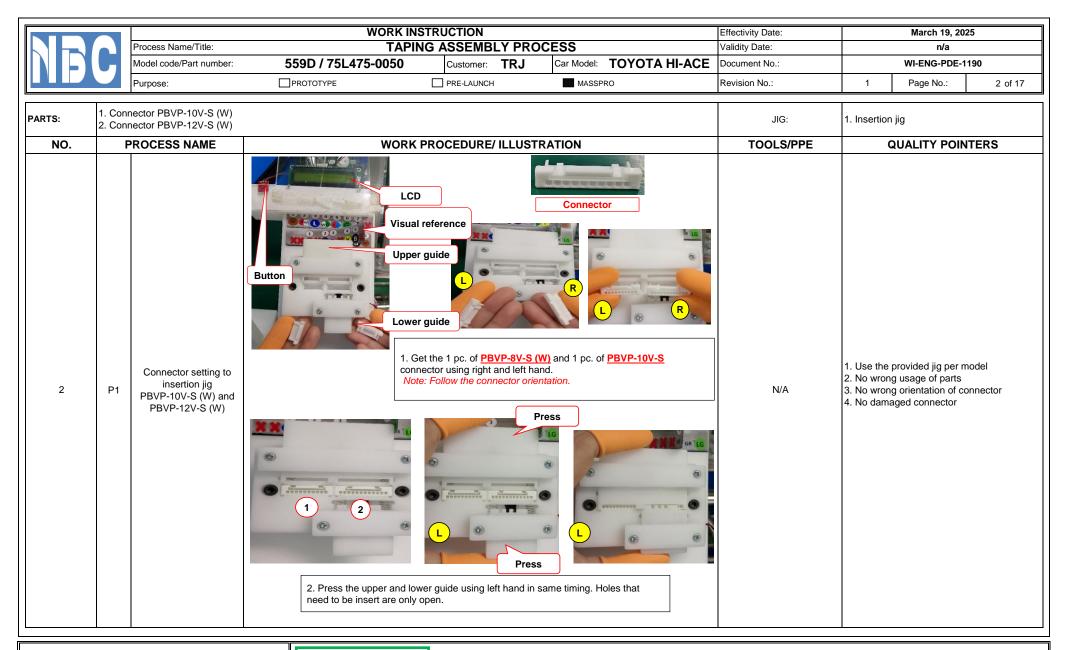
L38642mm; AVSS 0.3 RM L37642mm; AVSS 0.3 W/G L37642mm; AVSS 0.3 BR L38642mm; Black VM sube a8 L44643mm; Green NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS TABLE LAY-OUT Safety Instruction Be sure to wear required personal protective equipment during genetic or (glovens, ben octs, the sample insertion) is practiced 5's. 2 layer Navigator Housekeeping 1. Maintain and always practice 5's. 2 Personal thirds is protective equipment during genetic or (glovens, ben octs, (glovens, ben octs, the sample insertion) is practiced 5's. 2 Personal thirds is protective exception of the sample insertion is greater to wear required personal protective equipment during genetic or the sample insertion is greater to the sample insertion is greater to wear required personal protective equipment during genetic or the sample insertion is greater to wear required personal protective exception of the sample insertion is greater to wear required personal protective exception of the sample insertion is greater to wear required personal protective exception of the sample insertion is greater to wear required personal protective exception of the sample insertion is greater to wear required personal protective exception of the sample insertion is greater to wear required personal and always practice 5's. 2 Personal thirds are the sample insertion in greater to wear required personal and always practice 5's. 3 No worng usage of parts with the sample insertion in greater to wear required personal and always practice 5's. 4 No deformed terminal 2 No worng usage of parts with the sample insertion in greater to wear required personal and always practice 5's. 5 Personal thirds are the sample insert to wear required personal and always practice 5's. 6 Personal thirds are the sample insert to wear required personal and always practice 5's. 7 No deformed terminal 2 No worng usage of parts with the sample insert t				WORK IN	ISTRUCTION				Effec	ctivity Date:		March 19, 20	25
PARTS: Connector 1748972-1 (B): connector PRVP-10V-8 (W): connector PRVP-12V-8 (W): Will and AVSS 0.3 LC L. = 1862-2mm; AVSS 0.3 B. L. = 1862-2mm; AVSS 0.3 L. = 1862-2mm; AVSS 0.3 B. L. = 1862-2mm; AVSS 0.3 L. = 1862-2mm; AVSS 0.3 L. = 1862-2mm; AVSS 0.3 B. L. = 1862-2mm; AVSS 0.3 L. = 1862-2mm; AVSS 0.3 B. L. = 1862-2mm; AVSS 0.3 ML = 1862-2mm; AVSS 0.3 L. = 1862-2mm; AVSS 0			Process Name/Title:	TAPI	NG ASSEMBLY PRO	CESS			Valid	lity Date:		n/a	
1. Connector 1746872-1 (B). connector PBVP-10V-S (W); connector PBVP-12V-S (W); wire AVSS.0.3 LC Ls188±2mm; AVSS.0.3 R Ls18±2mm; AVSS.0.3 R Ls28±2mm; AVSS.0.3 R Ls28±2mm; AVSS.0.3 R R Ls28±2mm;			Model code/Part number:	559D / 75L475-0050	Customer: TRJ	Car Model:	TOYO	TA HI-ACE	Docu	ıment No.:		WI-ENG-PDE-	1190
