



## WORK INSTRUCTION

Effectivity Date:

May 16, 2024

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

683B / 75N359-7051

Customer:

TRJ

Car Model: TOYOTA-4 RUNNER

Document No.:

WI-ENG-PDE-118

Purpose:

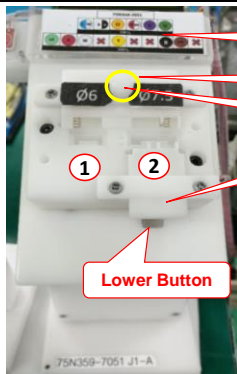
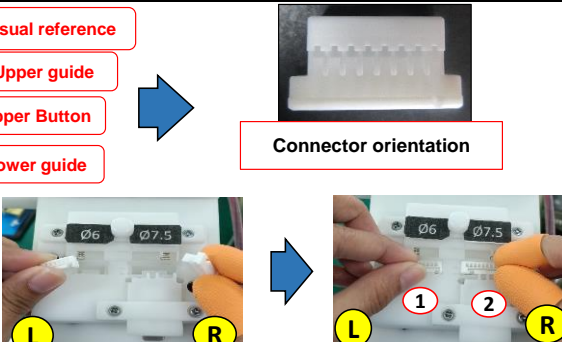
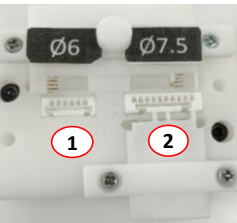
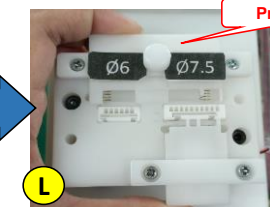




☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Connector PBVP-06V-S (W) 2. Connector PBVP-10V-S (W)				JIG:	1. Insertion jig							
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS					
1	P1	Connector setting to insertion jig PBVP- 06V-S (W) PBVP-10V-S (W)	<div><p><b>Visual reference</b></p><p><b>Upper guide</b></p><p><b>Upper Button</b></p><p><b>Lower guide</b></p><p><b>Lower Button</b></p></div> <div><p><b>Connector orientation</b></p></div> <div><p><b>Insertion Jig</b></p></div> <div><p><b>Press</b></p></div> <div></div> <p>1. Get the 1 pc of <b>PBVP-06V-S</b> connector using left hand and get 1 pc of <b>PBVP-10V-S</b> connector using right 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><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. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector					
Revision History							Prepared by		Reviewed by		Approved by		Noted by	
05/16/24	9	Change the folding facing due to improvement of abnormality. Update the Work procedure/Illustration of Process 5,7, 13-15. Update Quality pointers. Change hand method (Process 3). Change Electrical test document number due to transfer process from Production to QC. Inclusion of Car model "TOYOTA-4 RUNNER"				D.Castillo	C.Villanueva	A. Arañes	n/a	 D. Castillo	 C.Villanueva	 A. Arañes		n/a
03/31/23	8	Improved the insertion jig and procedure (Page 1-6). Improved work process/illustration (Page 4, 8-12).				D.Castillo	J. Loterte	C. Villanueva	A. Arañes					
01/19/23	7	Improve work procedure and illustration in process no.3, 5 and 8 as process improvement. Change of wordings from Black sunprene tube to Black VM tube (Sunprene) as standard tube description.				M. Catapang	J. Loterte	C. Villanueva	A. Arañes					
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date:		May 08, 2019		

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## TAPING ASSEMBLY PROCESS

Model code/Part number:

683B / 75N359-7051

Customer:

TRJ

Car Model:

TOYOTA-4 RUNNER

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

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### PARTS:

1. AVSSf 0.3 W/L L=366±2mm ; B/W L=194±2mm; OR L=350±2mm; R/W L=190±2mm; V L=350±2mm; G L=186±2mm

JIG:

1. Insertion Jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE

### QUALITY POINTERS

2

P1

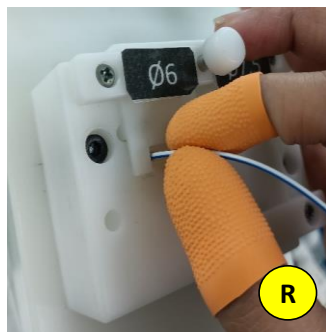
Wire insertion to connector PBVP-06V-S (W)

#### INSERTION SEQUENCE FROM LEFT TO RIGHT



#### WIRE INSERTION ILLUSTRATION

1	2	3	4	5	6
W/L	B/W	OR	R/W	V	G
366	194	350	190	350	186



Wire facing



1. Get the **W/L** wire using right hand and insert to connector. Repeat the process for **B/W-OR-R/W-V-G** wires.

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

#### STEERING NAVIGATION



#### 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. Please hold the wire near terminal during insertion.
2. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion. Do not exert extra force.

