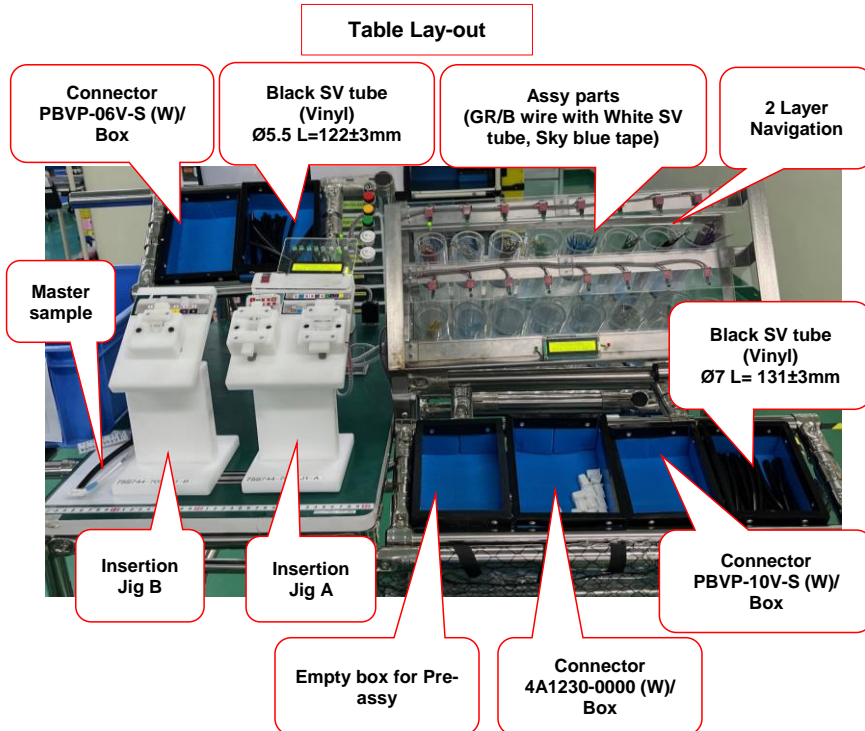

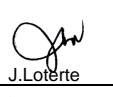

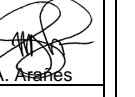
	WORK INSTRUCTION				Effectivity Date:		April 3, 2025	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 310D / 75S744-7051		Customer: TRJ	Car Model: TOYOTA-RAV 4		Document No.: WI-ENG-PDE-1120		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: 3		Page No.: 3	1 of 18		

PARTS:		1. Assy parts (GR/B wire with White SV tube, Sky blue tape); Connector PBVP-06V-S (W); Black SV tube (Vinyl) Ø7 L= 131±3mm; Black SV tube (Vinyl) Ø5.5 L=122±3mm; Connector PBVP-10V-S (W); Connector 4A1230-0000 (W); AVSS 0.3 R L=166±2mm; W/G L=168±2mm; BR L=172±2mm; LG L=289±2mm; G L=285±2mm; B L=285±2mm; V L=285±2mm; Y L=285±2mm			JIG:		1. Insertion jig 2. Steering Navigation	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE		QUALITY POINTERS	
1	P1	<div>Table Lay-out</div>  <div>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>			<div>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to WI-ENG-PDE-1151 for Taping assembly process (Pre-assy)</div> <div>1. No deformed terminal 2. No wrong usage of parts</div>			


Revision History								Prepared by	Checked by	Reviewed by	Approved by		
04/03/25	3	Change from folding to straight based on customer request.						 D. Castillo	 J. Loterte	 C. Villanueva	 A. Arañes		
12/19/24	2	Update Measurement due to wrong facing.											
11/11/24	1	Change from Pre-launch to Masspro. Inclusion of Table lay-out and improved measurement work procedure. Provision of Insertion jig. Separation of GR/B wire to tube taping.											
10/18/24	0	Initial issue.											
Eff. Date	Rev. No	Details of Change						Revised	Checked	Reviewed	Approved	Est. Date:	October 18, 2024



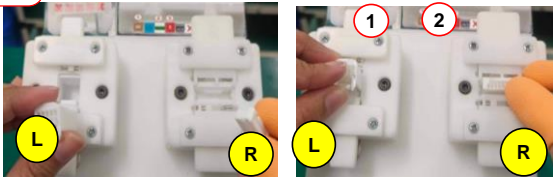
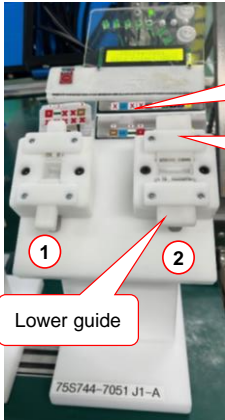



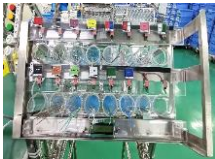

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	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: 310D / 75S744-7051		Customer: TRJ	Car Model: TOYOTA-RAV 4	Document No.:	WI-ENG-PDE-1120		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	3	Page No.:	2 of 18