L=187±2mm AVSS 0.3 R L=188±2mm AVSS 0.3 F L=191±2mm AVSS 0.3 F L=193±2mm AVSS 0.3 R L=194±2mm AVSS 0.3 R L=194±2			Purpose:	PROTOTYPE	PRE-LAUNCH	MASSP	RO		Revis	sion No.:	1	Page No.:	1 of 17
TABLE LAY-OUT Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger citcs, etc.)		L=187± L=196± L=360± VM tube	2mm; AVSS 0.3 GR L=188 2mm; AVSS 0.3 B L=199± 2mm; AVSS 0.3 R/W L=37 9 Ø8 L=146±3mm	±2mm; AVSS 0.3 V L=191±2mm; AVSS 2mm; AVSS 0.3 W L=200±2mm; AVSS 0±2mm; AVSS 0.3 W/G L=376±2mm; A	S 0.3 P L=193±2mm; AVSS 0 0.3 L L=204±2mm; AVSS 0. AVSS 0.3 BR L=388±2mm;BI	0.3 Y L=197±2 3 GR/B L=360 ack VM tube ø	mm; AVSS ±2mm; AV	S 0.3 G /SS 0.3 R/L			1. Ins		
Black VM tube(sunprene) e8 L=14623mm 1	NO.	Р	ROCESS NAME	WORK	PROCEDURE/ ILLUSTI	RATION				TOOLS/PPE		QUALITY POIN	NTERS
03/19/25 1 Change pre laucnh to mass pro and inclusion of table lay-out. Inclusion of permanent jig and table lay-out. A. Arañes A. Arañes A. Arañes A. Arañes A. Arañes A. Hernandez A. Arañes	1	P1	Table Lay-out	Connector 1746872-1 (B) Master sample Insertion jig B	M nprene) ø8 3mm 2 I Insertion jig A Connector PBVP	Cont	Greer (sunp L=146	erene) ø8 6±3mm	pı (Be sure to wear required personal rotective equipme during operation (gloves, finger cots etc.) Housekeeping Maintain and alway practice 5's. Personal things of the workplace is prohibited. Keep it your locker. Alert level or any trouble, inforce Assembly Assist Supervisor or Line eader for immedia	ays 1. No in 2. No rm ant exterior		
03/14/25 0 Initial issue A. Arañes A. Arañes A. Arañes A. Hernandez () J. Lorerte (C. Villanueva A. Arañes	r	1	1	Revision History						Prepared by	Checked b	y Reviewed by	Approved by
03/14/25 0 Initial issue A. Arañes A. Arañes A. Arañes A. Hernandez () J. Lorerte (C. Villanueva A. Arañes		1								1			
03/14/25 0 Initial issue A. Arañes A. Arañes A. Arañes A. Hernandez () J. Lorerte (C. Villanueva A. Arañes	03/19/25 1	Change n	e laucnh to mass pro and inclusion	n of table lay-out. Inclusion of permanent iid and to	able lav-out.	A Horsesda	II ott-	C Villanum A	Aroffee		<u> </u>	1/ 1- 11	CAN COLOR
				, , , , , , , , , , , , , , , , , , ,	y					A.Hernandez	J. Loterte	C. Villanueva	A. Aranes
Eff. Date Rev. No Details of Change Revised Checked Reviewed Approved Est. Date: March 14, 2025	Eff. Date Rev. No			Details of Change		Revised	Checked				March 14, 202		





				STRUCTION			Effectivity Date:		March 19, 202	5
		Process Name/Title:	TAPII	NG ASSEMBLY PRO	OCESS		Validity Date:		n/a	
		Model code/Part number:	559D / 75L475-0050	Customer: TRJ	Car Model:	TOYOTA HI-ACE	Document No.:		WI-ENG-PDE-11	90
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSP	PRO	Revision No.:	1	Page No.:	3 of 17
PARTS:	AVSS L=388:	0.3 GR/B L=360±2mm; AVS ±2mm; Black VM tube ø8 L=	AVSS 0.3 V L=191±2mm; AVSS 0.3 P I SS 0.3 R/L L=360±2mm; AVSS 0.3 R/W =146±3mm				JIG:	1. Insertion	jig	
