


	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>September 12, 2024</b>		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>400B / 75N240-0270</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA VITZ</b>	Document No.: <b>WI-ENG-PDE-090</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	11	Page No.:	1 of 18

PARTS:		1. Connector PBVP-10V-S (W) [2pcs.]; Connector 1746872-1 (B); AVSS 0.3 R, W/G, BR, Y, V, B, G, GR, GR/B, P L=130±2mm; AVSS 0.3 R/L L=211±2mm; AVSS 0.3 OR, LG, R/W, B/W L=208±2mm; Black VM tube (Sunprene) ø8 L=85±2mm; Blue VM tube (Sunprene) ø8 L=85±2mm.		JIG:	1. Insertion jig 2. Steering Navigation
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1 <div>11</div> Table lay-out	<div>TABLE LAY-OUT</div> <div><div>Connector 1746872-1 (B)/ Box</div><div>Blue VM tube (Sunprene) Ø8 L= 85±2mm</div><div>Steering Navigation</div><div>Master sample</div><div>Black VM tube (Sunprene) Ø8 L= 85±2mm</div><div>Insertion Jig B</div><div>Insertion Jig A</div><div>Connector PBVP-10V-S (W)/ Box</div></div>		<div><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div> <div><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>	1. No deformed terminal 2. No wrong usage of parts

Revision History							Prepared by	Reviewed by	Approved by	Noted by
09/12/24	11	Improved insertion jig: Change connector (PBVP-10V-S) orientation, terminal orientation and color sequence as customer claim countermeasure. Inclusion of Table lay-out. Improved Wire arrangement, Measurement and Visual inspection/Quality checkpoints. Change document number of Steering Electrical test (WI-QAD-QAC-252).	D.Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
04/17/24	10	Change R/L wire length from "L=208mm to L=211mm due to customer feedback "Terminal Backing out R/L wire".	A.Hernandez	J. Loterte	C. Villanueva	A. Arañes				
04/24/23	9	Inclusion of quality checkpoints.	J. Loterte	C. Villanueva	C. Villanueva	n/a				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 24, 2018		

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

September 12, 2024

Validity Date:

n/a

Model code/Part number:

400B / 75N240-0270

Customer:

TRJ

Car Model:

TOYOTA VITZ

Document No.:

WI-ENG-PDE-090

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

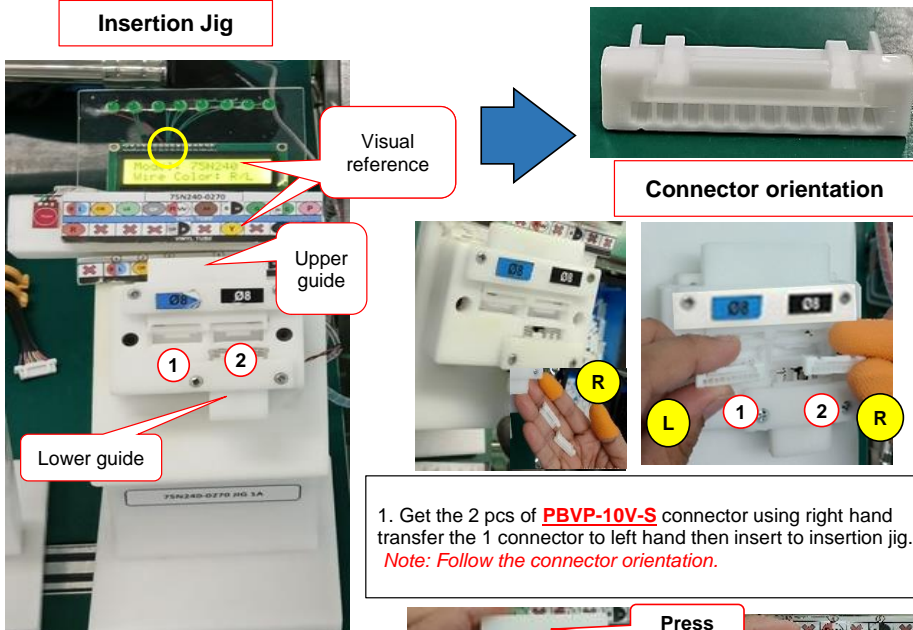
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PARTS:		1. Connector PBVP-10V-S (W) [2pcs]		JIG:	1. Insertion jig
NO.	PROCESS NAME	11 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1 Connector setting to insertion jig PBVP-10V-S (W)	<div><div>Insertion Jig</div><div><p>Visual reference</p><p>Upper guide</p><p>Lower guide</p><p>Connector orientation</p><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. <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>		n/a	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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Process Name/Title:

## TAPING ASSEMBLY PROCESS

Model code/Part number:

400B / 75N240-0270

Customer:

TRJ

Car Model:

TOYOTA VITZ

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

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### PARTS:

1. AVSS 0.3 R/L L=211±2mm; OR L=208±2mm; LG L=208±2mm; GR L=130±2mm; R/W L=208±2m; BR L=130±2mm; B/W L=208±2mm; G L=130±2mm; W/G L=130±2mm; P L=130±2mm;

JIG:

1. Insertion jig
2. Steering Navigation

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

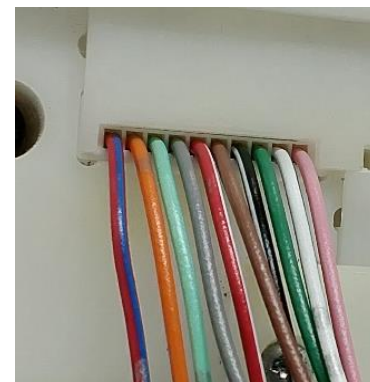
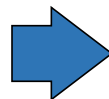


### WIRE FACING



### WIRE INSERTION ILLUSTRATION

1	2	3	4	5	6	7	8	9	10
R/L	OR	LG	GR	R/W	BR	B/W	G	W/G	P
211	208	208	130	208	130	208	130	130	130



1. Get the R/L wire using left hand and transfer to right hand then insert to connector. Repeat the process for OR-LG-GR-R/W-BR-B/W-G-W.G-P wires. Check the wire after insertion.

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

### STEERING

NAVIGATION (2 layer)



### CONTROLLER



### Important reminders/Note/s:

1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
2. Please hold the wire near terminal during insertion.
3. Insertion of wire must be from left to right.


### Important reminders/Note/s:

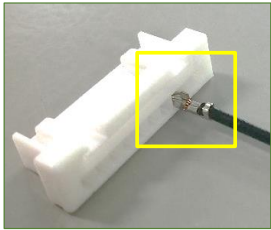
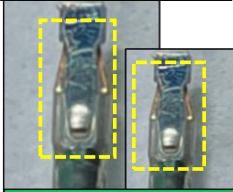
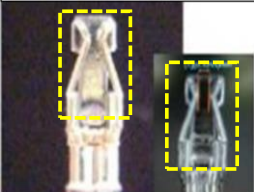

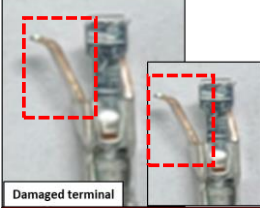
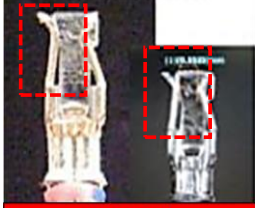
1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
3. Refer to GL-PRO-ASY for Pull-Push procedure.