PARTS:	1. Connector 4A1230-0000 (W) 2. Connector PBVP-10V-S (W)			JIG:	1. Insertion jig 2. Steering Navigation		
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
2	P1 Connector setting to insertion jig 4A1230-0000 (W) and PBVP-10V-S (W)	<div><div>Insertion Jig</div><div></div><div>Visual reference</div><div>Upper guide</div><div></div><div>Lower guide</div><div>Connector orientation</div><div></div><div>1. Get the 1 pc of 4A1230-0000 (W) using left hand and 1 pc of PBVP-10V-S (W) connector using right hand then insert to insertion jig. <i>Note: Follow the connector orientation.</i></div><div>2. Press the upper and lower guide using both hands in same timing. Holes that need to be insert are only open.</div></div> <div><div>STEERING NAVIGATION (2 layer)</div><div>CONTROLLER</div></div> <div><div>1. Use the provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div></div>					

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TAPING ASSEMBLY PROCESS

Effectivity Date:

April 3, 2025

Model code/Part number:

310D / 75S744-7051

Customer: TRJ

Car Model: TOYOTA-RAV 4

Validity Date:

n/a

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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3

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PARTS:

1. AVSS 0.3 R L=166±2mm; W/G L=168±2mm; BR L=172±2mm

JIG:

1. Insertion jig
2. Steering Navigation

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

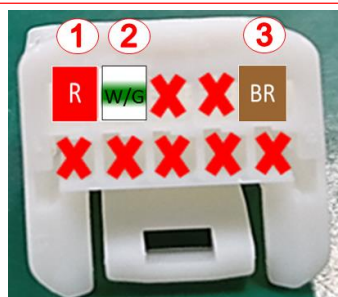
QUALITY POINTERS

3

P1

Wire insertion to
Connector
4A1230-0000 (W)

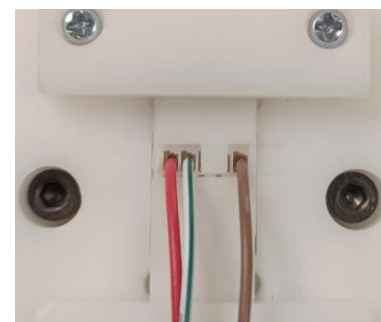
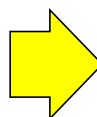
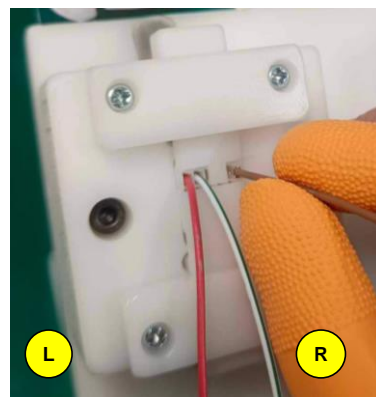
INSERTION SEQUENCE FROM LEFT TO RIGHT



TERMINAL FACING

WIRE INSERTION ILLUSTRATION

1	2			3
R	W/G	X	X	BR
166	168	X	X	172
X	X	X	X	X



1. Get the **R** wire using left hand and transfer to right hand then insert to connector. Repeat the process for **W/G** and **BR** wires. Check the wire after insertion.
Note: Follow the insertion sequence based on the illustration.

STEERING
NAVIGATION (2 layer)

CONTROLLER



1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

Important reminders/Note/s:

1. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion. Do not exert extra force.
2. Please hold the wires near terminal during insertion.
3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.
4. Insertion of wires must be from left to right.


Document reference/s:

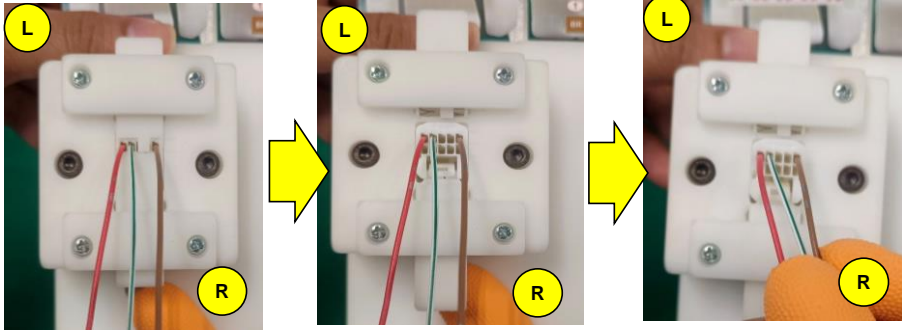
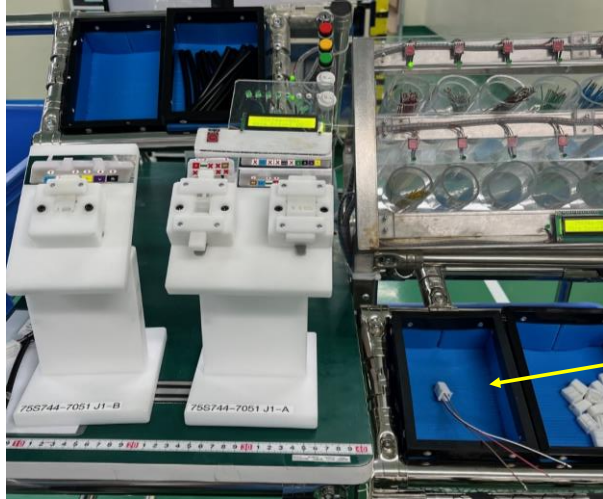
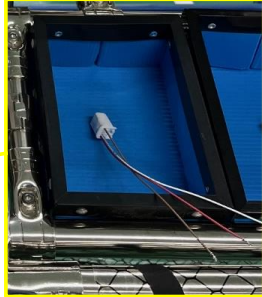