NO.	F	PROCESS NAME	WORK	PROCEDURE/ ILLUST	FRATION		TOOLS/PPE	(QUALITY POINT	ΓERS
3	P1	Wire insertion to Connector PBVP-10V-S (W)	1. Get the R/L wire using right hand a P-W/G-Y-B-BR wires. Note: Follow the insertion sequence	9 10 B R W 1 2 3 R/L R/W R 360 370 187	VIRE INSERTION ILLU 4 5 6 GR/B V P 360 191 193 Peat the process	7 8 9 10 W/G Y B BR 3 376 197 199 388		2. No wron 3. One by 0 4. No wron 5. No defor 6. No stuck Importai 1. Make st Conduct P insertion. Do not exe 2. Please i during inse 3. Follow t the illustra Docume 1. Refer t procedure 2. Refer t	med terminal of terminal tip of terminders/No ure wires are proper ull-Push-Pull-Pus ert extra force. chold the wire near certion. the insertion seque tion. cent references:	ote/s: erly inserted. sh after terminal nce based on 29 for Pull-Push
4		Wire insertion to Black VM tube (sunprene) Ø8 L=146±3mm	L		tt L h u ir	1. Get the Black VM tube (Sunprene) ø8 L=146±3mm using right hand. Hold the wires using left hand and insert the wires using right hand.	N/A		g usage of parts med terminal ed wires	

			WORK IN	STRUCTION		Effectivity Date:	$\overline{\top}$	March 19, 2025	5
		Process Name/Title:	TAPIN	NG ASSEMBLY PRO	CESS	Validity Date:		n/a	
		Model code/Part number:	559D / 75L475-0050	Customer: TRJ	Car Model: TOYOTA HI-ACE	Document No.:		WI-ENG-PDE-11	90
		Purpose:	□PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	1	Page No.:	4 of 17
PARTS:			SS 0.3 V L=191±2mm; AVSS 0.3 P L=193± 360±2mm; AVSS 0.3 R/W L=370±2mm; AV			JIG:	1. Insertion ji	jig	
NO.	Р	ROCESS NAME	WORK	PROCEDURE/ ILLUSTF	RATION	TOOLS/PPE	C	QUALITY POINT	rers
5	P1	Wire insertion to connector PBVP-10V-S (W) (Continuation)	BACK VIEW OF TERMINAL GOOD Terminal condition Note: *Make sure the terminal wa *Avoid hitting the terminal	into the connector during	Damaged terminal NO GOOD Terminal condition	NO GOOD Terminal codition	2. No wrong 3. No wrong 4. No deform 5. No stuck of 6. One by or 1. Mai inserte Push a Do no 2. Plea termin 3. Aut replac encou difficu locked 4. Inse left to Docum 1. Refe Wire a 2. Refe Steerin procec 3. Refe Pull-Pu 4. Refe	ned terminal of terminal of terminal tip ne insertion retant reminders/Notake sure wires are ted. Conduct Pullafter insertion. The exert extra force as a hold the wires tomatically disposice the unit if once untered bend termulty of insertion and connector. The error of wires multiple of the error with the error of the error of wires multiple of the error of the err	e. s near on. se and hinal, nd half-ust be from C-017 for Folerance. E-044 for ntroller Y-029 for

			WORK IN	STRUCTION			Effectivity Date:		March 19, 202	25
		Process Name/Title:	TAPIN	NG ASSEMBLY F	PROCESS		Validity Date:		n/a	
		Model code/Part number:	559D / 75L475-0050	Customer: TR	J Car Model:	TOYOTA HI-ACE	Document No.:		WI-ENG-PDE-1	190
