



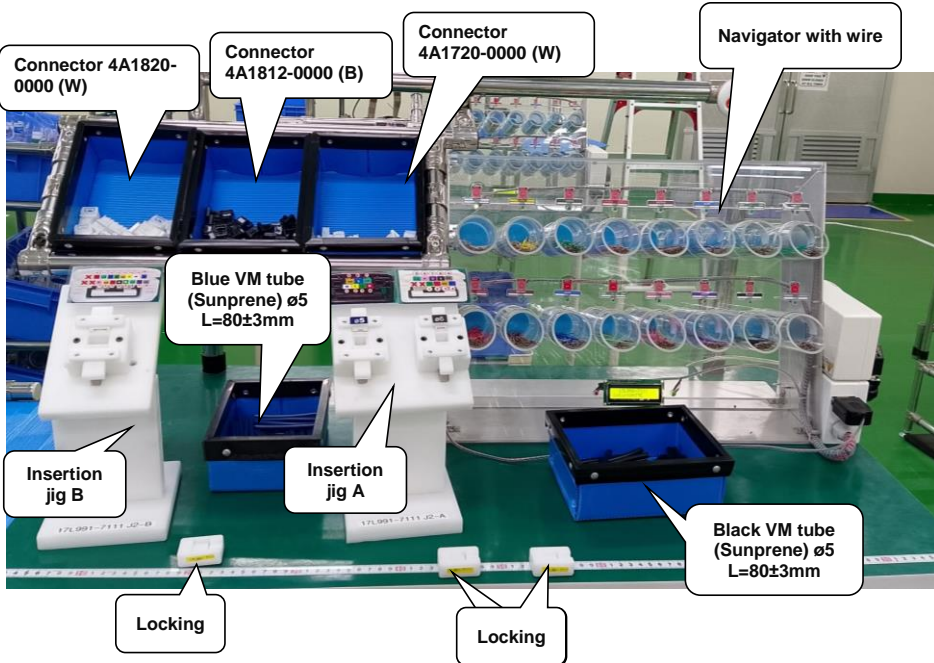
WORK INSTRUCTION
ASSEMBLY PROCESS





Effectivity Date:	April 02, 2025		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-1170A		
Revision No.:	2	Page No.:	1 of 16

Process Name/Title: **ASSEMBLY PROCESS**

Model code/Part number: **311D /400D / 17L991-7111** Customer: **TRMX** Car Model: **TOYOTA RAV-4**
TOYOTA Bz4x (BEV)

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Connector 4A1820-0000 (W), 4A1812-0000 (B), 4A1720-0000 (W), Civus Wire 0.13 P-BR-R-B-G-LG-V-GR-L-Y-W L= 116±1mm, Blue VM tube (Sunprene) ø5 L=80±3mm, Black VM tube (Sunprene) ø6 L=80±3mm		JIG:	1. Insertion jig 2. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1	<p>TABLE LAY-OUT</p> 		<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	1. No deformed terminal 2. No wrong usage of parts

Revision History							Prepared by	Checked by	Reviewed by	Approved by	
							 A.Hernandez	 J. Loterte	 C. Villanueva	 A. Arañes	
04/02/25	2	Additional model code "400D" due to new project.Insertion Process improvement. Align process sequence with levercon model.		A.Hernandez	J.Loterte	C. Villanueva					A. Arañes
12/10/24	1	Change document purpose from pre-launch to mass pro and transfer taping process to P2.		A.Hernandez	C. Villanueva	A. Arañes					n/a
11/13/24	0	Initial issue.		A.Hernandez	C. Villanueva	A. Arañes					n/a
Eff. Date	Rev. No	Details of Change			Revised	Checked	Reviewed	Approved	Est. Date:	November 13, 2024	

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311D /400D / 17L991-7111

Customer:

TRMX

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TOYOTA RAV-4
TOYOTA Bz4x (BEV)

Purpose:



PROTOTYPE



PRE-LAUNCH



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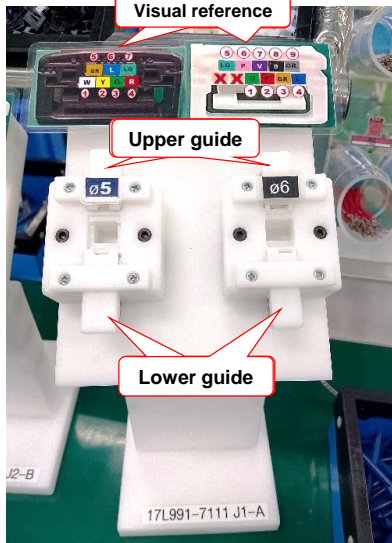
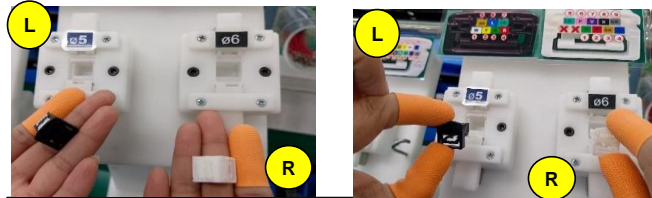
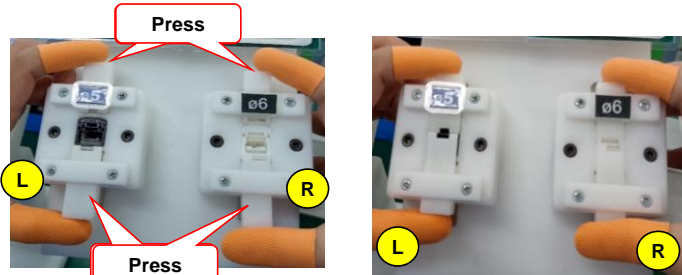
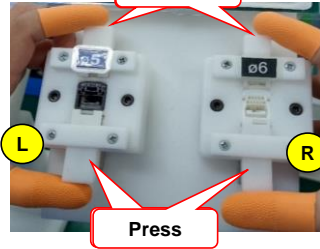
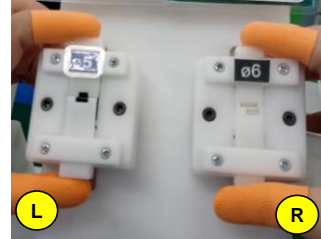
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PARTS:		1. Connector 4A1812-0000 (B) 2. Connector 4A1720-0000 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<div>Connector setting to insertion jig 4A1812-0000 (B) and 4A1720-0000 (W)</div>     			<div>1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</div>

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PROTOTYPE



PRE-LAUNCH



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PARTS:

- Connector 4A1812-0000 (B).
- Civus Wire 0.13 W-Y-G-R-BR-L-LG L= 116±1mm

JIG:

- Insertion jig

NO.

PROCESS NAME

2

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

2 QUALITY POINTERS

INSERTION SEQUENCE FROM LEFT
TO RIGHTWIRE INSERTION
ILLUSTRATION

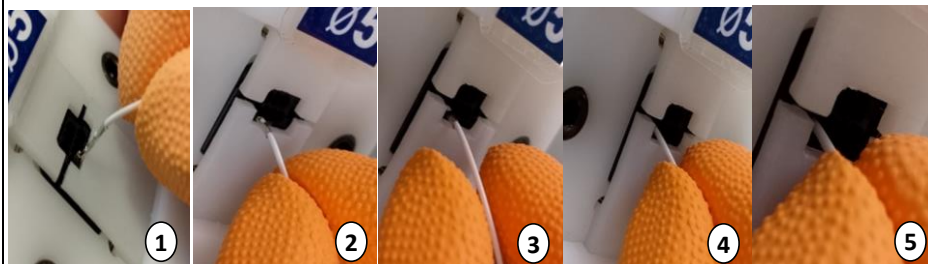
5	6	7
BR	L	LG
116	116	116

1	2	3	4
W	Y	G	R
116	116	116	116

TERMINAL
FACING

4

P1

Wire insertion to
Connector
4A1812-0000 (B)

- Get the wire and hold it 5mm away from terminal.
- Half insert the wire
- Release wire to check the color
- Conduct point checking in visual
- Hold again 5mm away from terminal

5mm

NAVIGATION(2 layer)
with CONTROLLER

Important reminders/Note/s:

- Automatically dispose and replace the unit if once encountered Bend ternal. Difficulty of insertion , Half-locked connector.
- If encountered abnormality, STOP and immediately CALL the attention of the leader. Wait for further instruction and continue the process. Do not attempt to repair.
- Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
- Follow the insertion sequence based on the visual reference
- Hold on wire during insertion must be 5mm away from terminal end.

Document references:

- Refer to GL-PRO-ASY-029 for Pull-Push procedure.
- Refer to WI-PRO-CNC-017 for wire Strip Length Tolerance

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TOYOTA Bz4x (BEV)**

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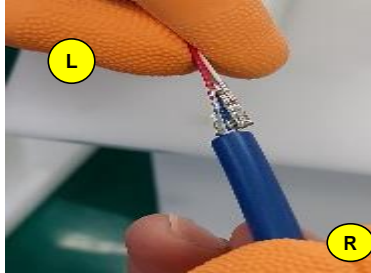
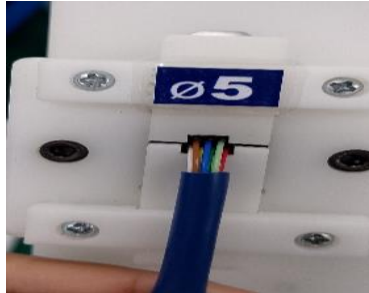
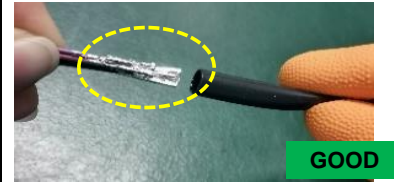
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PARTS:		1. Assy Parts 2. Blue VM tube (Sunprene) $\phi 5$ L=80 \pm 3mm		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	<div>  <div>1. Get the Blue VM tube (Sunprene) $\phi 5$ L=80\pm3mm using right hand. Hold the wires using left hand and insert the wires using right hand.</div></div>		n/a	<div> 1. No wrong use of parts 2. No deformed terminal</div>

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TOYOTA Bz4x (BEV)

Purpose:



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PARTS:

- Connector 4A1720-0000 (B).
- Civus Wire 0.13 G-R-BR-L-LG-P-V-B-GR L= 116±1mm

JIG:

- Insertion jig

NO.