1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 310D / 75S744-7051		Customer: TRJ	Car Model: TOYOTA-RAV 4	Document No.: WI-ENG-PDE-1120		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	3	Page No.:	4 of 18

PARTS: 1. 4A1230-0000 (W) 2. Connector PBVP-10V-S (W)/		JIG: 1. Insertion jig 2. Steering Navigation	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
4	P1 Wire insertion to Connector 4A1230-0000 (W) (Continuation)	<div>  </div> <div> <p>2. Press the Upper and lower button using both hands. Remove the 1st connector with inserted wires using right hand.</p> </div> <div>  </div> <div> <p>3. After removal to insertion jig, put the assy parts to empty box. Note: Follow the illustration.</p>  </div>	<div> <p>STEERING NAVIGATION (2 layer)</p>  </div> <div> <p>CONTROLLER</p>  </div>

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WORK INSTRUCTION

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TAPING ASSEMBLY PROCESS

Effectivity Date:

April 3, 2025

Model code/Part number:

310D / 75S744-7051

Customer:

TRJ

Car Model:

TOYOTA-RAV 4

Document No.:

WI-ENG-PDE-1120

Purpose:



PROTOTYPE



PRE-LAUNCH



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PARTS:

1. AVSS 0.3 LG L=289±2mm; G L=285±2mm; B L=285±2mm; V L=285±2mm; Y L=285±2mm
2. Assy parts (GR/B with tube taping)

JIG:

1. Insertion jig
2. Steering Navigation

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

5

P1

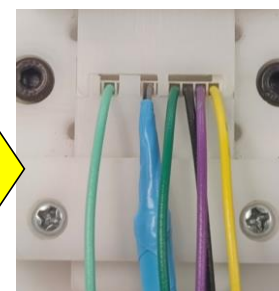
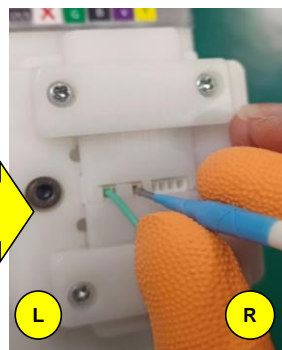
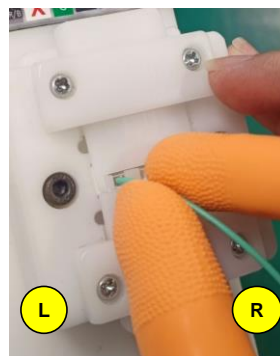
Wire insertion to
Connector
PBVP-10V-S (W)

INSERTION SEQUENCE FROM LEFT TO RIGHT

TERMINAL
FACING

WIRE INSERTION ILLUSTRATION

	1			2		3	4	5	6
X	LG 289	X	X	GR/B 120	X	G 285	B 285	V 285	Y 285

STEERING
NAVIGATION (2 layer)

CONTROLLER



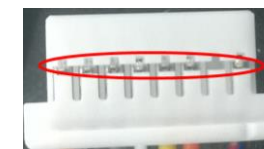
1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

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 wires near terminal during insertion.
3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.
4. Insertion of wires must be from left to right.

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.




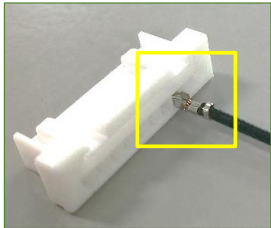

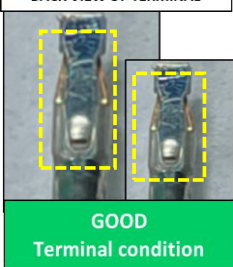
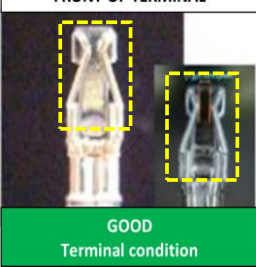
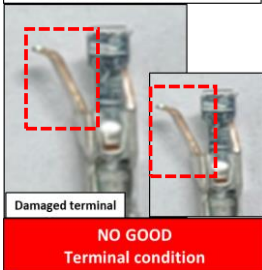

Terminal tip must be visible

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	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 310D / 75S744-7051		Customer: TRJ	Car Model: TOYOTA-RAV 4	Document No.: WI-ENG-PDE-1120		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	3	Page No.:	6 of 18


PARTS:	1. AVSS 0.3 LG L=289±2mm; G L=285±2mm; B L=285±2mm; V L=285±2mm; Y L=285±2mm 2. Assy parts (GR/B with tube taping)			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) (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: *Make sure the terminal was in proper alignment before insert. *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.</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>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 wires near terminal during insertion. 3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector. 4. Insertion of wires must be from left to right.</div> <div>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance. 2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.. 3. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</div>	