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSP		Revision No.:	1	Page No.:	5 of 17
PARTS:	1. Wire	AVSS 0.3 LG L=186±2mm	n; AVSS 0.3 W L=200±2mm; AVSS 0.3	L L=204±2mm; AVSS (0.3 G L=196±2mm;	GR L=188±2mm	JIG:	1. Insertior	n jig	
NO.	F	PROCESS NAME	WORK	PROCEDURE/ ILLU	USTRATION		TOOLS/PPE	(QUALITY POIN	TERS
6	P1	Wire insertion to Connector PBVP-12V-S (W)	INSERTION SEQUENCE FROM LEFT 1 2 3	A 5 GR LG 1 2 3 4 X X L 204 Note: Holes to open. Lower guide		STRATION		2. No wron 3. One by 4. No wron 5. No defo 6. No stuci Importa 1. Please during in 2. Refer Push pro 3. Make Conduct insertion. Do not e. 4. Follow	ant reminders/ e hold the wire neasertion. to GL-PRO-ASY-cocedure. sure wires are pro-	Note/s: ar terminal 029 for Pull- perly inserted. ush after

			WORK IN	NSTRUCTION		Effectivity Date:	$\overline{}$	March 19, 202	5
		Process Name/Title:	TAPI	ING ASSEMBLY PRO	DCESS	Validity Date:		n/a	
		Model code/Part number:	559D / 75L475-0050	Customer: TRJ	Car Model: TOYOTA HI-ACE	Document No.:		WI-ENG-PDE-11	90
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	1	Page No.:	6 of 17
						<u> </u>			
PARTS:	1. Wire	AVSS 0.3 LG L=186±2mm	; AVSS 0.3 W L=200±2mm; AVSS 0.3	3 L L=204±2mm; AVSS 0.3 C	G L=196±2mm; GR L=188±2mm	JIG:	1. Insertion ji	iig	
NO.	P	ROCESS NAME	WORK	K PROCEDURE/ ILLUST	RATION	TOOLS/PPE	C	QUALITY POIN	ΓERS
7	P1	Wire insertion to connector PBVP-10V-S (W) (Continuation)	BACK VIEW OF TERMINAL GOOD Terminal condition Note: *Make sure the terminal w *Avoid hitting the terminal		Damaged terminal NO GOOD Terminal condition	NO GOOD Terminal codition	2. No wrong 3. No wrong 4. No deform 5. No stuck of 6. One by on Impor 1. Malinserte Push a Do noi 2. Plea termin 3. Autt replac encou difficu locked 4. Inse left to Docum 1. Refe Wire au 2. Refe Steerir proced 3. Refe Pull-Pu 4. Refe	ned terminal of terminal tip ne insertion retant reminders/New sure wires are ed. Conduct Pullafter insertion. It exert extra forcase hold the wire neal during insertional during insertionatically dispose the unit if once untered bend termility of insertion ad connector. It erto of wires mirght. ment reference/s: ert to WI-PRO-CNU and Strip Length in the WI-ENG-PDE and Navigation Codure. It is a connecture. It is a connecture to GL-PRO-AS ush procedure. It is a connecture to GL-PRO-AS ush procedure. It is a connecture to GL-PRO-AS ush procedure.	e properly -Push-Pull- e. s near on. se and ininal, ind half- ust be from C-017 for Folerance. E-044 for introller Y-029 for

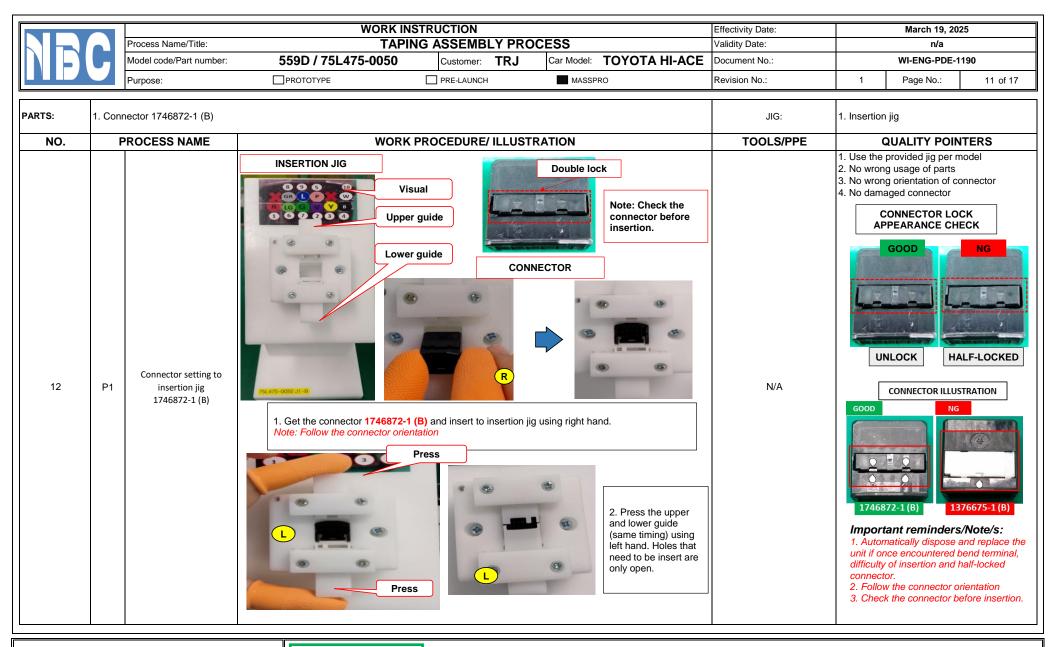
	_		WORK	INSTRUCTION			Effectivity Date:		March 19, 202	25
		Process Name/Title:		PING ASSEMBLY PR	OCESS		Validity Date:		n/a	
	H	Model code/Part number:	559D / 75L475-0050		Car Model:	TOYOTA HI-ACE	Document No.:		WI-ENG-PDE-1	190
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSI	PRO	Revision No.:	1	Page No.:	7 of 17
