



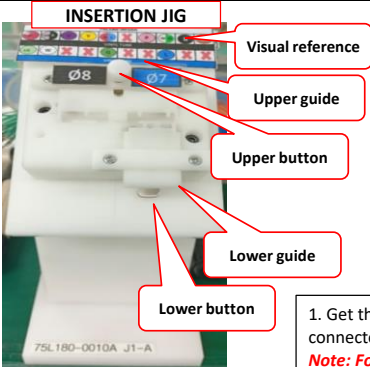
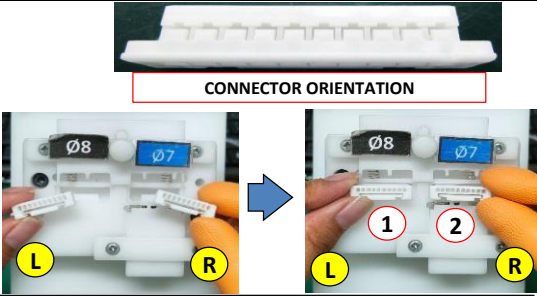
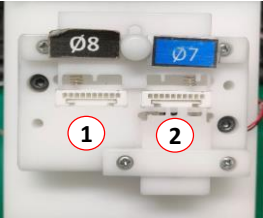


WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:	July 11, 2023		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-255		
Revision No.:	4	Page No.:	1 of 15

Process Name/Title: **TAPING ASSEMBLY PROCESS**

Model code/Part number **011B / 75L180-0010A** Customer: **TRJ** Car Model: **Toyota-Camry**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Connector PBVP-10V-S (W) [2pcs]		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1 <div>4</div> Connector setting to insertion jig PBVP-10V-S (W)	<div><div>INSERTION JIG</div><div></div><div></div><div></div><div></div><div></div><div>1. Get the 2pcs of PBVP-10V-S connector using right hand and transfer the 1 connector to left hand then insert to insertion jig. Note: Follow the connector orientation.</div><div>2. Press the upper and lower guide using left hand in same timing. Holes that need to be insert are only open.</div></div>		<div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector

Revision History				Prepared by	Reviewed by	Approved by	Noted by
7/11/23	4	Improve the insertion jig procedure. Improved work procedure/illustration. Update of Quality Checkpoint. Inclusion of Car model "Toyota-Camry".	D. Castillo	C. Villanueva	A. Arañes	n/a	
5/10/23	3	Inclusion of quality checkpoints; Standardize VM tube (Sunprene) term.	D. Castillo	J. Loterte	C. Villanueva	A. Arañes	
08/25/22	2	Improve process illustration. Merged P1 and P2 due to the process improvement. Additional quality pointers in wire insertion refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance. Include WI-ENG-PDE-431 for Steering Electrical Test after assembly.	D. Castillo	J. Loterte	C. Villanueva	A. Arañes	
Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	
				Est. Date:	July 10, 2017		

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model code/Part number:

011B

/

75L180-0010A

Customer:

TRJ

Car Model:

Toyota-Camry

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

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n/a

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PARTS:

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; P L=203±2mm; W/G L=386±2mm; B L=207±2mm; BR L=384±2mm

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

P1

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

INSERTION SEQUENCE FROM LEFT TO RIGHT



WIRE INSERTION ILLUSTRATION

1	2	3	4	5	6	7	8	9	10
R	GR/B	V	Y	R/L	X	P	W/G	B	BR
191	380	195	197	382		203	386	207	384



Wire facing



1. Get the **R wire** using right hand and insert to connector at terminal slot **1**. Repeat the process for **GR/B-V-Y-R/L-P-W/G-B-BR** wires.

Note: Follow the insertion sequence based on the illustration.

STEERING NAVIGATION



CONTROLLER



1. Use the provided jig per model
2. No wrong use of parts
3. No wrong insertion of wires
4. No deformed terminal
5. One by one insertion
6. No stuck-up 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.

