2. Sidering Navigation NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TABLE LAY-OUT Safety Instruction Be sure to wear required personally during personally during personally during operation (gloves, finger cots, etc.) 1. P1 Table Lay-out Master surple Master surple for any frequency becomes the master of the surple for any frequency becomes the master of the surple for any frequency becomes the master of the surple for any frequency becomes the master of the surple for any frequency becomes the master of the surple for any frequency becomes the master of the surple for any frequency and frequency and frequency an					WORK INS	STRUCTION					Effect	tivity Date:		January 23, 2	025
Table Lay-out Process				Process Name/Title:	TAPIN	IG ASSEMBL	Y PROC	ESS			Validi	ty Date:		n/a	
PARTS: L=160u2mm: CL=291u2mm; RVL=291u2mm; R				Model code/Part number:	920B / 75S321-0081	Customer:	TRMX	Car Model:	TOYOT	A-TACOMA	Docu	ment No.:		WI-ENG-PDE-1	185
PARTS: L=160:2/mm; IC L=297-2/mm; RM L=297-2/mm; RM L=297-2/mm; AVB, L=297-2/mm; AVB, L=297-2/mm; AVB, L=297-2/mm; AVB, L=207-2/mm; AVB, L=207				Purpose:	PROTOTYPE	PRE-LAUNCH		MASSP	RO		Revis	ion No.:	1	Page No.:	1 of 18
TABLE LAY-OUT Safety Instruction Basure to wear required personal protective equipment displayed personal indigenous form pre-bounds to mass pro. A Basure to wear required personal inguisers of the protection of the prote	PARTS:		L=160± L=162± L=120±	2mm; LG L=297±2mm; R/\ 2mm; G L=162±2mm; BR 3mm.	W L=297±2mm; B/W L=297±2mm; OR L L=162±2mm; GR L=162±2mm; Black VM	=297±2mm; R/L L= 1 tube (Sunprene) ø	=297±2mm; ø8 L=118±3	; AVSS 0.3 F 3mm; Green	L=162±2r	mm; W/G			2. Steerin	g Navigation	ITEDS
1 P1 Table Lay-out Black VM tube (sumprene) as Lat 1883mm 2 layer Navigator	NC).	P	ROCESS NAME	WORK	PROCEDURE/ I	LLUSTRA	ATION				TOOLS/PPE		QUALITY POIN	HERS
01/23/25 1 Change document purpose from pre-launch to mass pro. A. Buban C. Villanueva A. Arañes n/a A. Buban C. Villanueva A. Buban C. Vill	1		P1	Table Lay-out	Connector 1746872-1 (B) Master sample Insertion jig B	ne) ø8 nsertion jig A Connector PBVP-	2 lay	yer Navigato	Green VM (sunpren	e) ø8	. pr (!	Be sure to wear required personal otective equipme during operation gloves, finger cotter.) Housekeeping Maintain and alway practice 5's. Personal things the workplace is rohibited. Keep it your locker. Alert level r any trouble, infort Assembly Assist Supervisor or Line ader for immedia	ays on 1. No defo in 2. No wro		
01/14/25 0 Initial issue. A. Buban C. Villanueva A. Arañes n/a A. Buban C. Villanueva A. Arañes n/a					Revision History				,	1		Prepared by	Reviewed by	Approved by	Noted by
01/14/25 0 Initial issue. A. Buban C. Villanueva A. Arañes n/a A. Buban C. Villanueva A. Arañes n/a															
01/14/25 0 Initial issue. A. Buban C. Villanueva A. Arañes n/a A. Buban C. Villanueva A. Arañes n/a A. Buban C. Villanueva A. Arañes n/a	01/23/25	1	Change d	ocument purpose from pre-launch	n to mass pro.			A. Buban	C. Villanueva	A. Arañes	n/a	glava abaa	South Titlown	_ AMA	
Eff. Date Rev. No Details of Change Revised Revised Approved Noted Est. Date: January 14, 2025	01/14/25		Initial issu	e.				A. Buban	C. Villanueva	A. Arañes	n/a	A. Buban		A. Araños	n/a
	Eff. Date	Rev. No	<u> </u>		Details of Change			Revised	Reviewed	Approved N	oted	Est. Date:	January 14, 2025		



				ISTRUCTION	•		Effectivity Date:		January 23, 20)25
		Process Name/Title:	TAPI	NG ASSEMBLY PROC	CESS		Validity Date:		n/a	
		Model code/Part number:	920B / 75S321-0081	Customer: TRMX	Car Model:	TOYOTA-TACOMA	Document No.:		WI-ENG-PDE-1	185
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSP	RO	Revision No.:	1	Page No.:	2 of 18
PARTS:		nector PBVP-10V-S (W) [2		/ DD005DUDE/ II L HETD	ATION			1. Insertion		TEDE
NO.	F	ROCESS NAME	WORK	PROCEDURE/ ILLUSTR	ATION		TOOLS/PPE	,	QUALITY POIN	IEKS
2	P1	Connector setting to insertion jig PBVP-10V-S (W)	Lower Lower 1. Cottrant No.	I reference r guide Get the 2 pcs of PBVP-10V-S (insfer the 1 connector to left handle: Follow the connector orients Press Ower guide using left hand in sa	nd then insert	r using right hand then to insertion jig.	N/A	No wronNo wron	provided jig per m g usage of parts g orientation of co aged connector	

