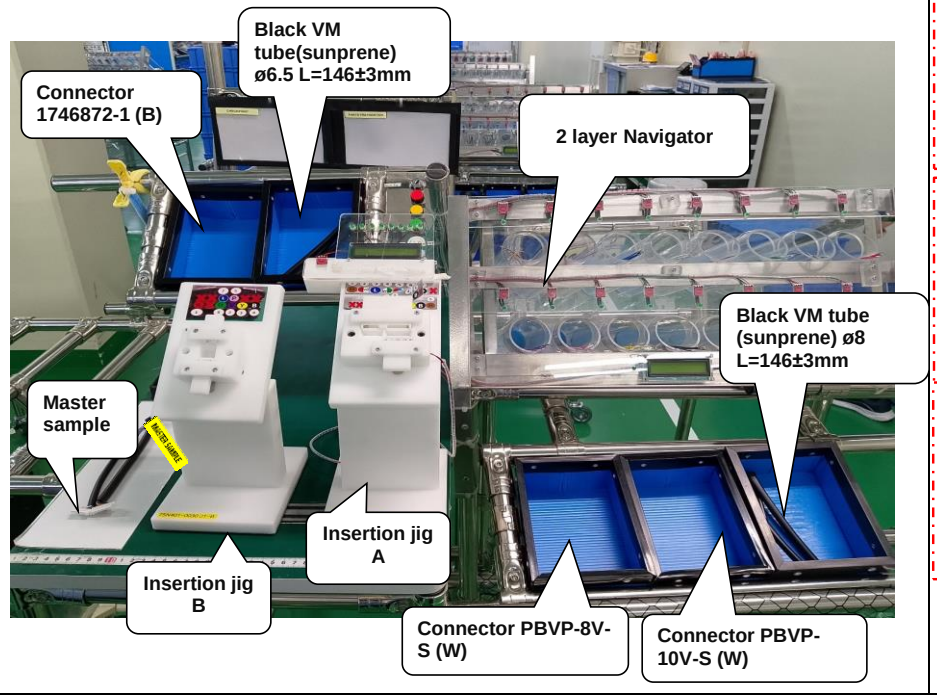
| | WORK INSTRUCTION | | | Effectivity Date: | March 11, 2025 | | |
|---|---|---|---|---|---|---|---|
| | Process Name/Title: | TAPING ASSEMBLY PROCESS | | Validity Date: | n/a | | |
| | Model code/Part number: | 559D / 75N401-0030 | Customer: TRJ | Car Model: TOYOTA HI-ACE | Document No.: | WI-ENG-PDE-892 | |
| | Purpose: | ☐ PROTOTYPE | ☐ PRE-LAUNCH | ■ MASSPRO | Revision No.: | 1 | Page No.: 1 of 17 |

| | | | |
|---|---|---|---|
| **PARTS:** | 1. Connector 1746872-1 (B); connector PBVP-8V-S (W); connector PBVP-10V-S (W);Wire AVSS 0.3 BR L=384±2mm; B L=199±2mm; Y L=197±2mm; W/G L=372±2mm; P L=193±2mm; V L=191±2mm; GR/B L=360±2mm; R L=189±2mm; R/W L=366±2mm; R/L L=360±2mm; Wire AVSS 0.3 G L=196±2mm; L L=200±2mm; Black VM tube ø8 L=146±3mm; Black VM tube ø6.5 L=146±3mm | JIG: | 1. Insertion jig |

| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|---|---|---|---|---|---|
| 1 | P1 | Table Lay-out | **TABLE LAY-OUT**<br>  <br> | **Safety Instruction**<br>Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)<br><br>**Housekeeping**<br>1. Maintain and always practice 5's.<br>2. Personal things on the workplace is prohibited. Keep it in your locker.<br><br>**Alert level**<br>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. | 1. No deformed terminal<br>2. No wrong usage of parts |

Revision History

| Eff. Date | Rev. No | Details of Change | Revised | Checked | Reviewed | Approved | Prepared by | Checked by | Reviewed by | Approved by |
|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | | |
| | | | | | | | | | | |
| 03/11/25 | 1 | Change pre laucnh to mass pro and inclusion of table lay-out. Inclusion of permanent jig and table lay-out. | A.Hernandez | J.Loterte | C. Villanueva | A. Arañes | A.Hernandez | J. Loterte | C. Villanueva | A. Arañes |
| 01/04/25 | 0 | Initial issue | A.Hernandez | n/a | C. Villanueva | A. Arañes | | | | |
| | | | | | | | Est. Date: | January 4, 2025 | | |

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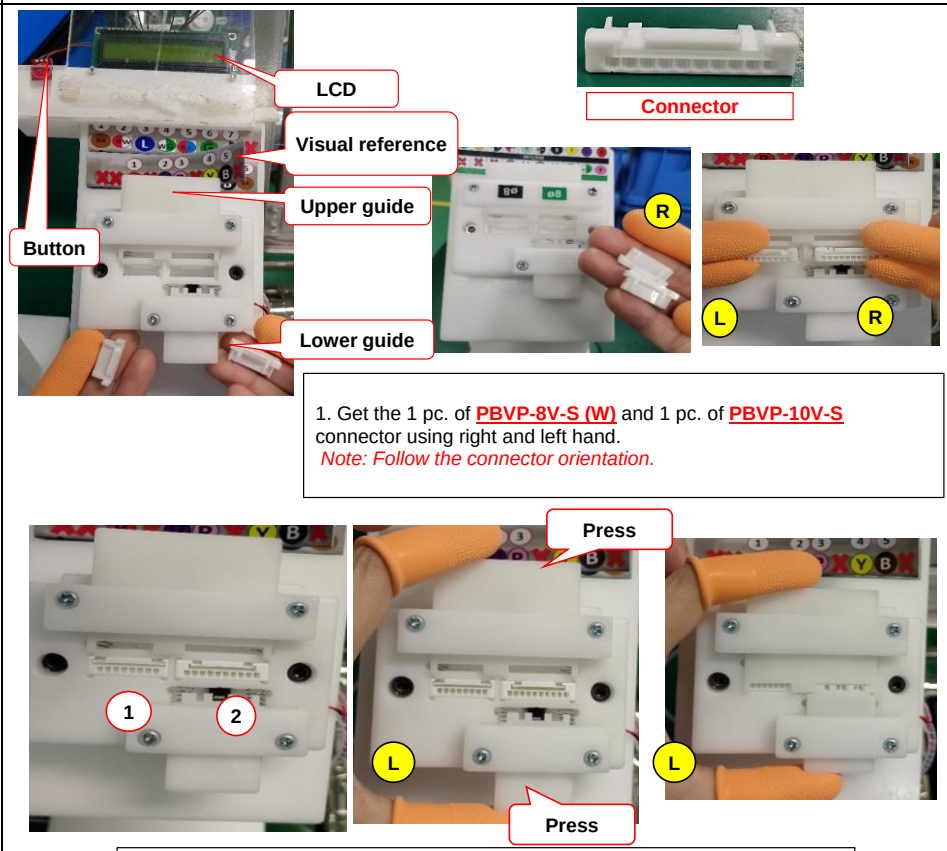
| | Process Name/Title: | TAPING ASSEMBLY PROCESS | | Validity Date: | n/a | |
| | Model code/Part number: | 559D / 75N401-0030 | Customer: TRJ / Car Model: TOYOTA HI-ACE | Document No.: | WI-ENG-PDE-892 | |
| | Purpose: | ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO | | Revision No.: | 1 | Page No.: 2 of 17 |

