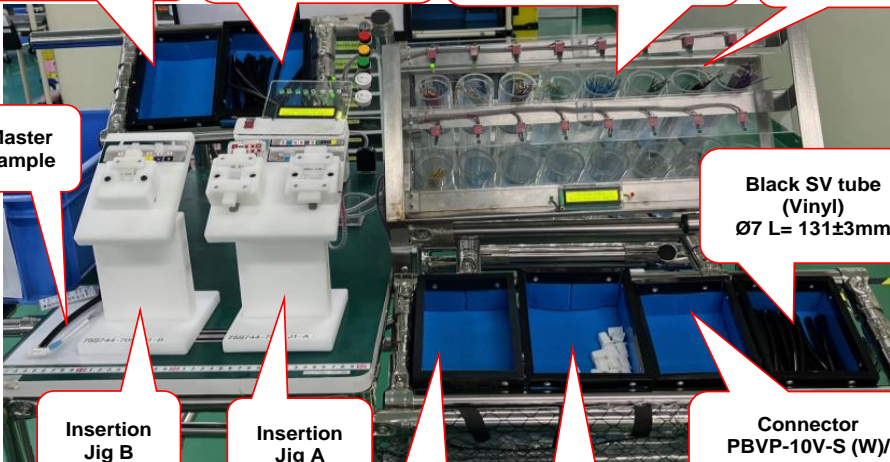




	<b>WORK INSTRUCTION</b>				Effectivity Date:		<b>March 04, 2025</b>	
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Process Name/Title:		Model code/Part number: <b>311D/400D / 75S834-7051</b>		Customer: <b>TRJ</b>		Car Model: <b>TOYOTA-RAV 4/BZ4X</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.:		<b>WI-ENG-PDE-1152</b>	
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<b>PARTS:</b>	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); 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
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
1	P1 Table lay-out	<div><div>Table Lay-out</div><div><div>Connector PBVP-06V-S (W)/ Box</div><div>Black SV tube (Vinyl) Ø5.5 L=122±3mm</div><div>Assy parts (GR/B wire with White SV tube, Sky blue tape)</div><div>2 Layer Navigation</div><div>Master sample</div><div>Black SV tube (Vinyl) Ø7 L= 131±3mm</div><div>Insertion Jig B</div><div>Insertion Jig A</div><div>Empty box for Pre-assy</div><div>Connector 4A1230-0000 (W)/ Box</div></div><div></div></div>		<div><b>Safety Instruction</b> Be sure to wear required 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>	<div><b>Document reference/s:</b> 1. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length Tolerance 2. Refer to <b>WI-ENG-PDE-1151</b> 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
							 D. Castillo	 J. Loterte	 C. Villanueva	 A. Arañes
03/04/25	2	Additional model code "400D" and car model "Toyota-BZ4X" due to new project. Update Measurement due to wrong facing.	D.Castillo	J. Loterte	C. Villanueva	A. Arañes				
12/06/24	1	Changr from Pre-launch to Masspro.	D.Castillo	n/a	C. Villanueva	A. Arañes				
11/15/24	0	Initial issue.	D.Castillo	n/a	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved	Est. Date:	November 15, 2024		



# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

March 04, 2025

Process Name/Title:

Model code/Part number:

311D/400D / 75S834-7051

Customer: TRJ

Car Model: TOYOTA-RAV 4/BZ4X

Document No.:

WI-ENG-PDE-1152

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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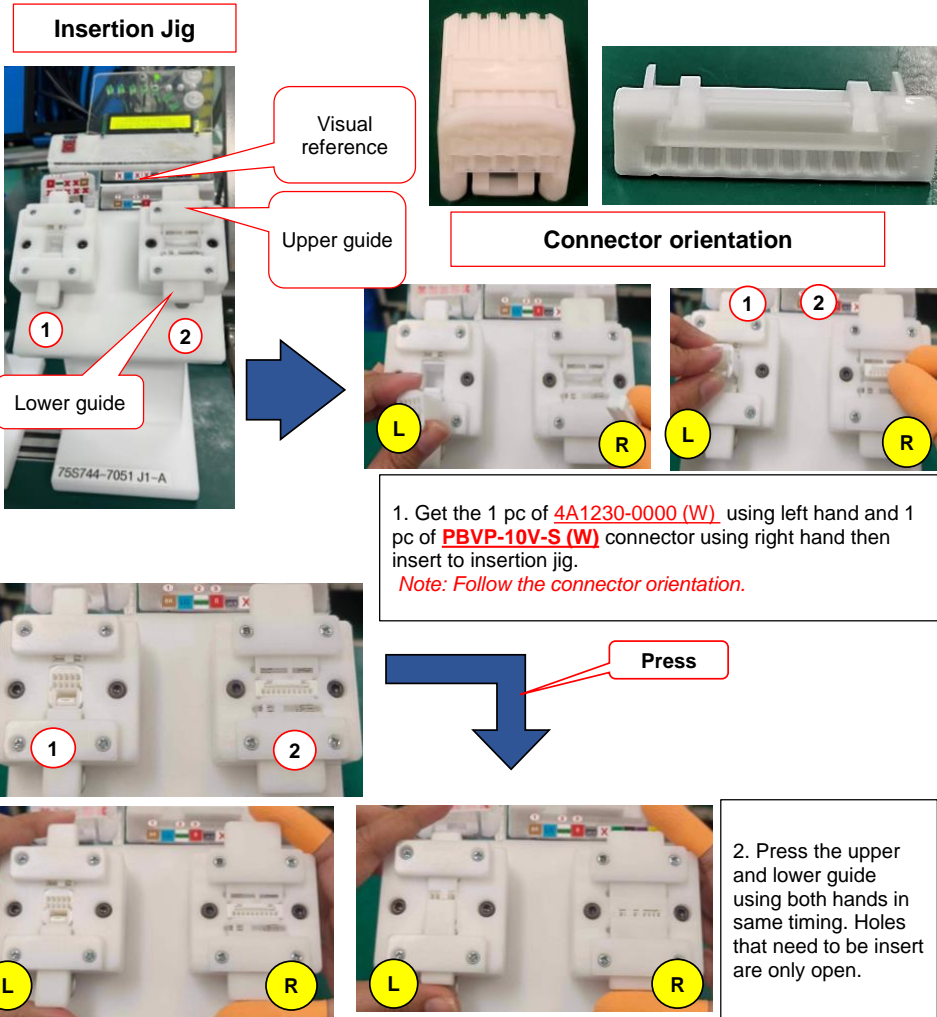


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**PARTS:**

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	<p>Connector setting to insertion jig 4A1230-0000 (W) and PBVP-10V-S (W)</p>  <p>1. Get the 1 pc of <b>4A1230-0000 (W)</b> using left hand and 1 pc of <b>PBVP-10V-S (W)</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 both hands in same timing. Holes that need to be insert are only open.</p>	<p><b>STEERING NAVIGATION (2 layer)</b></p>  <p><b>CONTROLLER</b></p> 	<ol style="list-style-type: none"><li>1. Use the provided jig per model</li><li>2. No wrong usage of parts</li><li>3. No wrong orientation of connector</li><li>4. No damaged connector</li></ol>

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## WORK INSTRUCTION

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## TAPING ASSEMBLY PROCESS

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Model code/Part number:

311D/400D / 75S834-7051

Customer:

TRJ

Car Model:

TOYOTA-RAV 4/BZ4X

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Purpose:

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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

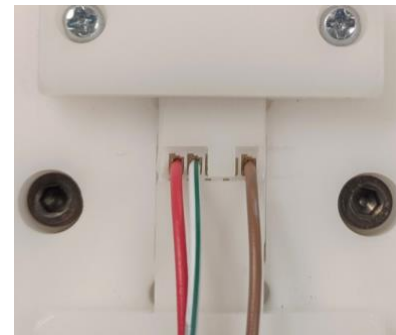
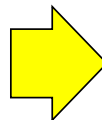
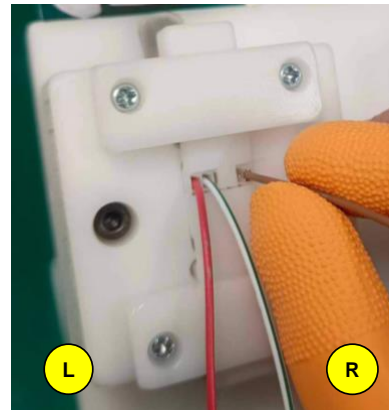
3

P1

Wire insertion to  
Connector  
4A1230-0000 (W)INSERTION SEQUENCE FROM LEFT TO  
RIGHTTERMINAL  
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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## WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

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Process Name/Title:

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Model code/Part number:

311D/400D / 75S834-7051

Customer:

TRJ

Car Model:

TOYOTA-RAV 4/BZ4X

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## PARTS:

1. 4A1230-0000 (W)
2. Connector PBVP-10V-S (W)/

JIG:

1. Insertion jig
2. Steering Navigation

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

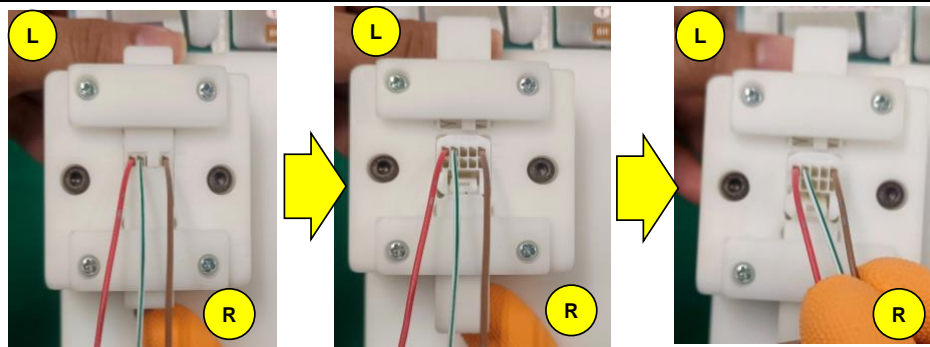
TOOLS/PPE

QUALITY POINTERS

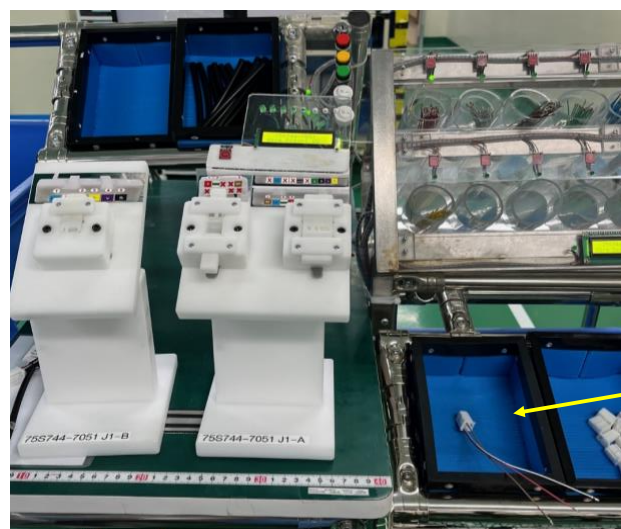
4

P1

Wire insertion to  
Connector  
4A1230-0000 (W)  
(Continuation)

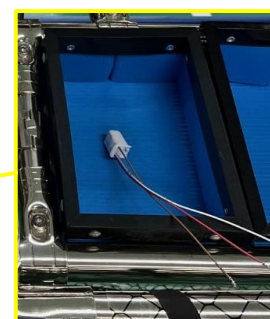


2. Press the Upper and lower button using both hands. Remove the 1st connector with inserted wires using right hand.



3. After removal to insertion jig, put the assy parts to empty box.

Note: Follow 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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## WORK INSTRUCTION

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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

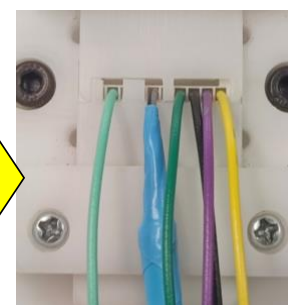
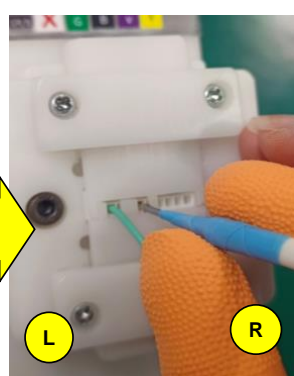
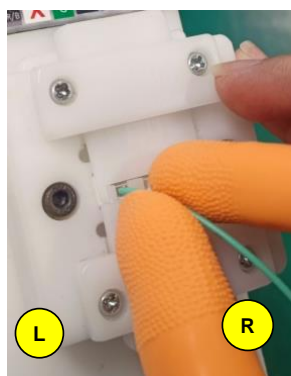
QUALITY POINTERS

## INSERTION SEQUENCE FROM LEFT TO RIGHT

TERMINAL  
FACING

## WIRE INSERTION ILLUSTRATION

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



1. Get the LG wire using right hand then insert to connector. Get the assy parts (GR/B with White tube taping) using right hand. Position the finger in the middle of wire and tube, slightly pinch while inserting to connector. Repeat the process for G,B,V and Y wires. Check the wire after insertion.

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

STEERING  
NAVIGATION (2 layer)

## CONTROLLER



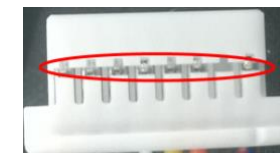
1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

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



Terminal tip must be visible

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## WORK INSTRUCTION

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March 04, 2025

Process Name/Title:

Model code/Part number:

311D/400D / 75S834-7051

Customer: TRJ

Car Model: TOYOTA-RAV 4/BZ4X

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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

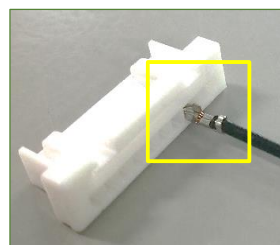
QUALITY POINTERS

5

P1

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

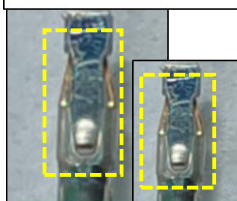
Proper alignment of terminal to connector



