 382 | 378  | 203  | 386   | 207 | 384 |   |   |   |   |   |   |    |   |      |   |   |     |     |   |     |   |    |     |     |     |     |     |     |     |     |     |     |  |
| 3             | Wire insertion to Black VM tube (Sunprene) Ø8 L=151±3mm  | <div></div> <div></div> <div>1. Get the <b>Black VM tube (Sunprene) Ø8 L=151±3mm</b> using right hand. Hold the wires using left hand and insert the wires using right hand.</div>   |     |     |      | N/A  | <div>1. No wrong usage of parts</div> <div>2. No deformed terminal</div> <div>3. No tangled wires</div> |     |     |   |   |   |   |   |   |    |   |      |   |   |     |     |   |     |   |    |     |     |     |     |     |     |     |     |     |     |  |

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☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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### PARTS:

1. AVSS 0.3 LG L=217±2mm; W L=215±2mm; G L=209±2mm; L L=203±2mm

JIG:

1. Insertion jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE

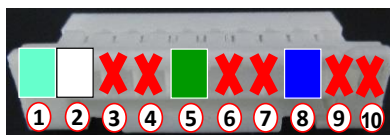
### QUALITY POINTERS

3

P1

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

INSERTION SEQUENCE FROM LEFT TO RIGHT



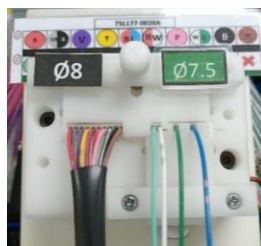
Wire facing

|     |     |   |   |     |   |   |     |   |    |
|-----|-----|---|---|-----|---|---|-----|---|----|
| 1   | 2   | 3 | 4 | 5   | 6 | 7 | 8   | 9 | 10 |
| LG  | W   | X | X | G   | X | X | L   | X | X  |
| 217 | 215 |   |   | 209 |   |   | 203 |   |    |



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

Lower guide



1. Get the **LG wire** using  
right hand and insert to  
connector. Repeat the  
process for **W-G-L**  
**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. 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.

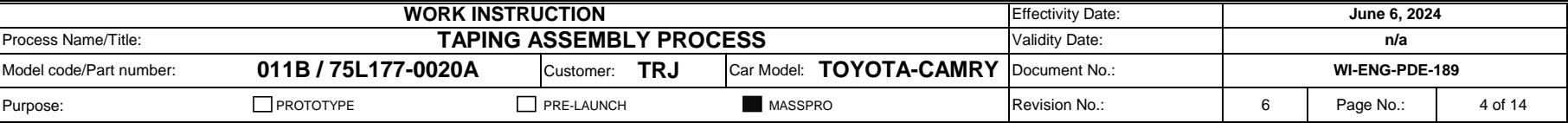
### Document References:

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.

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## PARTS:

1. Assy parts

JIG:

1. Insertion jig

NO.

PROCESS NAME

6

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

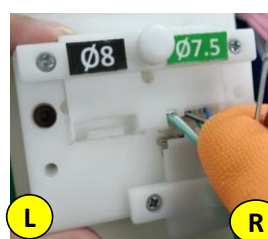
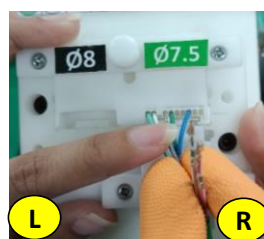
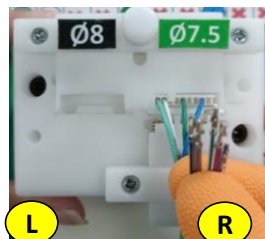
QUALITY POINTERS