				STRUCTION	0500	Effectivity Date:		January 23, 202	25
		Process Name/Title: Model code/Part number:	920B / 75S321-0081	NG ASSEMBLY PRO	CESS Car Model: TOYOTA-TACOM	Validity Date: A Document No.:		n/a WI-ENG-PDE-11	05
				Customer: TRMX				-	
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	1	Page No.:	3 of 18
PARTS:	L=297:	S 0.3 R L=160±2mm; V L= ±2mm; OR L=297±2mm; R/I k VM tube (Sunprene) ø8 L		nm; GR/B L=160±2mm; LG L=	=297±2mm; R/W L=297±2mm; B/W	JIG:	1. Insertion	jig	
NO.		PROCESS NAME		PROCEDURE/ ILLUST	RATION	TOOLS/PPE		QUALITY POINT	
3	P1	Wire insertion to Connector PBVP-10V-S (W)	1. Get the R/L wire using right hand a LG-GR/B-B-Y-V-R wires. Note: Follow the insertion sequence	9 10 1 2 3 R/L OR B/W 297 297 297 297 297 297	R/W LG GR/B B Y V 297 160 160 160 160 160 1	STEERING NAVIGATION(2 layer) CONTROLLER	2. No wrong 3. One by 0 4. No wrong 5. No defor 6. No stuck Importan 1. Make su Conduct Prinsertion. Do not exe 2. Please Induring inse 3. Follow to the illustran 1. Refer to procedure 2. Refer to	med terminal to ferminal tip nt reminders/No ure wires are proper tull-Push-Pull-Push ert extra force. thold the wire near tertion. the insertion sequention. ent references: to GL-PRO-ASY-02	ote/s: In the inserted. In after Iterminal Ince based on 29 for Pull-Push
4		Wire insertion to Black VM tube (sunprene) ø8 L=118±3mm	L	R	1. Get the Black VM tube (Sunprene) ø8 L=118±3mm using righ hand. Hold the wires using left hand and insert the wires using right hand.	N/A		g usage of parts med terminal ed wires	

			WORK IN	STRUCTION		Effectivity Date:		January 23, 202	25
		Process Name/Title:		NG ASSEMBLY PROC	CESS	Validity Date:	+	n/a	
		Model code/Part number:	920B / 75S321-0081	Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:		WI-ENG-PDE-11	85
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	1	Page No.:	4 of 18
PARTS:		0.3 R L=160±2mm; V L=160 97±2mm; R/L L=297±2mm;	0±2mm; Y L=160±2mm; B L=160±2mm; GR	/B L=160±2mm; LG L=297±2mn	n; R/W L=297±2mm; B/W L=297±2mm;	JIG:	1. Insertion ji	jig	
NO.	Р	ROCESS NAME	WORK	PROCEDURE/ ILLUSTR	ATION	TOOLS/PPE	C	QUALITY POINT	ΓERS
5	P1	Wire insertion to connector PBVP-10V-S (W) (Continuation)	BACK VIEW OF TERMINAL GOOD Terminal condition Note: *Make sure the terminal wa *Avoid hitting the terminal		Damaged terminal NO GOOD Terminal condition	NO GOOD Terminal codition	2. No wrong 3. No wrong 4. No deform 5. No stuck of 6. One by or 1. Mai inserte Push a Do no 2. Plea termin 3. Aut replac encou difficu locked 4. Inse left to Docum 1. Refe Wire a 2. Refe Steerin procec 3. Refe Pull-Pu 4. Refe	ned terminal of terminal of terminal tip ne insertion retant reminders/Notes are ted. Conduct Pullafter insertion. The exert extra force as a hold the wire to matically dispose the unit if once untered bend termility of insertion and connector. The erto of wires must reference of the erto WI-PRO-CNOT the to WI-PRO-CNOT to WI-PRO-CNOT to WI-PRO-CNOT to WI-PRO-CNOT to WI-PRO-CNOT to WI-PRO-CNOT to WI-PRO-AST to GL-PRO-AST to Standard for the suspense of the erto WI-PRO-CNOT to GL-PRO-AST to GL-PRO-AST to Standard for the suspense of the erto Standard for the entire to Standard for t	e properly -Push-Pull- e. s near on. ss e and e) ininal, ind half- ust be from C-017 for Tolerance. E-044 for introller Y-029 for