#### Document 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-028** for Pull-Push procedure.

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Purpose:


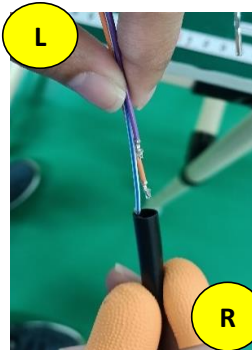



☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Black VM tube (sunprene) Ø6 L=145±3mm		JIG:	1. Insertion Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1	<div><div><div></div><div><div>9</div><div>1. Get the <b>Black VM tube (Sunprene)</b> <b>Ø6 L=145±3mm</b> using right hand. Hold the wires using left hand and insert the wires using right hand.</div></div></div><div><div><div></div><div></div><div></div><div></div></div></div><div>n/a</div><div><div>1. No wrong usage of parts</div><div>2. No deformed terminal</div><div>3. No tangled wires</div></div></div>			

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### PARTS:

1. AVSSf 0.3 LG L=181±2mm; R L=183±2mm; W L=185±2mm; Y L=189±2mm; B L=195±2mm; BR L=197±2mm

JIG:

1. Insertion Jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE

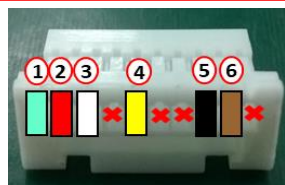
### QUALITY POINTERS

4

P1

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

#### INSERTION SEQUENCE FROM LEFT TO RIGHT



#### WIRE INSERTION ILLUSTRATION

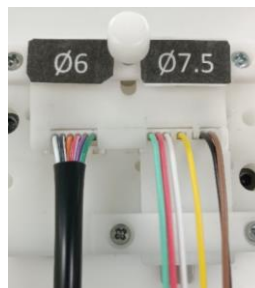
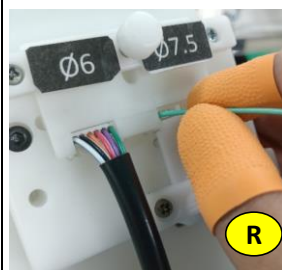
1	2	3	4	5	6	7	8	9	10
LG	R	W	X	Y	X	X	B	BR	X
181	183	185		189			195	197	



#### Wire facing

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

**Lower guide**



1. Get the **LG wire** using  
right hand and insert to  
connector. Repeat the  
process for **R-W-Y-B-BR  
wires**. Check the wire after  
insertion.  
**Note: Follow the insertion  
sequence based on the  
above illustration.**

#### STEERING NAVIGATION



#### 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. Please hold the wire near terminal  
during insertion.
2. Make sure wires are properly  
inserted. Conduct **Pull-Push-Pull-Push**  
after insertion.  
Do not exert extra force.


#### Document 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-028** for Pull-  
Push procedure.

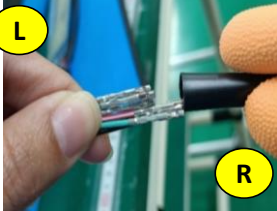
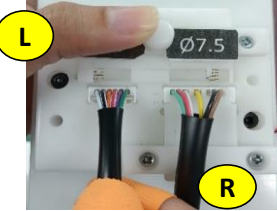
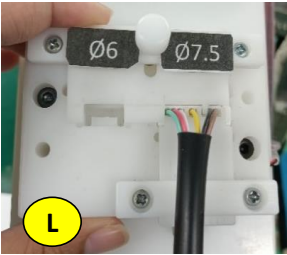
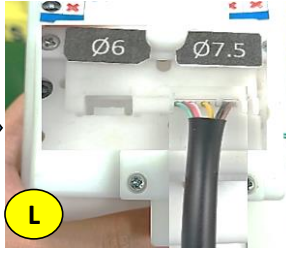
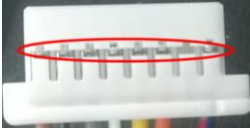
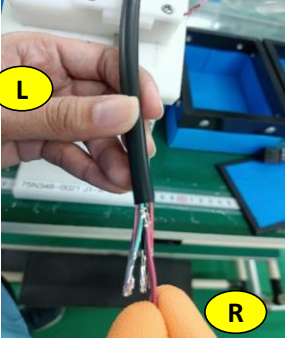

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	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	<b>n/a</b>					
	Process Name/Title:		Model code/Part number: <b>683B / 75N359-7051</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-4 RUNNER</b>		Document No.: <b>WI-ENG-PDE-118</b>			
	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:	9	Page No.:

<b>PARTS:</b>		1. Assy parts 2. Black VM tube (sunprene) Ø7.5 L=140±3mm		JIG:	1. Insertion Jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>9 WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
5	Wire insertion to Black VM tube (sunprene) Ø7.5 L=140±3mm	<div>   </div> <div> <p>1. Get the <b>Black VM tube (sunprene) Ø7.5 L=140±3mm</b> using right hand. Hold the wire using left hand then insert the wires.</p> <p>2. Press the Upper button using left hand. Remove the 1st connector with inserted wires and <b>Black VM tube (Sunprene)</b> using right hand</p> </div> <div>   </div> <div> <p>3. Press the upper guide using left hand and press the lower button using left hand. Holes that need to be insert are only open. Check the wire insertion condition.</p> <p><b>Note: Second connector with inserted wire and Black Sunprene tube will stay in the jig.</b></p> </div>		n/a	<div>  <p><b>Terminal tip must be visible</b></p> </div> <p><b>Document reference/s:</b></p> <p>1. Refer to <b>GL-PRO-ASY-025</b> for <b>Inspection Standard for Coupler Insertion.</b></p>
6	Wire insertion to assy parts	<div>   </div> <div> <p>1. Hold the <b>Black VM tube (Sunprene)</b> using left hand and insert the wires from <b>Black VM tube (Sunprene)</b> using right hand.</p> </div>		n/a	<p>1. No wrong use of parts          2. No deformed terminal          3. No tangled wires</p>

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683B / 75N359-7051

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TOYOTA-4 RUNNER

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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## PARTS:

1. Assy parts

JIG:

1. Insertion Jig

NO.

PROCESS NAME

9

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

7

P1

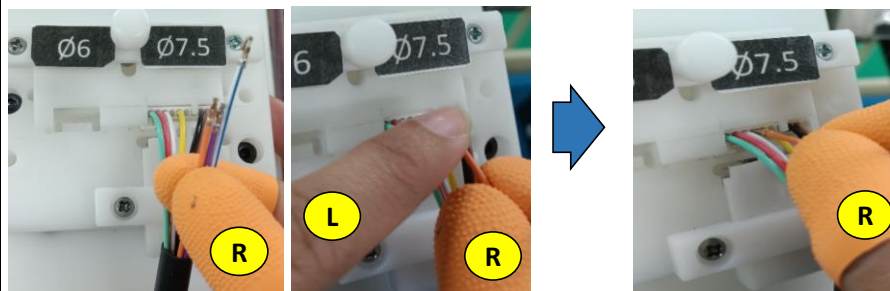
Wire insertion to  
connector  
PBVP-10V-S (W)INSERTION SEQUENCE FROM  
LEFT TO RIGHT

## WIRE INSERTION ILLUSTRATION

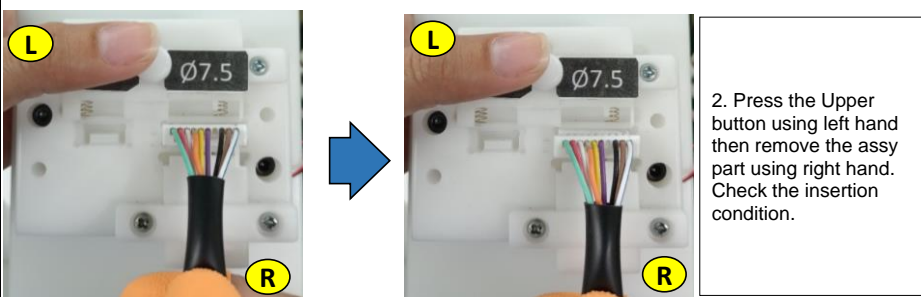
1	2	3	4	5	6	7	8	9	10
LG	R	W	OR	Y	V	X	B	BR	W/L
181	183	185	350	189	350		195	197	366



Wire facing



1. Hold the **OR** wire using right hand and support the wire by left index finger then insert to connector using right hand. Repeat the process on **V-W/L** wires. Check the wire after insertion  
*Note: Follow the insertion sequence based on the above illustration.*



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

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. Please hold the wire near terminal during insertion.
2. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion. Do not exert extra force.

## Document 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-028** for Pull-Push procedure.

STEERING  
NAVIGATION


## CONTROLLER


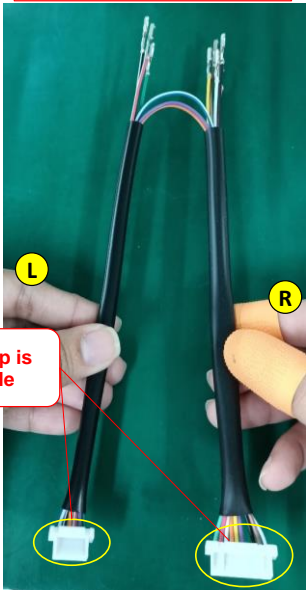


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	Model code/Part number: <b>683B / 75N359-7051</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-4 RUNNER</b>	Document No.:		<b>WI-ENG-PDE-118</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		9	Page No.: 7 of 17