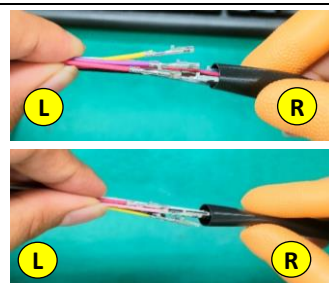
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Document References:

1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
2. Refer to GL-PRO-ASY-028 for Pull-Push procedure.
3. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.

3

Wire insertion to Black VM tube (Sunprene) Ø8 L=151±3mm



1. Get the **Black VM tube (Sunprene) Ø8 L=151±3mm** using left hand and transfer to right hand. Hold the wires using left hand and insert the wires using right hand.

n/a

1. No wrong use of parts
2. No deformed terminals
3. No tangled wires

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WORK INSTRUCTION

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Model code/Part number:

011B

/ 75L180-0010A

Customer:

TRJ

Car Model:

Toyota-Camry

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

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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

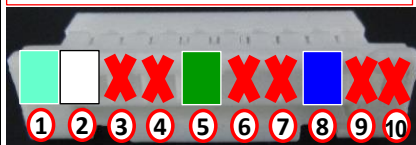
QUALITY POINTERS

4

P1

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

INSERTION SEQUENCE FROM LEFT TO RIGHT



WIRE INSERTION ILLUSTRATION

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



Wire facing

Note: Holes that need to be insert are only open

Lower guide



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

Note: Follow the insertion sequence based on the illustration.

STEERING NAVIGATION



CONTROLLER



1. Use the provided jig per model
2. No wrong use of parts
3. No wrong insertion of wires
4. No deformed terminal
5. One by one insertion
6. No stuck-up 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 GL-PRO-ASY-028 for Pull-Push procedure.
3. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

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Customer: TRJ

Car Model: Toyota-Camry

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☐ PROTOTYPE

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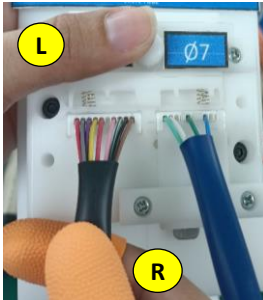

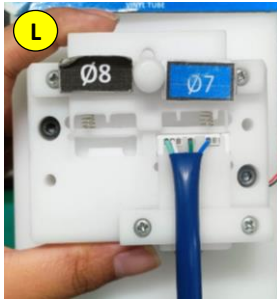

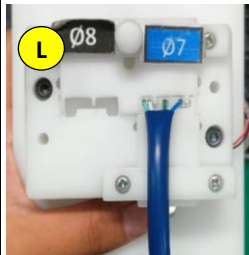


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PARTS:

1. Assy parts
2. Blue VM tube (Sunprene) $\varnothing 7$ L=163 \pm 3mm

JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1 Wire insertion to Blue VM tube (Sunprene) $\varnothing 7$ L=163 \pm 3mm	<div><p>1. Get the Blue VM tube (Sunprene) $\varnothing 7$ L=163\pm3mm using right hand. Hold the wire using left hand then insert the wires.</p></div> <div><p>2. Press the button using left hand. Remove the 1st connector with inserted wires and Blue VM tube (Sunprene) using right hand.</p></div> <div><p>3. Press the upper guide using left hand. Check the wire insertion condition.</p><p>Note: Second connector with inserted wires and Blue VM tube (Sunprene) will stay on the jig.</p></div> <div><p>4. Press the lower button using right hand. Holes that need to be insert are only open.</p></div>	n/a	<div><p>GOOD</p></div> <div><p>NG</p></div> <p>Note: Wires must be offset with each other</p> <ol style="list-style-type: none">1. No wrong usage of parts2. No deformed terminal

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TAPING ASSEMBLY PROCESS

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n/aModel code/Part number: **011B / 75L180-0010A**Customer: **TRJ**Car Model: **Toyota-Camry**