PARTS:	1. Assy 2. Gree	v parts en VM tube (sunprene) ø8 L	.=146±3mm				JIG:	1. Insertior	ı jig	
NO.	F	PROCESS NAME	WO	RK PROCEDURE/ ILLUS	TRATION		TOOLS/PPE	(QUALITY POIN	TERS
8	P1	Wire insertion to Green VM tube (sunprene) ø8 L=146±3mm	1. Get the Green VM tube (Sunp L=146±3mm using right hand. Ho hand then insert the wires. 3. Remove the 1st connector with press the upper guide using left holds. Note: Second connector with insert the vires are upper guide using left holds. Second connector with insert the upper guide using left holds. Second connector with insert the upper guide using left holds.	In inserted wires and Black VM land. Check the wire insertion of	condition. (Sunprene) will s	stay in the jig.		Z. No defo 3. No tang	ninal tip must be nent References: er to GL-PRO-AS tion Standard for O	Y-025 for Coupler Y-043 for

			WORK IN:	STRUCTION		Effectivity Date:		March 19, 202	25
		Process Name/Title:	TAPIN	NG ASSEMBLY PRO	CESS	Validity Date:		n/a	
		Model code/Part number:	559D / 75L475-0050	Customer: TRJ	Car Model: TOYOTA HI-ACE	Document No.:		WI-ENG-PDE-1	190
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	1	Page No.:	8 of 17
PARTS:	1. Assy	·				JIG:	1. Insertior		
NO.	F	ROCESS NAME	WORK	PROCEDURE/ ILLUST	RATION	TOOLS/PPE	(QUALITY POIN	ITERS
9	P1	Wire insertion to assy parts		R	1. Hold the Green VM tube (Sunprene) ø8 using left hand and insert the wires from Black VM tube (Sunprene) ø8 using right hand.		Z. No defo 3. No tang Tern Docum 1. Refi Inspecting Service 2. Refee	ninal tip must be nent References: er to GL-PRO-AS' tion Standard for O	Y-025 for Coupler /-043 for

			WORK INS	TRUCTION		Effectivity Date:		March 19, 202	5
		Process Name/Title:	TAPIN	G ASSEMBLY PR	OCESS	Validity Date:		n/a	
		Model code/Part number:	559D / 75L475-0050	Customer: TRJ	Car Model: TOYOTA HI-ACE	Document No.:		WI-ENG-PDE-11	90
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	1	Page No.:	9 of 17
PARTS:	1. Assy	parts				JIG:	1. Insertion	ı jig	
NO.	F	ROCESS NAME	WORK I	PROCEDURE/ ILLUS	TRATION	TOOLS/PPE	(QUALITY POIN	ΓERS
10	P1	Wire insertion to Connector PBVP-10V-S (W)	2. Hold the R/L wire using right hand a finger then insert to connector using right Note: Follow the insertion sequence between the Note: Follow the insertion sequence the Insertion seque	I 2 38 R/W I 388 370 20	14 376 200 360 196 360 188 186 Terminal facing ft index cess on	STEERING NAVIGATION(2 layer) CONTROLLER	2. No wron 3. One by 0 4. No wron 5. No defoi 6. No stuck 7. No defoi 8. No tangl 9. No wron 1. Please during in 2. Make Conduct insertion. Do not ex Docume 1. Refer Steering 2. Refer and Strip 3. Refer Push pro	med terminal to of terminal tip rmed terminals to of terminals tip rmed terminals ed wires g facing Int reminders/Note to hold the wire near sertion. Sure wires are propull-Push-Pull-Push-Pull-Push-Vall-Push-Pull-Push to WI-ENG-PDE-C Navigation Contro to WI-PRO-CNC-0 to Length Tolerance to GL-PRO-ASY-0.	vs: r terminal perly inserted. sh after 044 for fler procedure. 17 for Wire 28 for Pull-