| PARTS: | 1. Connector PBVP-8V-S (W)<br>2. Connector PBVP-10V-S (W) | JIG: | 1. Insertion jig |
|---|---|---|---|

| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|---|---|---|---|---|---|
| 2 | P1 | Connector setting to insertion jig PBVP-10V-S (W) |  <br>1. Get the 1 pc. of **PBVP-8V-S (W)** and 1 pc. of **PBVP-10V-S** connector using right and left hand.<br>*Note: Follow the connector orientation.*<br>2. Press the upper and lower guide using left hand in same timing. Holes that need to be insert are only open. | N/A | 1. Use the provided jig per model<br>2. No wrong usage of parts<br>3. No wrong orientation of connector<br>4. No damaged connector |

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| | | | | | |
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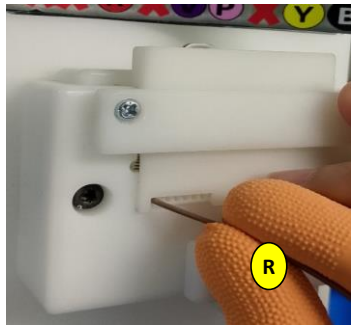
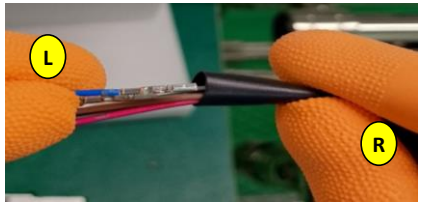
| | Process Name/Title: | TAPING ASSEMBLY PROCESS | | Validity Date: | n/a |
| | Model code/Part number: 559D / 75N401-0030 | Customer: TRJ | Car Model: TOYOTA HI-ACE | Document No.: | WI-ENG-PDE-892 |
| | Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO | | | Revision No.: 1 | Page No.: 3 of 17 |

| | | | |
|---|---|---|---|
| **PARTS:** | 1.Wire AVSS 0.3 BR L=384±2mm; B L=199±2mm; Y L=197±2mm; W/G L=372±2mm; P L=193±2mm; V L=191±2mm; GR/B L=360±2mm; R L=189±2mm; R/W L=366±2mm; R/L L=360±2mm;<br>2. Black VM tube (sunprene) ø6.5 L=146±3mm | JIG: | 1. Insertion jig |

| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|---|---|---|---|---|---|
| 3 | P1 | Wire insertion to Connector PBVP-8V-S (W) | **INSERTION SEQUENCE FROM LEFT TO RIGHT**<br> <br><br>**Terminal facing**<br> <br>\| 1 \| 2 \| 3 \| 4 \| 5 \| 6 \| 7 \| 8 \|<br>\| BR \| R/W \| L \| W/G \| R/L \| G \| GR/B \| X \|<br>\| 384 \| 366 \| 200 \| 372 \| 360 \| 196 \| 360 \|<br>  <br><br> <br>1. Get the **R/L wire** using right hand and insert to connector. Repeat the process for **OR-B/W-R/W-LG-GR/B-B-Y-V-R wires.**<br>***Note: Follow the insertion sequence based on the illustration.*** | **STEERING NAVIGATION(2 layer)**<br> <br>**CONTROLLER**<br> | 1. Use provided jig per model<br>2. No wrong usage of parts<br>3. One by one insertion<br>4. No wrong insertion<br>5. No deformed terminal<br>6. No stuck of terminal tip<br>***Important reminders/Note/s:***<br>*1. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion.*<br>*Do not exert extra force.*<br>*2. Please hold the wire near terminal during insertion.*<br>*3. Follow the insertion sequence based on the illustration.*<br>***Document references:***<br>*1. Refer to **GL-PRO-ASY-029** for Pull-Push procedure.*<br>*2. Refer to **WI-ENG-PDE-044** for Steering Navigation Controller procedure.* |
| 4 | | Wire insertion to Black VM tube (sunprene) ø6.5 L=146±3mm |  <br><br> <br>1. Get the **Black VM tube (Sunprene) ø6.5 L=146±3mm** using right hand. Hold the wires using left hand and insert the wires using right hand. | N/A | 1. No wrong usage of parts<br>2. No deformed terminal<br>3. No tangled wires |

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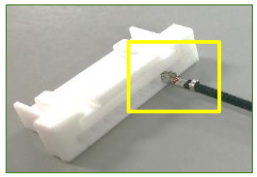
| | Model code/Part number: 559D / 75N401-0030 | Customer: TRJ | Car Model: TOYOTA HI-ACE | Document No.: | WI-ENG-PDE-892 |
| | Purpose: ☐ PROTOTYPE | ☐ PRE-LAUNCH | ■ MASSPRO | Revision No.: | 1 |