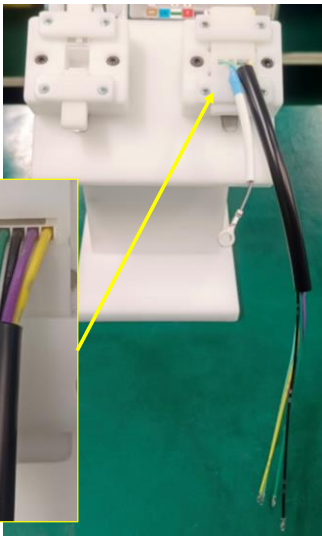
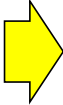
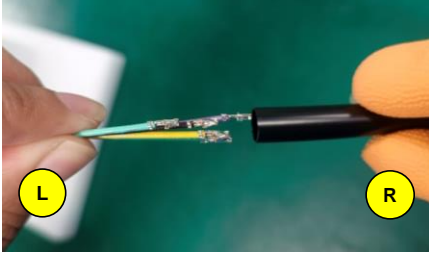

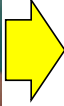
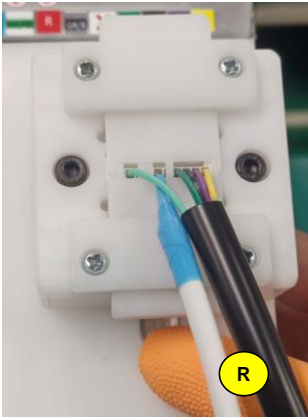
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	Model code/Part number: 310D / 75S744-7051		Customer: TRJ	Car Model: TOYOTA-RAV 4	Document No.:	WI-ENG-PDE-1120	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	3	Page No.:	7 of 18

PARTS:	1. Black SV tube (Vinyl) Ø7 L=131±3mm			JIG:	1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
6	P1 Wire insertion to Black SV tube (Vinyl) Ø7 L=131±3mm	<div><p>1. Get the Black SV tube (Vinyl) Ø7 L=131±3mm using right hand. Hold the wire using left hand then insert the wires.</p><p><i>Note: Make sure that the assy part (GR/B with tube taping) is under the Black SV tube after insertion.</i></p><p>2. Press the lower guide using right hand. Holes that need to be inserted are only open.</p></div>		n/a	1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires	

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Customer:

TRJ

Car Model:

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Document No.:

WI-ENG-PDE-1120

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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8 of 18**PARTS:**

1. Assy parts

JIG:

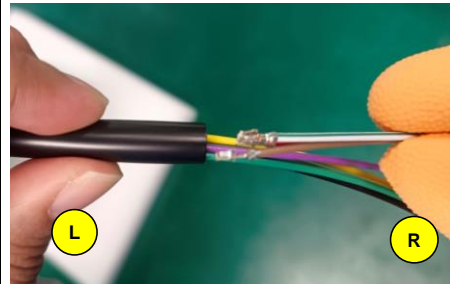
1. Insertion jig

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

7

P1

Wire insertion to assy parts



1. Hold the **Black VM tube (Sunprene)** using left hand and insert the wires of assy parts (Connector with wire) using right hand.



n/a

1. No wrong usage of parts
2. No deformed terminal
3. No tangled wires

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Purpose:



PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Assy parts

JIG:

1. Insertion jig
2. Steering Navigation

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

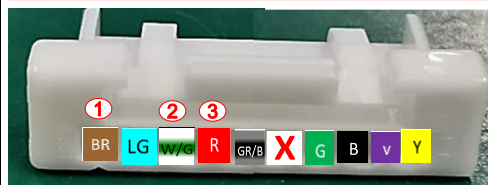
QUALITY POINTERS

8

P1

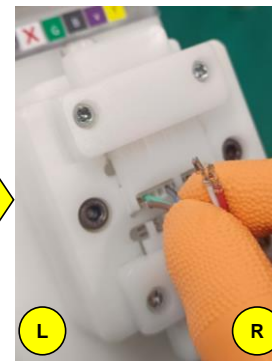
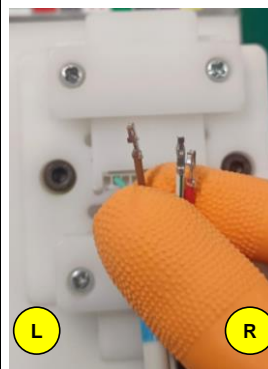
Wire insertion to
Connector
PBVP-10V-S (W)

INSERTION SEQUENCE FROM LEFT TO RIGHT

TERMINAL
FACING

WIRE INSERTION ILLUSTRATION

1		2	3						
BR	LG	W/G	R	GR/B	X	G	B	V	Y
172	289	168	166	120	X	285	285	285	285



1. Hold the **BR 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 **W/G and R wires**.
Note: Follow the insertion sequence based on the above illustration.

STEERING
NAVIGATION (2 layer)

CONTROLLER



1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

Important reminders/Note/s:

1. **Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.**
2. **Please hold the wires near terminal during insertion.**
3. **Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.**
4. **Insertion of wires must be from left to right.**

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.