INSERTION SEQUENCE FROM LEFT  
TO RIGHT

Wire facing

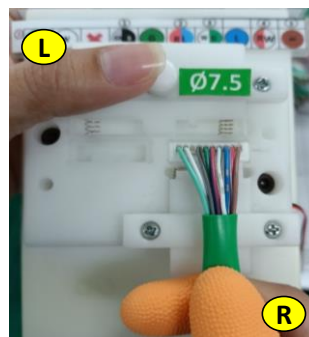
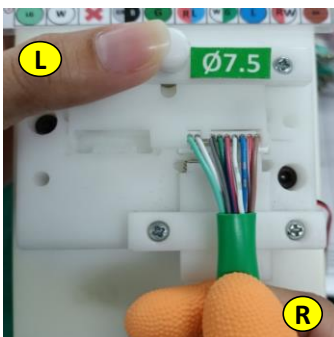


|     |     |   |      |     |     |     |     |     |     |
|-----|-----|---|------|-----|-----|-----|-----|-----|-----|
| 1   | 2   | 3 | 4    | 5   | 6   | 7   | 8   | 9   | 10  |
| LG  | W   | X | GR/B | G   | R/L | W/G | L   | R/W | BR  |
| 217 | 215 |   | 380  | 209 | 382 | 386 | 203 | 378 | 384 |



1. Hold the **GR/B wire** using right hand and support the wire by left index finger then insert to connector using right hand. Repeat the process on **R/L-W/G-R/W-BR wires**. Check the wire after insertion

*Note: Follow the insertion sequence based on the above illustration.*



2. 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

**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:**

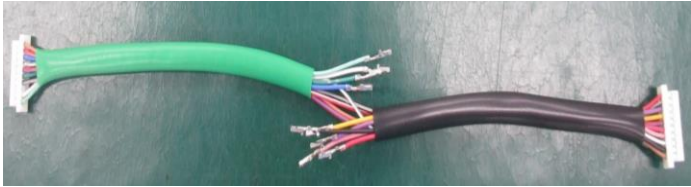
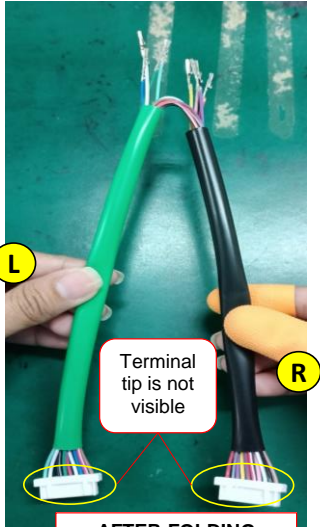
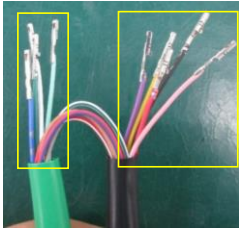
1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
3. Refer to GL-PRO-ASY-028 for Pull-Push procedure.

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|   | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO |  |                      |                                | Revision No.:     | 6                     | Page No.: | 6 of 14 |

|               |                     |  |  |                  |   |
|---------------|---------------------|--|--|------------------|---|
| <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>   |
| 7             | P1                  | <div><p>BEFORE FOLDING</p><p>AFTER FOLDING</p><p>Terminal tip is not visible</p><p>1. Hold the assy parts using both hands then conduct wire arrangement.</p></div> |  | N/A              | 1. No deformed terminals<br>2. No tangled wires<br>3. No wrong facing |

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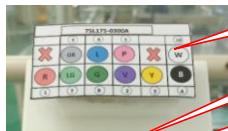
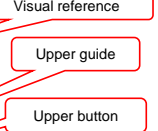
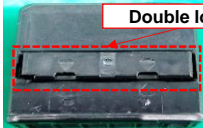
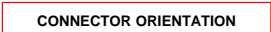

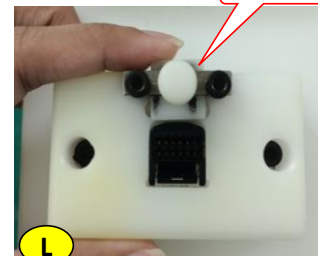


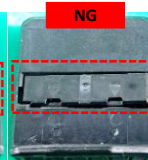
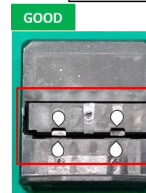