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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5 of 15**PARTS:**

1. Assy parts
2. Blue VM tube (Sunprene) Ø7 L=163±3mm

JIG

1. Insertion jig

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

6

P1

Wire insertion to assy parts



1. Hold the **Blue VM tube (Sunprene)** using left hand, and insert the wires from **Black VM tube (Sunprene)** using right hand.

n/a

1. No wrong usage of parts
2. No deformed terminal

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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

7

P1

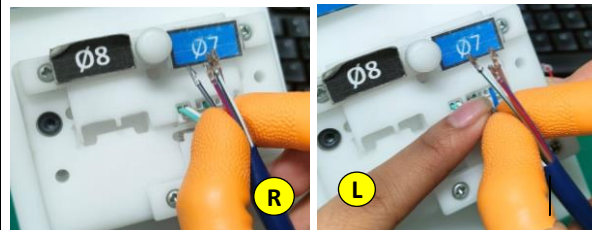
Wire insertion to
connector
PBVP-10V-S (W)

INSERTION SEQUENCE FROM LEFT TO RIGHT



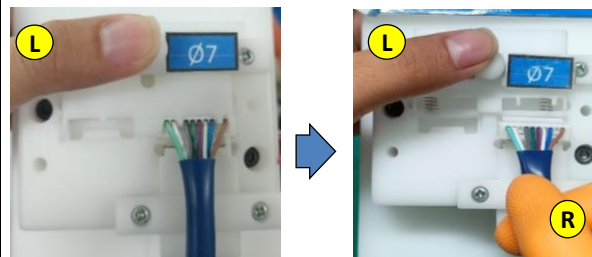
WIRE INSERTION ILLUSTRATION

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



1. Hold the **GR/B wire** using right hand support the wire using left finger then insert to connector slot **4** using right hand. Repeat the process for **R/L-W/G-BR wires**. Check the wire after insertion.

Note: Follow the insertion sequence based on the illustration.



2. Press the upper button using left hand then remove the assy part using right hand. Check the insertion condition.

Wire facing

STEERING
NAVIGATION

CONTROLLER



1. Use the provided jig per model
2. No wrong use of parts
3. No wrong insertion of wires
4. No deformed terminal
5. One by one insertion
6. No stuck-up 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 GL-PRO-ASY-028 for Pull-Push procedure.

3. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.

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

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WORK INSTRUCTION

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Customer: TRJ

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☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

4

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

8

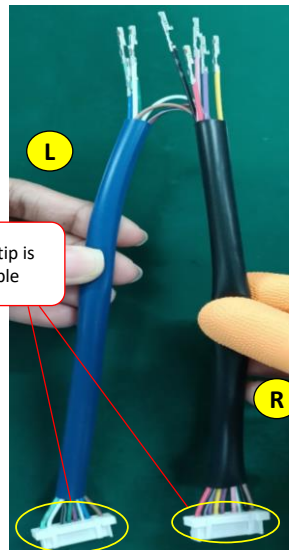
P1

Wire arrangement



BEFORE

AFTER FOLDING



Terminal tip is not visible

1. Hold the assy parts using both hand then conduct wire arrangement.

n/a

1. No deformed terminals
2. No tangled wires
3. No wrong facing

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Model code/Part number: 011B / 75L180-0010A

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PARTS:		1. Connector 1746872-1 (B)		JIG	1. Insertion jig
NO.	PROCESS NAME	4 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1	<div><div><div><div>Visual reference</div><div>Upper guide</div><div>Upper button</div><div>Lower guide</div><div>Lower button</div></div><div><div>Double lock</div><div>CONNECTOR ORIENTATION</div></div><div><div>Press</div></div></div><div>Connector setting to insertion jig 1746872-1 (B)</div><div><div>1. Get the connector 1746872-1 (B) using right hand then insert to insertion jig. Note: Follow the connector orientation above.</div><div><div>2. Press the upper guide using left hand. Holes that need to be insert are only open.</div></div></div></div>		n/a	<div><div>CONNECTOR LOCK APPEARANCE CHECK</div><div><div>GOOD</div><div>NG</div></div><div><div>UNLOCK</div><div>HALF-LOCKED</div></div><div>CONNECTOR ILLUSTRATION</div><div><div>GOOD</div><div>NG</div></div><div><div>1746872-1 (B)</div><div>1376675-1 (B)</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>Important reminders/Note/s:</div><div>1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half- locked connector.</div></div></div>