<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>	
8	P1	Wire arrangement	<div><p>BEFORE FOLDING</p><p>AFTER FOLDING</p><p>Terminal tip is not visible</p><p>1. Hold the assy parts using both hands then conduct wire arrangement.</p></div>	n/a	1. No deformed terminals 2. No tangled wires 3. No wrong facing

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☐ PROTOTYPE

☐ PRE-LAUNCH

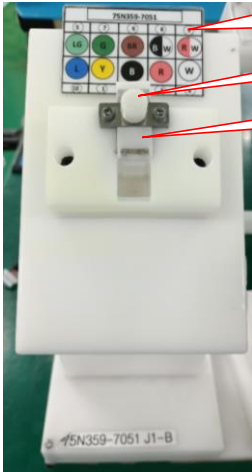
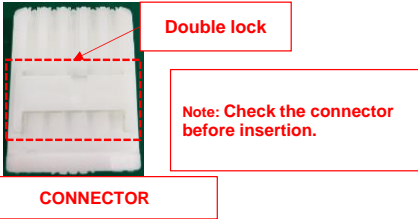
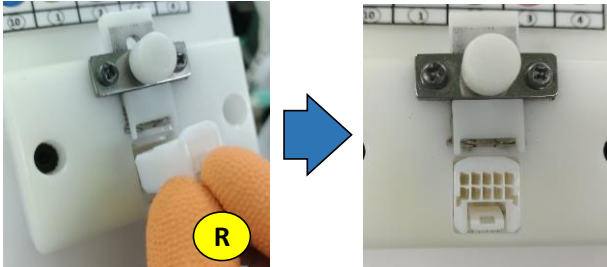
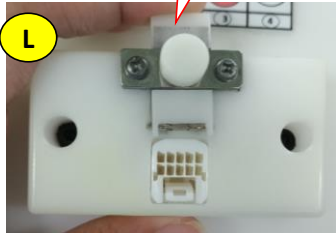
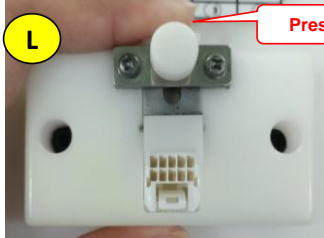
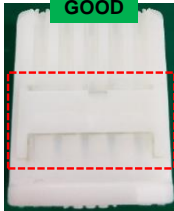
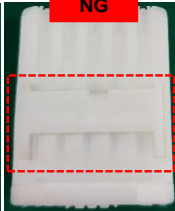
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PARTS:		1. Connector 4A1230-0000 (W)		JIG:	1. Insertion Jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1	<div><div><div><div><div>INSERTION JIG</div><div></div><div></div><div></div></div><div><div><div><div>1. Get the connector <b>4A1230-0000 (W)</b> and insert to insertion jig using right hand. <i>Note: Follow the connector orientation</i></div><div></div><div></div></div><div>2. Press the upper using left hand. Holes that need to be insert are only open.</div></div></div></div><div><div><div><div>1. Use the provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div></div><div><div><b>Important reminders/Note/s:</b></div><div>1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half- locked connector.</div></div><div><div><div><b>CONNECTOR LOCK APPEARANCE CHECK</b></div><div><div><div><div>GOOD</div><div></div><div>UNLOCK</div></div><div><div>NG</div><div></div><div>HALF-LOCKED</div></div></div></div></div></div></div></div></div></div>		n/a	

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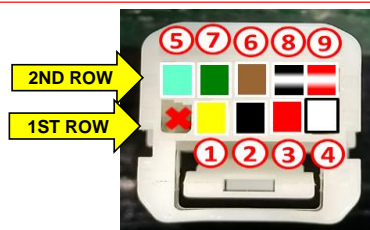
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PARTS: 1. Assy parts JIG: 1. Insertion Jig

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

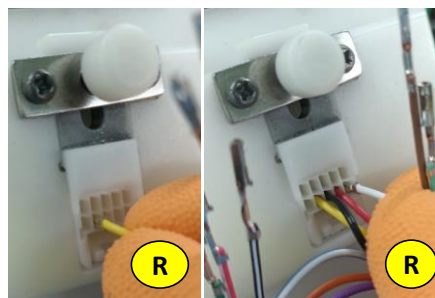
10

P1

Connector setting to  
insertion jig  
4A1230-0000 (W)INSERTION SEQUENCE FROM LEFT  
TO RIGHT

Wire facing

## FIRST ROW (LEFT TO RIGHT)



1. Insert first the wires from **Black VM tube (Sunprene)**. Hold the **Y wire** and insert to terminal slot 1 using right hand. Repeat the process for **B-R-W-LG-BR** wires.