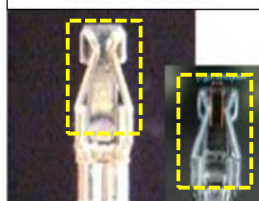
Improper alignment of terminal to connector



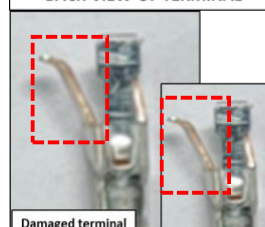
BACK VIEW OF TERMINAL

GOOD  
Terminal condition

FRONT OF TERMINAL

GOOD  
Terminal condition

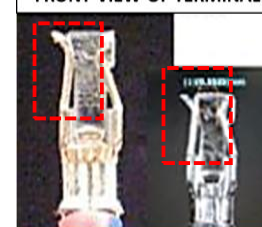
BACK VIEW OF TERMINAL



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.*

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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## WORK INSTRUCTION

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311D/400D / 75S834-7051

Customer: TRJ

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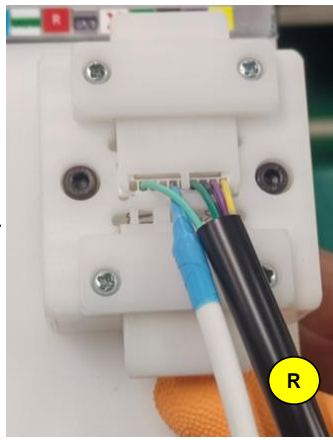
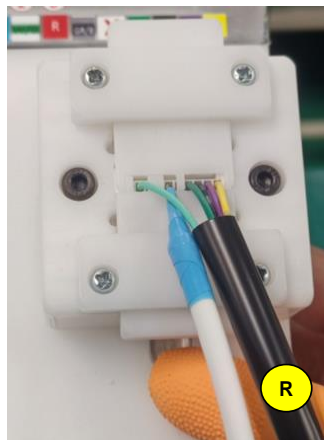
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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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></div> <div><p>1. Get the <b>Black SV tube (Vinyl) Ø7 L=131±3mm</b> 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></div> <div></div>		n/a	1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires

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**311D/400D / 75S834-7051**

Customer:

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Car Model:

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Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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**8 of 18****PARTS:**

1. Assy parts

JIG:

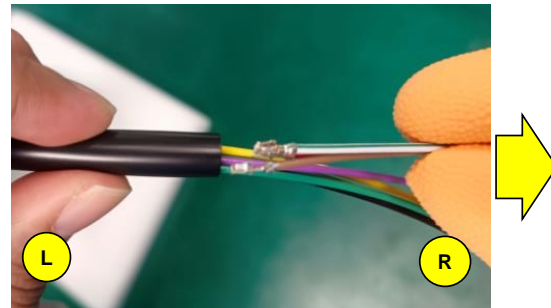
1. Insertion jig

**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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## WORK INSTRUCTION

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## PARTS:

1. Assy parts

JIG:

1. Insertion jig
2. Steering Navigation

NO.

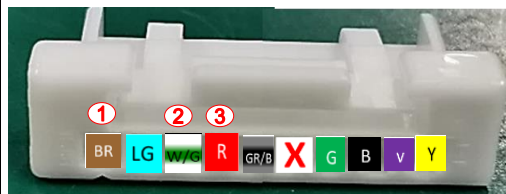
PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

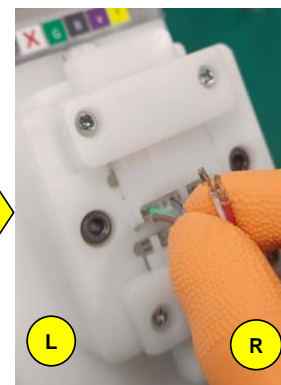
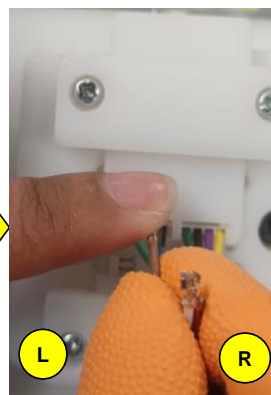
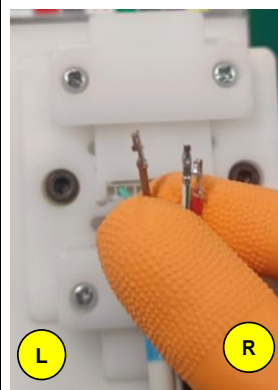
QUALITY POINTERS

## 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

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.