				ISTRUCTION			Effectivity Date:		March 19, 202	25
		Process Name/Title:		NG ASSEMBLY P			Validity Date:	1	n/a	
		Model code/Part number:	559D / 75L475-0050	Customer: TRJ	l .		Document No.:		WI-ENG-PDE-1	
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASS	PRO	Revision No.:	1	Page No.:	10 of 17
PARTS:	1. Assy						JIG:	n/a		
NO.	F	PROCESS NAME	WORK	PROCEDURE/ ILLU	STRATION		TOOLS/PPE	(QUALITY POIN	TERS
11	P1	Wire Folding 1	Connector 8V-S Connector 8V-S Terminal tip is visible Connector 8V-S Terminal tip is visible Terminal tip is visible	Terminal tip visible nal tip is sible	1 G (s b p p B Ø b	. Hold the connector with treen VM tube sunprene) ø8 and slightly end the wire. Repeat the rocess to connector lack VM tube (sunprene) 8. Checked the facing of oth connector.	n/a	2. No defo 3. No wror 4. No dam	ng orientation of co rmed terminal ng terminal facing age lance ng folding position	onnector

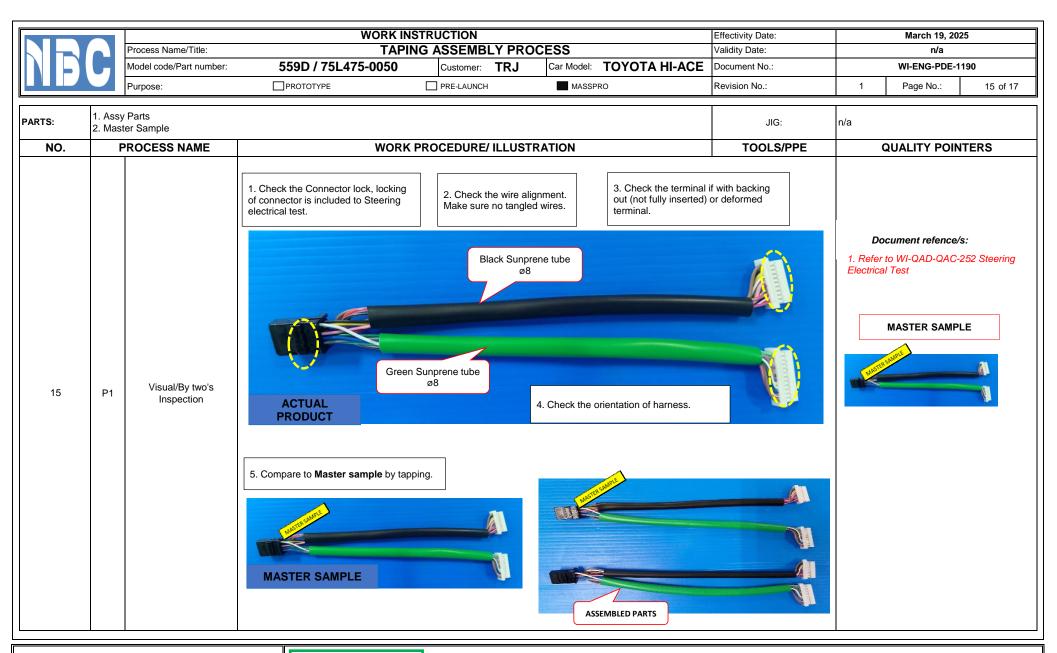


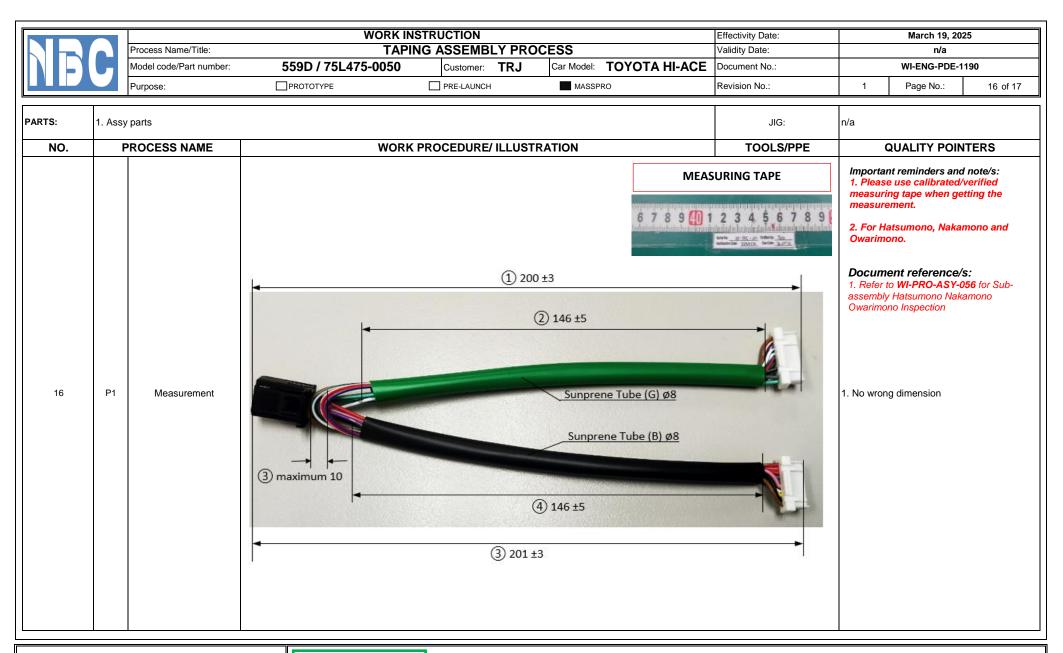


PRATS: 1. Assy parts NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION WORK PROCEDURE/ ILLUSTRATION WORK PROCEDURE/ ILLUSTRATION WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS 1. Use growided jig per model 2. No strong usage of parts 3. One study of seminal in 5. No detomate imminal 5. No study determinal in 5. No detomate imminal 5. No study departs and replace the insertion jig 174697-1 [is] 1. Insert first the wires from Black Sunprene tube. Hold the R vire and insert to terminal slot 1 using right hand. Reposal The prior for the insertion againness 1. Insert for the macrois requence 1. Insert for the macrois requence 1. Insert to GL-PRO-ASY-029 for Pull- Push process for V-FB wires and insert to terminal slot 5. Insert to GL-PRO-ASY-029 for Pull- Push process for V-FB wires and insert to terminal slot 5. Insert to GL-PRO-ASY-029 for Pull- Push process for V-FB wires and insert to terminal slot 5. Insert to the macrois requence 1. Review to Macro-ASY-029 for Pull- Push process for V-FB wires and insert to terminal slot 5. Insert to GL-PRO-ASY-029 for Pull- Push process for V-FB wires and insert to terminal slot 5. Insert to GL-PRO-ASY-029 for Pull- Push process for V-FB wires and insert to terminal slot 5. Insert to GL-PRO-ASY-029 for Pull- Push process for V-FB wires and insert to terminal slot 5. Insert to GL-PRO-ASY-029 for Pull- Push process for V-FB wires and insert to terminal slot 5. Insert to GL-PRO-ASY-029 for Pull- Push process for V-FB wires and insert to terminal slot 5. Insert to GL-PRO-ASY-029 for Pull- Push process for