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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|        |  |  |  |           |  |
|--------|--|--|--|-----------|--|
| PARTS: |  | 1. Connector 1746872-1 (B)   |  | JIG:      | 1. Insertion jig   |
| NO.    | PROCESS NAME   | WORK PROCEDURE/ ILLUSTRATION   |  | TOOLS/PPE | QUALITY POINTERS   |
| 8      | P1<br><br>Connector setting to insertion jig 1746872-1 (B) | <div><div><p>Visual reference</p></div><div><p>Upper guide</p><p>Upper button</p></div><div><p>Double lock</p></div><div><p>Note: Check the connector before insertion.</p></div><div><p>CONNECTOR ORIENTATION</p></div><div><p><b>INSERTION JIG</b></p></div><div><p>1. Get the connector <b>1746872-1 (B)</b> and insert to insertion jig using right hand.</p><p>Note: Follow the connector orientation</p></div><div><p>Press</p></div><div><p>2. Press the upper guide using left hand. Holes that need to be insert are only open.</p></div></div> |  | N/A       | <p>1. Use the provided jig per model<br/>2. No wrong usage of parts<br/>3. No wrong orientation of connector<br/>4. No damaged connector</p> <div><div><p><b>CONNECTOR LOCK APPEARANCE CHECK</b></p><div><p>GOOD</p></div><div><p>NG</p></div><div><p>UNLOCK</p><p>HALF-LOCKED</p></div></div><div><p><b>CONNECTOR ILLUSTRATION</b></p><div><p>GOOD</p></div><div><p>NG</p></div><div><p>1746872-1 (B)</p><p>1376675-1 (B)</p></div></div><p><b>Important reminders/Note/s:</b><br/>1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half- locked connector.</p></div> |

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### PARTS:

1. Assy parts

JIG:

1. Insertion jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE

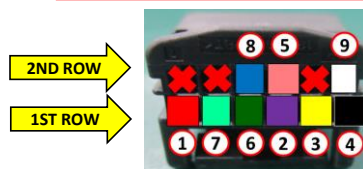
### QUALITY POINTERS

9

P1

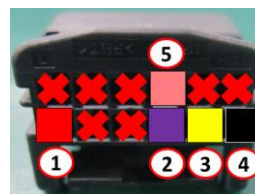
Wire insertion to  
Connector  
1746872-1 (B)

INSERTION SEQUENCE FROM LEFT TO  
RIGHT

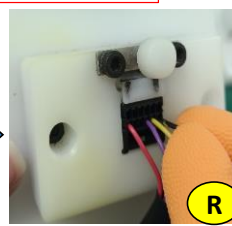
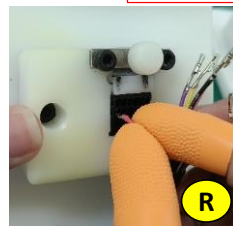


|     |     |     |     |     |     |
|-----|-----|-----|-----|-----|-----|
|     |     | 8   | 5   |     | 9   |
| X   | X   | L   | P   | X   | W   |
|     |     | 203 | 203 |     | 215 |
| 1   | 7   | 6   | 2   | 3   | 4   |
| R   | LG  | G   | V   | Y   | B   |
| 191 | 217 | 209 | 195 | 197 | 207 |

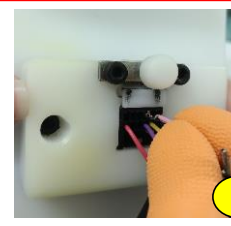
BLACK VM TUBE (SUNPRNE)



FIRST ROW (LEFT TO RIGHT)



SECOND ROW (LEFT TO RIGHT)



1. Insert first the wires from **Black VM tube (Sunprene)**.  
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 **P wire** and insert to terminal slot 5.  
*Note: Follow the insertion sequence based on the illustration stated above.*

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. 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, difficulty of insertion and half-locked connector.