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	11	Page No.:	4 of 18

<b>PARTS:</b>	1. AVSS 0.3 R/L L=211±2mm; OR L=208±2mm; LG L=208±2mm; GR L=130±2mm; R/W L=208±2m; BR L=130±2mm; B/W L=208±2mm; G L=130±2mm; W/G L=130±2mm; P L=130±2mm;			JIG:	1. Insertion jig 2. Steering Navigation		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>11 WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>			
3	P1  Wire insertion to Connector PBVP-10V-S (W) (Continuation)	<div><div>Proper alignment of terminal to connector</div><div>BACK VIEW OF TERMINAL  GOOD Terminal condition</div><div>FRONT OF TERMINAL  GOOD Terminal condition</div></div> <div><div>Improper alignment of terminal to connector</div><div>BACK VIEW OF TERMINAL  NO GOOD Terminal condition</div><div>FRONT VIEW OF TERMINAL  NO GOOD Terminal condition</div></div> <div>Note: <b>*Make sure the terminal was in proper alignment before insert.</b> <b>*Avoid hitting the terminal into the connector during wire insertion, if encountered abnormality stop the process and call the attention of Immediate superior and Automatically disposed and replace the unit.</b></div>		<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><b>Important reminders/Note/s:</b> <b>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</b> <b>2. Please hold the wires near terminal during insertion.</b> <b>3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</b> <b>4. Insertion of wires must be from left to right.</b></div> <div><b>Document reference/s:</b> <b>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</b> <b>2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..</b> <b>3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b> <b>4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</b></div>			


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	<b>WORK INSTRUCTION</b>				Effectivity Date:		<b>September 12, 2024</b>	
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:		<b>n/a</b>	
	Model code/Part number: <b>400B / 75N240-0270</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA VITZ</b>	Document No.:		<b>WI-ENG-PDE-090</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		11	Page No.: 5 of 18

<b>PARTS:</b>		1. Assy parts 2. Blue VM tube (Sunprene) Ø8 L=85±2mm		JIG:	1. Insertion jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
4	P1	<div></div> <div>1. Get the <b>Blue VM tube (Sunprene) Ø8 L=85±2mm</b> using right hand. Hold the wires using left hand and insert the wires using right hand.</div>		<div></div> <div></div>	n/a	1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Model code/Part number:

400B / 75N240-0270

Customer:

TRJ

Car Model:

TOYOTA VITZ

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

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### PARTS:

1. AVSS 0.3 R L=130±2mm; GR/B L=130±2mm; Y L=130±2mm; B L=130±2mm; V L=130±2mm

JIG:

1. Insertion jig
2. Steering Navigation

### NO.

### PROCESS NAME



### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE

### QUALITY POINTERS

5

P1

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

#### INSERTION SEQUENCE FROM LEFT TO RIGHT



#### WIRE FACING

#### WIRE INSERTION ILLUSTRATION

1	2	3	4	5
R	X	X	X	GR/B
130	X	X	X	130

1	2	3	4	5
R	X	X	X	GR/B
130	X	X	X	130

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

Lower guide

#### STEERING NAVIGATION(2 layer)



#### CONTROLLER



#### Important reminders/Note/s:

1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
2. Please hold the wire near terminal during insertion.
3. Insertion of wire must be from left to right.


#### Document reference/s:


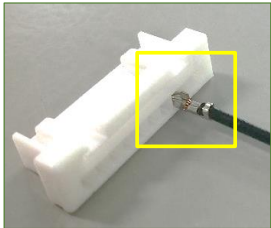

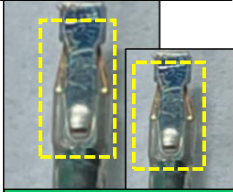
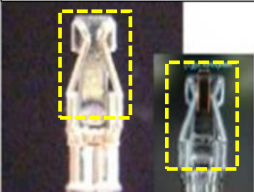
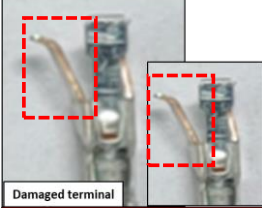

1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
3. Refer to GL-PRO-ASY-029 for Pull-Push-Push procedure.