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TAPING ASSEMBLY PROCESS

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Model code/Part number: 011B / 75L180-0010A

Customer: TRJ

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PARTS:

1. Connector 1746872-1 (B)

JIG

1. Insertion jig

NO.

PROCESS NAME

4

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

10

P1

Wire insertion to
connector
1746872-1 (B)

WIRE INSERTION ILLUSTRATION

BLACK VM TUBE (SUNPRENE)

FIRST ROW (LEFT TO RIGHT)

SECOND ROW

1. Insert 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** using right hand.
Note: Follow the insertion sequence based on the illustration stated above.

n/a

1. Use the provided jig per model
2. No wrong use of parts
3. No wrong insertion of wires
4. No deformed terminal
5. One by one insertion
6. No stuck-up 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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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

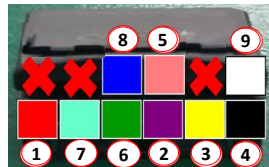
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WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

BLUE VM TUBE (SUNPRENE)



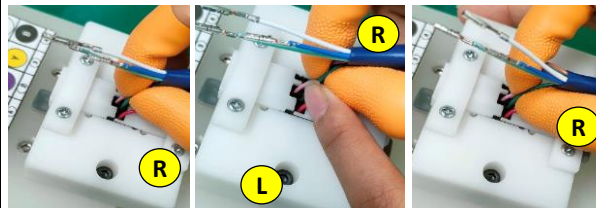
WIRE INSERTION ILLUSTRATION

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

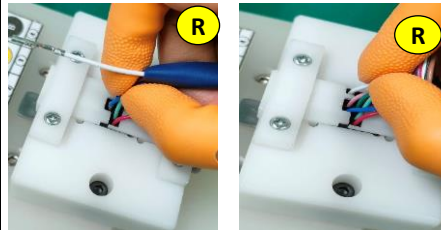


WIRE FACING

FIRST ROW (LEFT TO RIGHT)



SECOND ROW



3. Hold the **G wire** using right hand and support the wire by left index finger then insert to terminal **slot 6** using right hand. Repeat the process for **LG wire**.