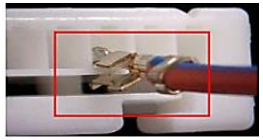
| | | | |
|---|---|---|---|
| **PARTS:** | 1. Wire AVSS 0.3 BR L=384±2mm; B L=199±2mm; Y L=197±2mm; W/G L=372±2mm; P L=193±2mm; V L=191±2mm; GR/B L=360±2mm; R L=189±2mm; R/W L=366±2mm; R/L L=360±2mm; | JIG: | 1. Insertion jig |

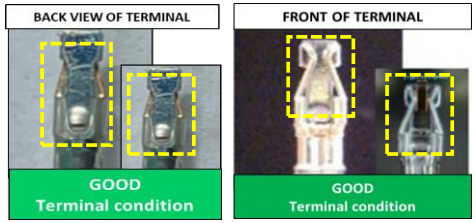
| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|---|---|---|---|---|---|
| 5 | P1 | Wire insertion to connector PBVP-10V-S (W) (Continuation) | | | 1. Use provided jig per model<br>2. No wrong usage of parts<br>3. No wrong insertion<br>4. No deformed terminal<br>5. No stuck of terminal tip<br>6. One by one insertion<br><br>***Important reminders/Note/s:***<br><br>***1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.***<br>***2. Please hold the wires near terminal during insertion.***<br>***3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.***<br>***4. Insertion of wires must be from left to right.***<br><br>***Document reference/s:***<br><br>***1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.***<br>***2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..***<br>***3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.***<br>***4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.*** |

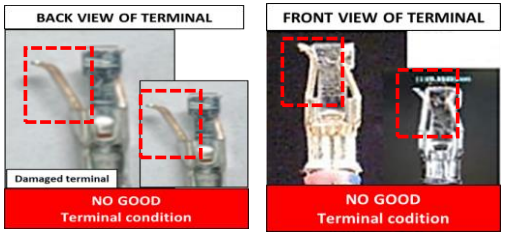
**Proper alignment of terminal to connector**



**Improper alignment of terminal to connector**






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.***

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| | Purpose: | ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO | | Revision No.: | 1 — Page No.: 5 of 17 |

| | | | | |
|---|---|---|---|---|
| **PARTS:** | 1. Wire AVSS 0.3 R L=189±2mm; V L=191±2mm;P L=193±2mm;Y L=197±2mm; B L=199±2mm | | JIG: | 1. Insertion jig |

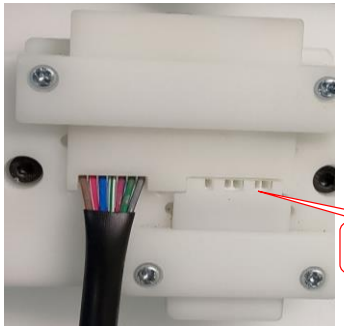
| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|---|---|---|---|---|---|
| 6 | P1 | Wire insertion to Connector PBVP-10V-S (W) | | | 1. Use provided jig per model<br>2. No wrong usage of parts<br>3. One by one insertion<br>4. No wrong insertion<br>5. No deformed terminal<br>6. No stuck of terminal tip |

**INSERTION SEQUENCE FROM LEFT TO**

**Terminal facing**

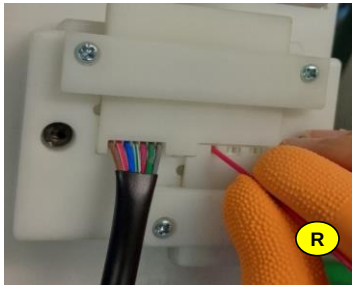
**WIRE INSERTION ILLUSTRATION**

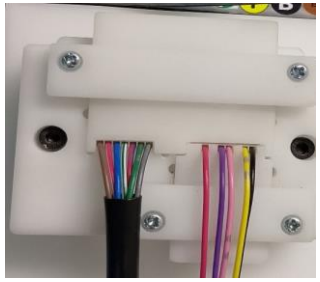
| 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 |
|---|---|---|---|---|---|---|---|---|---|
| X | X | R<br>189 | X | V<br>191 | P<br>193 | X | Y<br>197 | B<br>199 | X |



Lower guide

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

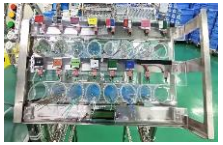


1. Get the **R wire** using right hand and insert to connector. Repeat the process for **V-P-Y-B wires.**

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

**STEERING NAVIGATION(2 layer)**



**CONTROLLER**

***Important reminders/Note/s:***

*1. Please hold the wire near terminal during insertion.*

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

*3. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion.*
*Do not exert extra force.*

*4. Follow the insertion sequence based on the above illustration.*

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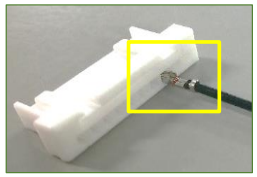
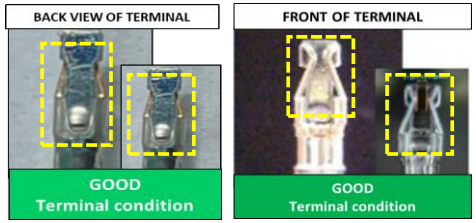
| | Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO | | | Revision No.: | 1 | Page No.: 6 of 17 |

| PARTS: | 1. Wire AVSS 0.3 G L=196±2mm; L L=200±2mm | JIG: | 1. Insertion jig |
|---|---|---|---|

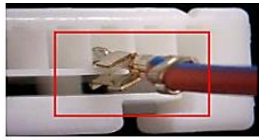
| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|---|---|---|---|---|---|
| 7 | P1 | Wire insertion to connector PBVP-10V-S (W) (Continuation) | | | 1. Use provided jig per model<br>2. No wrong usage of parts<br>3. No wrong insertion<br>4. No deformed terminal<br>5. No stuck of terminal tip<br>6. One by one insertion |