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.*

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## WORK INSTRUCTION

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## TAPING ASSEMBLY PROCESS

Effectivity Date:

March 04, 2025

Model code/Part number:

311D/400D / 75S834-7051

Customer: TRJ

Car Model: TOYOTA-RAV 4/BZ4X

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## PARTS:

1. Assy parts

JIG:

1. Insertion jig
2. Steering Navigation

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

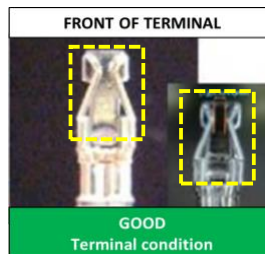
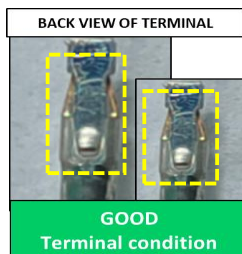
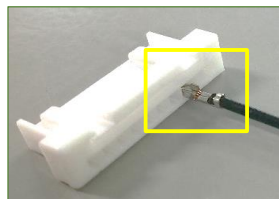
QUALITY POINTERS

8

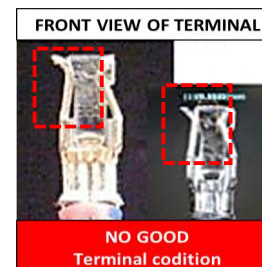
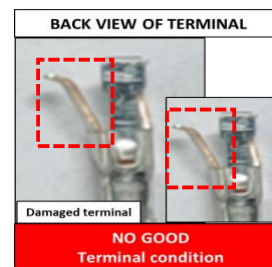
P1

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

Proper alignment of terminal to connector



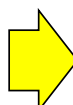
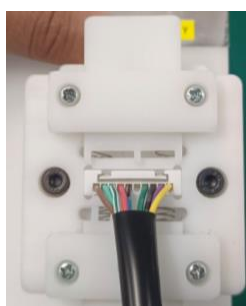
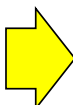
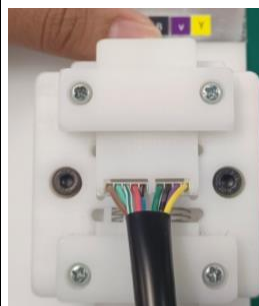
Improper alignment of terminal to connector



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.*



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

## 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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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**March 04, 2025**

Model code/Part number:

**311D/400D / 75S834-7051**

Customer:

**TRJ**

Car Model:

**TOYOTA-RAV 4/BZ4X**

Document No.:

**WI-ENG-PDE-1152**

Purpose:

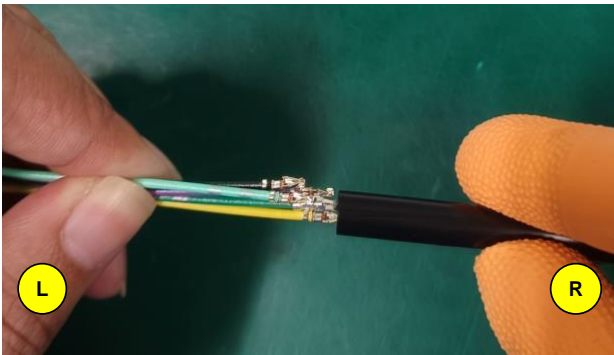
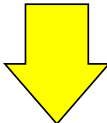

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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**2**

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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 <b>Black SV tube (Vinyl) Ø5.5 L=122±3mm</b> using right hand. Hold the wire of assy parts using left hand then insert the wires.</div></div> <div></div> <div></div>		n/a	1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires

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**WORK INSTRUCTION**

Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Effectivity Date:

**March 04, 2025**

Model code/Part number:

**311D/400D / 75S834-7051**Customer: **TRJ**Car Model: **TOYOTA-RAV 4/BZ4X**

Document No.:

**WI-ENG-PDE-1152**

Purpose:


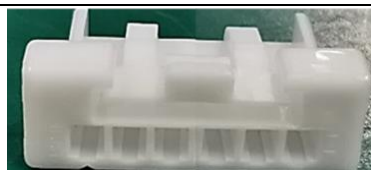
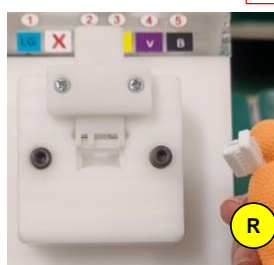


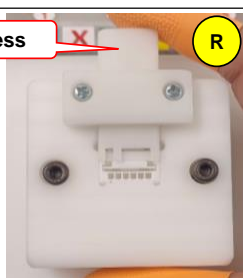
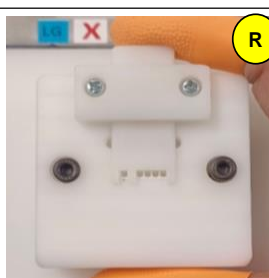
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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**2**