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

4. Hold the **L wire** and insert to terminal **slot 8** using right hand. Repeat the process for **W wire**.

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

n/a

1. Use the provided jig per model
2. No wrong use of parts
3. No wrong insertion of wires
4. No deformed terminal
5. One by one insertion
6. No stuck-up 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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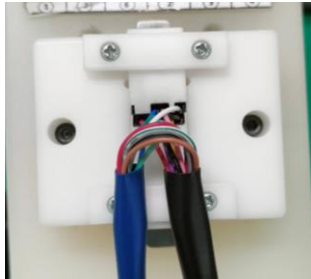
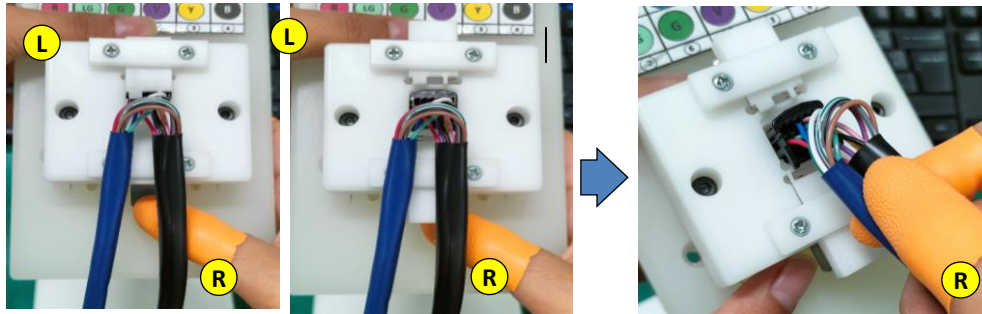
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts		JIG	1. Insertion jig
NO.	PROCESS NAME		<div>4</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
11	P1	Wire insertion to connector 1746872-1 (B) (Continuation)	<div><div>5. Press the upper and lower guide (same timing) using both hands then remove the assy part using right hand.</div></div> <div></div>	n/a	<div>1. Use the provided jig per model 2. No wrong use of parts 3. No wrong insertion of wires 4. No deformed terminal 5. One by one insertion 6. No stuck-up of terminal tip</div> <div>Important reminders/Note/s:</div> <div>1. Please hold the wire near terminal during insertion.</div> <div>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</div> <div>Document References:</div> <div>1. Refer to GL-PRO-ASY-028 for Pull-Push procedure.</div> <div>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div>

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Car Model: Toyota-Camry

Document No.:

WI-ENG-PDE-255

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

4

Page No.:

12 of 15

PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

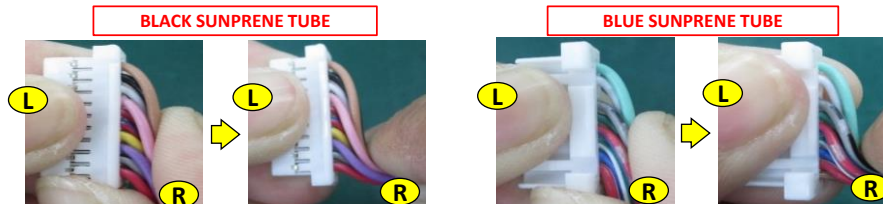
TOOLS/PPE

QUALITY POINTERS

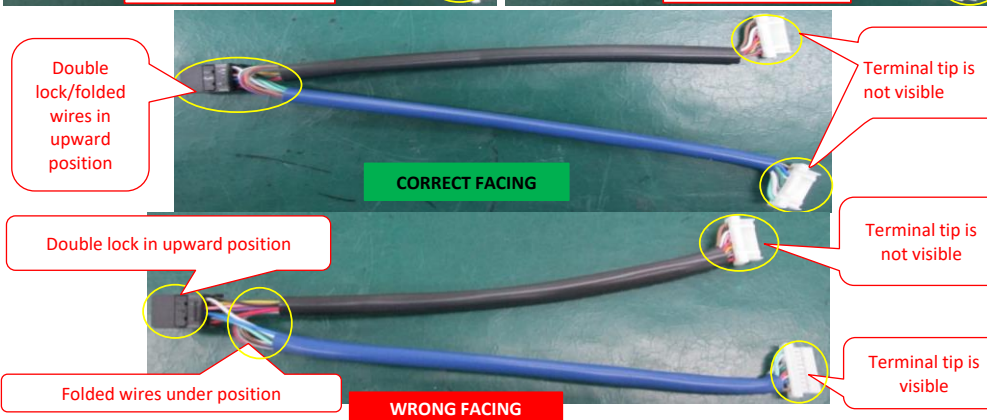
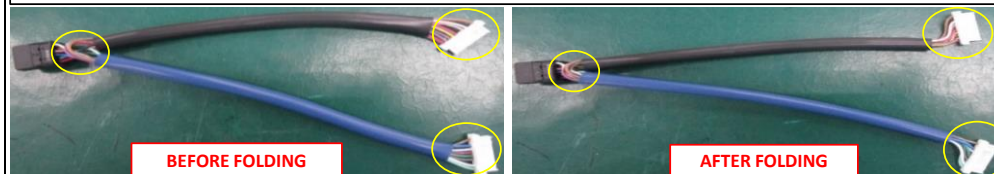
12