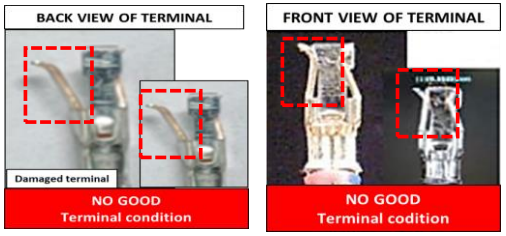
**Proper alignment of terminal to connector**






**Improper alignment of terminal to connector**






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.***

***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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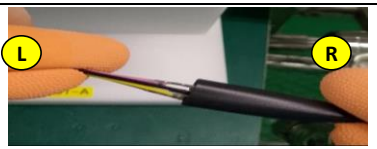
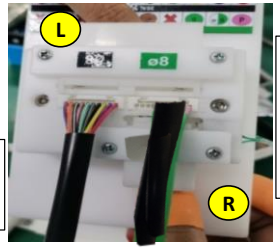
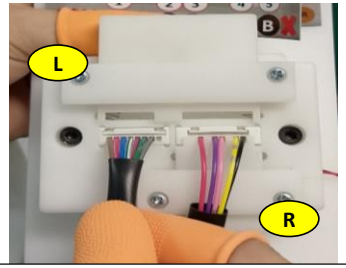
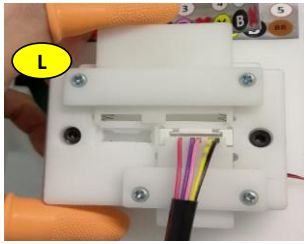
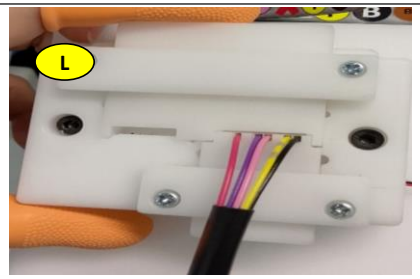
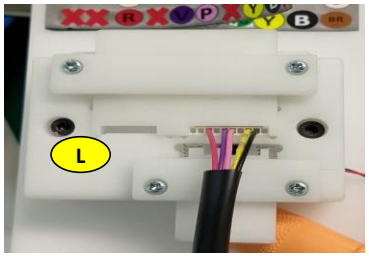
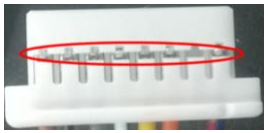
| | Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO | | | Revision No.: | 1 | Page No.: 7 of 17 |

| PARTS: | 1. Assy parts<br>2. Black VM tube (sunprene) ø8 L=146±3mm | JIG: | 1. Insertion jig |
|---|---|---|---|

| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|---|---|---|---|---|---|
| 8 | P1 | Wire insertion to Black VM tube (sunprene) ø8 L=146±3mm |  <br>1. Get the **Black VM tube ( Sunprene) ø8 L=146±3mm** using right hand. Hold the wire using left hand then insert the wires.<br>  <br>2. Press the Upper and lower guide button using left and right hand.<br>  <br>  <br>3. Remove the 1st connector with inserted wires and Black VM tube (Sunprene) using right hand then press the upper guide using left hand. Check the wire insertion condition.<br>Note: Second connector with inserted wire and Black VM tube (Sunprene) will stay in the jig.<br>  <br>  <br>4. Press the lower button using right hand. Holes that need to be inserted are only open. | N/A | 1. No wrong usage of parts<br>2. No deformed terminal<br>3. No tangled wires<br>  <br>**Terminal tip must be visible**<br>***Document References:***<br>*1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.*<br>*2. Refer to GL-PRO-ASY-043 for Verification of Fully Inserted Wires.* |

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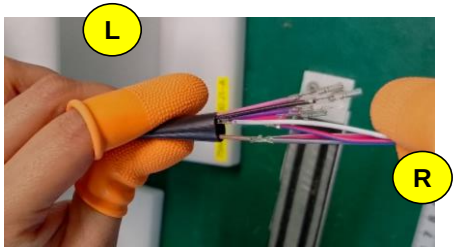
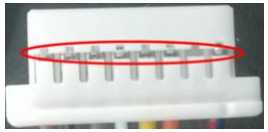
| NBC | WORK INSTRUCTION | | | Effectivity Date: | March 11, 2025 |
| | Process Name/Title: | TAPING ASSEMBLY PROCESS | | Validity Date: | n/a |
| | Model code/Part number: 559D / 75N401-0030 | Customer: TRJ | Car Model: TOYOTA HI-ACE | Document No.: | WI-ENG-PDE-892 |
| | Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO | | | Revision No.: 1 | Page No.: 8 of 17 |

| PARTS: | 1. Assy parts | JIG: | 1. Insertion jig |
|---|---|---|---|

| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|---|---|---|---|---|---|
| 9 | P1 | Wire insertion to assy parts |  <br>1. Hold the **Black VM tube (Sunprene) ø8** using left hand and insert the wires from **Black VM tube (Sunprene) ø6.5** using right hand.<br> | N/A | 1. No wrong usage of parts<br>2. No deformed terminal<br>3. No tangled wires<br>  <br>**Terminal tip must be visible**<br><br>***Document References:***<br>*1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.*<br>*2. Refer to GL-PRO-ASY-043 for Verification of Fully Inserted Wires.* |

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| | Model code/Part number: 559D / 75N401-0030 | Customer: TRJ | Car Model: TOYOTA HI-ACE | Document No.: | WI-ENG-PDE-892 | |
| | Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO | | | Revision No.: | 1 | Page No.: 9 of 17 |

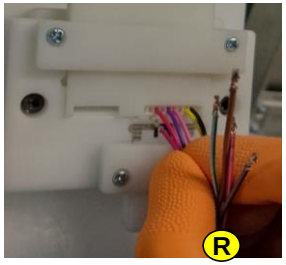
| PARTS: | 1. Assy parts | JIG: | 1. Insertion jig |
|---|---|---|---|