#### Document References:

1. Refer to GL-PRO-ASY-028 for Pull-Push procedure.
2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

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## WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

June 6, 2024

Model code/Part number:

011B / 75L177-0020A

Customer:

TRJ

Car Model:

TOYOTA-CAMRY

Document No.:

WI-ENG-PDE-189

Purpose:


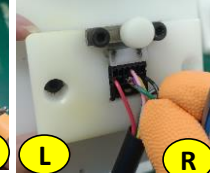
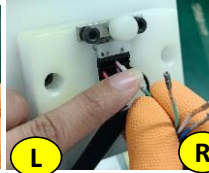
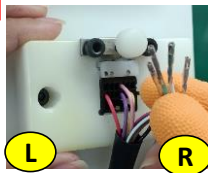
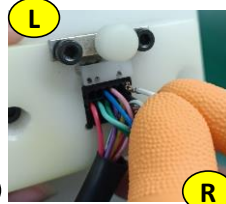
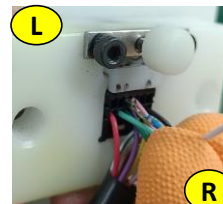
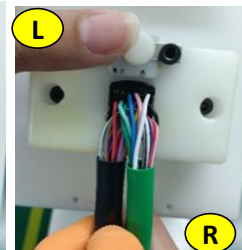
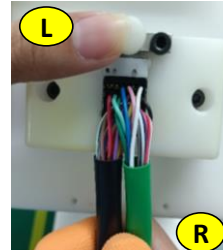
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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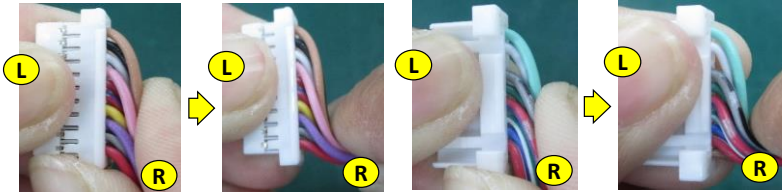


|        |   |  |           |                  |
|--------|---|--|-----------|------------------|
| PARTS: | 1. Assy parts   |  | JIG:      | 1. Insertion jig |
| NO.    | PROCESS NAME  | WORK PROCEDURE/ ILLUSTRATION   | TOOLS/PPE | QUALITY POINTERS |
| 9      | P1<br><br>Wire insertion to Connector 1746872-1 (B)<br>(Continuation) | <div><div>GREEN VM TUBE (SUNPRENE)</div><div></div><div></div><div>3. Hold the <b>G wire</b> using right hand and support the wire by left index finger then insert to terminal <b>slot 6</b> using right hand. Repeat the process for <b>LG wire</b>.<br/><i>Note: Follow the insertion sequence based on the above illustration.</i></div><div></div><div>4. Hold the <b>L wire</b> and insert to terminal <b>slot 8</b> using right hand. Repeat the process for <b>W wire</b>.<br/><i>Note: Follow the insertion sequence based on the illustration.</i></div><div></div><div>5. Press the Upper button using left hand then remove the assy part using right hand.</div></div> <div>N/A</div> <div><div>1. Use provided jig per model<br/>2. No wrong usage of parts<br/>3. One by one insertion<br/>4. No wrong insertion<br/>5. No deformed terminal<br/>6. No stuck of terminal tip</div><div><b>Important reminders/Note/s:</b><br/><b>1. Please hold the wire near terminal during insertion.</b><br/><b>2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion.</b><br/><b>Do not exert extra force.</b></div></div> |           |                  |