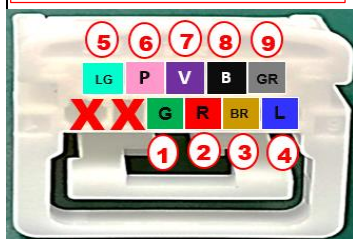
PROCESS NAME

2

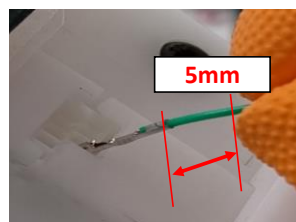
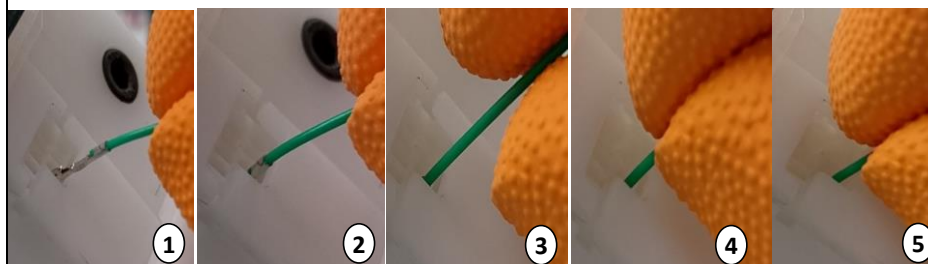
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

2 QUALITY POINTERS

INSERTION SEQUENCE FROM
LEFT TO RIGHTWIRE INSERTION
ILLUSTRATION

5	6	7	8	9
LG	P	V	B	GR
116	116	116	116	116
X	X	1	2	3
		G	R	BR
		116	116	116
				4
				L
				116

TERMINAL
FACINGNAVIGATION(2 layer)
with CONTROLLERWire insertion to
Connector
4A1720-0000 (B)

- Get the wire and hold it 5mm away from terminal.
- Half insert the wire
- Release wire to check the color
- Conduct point checking in visual
- Hold again 5mm away from terminal

- No wrong wire insertion
- No terminal backing out
- No deformed terminal
- Make sure wires are properly inserted
- Must have slight MOVEMENT after insertion
- No bend terminals/wires.

Important reminders/Note/s:

- Automatically dispose and replace the unit if once encountered Bend ternal. Difficulty of insertion , Half-locked connector.
- If encountered abnormality, STOP and immediately CALL the attention of the leader. Wait for further instruction and continue the process. Do not attempt to repair.
- Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
- Follow the insertion sequence based on the visual reference
- Hold on wire during insertion must be 5mm away from terminal end.

Document references:

- Refer to GL-PRO-ASY-029 for Pull-Push procedure.
- Refer to WI-PRO-CNC-017 for wire Strip Length Tolerance

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WORK INSTRUCTION

ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number: **311D /400D / 17L991-7111**

Customer: **TRMX**

Car Model: **TOYOTA RAV-4
TOYOTA Bz4x (BEV)**

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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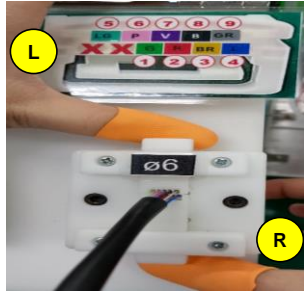
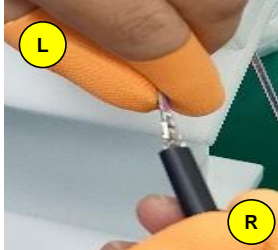

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PARTS:		1. Assy Parts 2. Black VM tube (Sunprene) $\phi 6$ L=80 \pm 3mm		JIG:	1. Insertion Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1	<div><div></div><div><p>1. Get the Black VM tube (Sunprene) $\phi 6$ L=80\pm3mm using right hand. Hold the wires using left hand and insert the wires using right hand.</p><p>2. Press the Upper and lower guide button using left and right thumb .</p><p>3. Remove the assy parts with Black VM tube (Sunprene) using right hand. Check the wire insertion condition.</p></div></div>		n/a	<div></div> <p>1. No wrong use of parts 2. No deformed terminal</p>

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Purpose:

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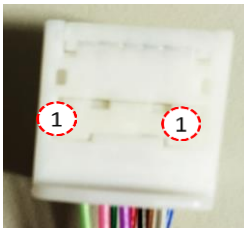
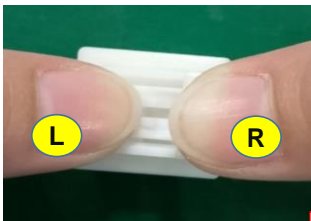