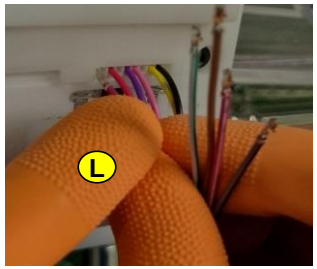
| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|---|---|---|---|---|---|
| 10 | P1 | Wire insertion to Connector PBVP-10V-S (W) | | | 1. Use provided jig per model<br>2. No wrong usage of parts<br>3. One by one insertion<br>4. No wrong insertion<br>5. No deformed terminal<br>6. No stuck of terminal tip<br>7. No deformed terminals<br>8. No tangled wires<br>9. No wrong facing |

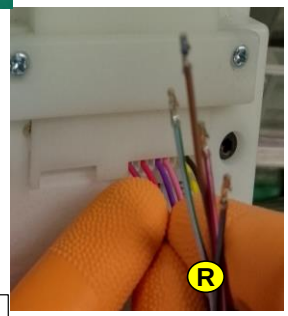
**WIRE INSERTION ILLUSTRATION**

| 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 |
|---|---|---|---|---|---|---|---|---|---|
| R/L | R/W | R | GR/B | V | P | W/G | Y | B | BR |
| 360 | 366 | 189 | 360 | 191 | 193 | 372 | 197 | 199 | 384 |

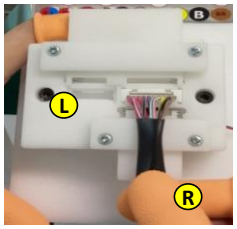
**Terminal facing**

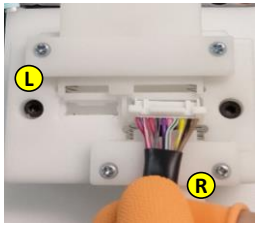


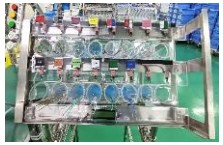

2. Hold the **R/L wire** using right hand and support the wire by left index finger then insert to connector using right hand. Repeat the process on **R/W-GR/B-W/G-BR wires**. Check the wire after insertion
*Note: Follow the insertion sequence based on the above illustration.*




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

**STEERING NAVIGATION(2 layer)**



**CONTROLLER**

***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 References:***
*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.*

**Terminal tip must be visible**

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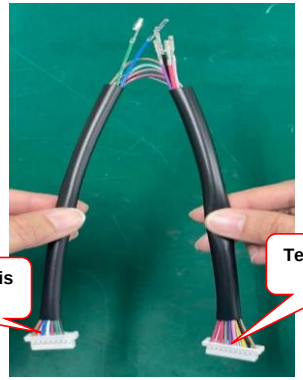
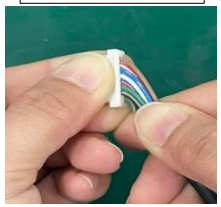
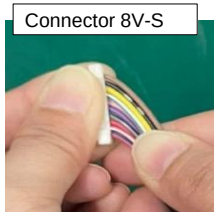
| | Model code/Part number: 559D / 75N401-0030 | Customer: TRJ | Car Model: TOYOTA HI-ACE | Document No.: | WI-ENG-PDE-892 | |
| | Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO | | | Revision No.: 1 | Page No.: | 10 of 17 |

| PARTS: | 1. Assy parts | JIG: | n/a |
|---|---|---|---|

| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|---|---|---|---|---|---|
| 11 | P1 | Wire Folding 1 |  <br>1. Hold the Assy parts using both hands and gently fold.<br>Connector 8V-S<br>  <br>Connector 8V-S<br>  <br> <br>1. Hold the connector with Black VM tube (sunprene) ø6.5 and slightly bend the wire. Repeat the process to connector Black VM tube (sunprene) ø8. Checked the facing of both connector. | n/a | 1. No wrong orientation of connector<br>2. No deformed terminal<br>3. No wrong terminal facing<br>4. No damage lance<br>5. No wrong folding position |

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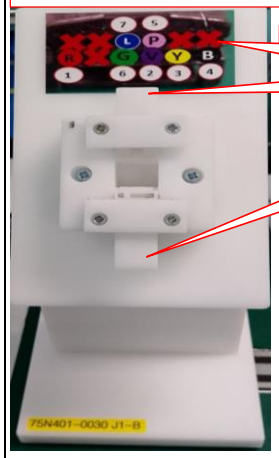
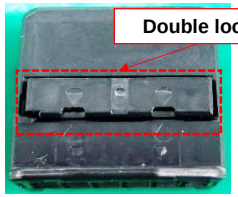
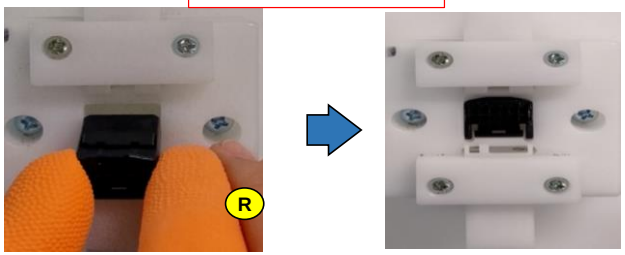
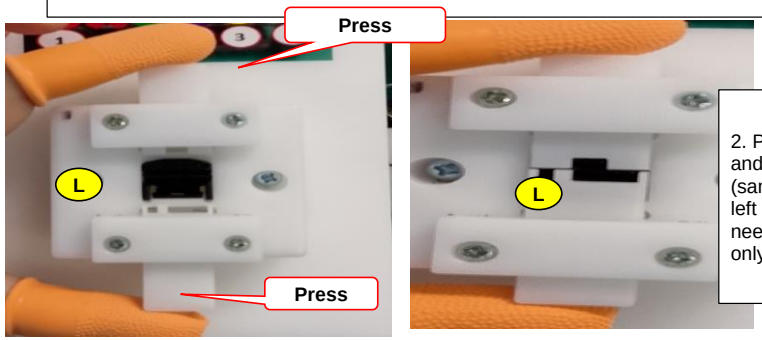
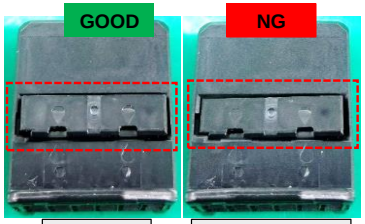
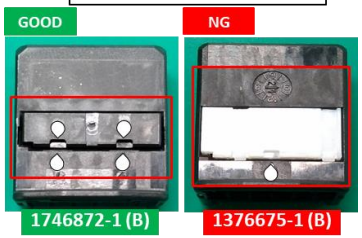
| | Purpose: | ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO | | Revision No.: | 1 |
| | | | | Page No.: | 11 of 17 |