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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>Insertion Jig</div><div></div><div>Visual reference</div><div>Upper guide</div><div></div><div>Connector orientation</div><div></div><div></div><div>1. Get the 1 pc of <b>PBVP-6V-S</b> connector using right hand then insert to insertion jig. <i>Note: Follow the connector orientation.</i></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> <td>n/a</td> <td>1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</td>		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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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

March 04, 2025

Validity Date:

n/a

Model code/Part number: 311D/400D / 75S834-7051

Customer: TRJ

Car Model: TOYOTA-RAV 4/BZ4X

Document No.:

WI-ENG-PDE-1152

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

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PARTS:

1. Assy parts

JIG:

1. Insertion jig

NO.

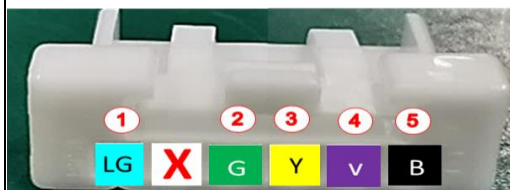
PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

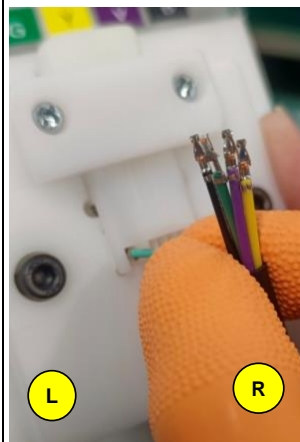
INSERTION SEQUENCE FROM LEFT TO RIGHT



TERMINAL  
FACING

WIRE INSERTION ILLUSTRATION

1	2	3	4	5
LG	X	G	Y	V
289	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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## WORK INSTRUCTION

Process Name/Title:

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Model code/Part number:

311D/400D / 75S834-7051

Customer:

TRJ

Car Model:

TOYOTA-RAV 4/BZ4X

Document No.:

WI-ENG-PDE-1152

Purpose:



PROTOTYPE



PRE-LAUNCH



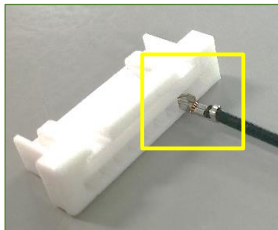
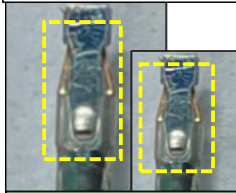
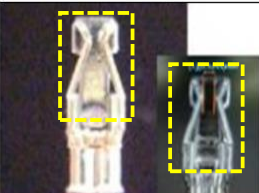
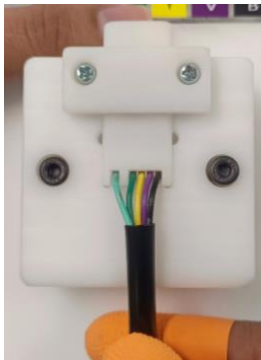

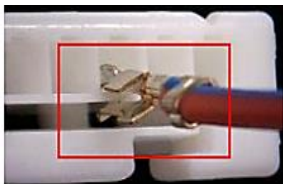
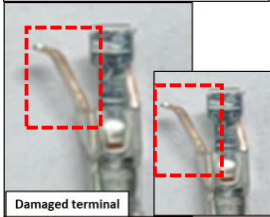
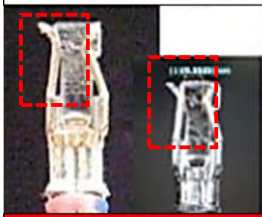
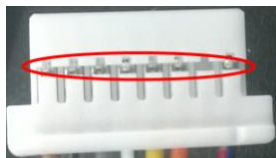
MASSPRO

Revision No.:

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

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# WORK INSTRUCTION

Effectivity Date:

March 04, 2025

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number:

311D/400D / 75S834-7051

Customer:

TRJ

Car Model:

TOYOTA-RAV 4/BZ4X

Document No.:

WI-ENG-PDE-1152

Purpose:



PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Assy parts

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

12

P1

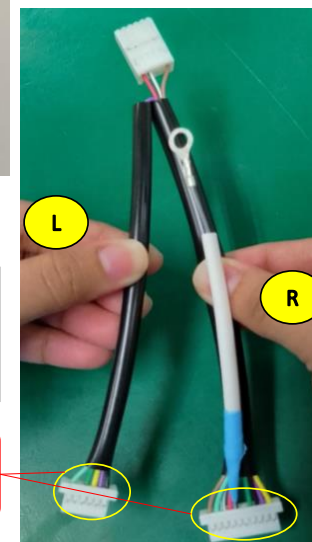
Wire folding/  
Wire arrangement



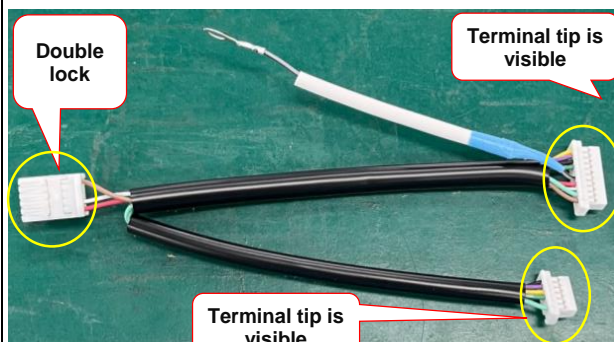
BEFORE FOLDING

1. Hold the assy parts using both hands the conduct folding and wire arrangement.

AFTER FOLDING

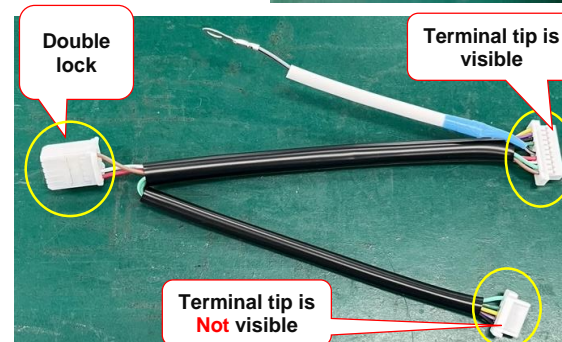


Terminal tip is visible



Terminal tip is visible

GOOD FACING



Terminal tip is Not visible

NG FACING

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

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## WORK INSTRUCTION

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311D/400D / 75S834-7051

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WI-ENG-PDE-1152

Purpose:



PROTOTYPE



PRE-LAUNCH



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## PARTS:

1. Assy parts
2. Master sample

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

13

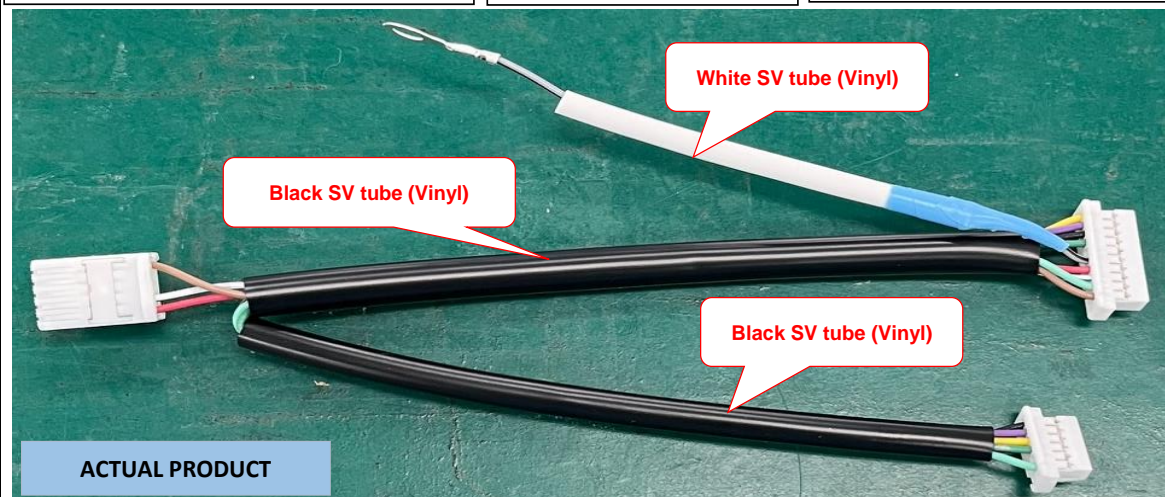
P1

Visual/By Two's  
Inspection

1. Check the connector lock. Locking of connector is included to Steering electrical test.

2. Check the wire alignment. Make sure 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.

Assembly product

Engineering Sample

**Document reference/s:**

1. Refer to **WI-QAD-QAC-252**  
Steering Electrical Test

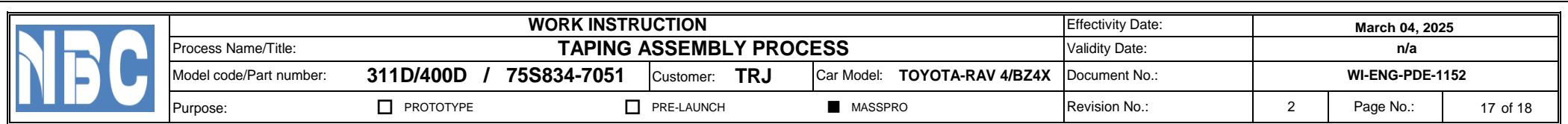
**MASTER SAMPLE**

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	<b>WORK INSTRUCTION</b>				Effectivity Date:		<b>March 04, 2025</b>	
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		<b>n/a</b>	
	Model code/Part number: <b>311D/400D / 75S834-7051</b>		Customer: <b>TRJ</b>	Car Model: <b>TOYOTA-RAV 4/BZ4X</b>	Document No.:		<b>WI-ENG-PDE-1152</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		<b>2</b>	Page No.: <b>18 of 18</b>