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	11	Page No.:	7 of 18


<b>PARTS:</b>	1. AVSS 0.3 R L=130±2mm; GR/B L=130±2mm; Y L=130±2mm; B L=130±2mm; V L=130±2mm			JIG:	1. Insertion jig 2. Steering Navigation		
<b>NO.</b>	<b>PROCESS NAME</b>	 <b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>			
5	P1  Wire insertion to Connector PBVP-10V-S (W) (Continuation)	<div><div>Proper alignment of terminal to connector</div></div> <div><div>Improper alignment of terminal to connector</div></div> <div><div>BACK VIEW OF TERMINAL</div><div>GOOD Terminal condition</div></div> <div><div>FRONT OF TERMINAL</div><div>GOOD Terminal condition</div></div> <div><div>BACK VIEW OF TERMINAL</div><div>Damaged terminal NO GOOD Terminal condition</div></div> <div><div>FRONT VIEW OF TERMINAL</div><div>NO GOOD Terminal condition</div></div> <div>Note: <b>*Make sure the terminal was in proper alignment before insert.</b> <b>*Avoid hitting the terminal into the connector during wire insertion, if encountered abnormality stop the process and call the attention of Immediate superior and Automatically disposed and replace the unit.</b></div>	<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><b>Important reminders/Note/s:</b>  <b>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</b> <b>2. Please hold the wires near terminal during insertion.</b> <b>3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</b> <b>4. Insertion of wires must be from left to right.</b></div> <div><b>Document reference/s:</b>  <b>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</b> <b>2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..</b> <b>3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b> <b>4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</b></div>				

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
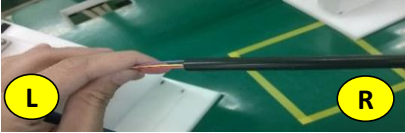
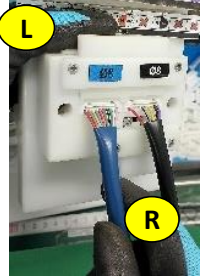

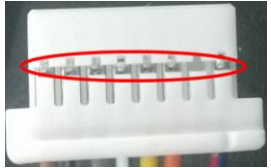
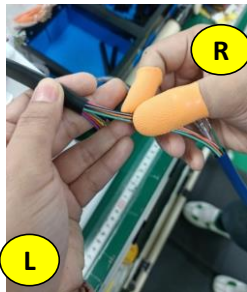
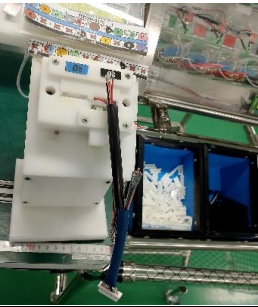
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	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:	11	Page No.:

<b>PARTS:</b>		1. Assy parts 2. Black VM tube (Sunprene) Ø8 L=85±2mm		JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	 <b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
6	Wire insertion to Black VM tube (Sunprene) Ø8 L=85±2mm  P1	<div>  <p>1. Get the <b>Black VM tube (Sunprene) Ø8 L=85±2mm</b> using right hand. Hold the wire using left hand then insert the wires.</p> </div> <div>  <p>2. Press the Upper 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 and press the lower button using right hand. Holes that need to be inserted are only open. Check the wire insertion condition.</p> <p><b>Note: Second connector with inserted wire and Black VM tube (Sunprene) will stay in the jig.</b></p> </div>	N/A	<p><b>Document reference/s:</b></p> <p>1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.</p> <p>1. No wrong usage of parts          2. No deformed terminal          3. No tangled wires</p> <div>  <p><b>Terminal tip must be visible</b></p> </div>	
7	Wire insertion to assy parts	<div>  <p>1. Hold the <b>Black VM tube (Sunprene)</b> using left hand and insert the wires from <b>Blue VM tube (Sunprene)</b> using right hand.</p> </div> <div>  </div>	N/A	<p>1. No wrong use of parts          2. No deformed terminal          3. No tangled wires</p>	

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## TAPING ASSEMBLY PROCESS

Model code/Part number:

400B / 75N240-0270

Customer:

TRJ

Car Model:

TOYOTA VITZ

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

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n/a

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### PARTS:

1. Assy parts

JIG:

1. Insertion jig
2. Steering Navigation

NO.