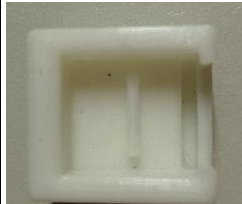
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PARTS:		1. Assy Parts		JIG:	1. Locking Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1	Connector Lock	<div></div> <div><p>Sequence of Pressing the Double Lock: ① - ① Method: Press same timing using both thumbs</p></div> <div></div> <div><p>1. Get the assy parts using left hand then put the connector locking jig using right hand. 2. Press down the connector to locking jig 2x using left & right thumb (Same timing) 3. Touch the connector lock after locking (See below sequence in checking of connector lock)</p></div> <div><p>Checking point (Left to right)</p></div> <div></div> <div></div> <div><p>4. Ensure the connector is in locked condition by slide touching the connector lock LEFT TO RIGHT using thumb.</p></div>	<div><p>Locking Jig</p></div>	<p>Important reminders/Note/s: 1. Manual locking may cause damaged connector lock</p> <p>1. No damaged double lock. 2. No half-locked connector.</p>

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Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:		1. Connector 4A1820-0000 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1	<div><div>Visual reference</div><div>Upper guide</div><div>Lower guide</div><div>Connector orientation</div><div>1. Get the 1 pc Connector 4A1720-0000 (W) using right hand then insert to insertion jig. <i>Note: Follow the connector orientation.</i></div><div>Press</div><div>Press</div><div>2. Press the upper and lower guide using left and right hand in same timing. Holes that need to be insert are only open.</div></div>			1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector

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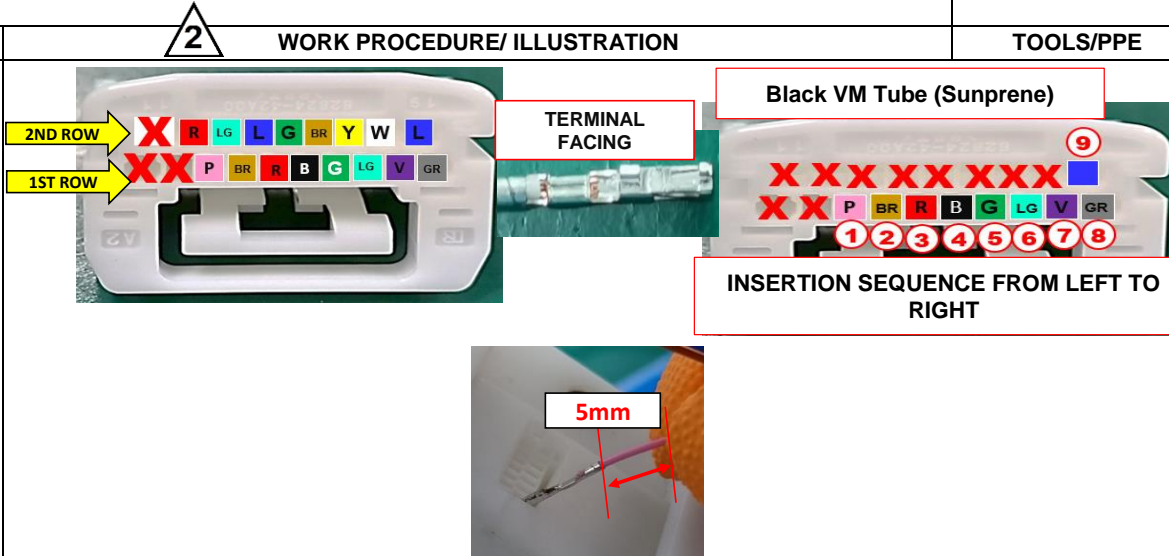
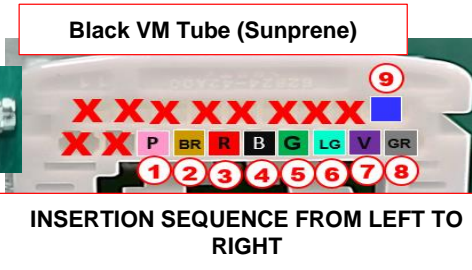
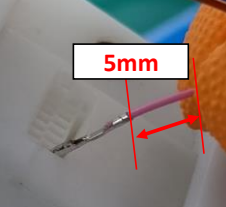