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|---|---|--|----------------------|--------------------------------|-------------------|-----------------------|-----------|----------|
|  | <b>WORK INSTRUCTION</b>   |  |                      |                                | Effectivity Date: | <b>June 6, 2024</b>   |           |          |
|   | <b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>  |  |                      |                                | Validity Date:    | n/a                   |           |          |
|   | Model code/Part number: <b>011B / 75L177-0020A</b>  |  | Customer: <b>TRJ</b> | Car Model: <b>TOYOTA-CAMRY</b> | Document No.:     | <b>WI-ENG-PDE-189</b> |           |          |
|   | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO |  |                      |                                | Revision No.:     | 6                     | Page No.: | 10 of 14 |



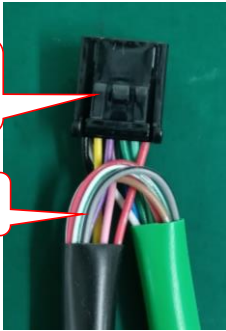
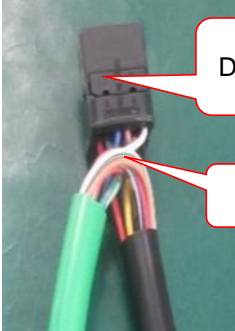
|               |                     |                                     |   |      |                  |                         |   |  |  |
|---------------|---------------------|-------------------------------------|---|------|------------------|-------------------------|---|--|--|
| <b>PARTS:</b> | 1. Assy parts       |                                     |   | JIG: | 1. Locking jig   |                         |   |  |  |
| <b>NO.</b>    | <b>PROCESS NAME</b> | <b>WORK PROCEDURE/ ILLUSTRATION</b> |   |      | <b>TOOLS/PPE</b> | <b>QUALITY POINTERS</b> |   |  |  |
| 10            | P1                  | Wire folding                        | <div><div>BLACK VM TUBE (SUNPRENE)</div><div>GREEN VM TUBE (SUNPRENE)</div><div></div><div>1. Hold the connector PBVP-10V-S (W) using left hand and slightly fold the wires from Black VM tube (Sunprene) <i>(as shown in illustration above)</i> using right hand. Repeat the process for Green sunprene tube.</div><div></div><div>BEFORE FOLDING</div><div></div><div>AFTER FOLDING</div></div> |      |                  | N/A                     | 1. No wrong orientation of connector<br>2. No tangled wires<br>3. No terminal backing out |  |  |

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|   | Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>  |  |                      | Validity Date:                 | n/a                 |                       |          |
|   | Model code/Part number: <b>011B / 75L177-0020A</b>  |  | Customer: <b>TRJ</b> | Car Model: <b>TOYOTA-CAMRY</b> | Document No.:       | <b>WI-ENG-PDE-189</b> |          |
|   | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO |  |                      | Revision No.:                  | 6                   | Page No.:             | 11 of 14 |


|               |                                      |  |                  |  |                |
|---------------|--------------------------------------|--|------------------|--|----------------|
| <b>PARTS:</b> | 1. Assy parts                        |  |                  | JIG:   | 1. Locking jig |
| <b>NO.</b>    | <b>PROCESS NAME</b>                  | <div><div>6</div><b>WORK PROCEDURE/ ILLUSTRATION</b></div>   | <b>TOOLS/PPE</b> | <b>QUALITY POINTERS</b>  |                |
| 10            | P1<br>Wire folding<br>(Continuation) | <div><div>Folding at the back</div><div>GOOD FACING</div><div>Folding in the front</div><div>NG FACING</div><div>GOOD FACING</div><div>Connector lock</div><div>Folding</div><div>NG FACING</div><div>Double lock</div><div>Folding</div><div>Terminal tip is NOT visible</div><div>Terminal tip is visible</div></div> <td>N/A</td> <td colspan="2"><div>1. No wrong orientation of connector</div><div>2. No tangled wires</div><div>3. No terminal backing out</div></td> | N/A              | <div>1. No wrong orientation of connector</div> <div>2. No tangled wires</div> <div>3. No terminal backing out</div> |                |