PROCESS NAME

11

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

### INSERTION SEQUENCE FROM LEFT TO RIGHT



WIRE FACING

### WIRE INSERTION ILLUSTRATION

	1	2	3	4	5				
R	R/L	OR	LG	GR/B	R/W	Y	B/W	B	V
130	208	208	208	130	208	130	208	130	130

### 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. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
2. Please hold the wire near terminal during insertion.
3. Insertion of wire must be from left to right.

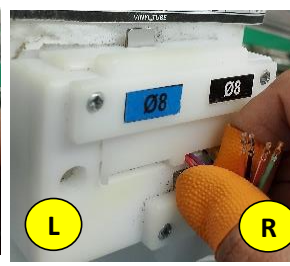
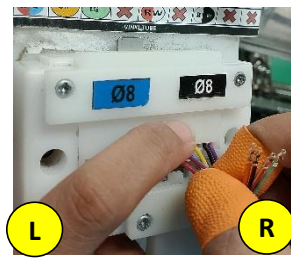
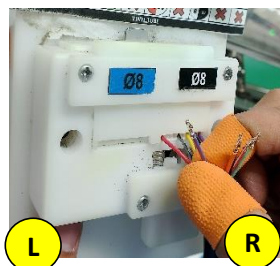
### Document reference/s:

1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

8

P1

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




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

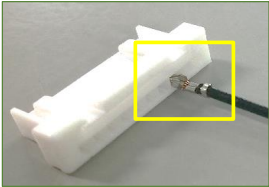
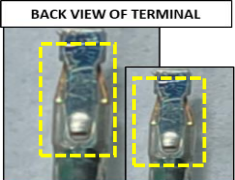
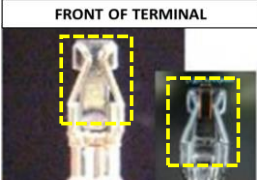

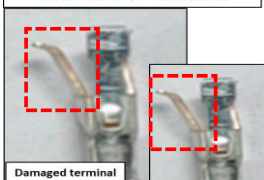

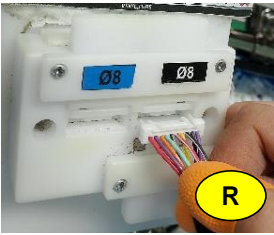
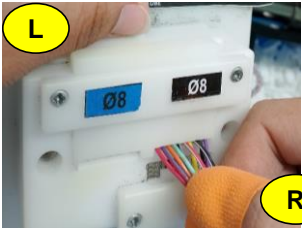
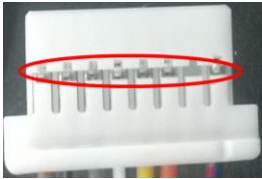
*Note: Follow the insertion sequence based on the above illustration.*

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	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 400B / 75N240-0270		Customer: TRJ	Car Model: TOYOTA VITZ	Document No.:	WI-ENG-PDE-090	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	11	Page No.:	10 of 18