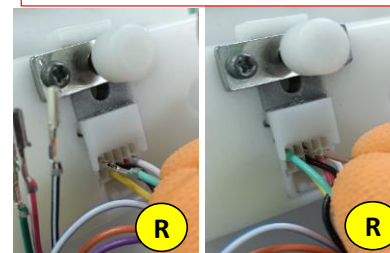
WIRE INSERTION  
ILLUSTRATION

5	7	6	8	9
LG	G	BR	B/W	R/W
181	186	197	194	190
10	1	2	3	4
X	Y	B	R	W
	189	195	183	185

## Black VM tube (Sunprene)



## SECOND ROW (LEFT TO RIGHT)



2. Hold the **LG wire** and insert to terminal slot 5. Repeat the process for **BR wire**.

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. Please hold the wire near terminal during insertion.
2. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion. Do not exert extra force.
3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.
4. Follow the insertion sequence based on the illustration stated above.

## Document References:

1. Refer to **GL-PRO-ASY-028** for Pull-Push procedure.
2. Refer to **WI-PRO-CNC-017** for Wire and Strip Length Tolerance.

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## WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

May 16, 2024

Model code/Part number:

683B / 75N359-7051

Customer:

TRJ

Car Model:

TOYOTA-4 RUNNER

Document No.:

WI-ENG-PDE-118

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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## PARTS:

1. Assy parts

JIG:

1. Insertion Jig

## NO.

## PROCESS NAME

## WORK PROCEDURE/ ILLUSTRATION

## TOOLS/PPE

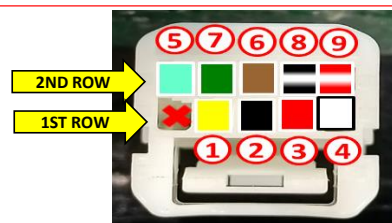
## QUALITY POINTERS

10

P1

Connector setting to  
insertion jig  
4A1230-0000 (W)  
(Continuation)

## INSERTION SEQUENCE FROM LEFT TO RIGHT



Wire facing

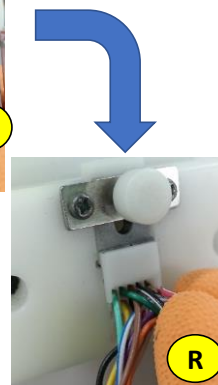
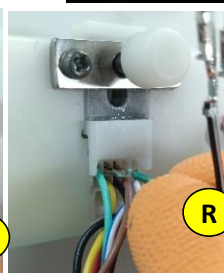
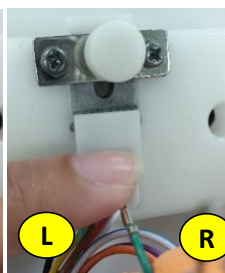
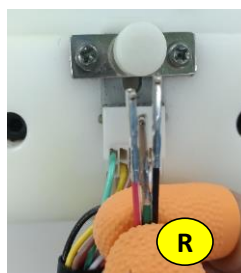
## WIRE INSERTION ILLUSTRATION

5	7	6	8	9
LG	G	BR	B/W	R/W
181	186	197	194	190
10	1	2	3	4
X	Y	B	R	W
	189	195	183	185

## Black VM Tube (Sunprene)



## FIRST ROW (LEFT TO RIGHT)



3. Hold the **G** wire using right hand and support the wire by left index finger then insert to terminal slot 7 using right hand. Repeat the process for **B/W-R/W** 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:**

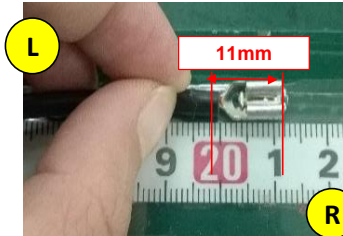






1. Please hold the wire near terminal during insertion.
2. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion. Do not exert extra force.

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	Model code/Part number: <b>683B / 75N359-7051</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-4 RUNNER</b>	Document No.:	<b>WI-ENG-PDE-118</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	9	Page No.:	11 of 17

<b>PARTS:</b>		1. AVSS 0.5 L L=154mm 2. Black VM tube (sunprene) Ø3 L=140±3mm		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
11	P1	<div>Wire insertion to Black VM tube (sunprene) Ø3 L=140±3mm</div> <div><div>1. Get the <b>Blue wire</b> using right hand and insert to <b>Black VM tube (Sunprene) Ø3 L=140±3mm</b>.</div><div>2. Measure the VM tube (Sunprene) up to the tip of the terminal, it should be <b>11mm</b>.</div></div> <td><div>Measuring tape</div></td> <td><div><div>Peel-off wire should be covered by Sunprene tube (White)</div><div><b>Important reminders/note/s:</b> <i>1.Please use calibrated/verified measuring tape when getting the measurement.</i></div></div></td>		<div>Measuring tape</div> 	<div><div>Peel-off wire should be covered by Sunprene tube (White)</div><div><b>Important reminders/note/s:</b> <i>1.Please use calibrated/verified measuring tape when getting the measurement.</i></div></div>