<b>PARTS:</b>	1. Assy parts	JIG:	n/a
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**VISUAL INSPECTION/ QUALITY CHECKPOINTS**

STEERING

75S834-7051

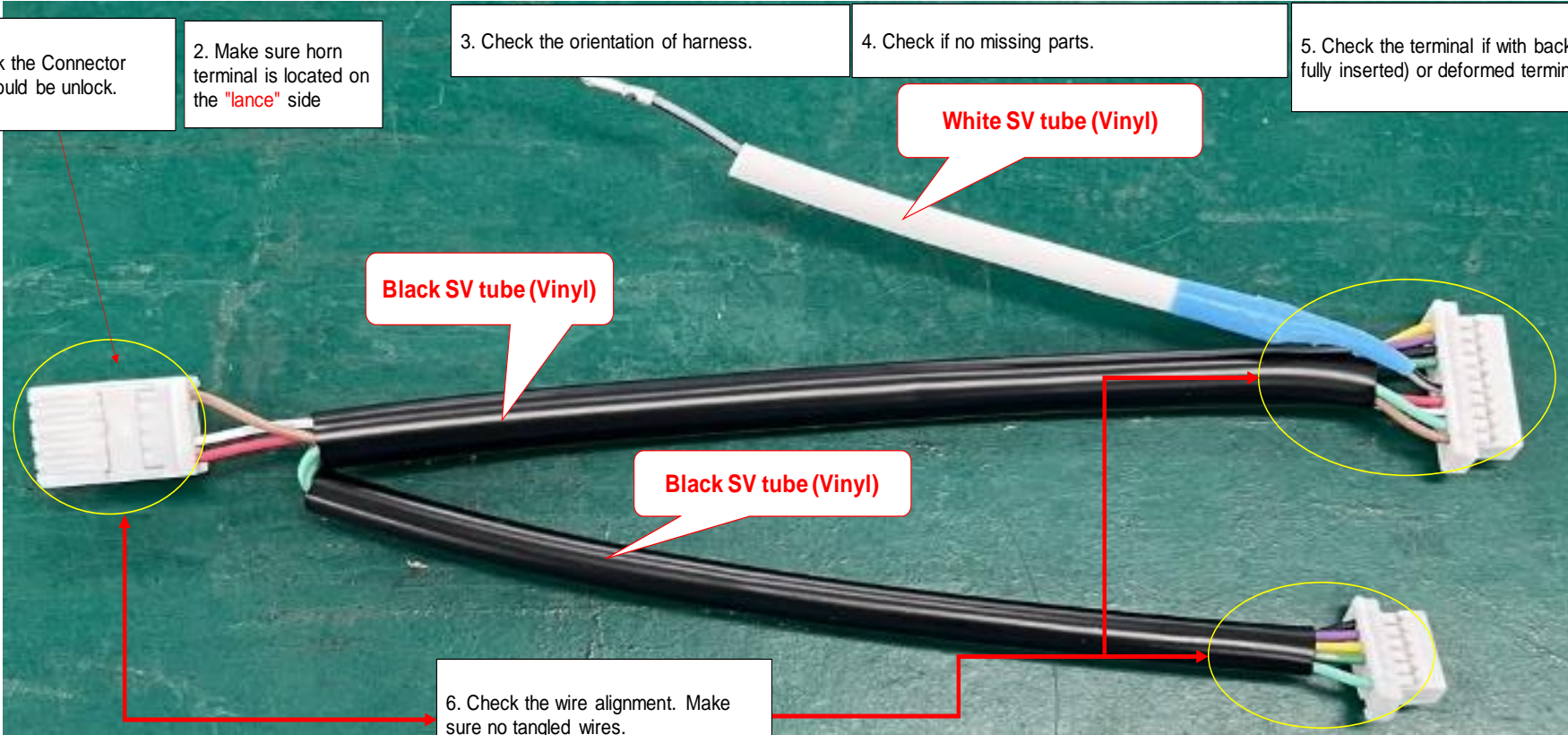
1. Check the Connector lock, should be unlock.

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.



White SV tube (Vinyl)

Black SV tube (Vinyl)

Black SV tube (Vinyl)

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

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