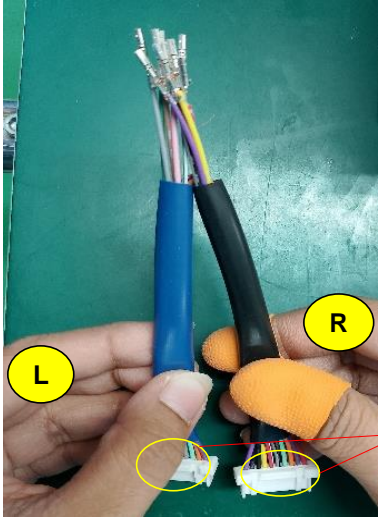
PARTS:	1. Assy parts			JIG:	1. Insertion jig 2. Steering Navigation		
NO.	PROCESS NAME	11 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS			
8	P1  Wire insertion to Connector PBVP-10V-S (W) (Continuation)	<div><div>Proper alignment of terminal to connector</div><div>BACK VIEW OF TERMINAL  GOOD Terminal condition</div><div>FRONT OF TERMINAL  GOOD Terminal condition</div></div> <div><div>Improper alignment of terminal to connector</div><div>BACK VIEW OF TERMINAL  NO GOOD Terminal condition</div><div>FRONT VIEW OF TERMINAL  NO GOOD Terminal condition</div></div> <div>Note: <b>*Make sure the terminal was in proper alignment before insert.</b> <b>*Avoid hitting the terminal into the connector during wire insertion, if encountered abnormality stop the process and call the attention of Immediate superior and Automatically disposed and replace the unit.</b></div> <div><div></div><div>3. Press the Upper button using left hand then remove the assy part using right hand. Check the wire insertion condition.</div><div> Terminal tip must be visible</div></div>		<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>Important reminders/Note/s: <b>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</b> <b>2. Please hold the wires near terminal during insertion.</b> <b>3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</b> <b>4. Insertion of wires must be from left to right.</b></div> <div>Document reference/s: <b>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</b> <b>2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..</b> <b>3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b> <b>4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</b></div>			

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	Model code/Part number: <b>400B / 75N240-0270</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA VITZ</b>	Document No.:	<b>WI-ENG-PDE-090</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	11	Page No.:	11 of 18

<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>
9	P1	<div><div><div>11</div></div><div><div>BEFORE FOLDING</div></div><div><div>AFTER FOLDING</div><div><div>1. Hold the assy parts using both hands then conduct wire arrangement.</div><div>Terminal tip is not visible</div></div></div></div> <div>N/A</div> <div><div>1. No deformed terminals</div><div>2. No tangled wires</div><div>3. No wrong facing</div></div>			


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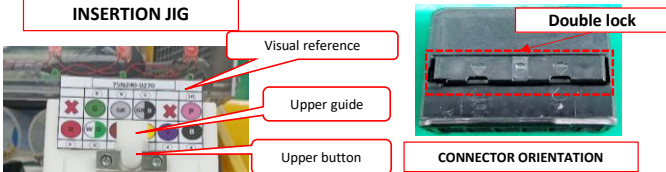



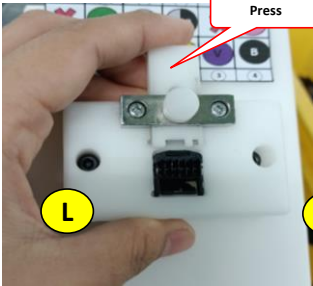
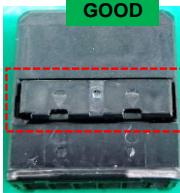
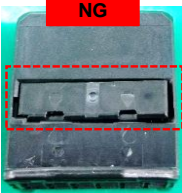
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	Model code/Part number: <b>400B / 75N240-0270</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA VITZ</b>	Document No.:	<b>WI-ENG-PDE-090</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	11	Page No.:	12 of 18

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

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## WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

September 12, 2024

Model code/Part number:

400B / 75N240-0270

Customer:

TRJ

Car Model:

TOYOTA VITZ

Document No.:

WI-ENG-PDE-090

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

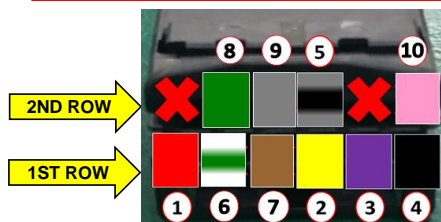
## QUALITY POINTERS

11

P1

Wire insertion to  
Connector  
1746872-1 (B)