V-FB wires and insert to terminal slot 5. Insert to GL-PRO-ASY-029 for Pull- Push process for V-FB wires and insert to terminal slot 5. Insert to GL-PRO-ASY-029 for Pull- Push process for V-FB wires and insert to terminal slot 5. Insert to GL-PRO-ASY-029 for Pull- Push process for V-FB wires and insert to terminal slot 5. Insert to GL-PRO-ASY-029 for Pull- Push process for V-FB wires and insert to terminal slot 5. Insert to GL-PRO-ASY-029 for Pu				WORK IN	ISTRUCTION							Effectivity Date:		March 19, 202	25
PARTS: 1. Assy parts NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS No.			Process Name/Title:	TAPI	NG ASSEMB	LY PF	ROCES	SS				Validity Date:		n/a	
PARTS: 1. Assy parts NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION WIRE INSERTION ILLUSTRATION TOOLS/PPE OUALITY POINTERS 1. Use provided jig per model 2. No wrong usage of parts 3. One by one insertion 4. R LG G V V Y B 1. STROW S			Model code/Part number:	559D / 75L475-0050	Customer:	TRJ	Ca	r Model:	TOY	ота н	I-ACE	Document No.:		WI-ENG-PDE-1	190
NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION WIRE INSERTION ILLUSTRATION WIRE INSERTION ILLUSTRATION WIRE INSERTION ILLUSTRATION 1. Use provided jig per model 2. No wrong usage of parts 3. One by one insertion 4. No wrong insertion 6. No deformed terminal 6. No stuck of terminal the facing Important reminders/Note/s: 1. Automatically dispose and replace the unit if once oncountered board terminal, difficulty of insertion. Do not event exits from the flustration stated above. 1. Insert first the wires from Black Sumprene tube. Hold the R wire and insert to terminal slot 1. Using right hand. Repeat the process for V-V-B wires.			Purpose:	PROTOTYPE	PRE-LAUNCE	+		MASSF	RO			Revision No.:	1	Page No.:	12 of 17
INSERTION SEQUENCE FROM LEFT TO RICH 1		_		WORK	(PROCEDURE	:/ ILLUS	STRATI	ON							TERS
Note: Follow the insertion sequence based on the llustration stated above.	13	P1	insertion jig	INSERTION SEQUENCE FROM LI ZND ROW IST ROW BLACK SUN BLACK SUN R wire and insert to terminal slot 1 us the process for V-Y-B wires. Note: Follow the insertion sequence is	EFT TO RIGHT S 10 P W Y B 2 3 4 IPRENE Ø8 5 P V Y B 2 3 4	X 1 R 187	8 GR 188 6 LG 186 Solution 186	9 L 204 7 G 196	P 193 2 V 191 re and ir	3 Y 197 Termin Facing	10 W 200 4 B 199 aal g	N/A	2. No wron 3. One by 0 4. No wron 5. No defor 6. No stuck Import 1. Auton unit if on difficulty connecte 2. Make Conduct insertion Do not e 3. Please during in 4. Follow the illust Docum 1. Refer Push pro 2. Refer	g usage of parts one insertion g insertion g insertion med terminal c of terminal tip ant reminders/ matically dispose a ce encountered b of insertion and hor. sure wires are propull-Push-Pull-Fin. xert extra force. e hold the wire nesertion. y the insertion segration stated above the insertion stated above the GL-PRO-ASY-modelure. to WI-PRO-CNC-Insertion insertion.	/Note/s: Ind replace the end terminal, alf-locked Independ of the end terminal en