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## TAPING ASSEMBLY PROCESS

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683B / 75N359-7051

Customer:

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Car Model:

TOYOTA-4 RUNNER

Document No.:

WI-ENG-PDE-118

Purpose:

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PARTS: 1. Assy parts

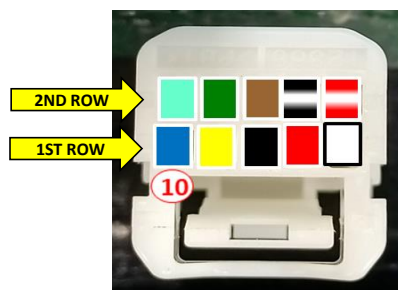
JIG:

1. Insertion Jig

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

12

P1

Connector setting to  
insertion jig  
4A1230-0000 (W)  
(Continuation)INSERTION SEQUENCE FROM LEFT TO  
RIGHT

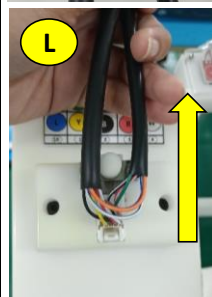
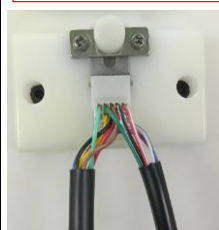
## WIRE INSERTION ILLUSTRATION

5	7	6	8	9
LG	G	BR	B/W	R/W
181	186	197	194	190
10	1	2	3	4
L	Y	B	R	W
154	189	195	183	185

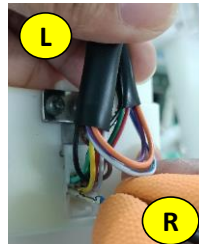


## Wire facing

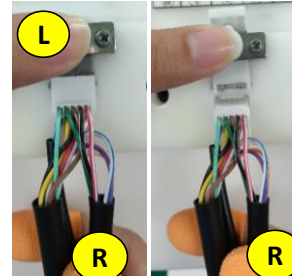
## FIRST ROW (LEFT TO RIGHT)



4. Hold the assy  
part and lift up  
using left hand to  
see the **slot 10** for  
insertion.



5. Get the **L wire**  
using right hand  
and insert to  
terminal **slot 10**  
using right hand.



6. Press the upper button using  
left hand then remove the assy  
part using right hand.

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:**

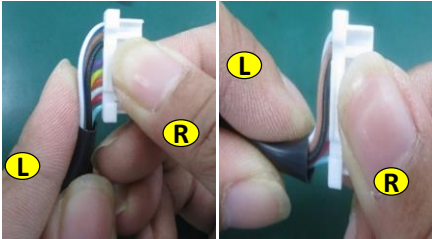
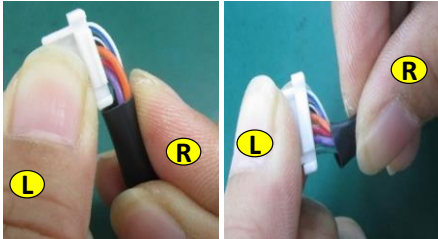


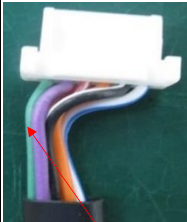
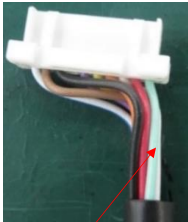
1. Please hold the wire near terminal during insertion.
2. Make sure wires are properly inserted.  
**Conduct Pull-Push-Pull-Push** after insertion.  
Do not exert extra force.
3. Follow the insertion sequence based on the above illustration.

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	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>May 16, 2024</b>		
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>683B / 75N359-7051</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-4 RUNNER</b>	Document No.:	<b>WI-ENG-PDE-118</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	9	Page No.:	13 of 17

<b>PARTS:</b>	1. Assy parts			JIG:	n/a				
<b>NO.</b>	<b>PROCESS NAME</b>	<div>9</div> <b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>			
13	P1	Wire folding	<div><div><b>Black VM tube (sunprene) (PBVP-10V-S)</b></div><div></div><div>1. Hold the connector <b>PBVP-10V-S (W)</b> using right hand and slightly fold the wires from Black sunprene tube <i>(as illustration above)</i> using left hand.</div></div> <div><div><b>Black VM tube (sunprene) (PBVP-06V-S)</b></div><div></div><div>2. Hold the connector <b>PBVP-06V-S (W)</b> using left hand and slightly fold the wires from Black sunprene tube <i>(as illustration above)</i> using right hand.</div></div> <div></div> <div><b>BEFORE FOLDING</b></div> <div></div> <div><b>AFTER FOLDING</b></div>			n/a	<div>1. No tangled wires 2. No wrong facing of connector</div> <div></div> <div><b>Green wire must not be bend</b></div> <div></div> <div><b>LG wire must not be bend</b></div>		