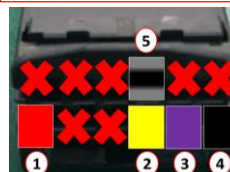
## INSERTION SEQUENCE FROM LEFT TO RIGHT



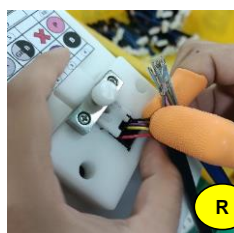
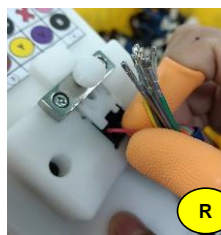
## WIRE INSERTION ILLUSTRATION

	8	9	5		10
X	G	GR	GR/B	X	P
	130	130	130		130
1	6	7	2	3	4
R	W/G	BR	Y	V	B
130	130	130	130	130	130

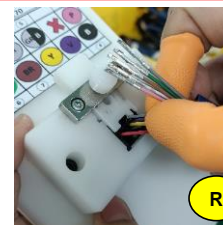
## BLACK VM TUBE



## 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 **Y-V-B wires**.  
*Note: Follow the insertion sequence based on the illustration stated above.*

2. Hold the **GR/B 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. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.
2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
3. Please hold the wire near terminal during insertion.


## Document reference/s:

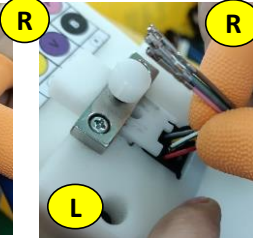
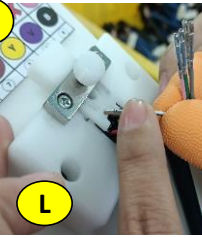
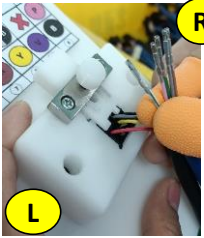
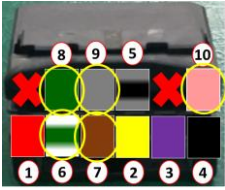
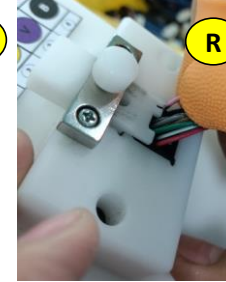
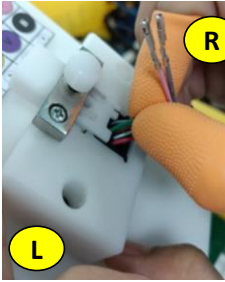
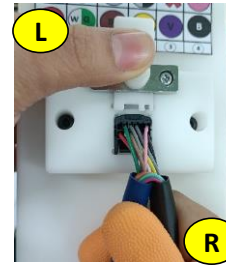
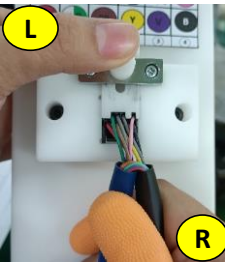
1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>400B / 75N240-0270</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA VITZ</b>	Document No.:	<b>WI-ENG-PDE-090</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	11	Page No.:	14 of 18


<b>PARTS:</b>	1. Assy parts		JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
11	P1  Wire insertion to Connector 1746872-1 (B) (Continuation)	<div><div>BLUE VM TUBE</div><p>3. Hold the <b>W/G wire</b> using right hand and support the wire by left index finger then insert to terminal slot 6 using right hand. Repeat the process for <b>BR wire</b>. <i>Note: Follow the insertion sequence based on the above illustration.</i></p><p>4. Hold the <b>G wire</b> and insert to terminal slot 8 using right hand. Repeat the process for <b>GR-P wires</b>. <i>Note: Follow the insertion sequence based on the illustration.</i></p><p>5. Press the Upper button using left hand then remove the assy part using right hand.</p></div>	N/A	<p>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</p> <p><b>Important reminders/Note/s:</b></p> <p>1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector. 2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 3. Please hold the wire near terminal during insertion.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion. 2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure. 3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p>