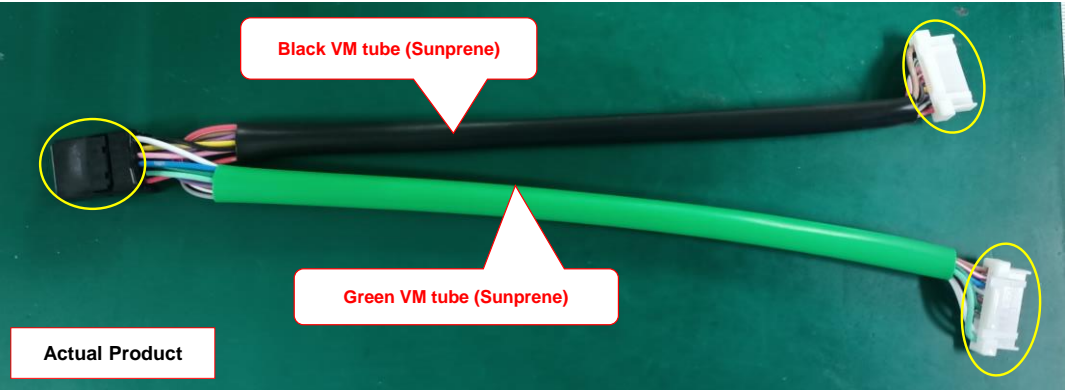
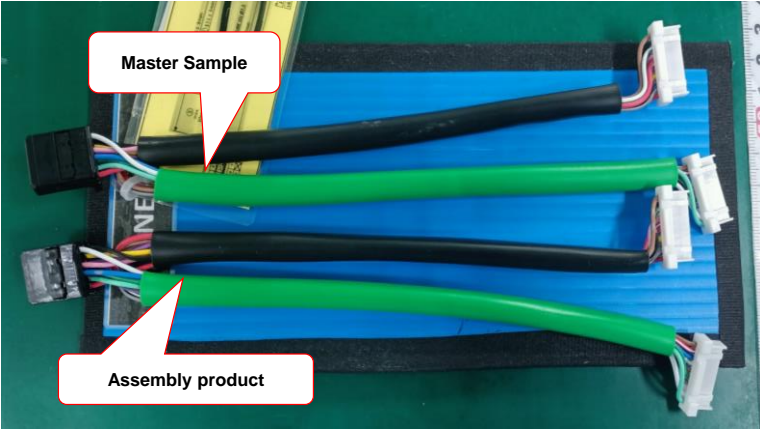

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|  | <b>WORK INSTRUCTION</b>   |  |                      |                                | Effectivity Date: | <b>June 6, 2024</b>   |           |          |
|   | <b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>  |  |                      |                                | Validity Date:    | n/a                   |           |          |
|   | Model code/Part number: <b>011B / 75L177-0020A</b>  |  | Customer: <b>TRJ</b> | Car Model: <b>TOYOTA-CAMRY</b> | Document No.:     | <b>WI-ENG-PDE-189</b> |           |          |
|   | Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO |  |                      |                                | Revision No.:     | 6                     | Page No.: | 12 of 14 |


|               |                     |                                     |  |  |      |                  |  |  |  |
|---------------|---------------------|-------------------------------------|--|--|------|------------------|--|--|--|
| <b>PARTS:</b> | n/a                 |                                     |  |  | JIG: | n/a              |  |  |  |
| <b>NO.</b>    | <b>PROCESS NAME</b> | <b>WORK PROCEDURE/ ILLUSTRATION</b> |  |  |      | <b>TOOLS/PPE</b> | <b>QUALITY POINTERS</b>  |  |  |
| 11            | 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>4. Check the orientation of harness.</div> <div></div> <div><div>5. Compare to <b>Master Sample</b> by tapping.</div><div></div></div> |  |      |                  | <div>1. No wrong facing of harness</div> <div>2. No Tangled wires</div> <div>3. No missing parts</div> <div><div>MASTER SAMPLE</div><div></div></div> <div><b>Document reference/s:</b></div> <div>1. Refer to <b>WI-ENG-PDE-252</b> for Steering Electrical Test after assembly.</div> |  |  |