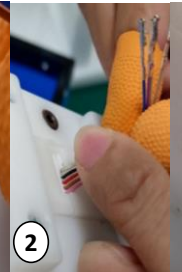

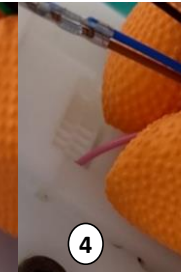
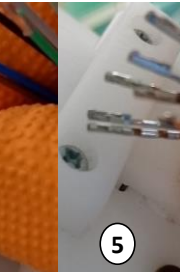
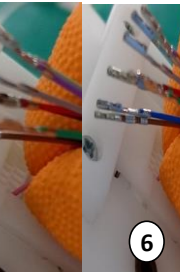
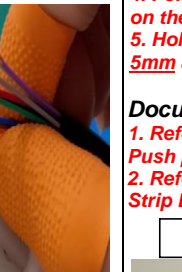
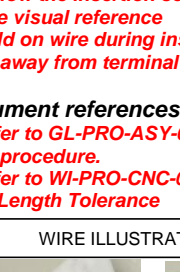
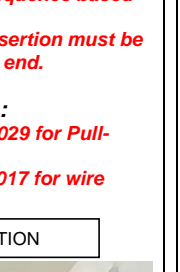
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PARTS:		1. Assy Parts 2. Connector 4A1820-0000 (W)		JIG:	1. Insertion Jig
NO.	PROCESS NAME	2 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	2 QUALITY POINTERS
9	P1 Assy Parts insertion to Connector 4A1820-0000 (W)	  			<p>1. No wrong wire insertion 2. No terminal backing out 3. No deformed terminal 4. Make sure wires are properly inserted 5. Must have slight MOVEMENT after insertion 6. No bend terminals/wires.</p> <p>Important reminders/Note/s:</p> <p>1. Automatically dispose and replace the unit if once encountered Bend ternal. Difficulty of insertion , Half-locked connector.</p> <p>2. If encountered abnormality, STOP and immediately CALL the attention of the leader. Wait for further instruction and continue the process. Do not attempt to repair.</p> <p>3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>4. Follow the insertion sequence based on the visual reference</p> <p>5. Hold on wire during insertion must be 5mm away from terminal end.</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>2. Refer to WI-PRO-CNC-017 for wire Strip Length Tolerance</p> <p>WIRE ILLUSTRATION</p>   <p>GOOD - W/OUT BEND WIRE</p> <p>NO GOOD - WITH BEND WIRE</p>
		        			<p>1. Get the wire and hold it 5mm away from terminal. 2. Support the wire by left index finger 3. Half insert the wire 4. Release wire to check the color 5. Conduct point checking in visual 6. Hold again 5mm away from terminal 7. Fully inserted wires (avoid bending during insertion).</p>

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311D /400D / 17L991-7111

Customer:

TRMX

Car Model:

**TOYOTA RAV-4
TOYOTA Bz4x (BEV)**

Purpose:



PROTOTYPE



PRE-LAUNCH



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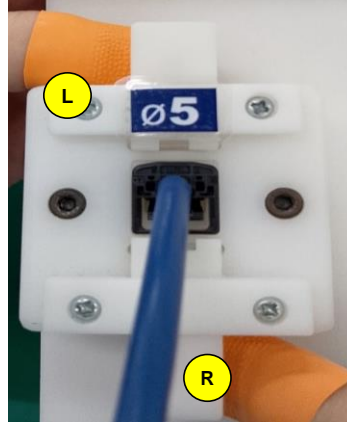
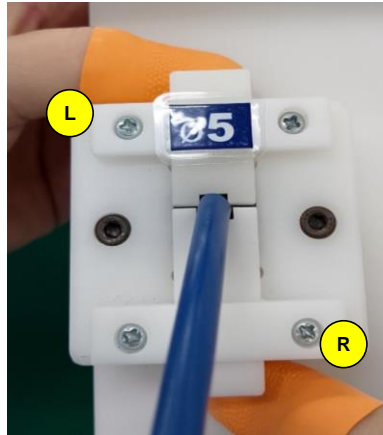
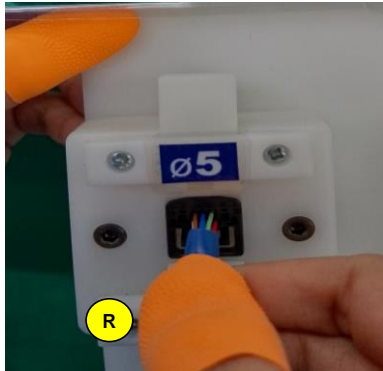
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PARTS:		1. Assy Parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	P1 Assy Parts insertion to Connector 4A1820-0000 (W) (Continuation)	<div><div>4. Press the Upper and lower guide button using left and right hand.</div><div>5. Remove the assy parts with Blue VM tube (Sunprene) using right hand. Check the wire insertion condition.</div></div>		n/a	<div>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</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>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>3. Please hold the wire near terminal during insertion.</div> <div>4. Follow the insertion sequence based on the illustration stated above.</div> <div>Document references:</div> <div>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div> <div>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div>

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**WORK INSTRUCTION**

Process Name/Title:

ASSEMBLY PROCESS

Effectivity Date:

April 02, 2025

Model code/Part number:

311D /400D / 17L991-7111

Customer:

TRMX

Car Model:

**TOYOTA RAV-4
TOYOTA Bz4x (BEV)**

Validity Date:

n/a

Purpose:



PROTOTYPE



PRE-LAUNCH



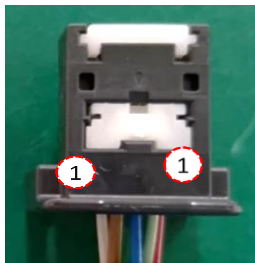
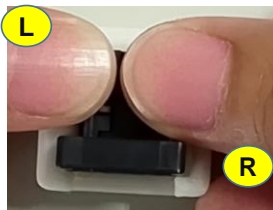
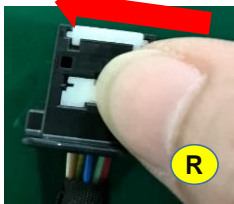
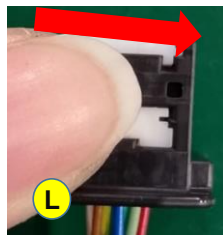