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# WORK INSTRUCTION

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683B / 75N359-7051

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Purpose:

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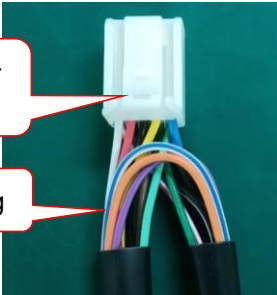
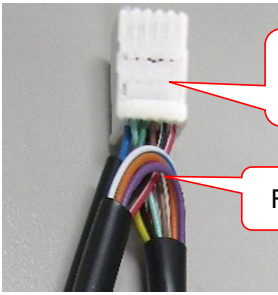
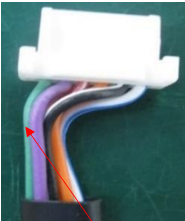
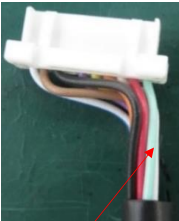
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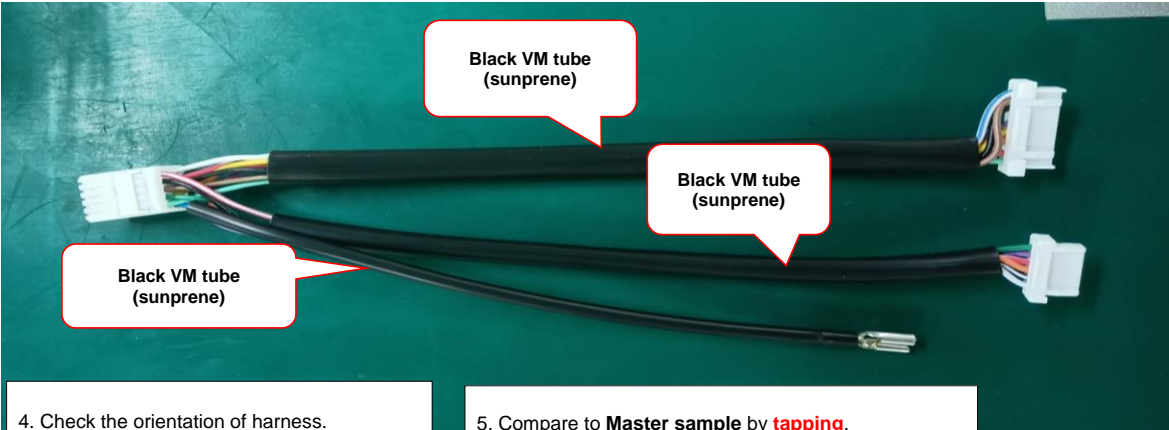




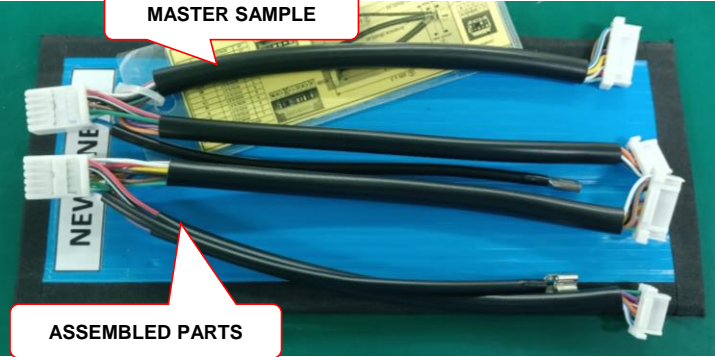


PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	<div>9</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
13	P1	Wire folding (Continutaion)	<div><div>Folding at the back</div><div>Terminal tip is NOT visible</div><div></div><div>GOOD FACING</div></div> <div><div>Folding in the front</div><div>Terminal tip is visible</div><div></div><div>NG FACING</div></div> <div><div>9</div><div><div>Connector lock</div><div>Folding</div><div></div></div><div><div>Double lock</div><div>Folding</div><div></div></div></div> <div>GOOD FACING</div> <div>NG FACING</div>	n/a	<div>1. No tangled wires 2. No wrong facing of connector</div> <div><div><div>Green wire must not be bend</div></div><div><div>LG wire must not be bend</div></div></div>

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	Model code/Part number: <b>683B / 75N359-7051</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-4 RUNNER</b>	Document No.:	<b>WI-ENG-PDE-118</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	9	Page No.:	15 of 17