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TAPING ASSEMBLY PROCESS

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Model code/Part number:

310D / 75S744-7051

Customer: TRJ

Car Model: TOYOTA-RAV 4

Validity Date:

n/a

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Document No.:

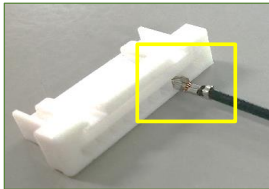
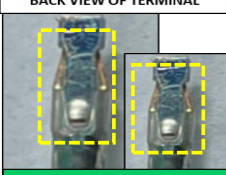
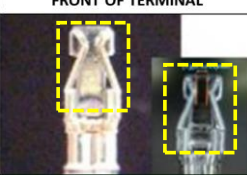

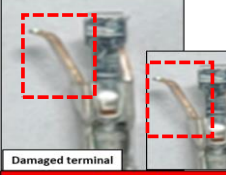




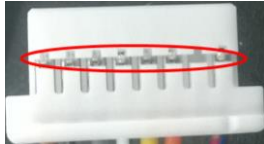
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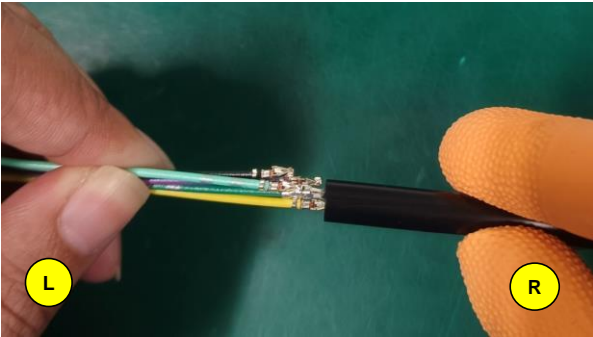

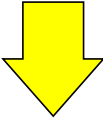
PARTS:		1. Assy parts		JIG:	1. Insertion jig 2. Steering Navigation
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1 Wire insertion to Connector PBVP-10V-S (W) (Continuation)	<div><div>Proper alignment of terminal to connector</div><div></div><div><div>BACK VIEW OF TERMINAL</div><div></div><div>GOOD Terminal condition</div></div><div><div>FRONT OF TERMINAL</div><div></div><div>GOOD Terminal condition</div></div></div> <div><div>Improper alignment of terminal to connector</div><div></div><div><div>BACK VIEW OF TERMINAL</div><div></div><div>Damaged terminal NO GOOD Terminal condition</div></div><div><div>FRONT VIEW OF TERMINAL</div><div></div><div>NO GOOD Terminal condition</div></div></div> <div><div>Note:</div><div><i>*Make sure the terminal was in proper alignment before insert.</i> <i>*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.</i></div></div> <div><div></div><div>2. Press the upper lock by left hand and hold the assy part by right hand. Check the wire after insertion</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 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 wires near terminal during insertion. 3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector. 4. Insertion of wires must be from left to right. Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance. 2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.. 3. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion. <div><div>Terminal tip must be visible</div></div>

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	WORK INSTRUCTION				Effectivity Date:		April 3, 2025	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: 310D / 75S744-7051		Customer: TRJ	Car Model: TOYOTA-RAV 4	Document No.:		WI-ENG-PDE-1120	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		3	Page No.: 11 of 18

PARTS:		1. Black SV tube (Vinyl) Ø5.5 L=122±3mm		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1 Wire insertion to Black SV tube (Vinyl) Ø5.5 L=122±3mm	<div><div>1. Get the Black SV tube (Vinyl) Ø5.5 L=122±3mm using right hand. Hold the wire of assy parts using left hand then insert the wires.</div></div>		n/a	1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires

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Customer:

TRJ

Car Model:

TOYOTA-RAV 4

Document No.:

WI-ENG-PDE-1120

Purpose:



PROTOTYPE



PRE-LAUNCH




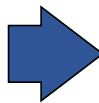

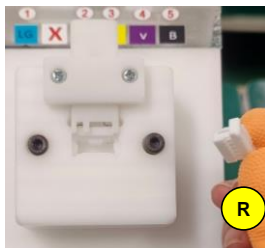

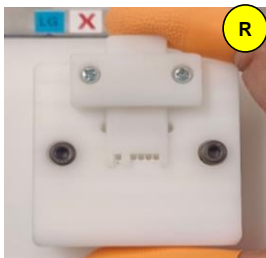

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PARTS:	1. Connector PBVP-6V-S (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	P1 Connector setting to insertion jig PBVP-6V-S (W)	<div><div><div><div><div>Insertion Jig</div><div></div></div><div><div>Visual reference</div><div>Upper guide</div></div></div><div></div><div><div>Connector orientation</div><div></div></div><div><div>1. Get the 1 pc of PBVP-6V-S connector using right hand then insert to insertion jig. <i>Note: Follow the connector orientation.</i></div></div><div><div></div><div><div><div>Press</div><div></div></div><div><div>2. Press the upper and lower guide using right hand in same timing. Holes that need to be insert are only open.</div></div></div></div></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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Purpose:



PROTOTYPE



PRE-LAUNCH



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13 of 18**PARTS:**

1. Assy parts

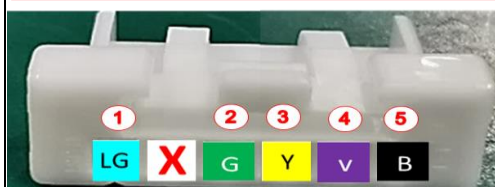
JIG:

1. Insertion jig

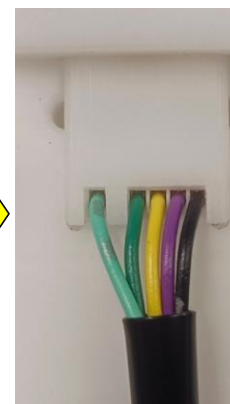
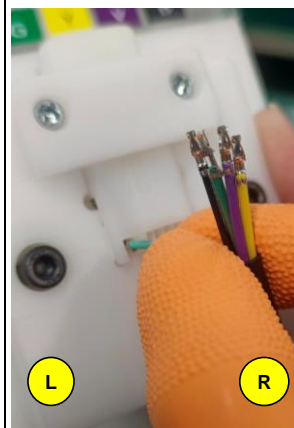
NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

11

P1

Wire insertion to
Connector
PBVP-6V-S (W)**INSERTION SEQUENCE FROM LEFT TO RIGHT****TERMINAL
FACING****WIRE INSERTION ILLUSTRATION**

1		2	3	4	5
LG	X	G	Y	V	B
289	X	285	285	285	285



1. Hold the **LG 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 **G, Y, V and B wires**.
Note: Follow the insertion sequence based on the above illustration.

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. **Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.**
2. **Please hold the wires near terminal during insertion.**
3. **Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.**
4. **Insertion of wires must be from left to right.**

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.
2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
3. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.

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Purpose:



PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Assy parts

JIG:

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

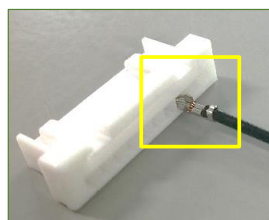
QUALITY POINTERS

11

P1

Wire insertion to
Connector
PBVP-6V-S (W)
(Continuation)

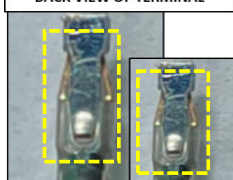
Proper alignment of terminal to connector



Improper alignment of terminal to connector



BACK VIEW OF TERMINAL



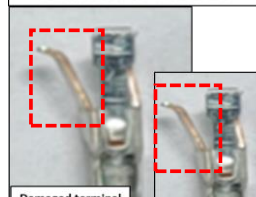
GOOD
Terminal condition

FRONT OF TERMINAL



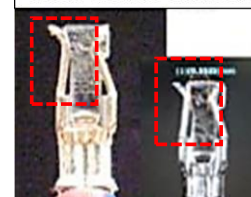
GOOD
Terminal condition

BACK VIEW OF TERMINAL



Damaged terminal
NO GOOD
Terminal condition

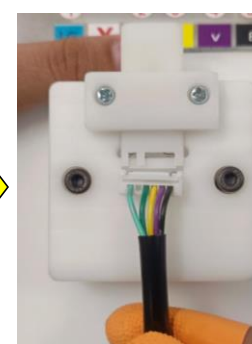
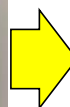
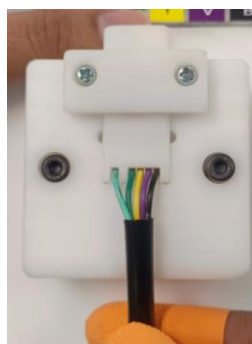
FRONT VIEW OF TERMINAL



NO GOOD
Terminal condition

Note:

**Make sure the terminal was in proper alignment before insert.
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.



2. Press the upper lock by left hand and hold the assy part by right hand. Check the wire after insertion

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 wires near terminal during insertion.

3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.

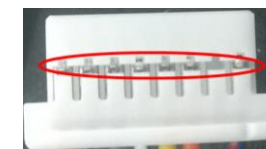
4. Insertion of wires must be from left to right.

Document reference/s:

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

2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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



Terminal tip must be visible

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TAPING ASSEMBLY PROCESS

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April 3, 2025

Model code/Part number:

310D / 75S744-7051

Customer:

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Car Model:

TOYOTA-RAV 4

Document No.:

WI-ENG-PDE-1120

Purpose:



PROTOTYPE



PRE-LAUNCH



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15 of 18**PARTS:**

1. Assy parts

JIG:

n/a

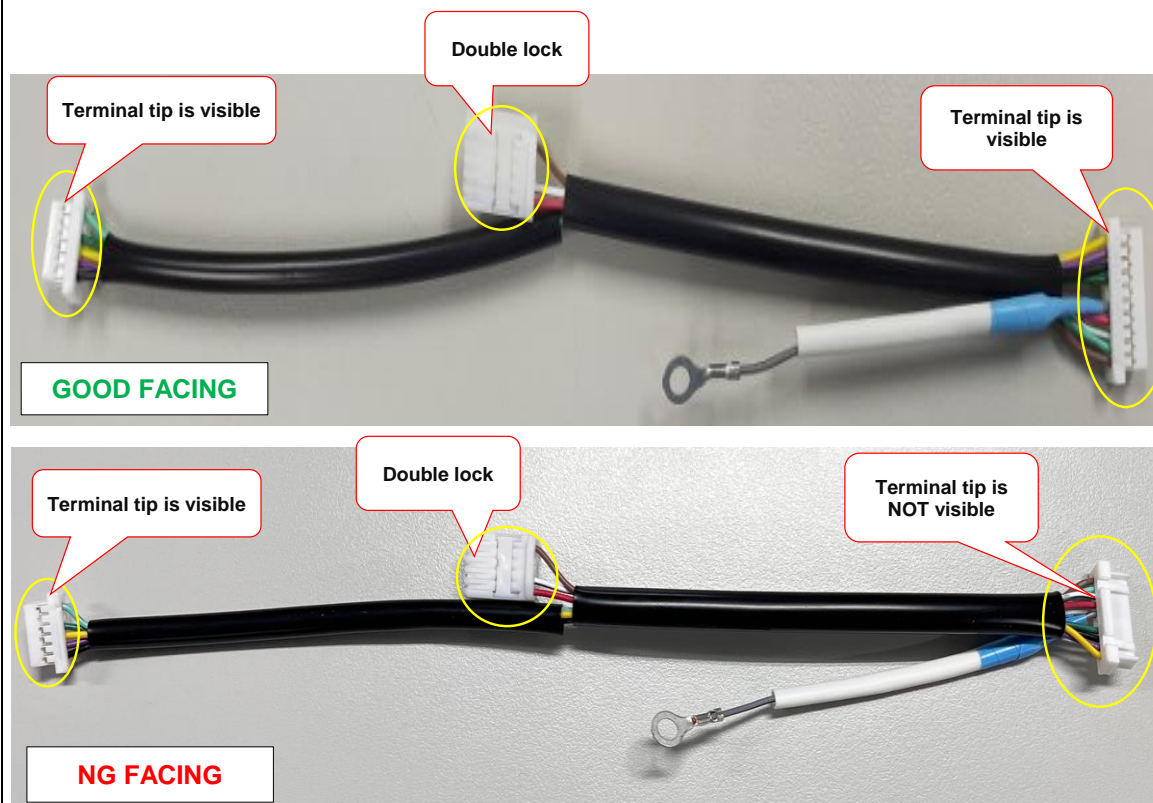
NO.**PROCESS NAME****3****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

12

P1

Wire arrangement

1. Hold the assy parts using both hands the conduct harness facing arrangement.




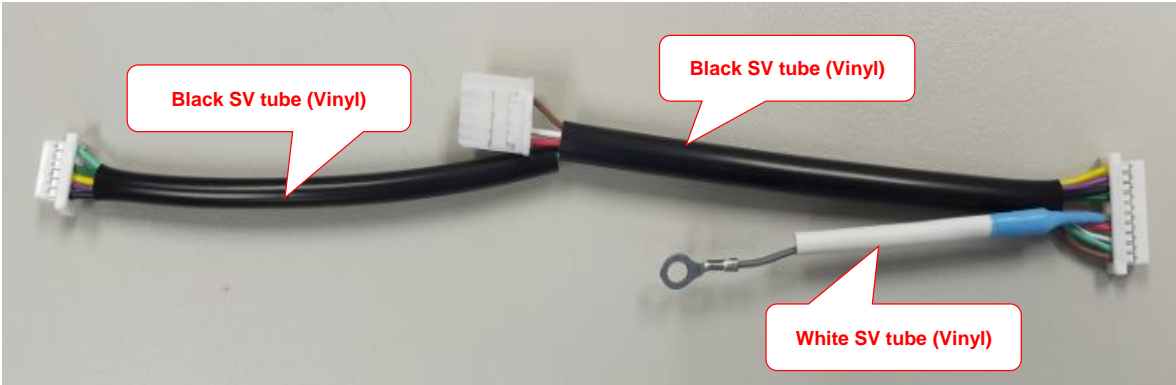
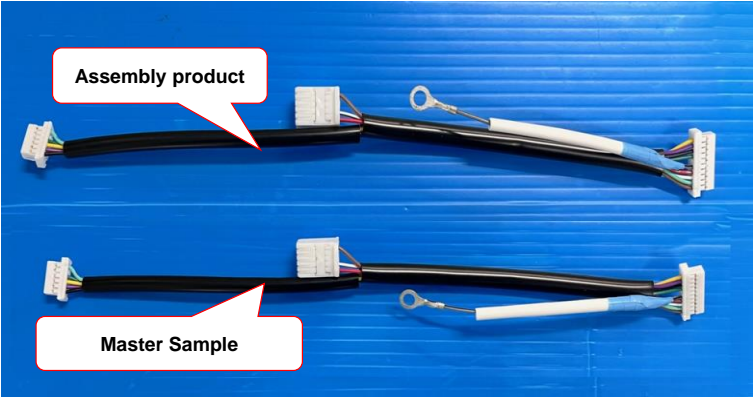