P1

Wire folding



1. Hold the connector **PBVP-10V-S (W)** using left hand and slightly fold the wires from Black sunprene tube *(as shown in illustration above)* using right hand. Repeat the process for connector of Blue sunprene tube.



n/a

1. No wrong orientation of connector
2. No tangled wires
3. No terminal backing out
4. No wrong facing
5. No tangled wires

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DCC Stamp



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model code/Part number: 011B / 75L180-0010A

Customer: TRJ

Car Model: Toyota-Camry

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

July 11, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-255

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PARTS:

n/a

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

13

P1

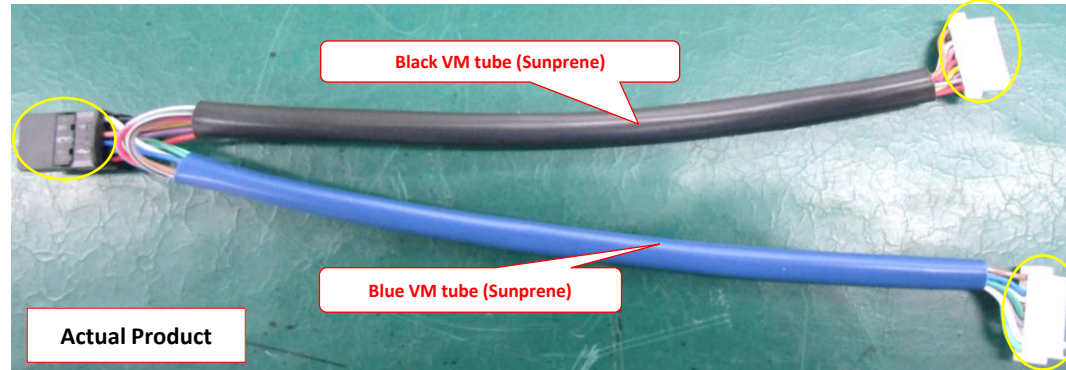
Visual/By two's inspection

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

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

3. Check the terminal if with backing out (not fully inserted) or deformed terminal.

4. Check the orientation of harness.



5. Compare to Master Sample by tapping.



Master Sample



Assembly product

Document References:

1. Refer to WI-ENG-PDE-431 for Steering Electrical Test after assembly.

MASTER SAMPLE



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Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

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Validity Date:

n/a

Model code/Part number: 011B / 75L180-0010A

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Revision No.:

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PARTS:

n/a

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

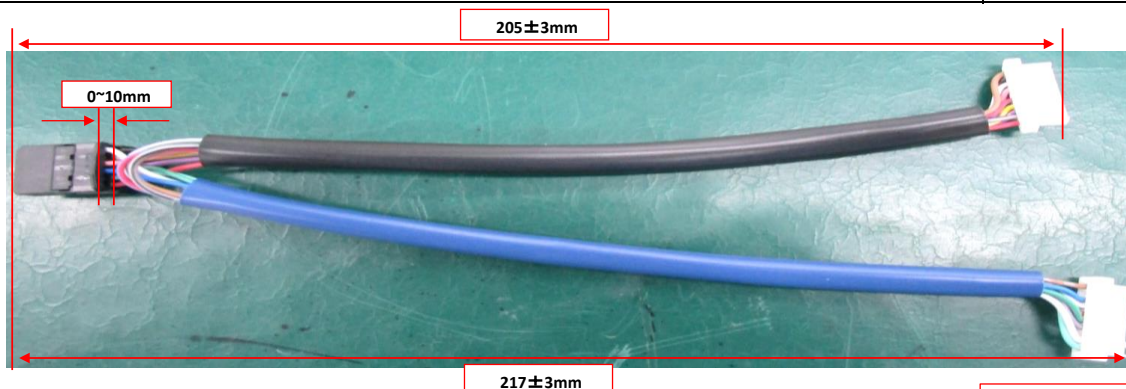
TOOLS/PPE

QUALITY POINTERS

14

P1

Measurement



Measuring tape

1. No wrong dimension

Important Reminder/Note/s:
1. Please use calibrated/verified measuring tape when getting the measurement.