			WORK IN	STRUCTION			Effectivity Date:		March 19, 202	25
		Process Name/Title:	TAPIN	NG ASSEMBLY PROC	CESS		Validity Date:		n/a	
		Model code/Part number:	559D / 75L475-0050	Customer: TRJ		TOYOTA HI-ACE	Document No.:		WI-ENG-PDE-1	190
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSP	PRO	Revision No.:	1	Page No.:	13 of 17
PARTS:	1. Assy	parts					JIG:	1. Insertior	n jig	
NO.	F	PROCESS NAME	WORK	PROCEDURE/ ILLUSTR	ATION		TOOLS/PPE	(QUALITY POIN	TERS
13	P1	Wire insertion to Connector 1746872-1 (B) (Continuation)	L wi su fin 6 c pro	(same timi	eert to terminal ertion sequence the upper and ling) using both	lower lever guide		2. No wron 3. One by 4. No wron 5. No defo 6. No stuci Import 1. Make Conduct insertio Do not e 2. Pleas terminal 3. Follow the about	rmed terminal to of terminal tip ant reminders, sure wires are property in the property in th	(Note/s: operly inserted. oush after ar uence based on

			WORK INS				Effectivity Date:		March 19, 202	25
		Process Name/Title:	TAPIN	G ASSEMBL	Y PROCESS		Validity Date:		n/a	
		Model code/Part number:	559D / 75L475-0050	Customer:	TRJ Car Model:	TOYOTA HI-ACE	Document No.:		WI-ENG-PDE-1	190
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSE	PRO	Revision No.:	1	Page No.:	14 of 17
PARTS:	1. Assy							n/a		
NO.	F	PROCESS NAME	WORK P	ROCEDURE/	ILLUSTRATION		TOOLS/PPE	(QUALITY POIN	ITERS
14	P1	Wire Folding 2	GREEN SUNPRENE TUBE L 1. Hold the Connector PBVP-12V-S us hand and slightly fold the wire from Gree8 L=146±3mm (as illustrated above) hand. BEFORE FOLDING Double lock in upward position Terminal tip is not visible	en VM tube Dusing right	R 2. Hold the Connector hand and slightly fold the tube ø8 L=146±3mm (a using right hand. AFTER FOLIONOLOGICAL SERVICE SWARD POSITION CONTROL OF THE PROPERTY OF THE PROPERT	PBVP-10V-S using rigth ne wire from Black VM as illustrated above)	n/a	2. No tang	ng orientation of co led wires. al backing out.	onnector.





	Effectivity Date:	March 19, 2025						
WORK INSTRUCTION Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a			
Model code/Part number: 559I	59D / 75L475-0050 Customer: TRJ Car Model: TOYOTA HI-ACE			Document No.:	WI-ENG-PDE-1190			
Purpose:	OTYPE PR	RE-LAUNCH	MASSPRO	Revision No.:	1	Page No.:	17 of 17	
PARTS: n/a	JIG:	n/a						
QUALITY CHECKPOINTS								
P1	2050							
P1 75L475-0050								
Check the connector lock. Lock of connector is included in Stee Electrical test.	ring 2. Chec	2. Check the wire alignment.			3. Check the Terminal if with Backing out (Not fully inserted) or no deformed terminal.			
Black Sunprene tube ø8 Black Sunprene tube ø8								
4. Check the orienta	5. Compare to Master sample by tapping							