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PARTS:		1. Assy Parts		JIG:	1. Locking Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1	Connector Lock	<div><p>Sequence of Pressing the Double Lock: ① - ① Method: Press same timing using both thumbs</p></div> <div><p>1. Get the assy parts using left hand then put the connector locking jig using right hand. 2. Press down the connector to locking jig 2x using left & right thumb (Same timing) 3. Touch the connector lock after locking (See below sequence in checking of connector lock)</p><div>Checking point (Left to right)</div><p>4. Ensure the connector is in locked condition by slide touching the connector lock LEFT TO RIGHT using thumb.</p></div> <div>Locking Jig</div> 	<p>Important reminders/Note/s: 1. Manual locking may cause damaged connector lock</p> <p>1. No damaged double lock. 2. No half-locked connector.</p>	

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TOYOTA RAV-4
TOYOTA Bz4x (BEV)

Validity Date:

n/a

Purpose:



PROTOTYPE



PRE-LAUNCH



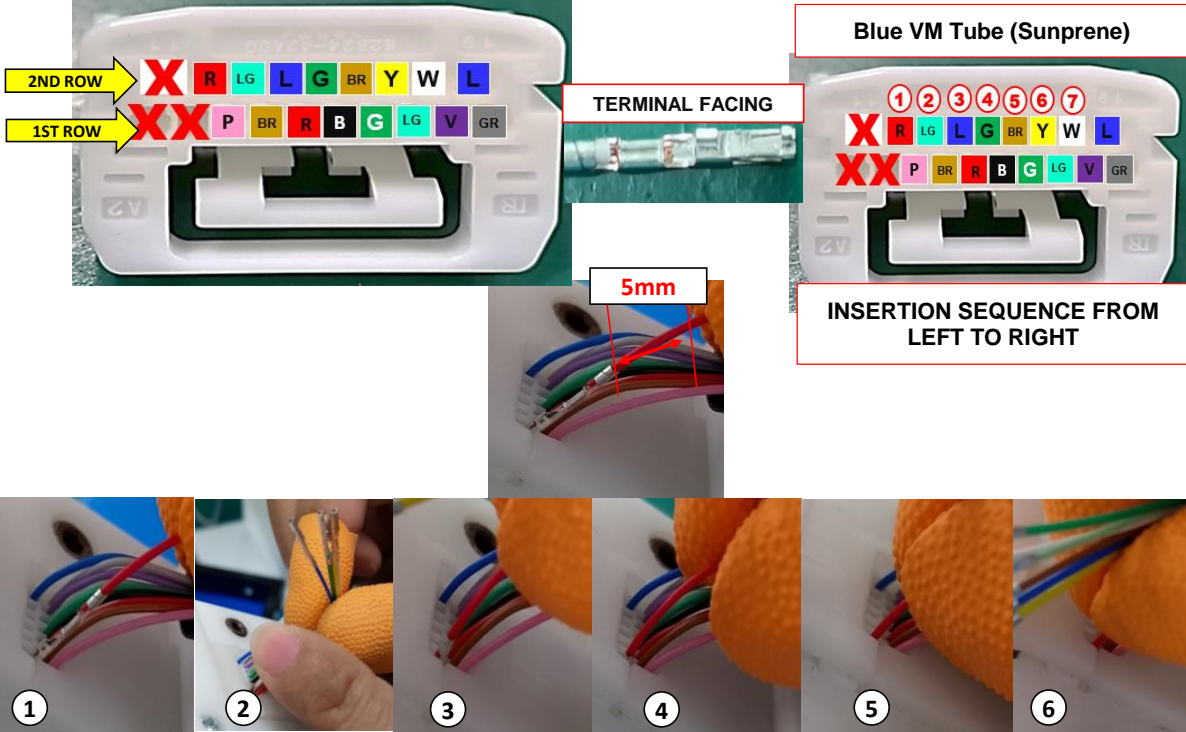


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Revision No.:

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PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	<div>2</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	<div>2</div> QUALITY POINTERS
12	P1 Assy Parts insertion to Connector 4A1820-0000 (W)	<div><div>Blue VM Tube (Sunprene)</div><div>TERMINAL FACING</div><div>5mm</div><div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div><div>1. Get the wire and hold it 5mm away from terminal. 2. Support the wire by left index finger 3. Half insert the wire 4. Release wire to check the color 5. Conduct point checking in visual 6. Hold again 5mm away from terminal 7. Fully inserted wires (avoid bending during insertion).</div></div>	<div>1. No wrong wire insertion 2. No terminal backing out 3. No deformed terminal 4. Make sure wires are properly inserted 5. Must have slight MOVEMENT after insertion 6. No bend terminals/wires.</div> <div>Important reminders/Note/s:</div> <div>1. Automatically dispose and replace the unit if once encountered Bend ternal. Difficulty of insertion , Half-locked connector. 2. If encountered abnormality, STOP and immediately CALL the attention of the leader. Wait for further instruction and continue the process. Do not attempt to repair. 3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 4. Follow the insertion sequence based on the visual reference 5. Hold on wire during insertion must be 5mm away from terminal end.</div> <div>Document references:</div> <div>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-PRO-CNC-017 for wire Strip Length Tolerance</div> <div>WIRE ILLUSTRATION</div> <div><div></div><div></div><div>GOOD - W/OUT BEND WIRE</div><div>NO GOOD - WITH BEND WIRE</div></div>	