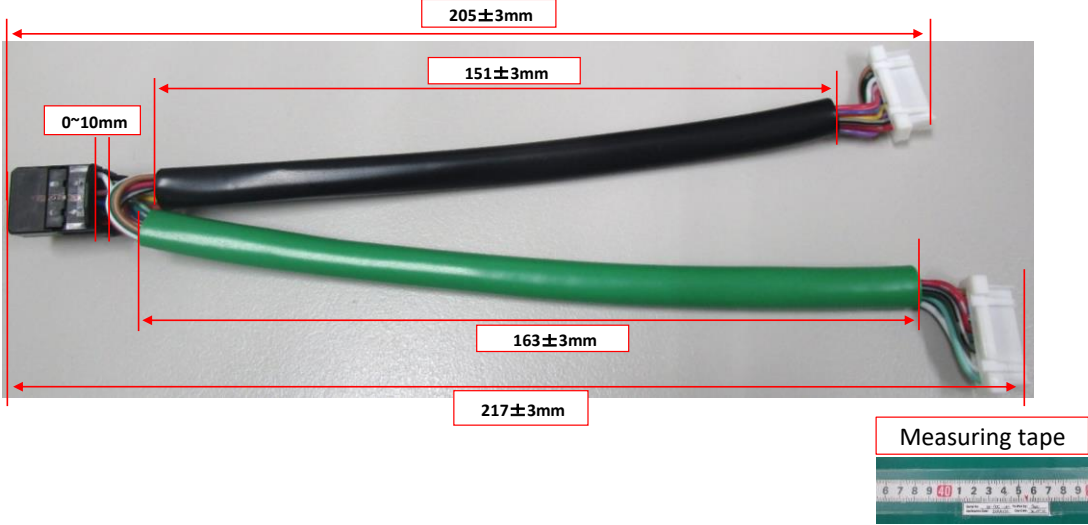
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|  | <b>WORK INSTRUCTION</b>                            |  |                                     |   | Effectivity Date: |  | June 6, 2024          |                    |
|   | Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b> |  |                                     |   | Validity Date:    |  | n/a                   |                    |
|   | Model code/Part number: <b>011B / 75L177-0020A</b> |  | Customer: <b>TRJ</b>                | Car Model: <b>TOYOTA-CAMRY</b>              | Document No.:     |  | <b>WI-ENG-PDE-189</b> |                    |
|   | Purpose: <input type="checkbox"/> PROTOTYPE        |  | <input type="checkbox"/> PRE-LAUNCH | <input checked="" type="checkbox"/> MASSPRO | Revision No.:     |  | 6                     | Page No.: 13 of 14 |

|               |                     |                                     |  |   |     |
|---------------|---------------------|-------------------------------------|--|---|-----|
| <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                  | Measurement                         |  | <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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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

June 6, 2024

Validity Date:

n/a

Model code/Part number:

011B / 75L177-0020A

Customer: TRJ

Car Model: TOYOTA-CAMRY

Document No.:

WI-ENG-PDE-189

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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### PARTS:

1. Assy parts

JIG:

N/A



### QUALITY CHECKPOINTS

## 75L177-0020A

1. Check the connector lock, should be unlock.

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

Black VM Tube (Sunprene)

Green VM Tube (Sunprene)

3. Check the terminal if with backing out (no fully inserted) or deformed terminal.

4. Check the orientation of harness.

5. Check if no missing parts.

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