1. No wrong orientation of connector
2. No wrong use of connector
3. No wrong terminal facing

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	3	Page No.:	16 of 18


PARTS:	1. Assy parts 2. Master sample				JIG:	n/a	
NO.	PROCESS NAME	<div>3</div> WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
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></div> <div>ACTUAL PRODUCT</div> <div><div>4. Check the orientation of harness.</div><div>5. Compare to Master sample by tapping.</div></div> <div><div>Assembly product</div><div>Master Sample</div></div>				Document reference/s: 1. Refer to WI-QAD-QAC-252 Steering Electrical Test <div>MASTER SAMPLE</div> <div></div>	

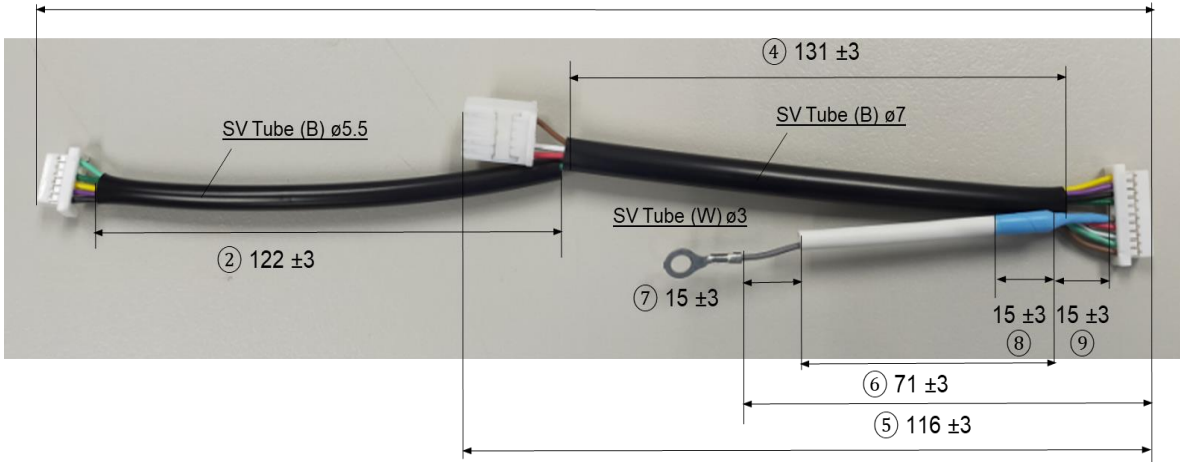

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		3	Page No.: 17 of 18

PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	<div><div>3</div>WORK PROCEDURE/ ILLUSTRATION</div>	TOOLS/PPE	QUALITY POINTERS	
14	P1	Measurement	<div><div>MEASURING TAPE</div><div>NOTE: *Unit of measurement is in millimeter</div></div>	<div>1. No wrong dimension.</div> <div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div>	

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PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Assy parts

JIG:

n/a



VISUAL INSPECTION/ QUALITY CHECKPOINTS

STEERING

75S744-7051

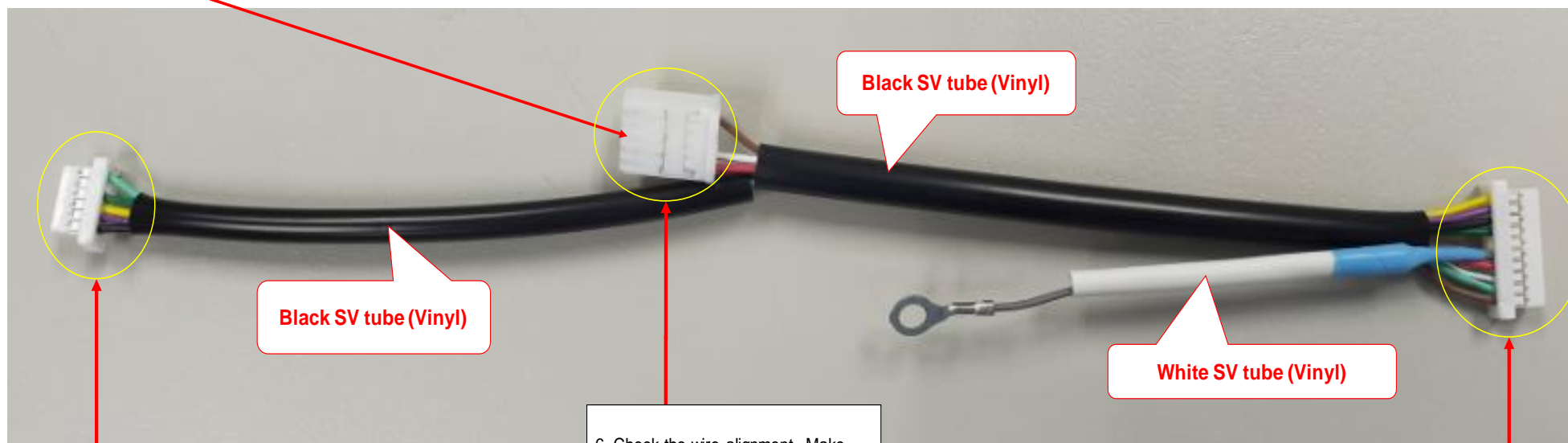
1. Check the Connector lock, should be unlock.

2. Make sure horn terminal is located on the "lance" side

3. Check the orientation of harness.

4. Check if no missing parts.

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



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

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