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**WORK INSTRUCTION****ASSEMBLY PROCESS**

Process Name/Title:

Effectivity Date:

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Model code/Part number:

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Customer:

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n/a

Purpose:



PROTOTYPE



PRE-LAUNCH



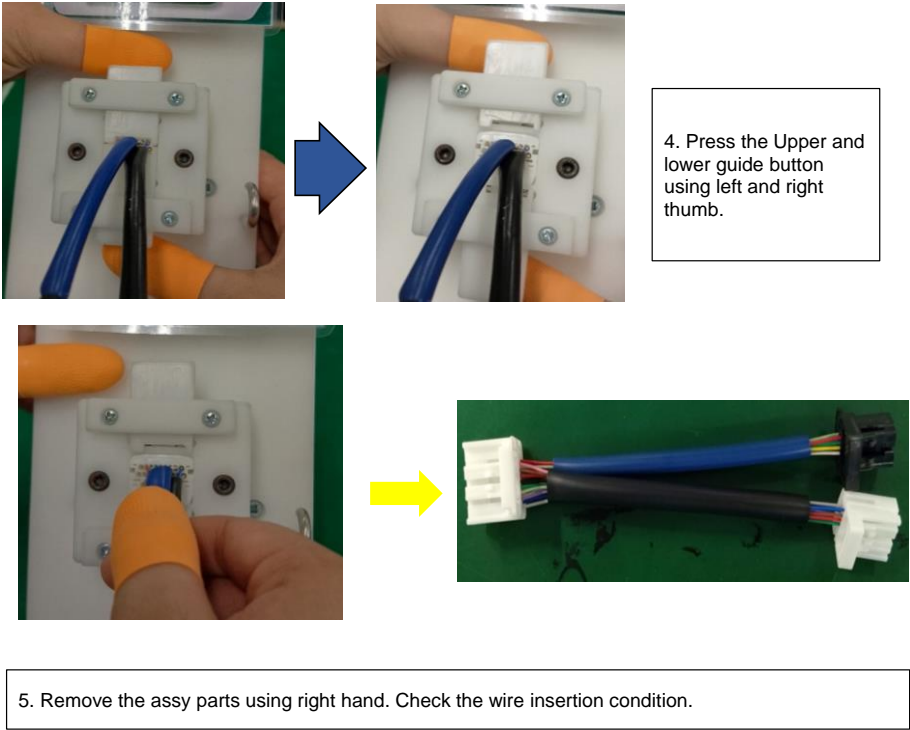
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Revision No.:

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PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
12	P1 Assy Parts insertion to Connector 4A1820-0000 (W) (Continuation)	 <div>4. Press the Upper and lower guide button using left and right thumb.</div> <div>5. Remove the assy parts using right hand. Check the wire insertion condition.</div>		n/a	<div>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</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>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>3. Please hold the wire near terminal during insertion.</div> <div>4. Follow the insertion sequence based on the illustration stated above.</div> <div>Document references:</div> <div>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div> <div>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div>

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WORK INSTRUCTION

ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number: **311D /400D / 17L991-7111**

Customer: **TRMX**

Car Model: **TOYOTA RAV-4
TOYOTA Bz4x (BEV)**

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

April 02, 2025

Validity Date:

n/a

Document No.:

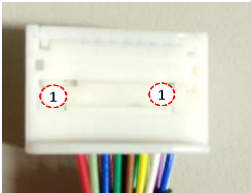
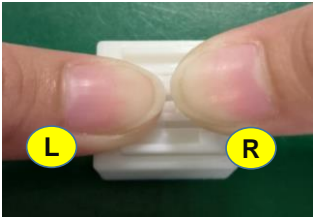

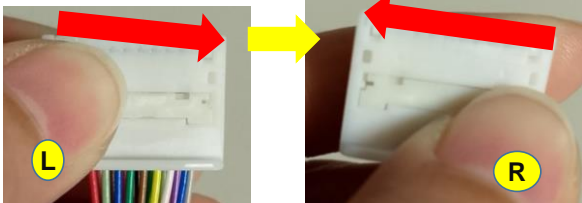
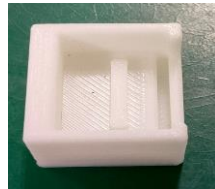
WI-ENG-PDE-1170A

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PARTS:		1. Assy Parts		JIG:	1. Locking Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
13	P1	Connector Lock	<div></div> <div>Sequence of Pressing the Double Lock: ① - ① Method: Press same timing using both thumbs</div> <div></div> <div>1. Get the assy parts using left hand then put the connector locking jig using right hand. 2. Press down the connector to locking jig 2x using left & right thumb (Same timing) 3. Touch the connector lock after locking (See below sequence in checking of connector lock)</div> <div>Checking point (Left to right)</div> <div></div> <div></div> <div>4. Ensure the connector is in locked condition by slide touching the connector lock LEFT TO RIGHT using thumb.</div>	<div>Locking Jig</div> <div></div>	Important reminders/Note/s: 1. Manual locking may cause damaged connector lock 1. No damaged double lock. 2. No half-locked connector.