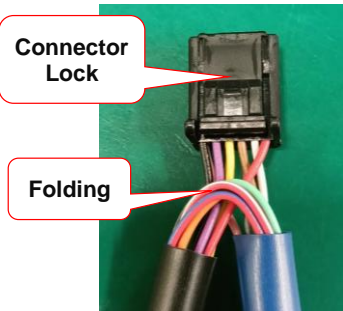
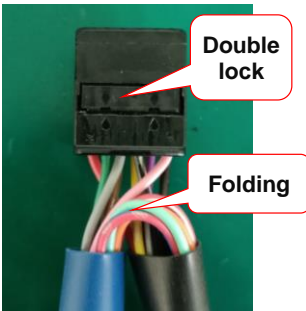
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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	11	Page No.:	15 of 18


<b>PARTS:</b>	1. Assy parts			JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	 <b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
12	P1 Wire Arrangement	<div><p>Folding at the back</p><p>Terminal tip is Not visible</p><p><b>GOOD FACING</b></p></div> <div><p>Terminal tip is visible</p><p><b>NG FACING</b></p></div> <div><p><b>GOOD FACING</b></p><p>1. Hold the harness using both hands. Arrange the wire properly to avoid tangled wires.</p><p>Connector Lock</p><p>Folding</p></div> <div><p><b>NG FACING</b></p><p>Double lock</p><p>Folding</p></div>	N/A	1. No wrong orientation of connector 2. No tangled wires 3. No wrong facing of wire folding	







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	Model code/Part number: <b>400B / 75N240-0270</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA VITZ</b>	Document No.:	<b>WI-ENG-PDE-090</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	11	Page No.:	16 of 18

<b>PARTS:</b>		1. Assembled parts 2. Master sample		JIG:	n/a	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
13	P1  Visual/By Two's Inspection	<div>1. Check the connector lock. Locking of connector is included to 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 no deformed terminal.</div> <div> <b>ACTUAL PRODUCT</b></div> <div>4. Check the orientation of harness.</div> <div>5. Compare to <b>Master sample</b> by tapping</div> <div> <b>MASTER SAMPLE</b></div> <div> <b>ASSEMBLED PARTS</b></div>		<div><b>MEASURING TAPE</b> </div>	<div> <b>Document reference/s:</b>  1. Refer to <b>WI-QAD-QAC-252</b> Steering Electrical Test</div> <div><b>MASTER SAMPLE</b> </div>	

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**WORK INSTRUCTION**

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Model code/Part number:

**400B / 75N240-0270**

Customer:

**TRJ**

Car Model:

**TOYOTA VITZ**

Document No.:

**WI-ENG-PDE-090**

Purpose:


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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>① 142 ± 3</div><div><div>② 85 ± 2</div><div>⑤ 20 ± 3</div><div>④ 85 ± 2</div><div>③ 142 ± 3</div></div><div>VM tube (Sunprene) (B) ø8</div><div>VM tube (Sunprene) (L) ø8</div></div>	<div>MEASURING TAPE</div> <div></div>	<div>Important reminders and note/s:</div> <div>1.Please use calibrated /verified measuring tape when getting the measurement.</div> <div>2. For Hatsumono,Nakamono and Owarimono.</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div>
				<div>1. No wrong dimension.</div>

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Document No.:

**WI-ENG-PDE-090**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****STEERING****75N240-0270**

1. Check the connector lock, should be unlock.

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

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.

Black VM Tube (Sunprene)

Blue VM Tube (Sunprene)

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DCC Stamp