| PARTS: | 1. Connector 1746872-1 (B) | JIG: | 1. Insertion jig |
|---|---|---|---|

| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|---|---|---|---|---|---|
| 12 | P1 | Connector setting to insertion jig 1746872-1 (B) |  <br>  <br>Note: Check the connector before insertion.<br>CONNECTOR<br>  <br>1. Get the connector **1746872-1 (B)** and insert to insertion jig using right hand.<br>*Note: Follow the connector orientation*<br>  <br>2. Press the upper and lower guide (same timing) using left hand. Holes that need to be insert are only open. | N/A | 1. Use the provided jig per model<br>2. No wrong usage of parts<br>3. No wrong orientation of connector<br>4. No damaged connector<br>CONNECTOR LOCK APPEARANCE CHECK<br>  <br>CONNECTOR ILLUSTRATION<br>  <br>***Important reminders/Note/s:***<br>*1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.*<br>*2. Follow the connector orientation*<br>*3. Check the connector before insertion.* |

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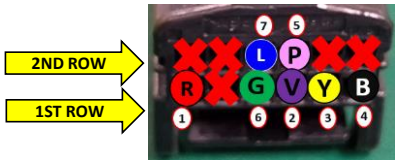
| | Model code/Part number: | 559D / 75N401-0030 | Customer: TRJ / Car Model: TOYOTA HI-ACE | Document No.: | WI-ENG-PDE-892 |
| | Purpose: | ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO | | Revision No.: | 1 |
| | | | | Page No.: | 12 of 17 |

| PARTS: | 1. Assy parts | JIG: | Insertion jig |
|---|---|---|---|

| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|---|---|---|---|---|---|
| 13 | P1 | Connector setting to insertion jig 1746872-1 (B) | | N/A | |

**INSERTION SEQUENCE FROM LEFT TO RIGHT**

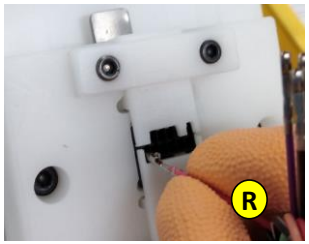


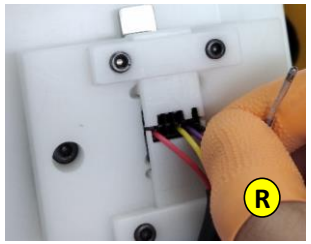

**WIRE INSERTION ILLUSTRATION**

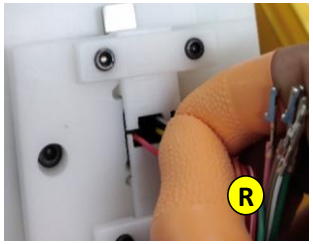
| 7 | 8 | 9 | 10 | 11 | 12 |
|---|---|---|---|---|---|
| X | X | L 200 | P 193 | X | X |
| 1 | 2 | 3 | 4 | 5 | 6 |
| R 189 | X | G 196 | V 191 | Y 197 | B 199 |

**BLACK SUNPRENE ø6.5**

**Terminal Facing**




1. Insert first the wires from **Black Sunprene tube.** Hold the **R wire** and insert to terminal slot 1 using right hand. Repeat the process for **V-Y-B wires**.
*Note: Follow the insertion sequence based on the illustration stated above.*

2. Hold the **P wire** and insert to terminal slot 5.
*Note: Follow the insertion sequence based on the illustration stated above.*

**QUALITY POINTERS**

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.*

*4. Follow the insertion sequence based on the illustration stated above.*

***Document references:***

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

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

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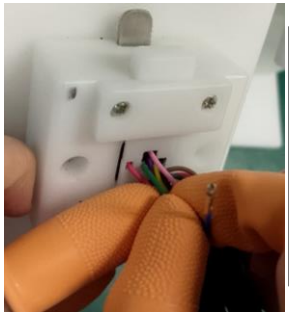
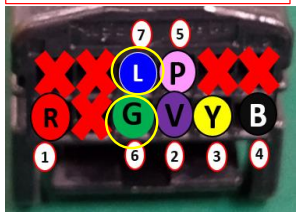
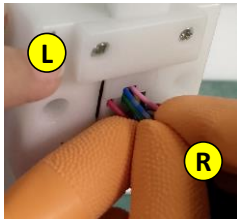
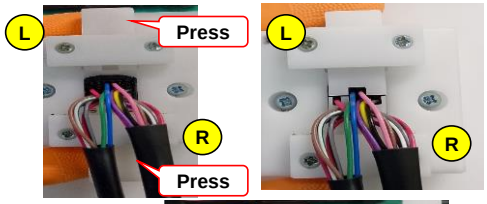
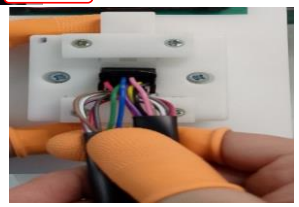
| | Model code/Part number: 559D / 75N401-0030 | Customer: TRJ | Car Model: TOYOTA HI-ACE | Document No.: | WI-ENG-PDE-892 | |
| | Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO | | | Revision No.: 1 | Page No.: | 13 of 17 |