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**WORK INSTRUCTION**

Process Name/Title:

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311D /400D / 17L991-7111

Customer:

TRMX

Car Model:

**TOYOTA RAV-4
TOYOTA Bz4x (BEV)**

Validity Date:

n/a

Purpose:



PROTOTYPE



PRE-LAUNCH



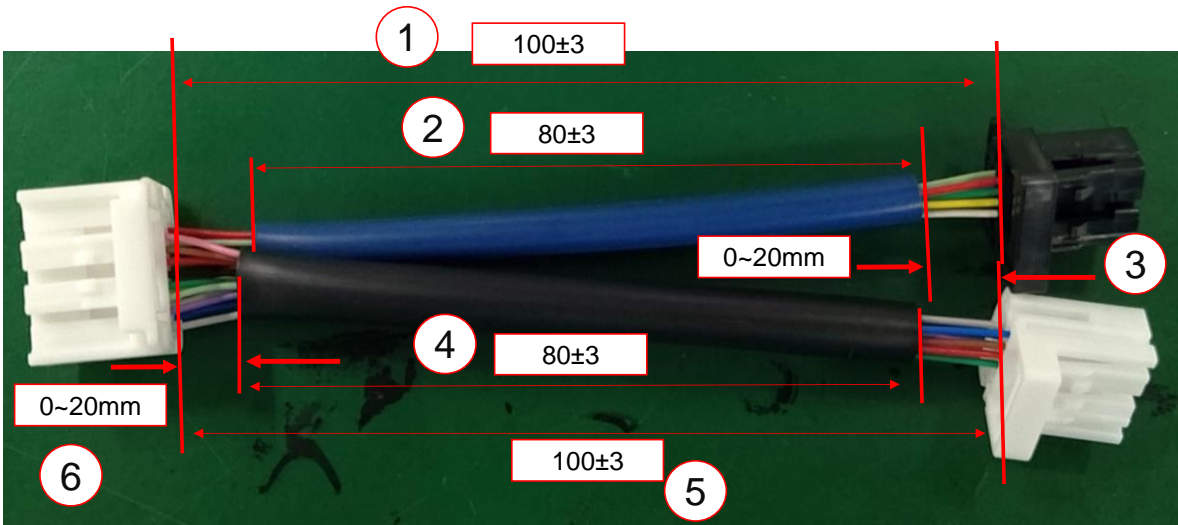
MASSPRO

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

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TOYOTA Bz4x (BEV)

Document No.:

WI-ENG-PDE-1170A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

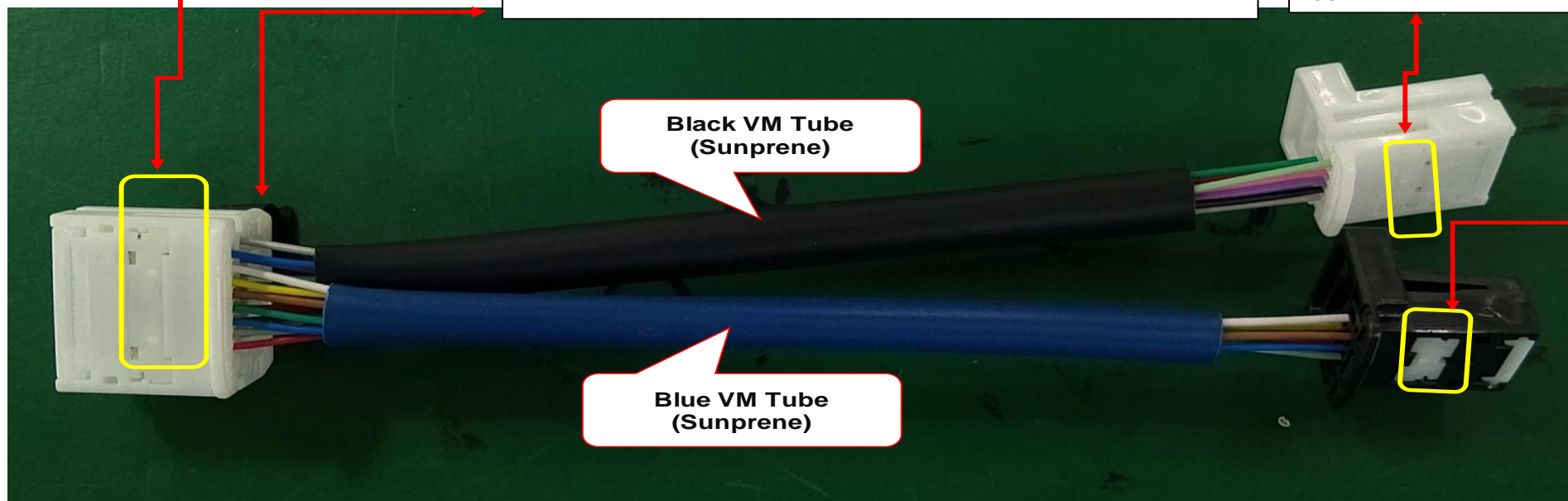
P1

17L991-7111

1. Check the connector lock.

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

1. Check the connector lock.



3. Check the orientation of harness.

5. No Bend Wire.

4. Check if no missing parts.

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

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