<b>PARTS:</b>	1. Assembled parts 2. Master sample			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<div>9</div> <b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
14	P1  Visual/By Two's Inspection	<div>1. Check the connector lock, locking of connector in included in 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 deformed terminal.</div> <div></div> <div>4. Check the orientation of harness.</div> <div>5. Compare to <b>Master sample</b> by <b>tapping</b>.</div> <div><div><div><div><b>1</b></div><div><b>2</b></div><div><b>3</b></div><div><b>4</b></div></div><div><div><b>MASTER SAMPLE</b></div><div><b>ASSEMBLED PARTS</b></div></div></div></div>		<div>1. No wrong facing of harness 2. No Tangled wires 3. No missing parts</div> <div><div><b>MASTER SAMPLE</b></div></div> <div><b>Document reference/s:</b>  1. Refer to <b>WI-ENG-PDE-252</b> for Steering Electrical Test after assembly.</div>	

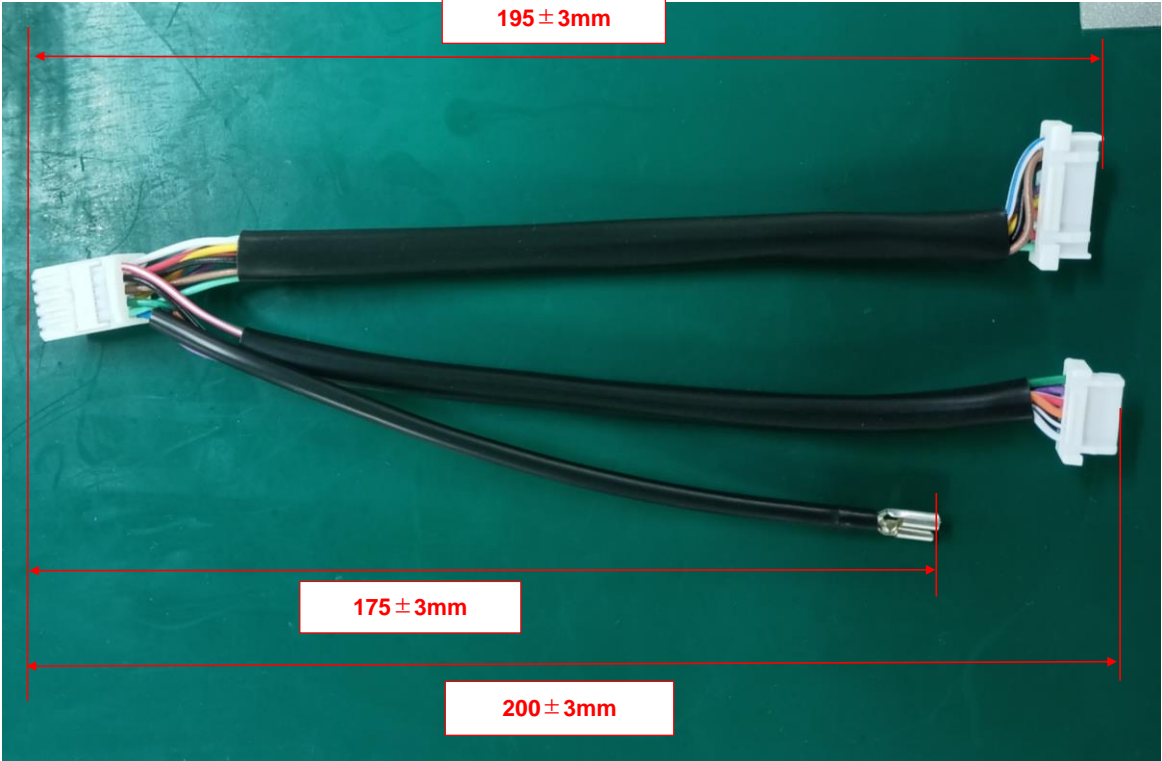
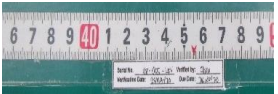
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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	9	Page No.:	16 of 17

<b>PARTS:</b>	n/a			JIG:	n/a		
<b>NO.</b>	<b>PROCESS NAME</b>	<div><div>9</div><b>WORK PROCEDURE/ ILLUSTRATION</b></div>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>			
15	P1	Measurement	<div><div>Measuring tape</div></div>	<div><b>Important reminders and note/s:</b> 1. Please use calibrated/verified measuring tape when getting the measurement.  2. For Hatsumono, Nakamono and Owarimono.  <b>Document reference/s:</b> 1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension.</div>			

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PARTS:

n/a

JIG:

n/a



### QUALITY CHECKPOINTS

## STEERING

# 75N359-7051

1. Check the connector lock, should be unlock.

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

Black VM Tube (Sunprene)

Black VM Tube (Sunprene)

Black VM Tube (Sunprene)

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.

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