| PARTS: | 1. Assy parts | JIG: | 1. Insertion jig |
|---|---|---|---|

| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|---|---|---|---|---|---|
| 14 | P1 | Wire insertion to Connector 1746872-1 (B) (Continuation) |  3. Insert the wires from **Black sunprene tube**, hold the G **wire** using right hand and support the wire by left index finger then insert to terminal slot 6 using right hand. Repeat the process for **L wire.** *Note: Follow the insertion sequence based on the above illustration.* **BLACK SUNPRENE ø8**     4. Hold the **L wire** and insert to terminal slot 7 using right hand. *Note: Follow the insertion sequence based on the illustration.*   5. Press the upper and lower lever guide (same timing) using both hands.  6. Remove the assy parts using right hand. | N/A | 1. Use provided jig per model<br>2. No wrong usage of parts<br>3. One by one insertion<br>4. No wrong insertion<br>5. No deformed terminal<br>6. No stuck of terminal tip<br><br>***Important reminders/Note/s:***<br>*1. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push after insertion.** Do not exert extra force.*<br>*2. Please hold the wire near terminal during insertion.*<br>*3. Follow the insertion sequence based on the above illustration.*<br><br>***Document references:***<br>*1. Refer to **GL-PRO-ASY-029** for Pull-Push procedure.* |

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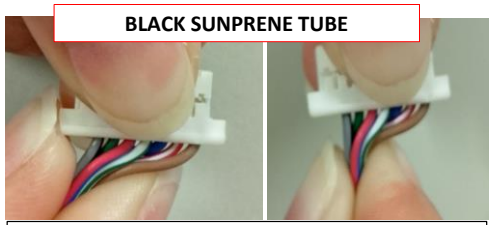
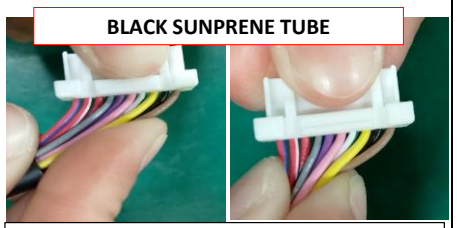
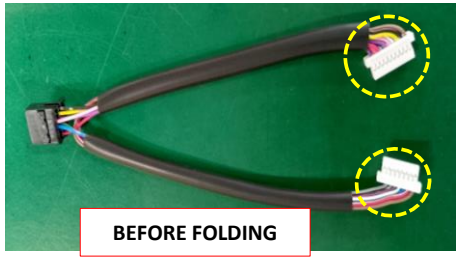
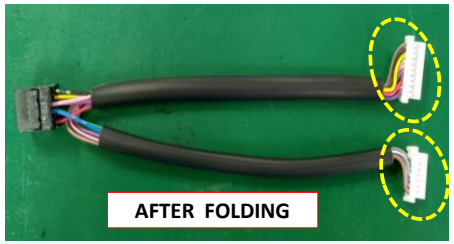
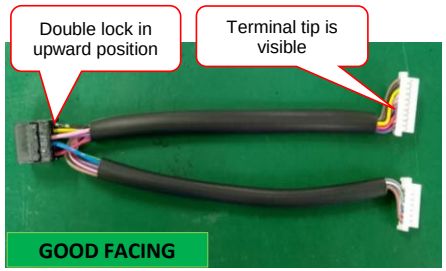
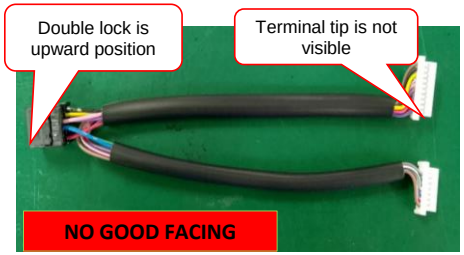
| | WORK INSTRUCTION | | | Effectivity Date: | March 11, 2025 | |
|---|---|---|---|---|---|---|
| | Process Name/Title: | TAPING ASSEMBLY PROCESS | | Validity Date: | n/a | |
| | Model code/Part number: | 559D / 75N401-0030 | Customer: TRJ / Car Model: TOYOTA HI-ACE | Document No.: | WI-ENG-PDE-892 | |
| | Purpose: | ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO | | Revision No.: | 1 | Page No.: 14 of 17 |

| PARTS: | 1. Assy parts<br>2. Master sample | JIG: | n/a |
|---|---|---|---|

| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|---|---|---|---|---|---|
| 15 | P1 | Wire Folding |  <br>1. Hold the **Connector PBVP-10V-S** using rigth hand and slightly fold the wire from **Black VM tube ø8 L=146±3mm *(as illustrated above)*** using right hand.<br>  <br>2. Hold the **Connector PBVP-8V-S** using rigth hand and slightly fold the wire from **Black VM tube ø6.5 L=146±3mm *(as illustrated above)*** using right hand.<br>  <br>  <br>  <br>  | n/a | 1. No wrong orientation of connector.<br>2. No tangled wires.<br>3. Terminal backing out. |

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| NBC | WORK INSTRUCTION | | | Effectivity Date: | March 11, 2025 |
| | Process Name/Title: | TAPING ASSEMBLY PROCESS | | Validity Date: | n/a |
| | Model code/Part number: | 559D / 75N401-0030 | Customer: TRJ / Car Model: TOYOTA HI-ACE | Document No.: | WI-ENG-PDE-892 |
| | Purpose: | ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO | | Revision No.: | 1 |
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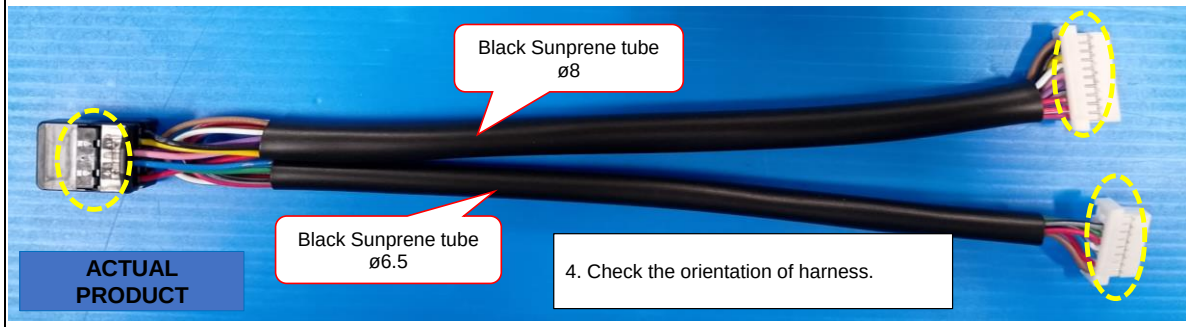
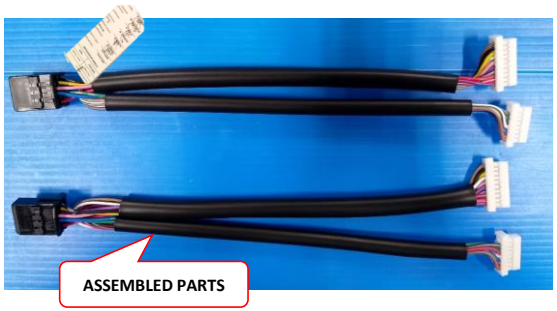
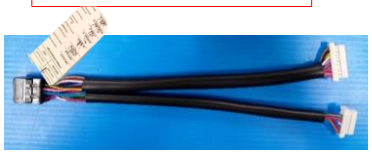
| | | | |
|---|---|---|---|
| **PARTS:** | 1. Assy parts<br>2. Master sample | JIG: | n/a |

| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|---|---|---|---|---|---|
| 16 | P1 | Visual/By two's Inspection | 1. Check the Connector lock, locking of connector is included to Steering electrical test.<br>2. Check the wire alignment. Make sure no tangled wires.<br>3. Check the terminal if with backing out (not fully inserted) or deformed terminal.<br>  <br><br>4. Check the orientation of harness.<br>5. Compare to **Master sample** by tapping.<br> <br><br>  <br> | | ***Document refence/s:***<br>*1. Refer to WI-QAD-QAC-252 Steering Electrical Test*<br>**ENGINEERING SAMPLE**<br>  |

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| | Model code/Part number: 559D / 75N401-0030 | Customer: TRJ | Car Model: TOYOTA HI-ACE | Document No.: | WI-ENG-PDE-892 |
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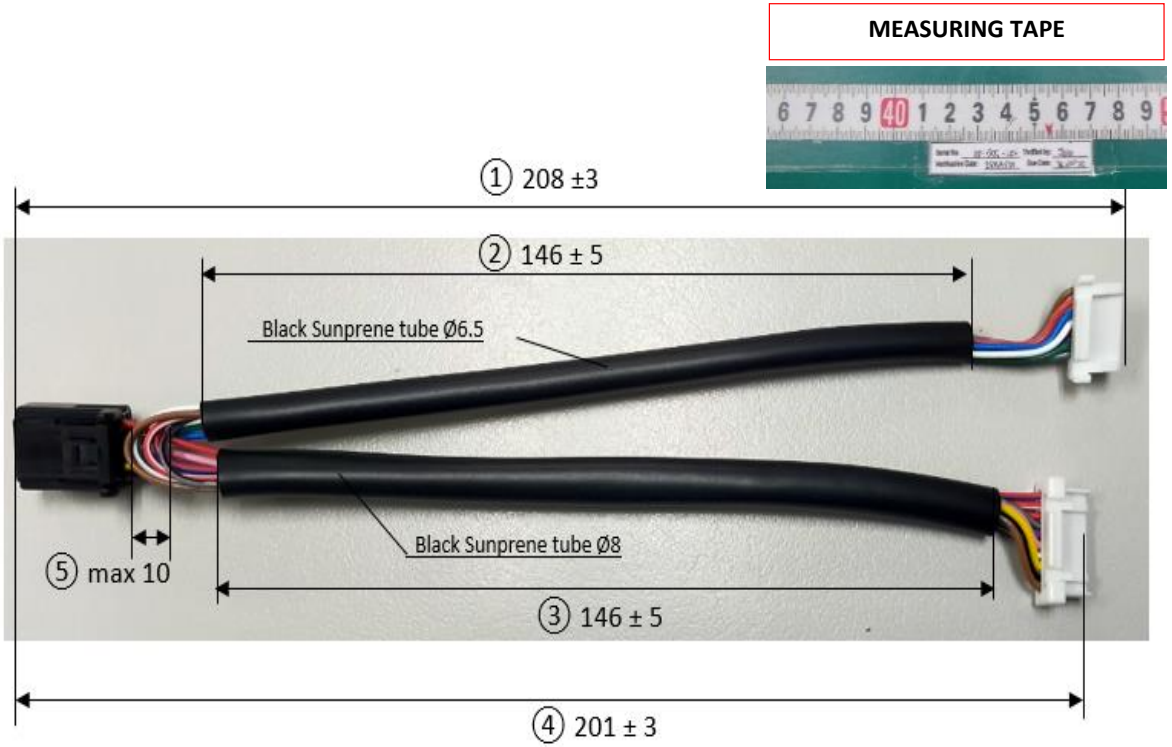
| | | | |
|---|---|---|---|
| **PARTS:** | 1. Assy parts | JIG: | n/a |

| NO. | PROCESS NAME | | WORK PROCEDURE/ ILLUSTRATION | TOOLS/PPE | QUALITY POINTERS |
|---|---|---|---|---|---|
| 17 | P1 | Measurement |   | | ***Important reminders and note/s:***<br>***1. Please use calibrated/verified measuring tape when getting the measurement.***<br><br>***2. For Hatsumono, Nakamono and Owarimono.***<br><br>***Document reference/s:***<br>*1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection*<br><br>1. No wrong dimension |

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| | | | |
|---|---|---|---|
| **PARTS:** | n/a | JIG: | n/a |

**QUALITY CHECKPOINTS**

| **P1** | **75N401-0030** |
|---|---|

1. Check the connector lock. Locking of connector is included in Steering Electrical test.

2. Check the wire alignment. Must be no tangled wires.

3. Check the Terminal if with Backing out (Not fully inserted) or no deformed terminal.

4. Check the orientation of harness.

5. Compare to **Master sample** by tapping

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