2. For Hatsumuno and Owarimono

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model code/Part number: **011B / 75L180-0010A**

Customer: **TRJ**

Car Model: **Toyota-Camry**

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

July 11, 2023

Validity Date:

n/a

Document No.:

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Revision No.:

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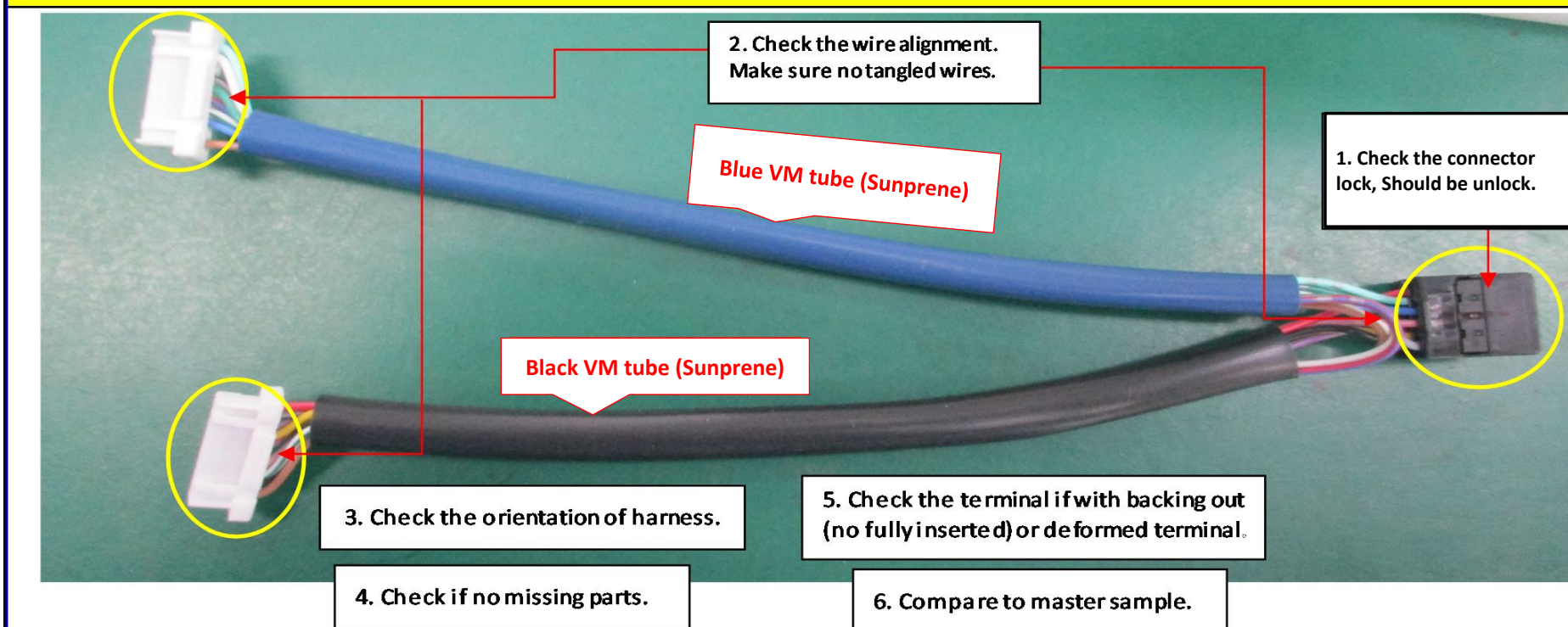
JIG:

n/a



QUALITY CHECKPOINTS

75L180-0010A



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