			WORK IN:	STRUCTION			Effectivity Date:		January 23, 20	25
		Process Name/Title:	TAPIN	NG ASSEMBLY PROC	CESS		Validity Date:		n/a	
		Model code/Part number:	920B / 75S321-0081	Customer: TRMX	Car Model: T(OYOTA-TACOMA	Document No.:		WI-ENG-PDE-1	185
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO		Revision No.:	1	Page No.:	5 of 18
PARTS:	1. AVS	S 0.3 P L=162±2mm; W/G	L=162±2mm; G L=162±2mm; BR L=162	±2mm; GR L=162±2mm;			JIG:	1. Insertion	ı jig	
NO.	F	ROCESS NAME	WORK	PROCEDURE/ ILLUSTR	ATION		TOOLS/PPE	(QUALITY POIN	TERS
6	P1	Wire insertion to Connector PBVP-10V-S (W)	BR-G-W/G-P wires.	TITO 1 2 3 4	8Ø Ø8 ector. Repeat the	8 9 10 G W/G P 162 162 162 e only		2. No wron 3. One by 6 4. No wron 5. No defoi 6. No stuck Importa 1. Please during in 2. Refer Push pro 3. Make Conduct insertion. Do not e. 4. Follow	ant reminders/ e hold the wire neasertion. to GL-PRO-ASY- coedure. sure wires are pro Pull-Push-Pull-P	Note/s: ar terminal 029 for Pull- perly inserted. ush after

				ISTRUCTION		Effectivity Date:	T	January 23, 20	25
		Process Name/Title:		NG ASSEMBLY PRO	CESS	Validity Date:		n/a	
		Model code/Part number:	920B / 75S321-0081	Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:		WI-ENG-PDE-11	≀85
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	1	Page No.:	6 of 18
						1			
PARTS:	1. AVS	S 0.3 P L=162±2mm; W/G	L=162±2mm; G L=162±2mm; BR L=16	2±2mm; GR L=162±2mm;		JIG:	1. Insertion ji	ig	
NO.	F	ROCESS NAME	WORK	PROCEDURE/ ILLUST	RATION	TOOLS/PPE	C	QUALITY POIN	ΓERS
7	P1	Wire insertion to connector PBVP-10V-S (W) (Continuation)	BACK VIEW OF TERMINAL GOOD Terminal condition Note: *Make sure the terminal w. *Avoid hitting the terminal		Damaged terminal NO GOOD Terminal condition	NO GOOD Terminal codition	2. No wrong 3. No wrong 4. No deform 5. No stuck of 6. One by on 1. Malinserte Push a Do noi 2. Pleatermin 3. Autt replace encou difficu locked 4. Inse left to Docum 1. Refe Wire au 2. Refe Steerir proced 3. Refe Pull-Pu 4. Refe	ned terminal of terminal tip terminal terminal during insertion and during insertion and connector. The terminal during insertion of wires multiply of insertion and connector. The terminal tip terminal te	e properly -Push-Pull- e. ss near on. ss e and e. ininal, and half- ust be from : C-017 for Tolerance. E-044 for ontroller Y-029 for

				STRUCTION		Effectivity Date:		January 23, 202	25
		Process Name/Title:	TAPII	NG ASSEMBLY PRO	CESS	Validity Date:		n/a	
		Model code/Part number:	920B / 75S321-0081	Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:		WI-ENG-PDE-11	85
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	1	Page No.:	7 of 18
PARTS:	1. Assy 2. Gree	r parts en VM tube (sunprene) ø8 L	=120±3mm			JIG:	1. Insertion	jig	
NO.	F	PROCESS NAME	WORK	PROCEDURE/ ILLUST	RATION	TOOLS/PPE	C	QUALITY POINT	ERS
8	P1	Wire insertion to Green VM tube (sunprene) ø8 L=120±3mm	R	L=120±3mm and then insert L ted wires and Black VM tube (Sun wire insertion condition.	2. Press the Upper and lower guide button using left and right hand. R Apprene) using right hand then press the e) will stay in the jig.		Z. No defor 3. No tangl Term Docum 1. Reference Insertion 2. Reference 2. Reference 2. Reference 2. Reference 3. Reference 3. Reference 4. Referen	ent References: er to GL-PRO-ASY- ion Standard for Co	-025 for oupler
			4. Press the lower button using left had		Jare only open.	N/A		g use of parts med terminal ed wires	

			WORK IN	ISTRUCTION		Effectivity Date:		January 23, 202	5
		Process Name/Title:	TAPI	NG ASSEMBLY PRO	CESS	Validity Date:		n/a	
		Model code/Part number:	920B / 75S321-0081	Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:		WI-ENG-PDE-118	35
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	1	Page No.:	8 of 18
PARTS:	1. Assy 2. Gree	parts n VM tube (sunprene) ø8 L	_=120±3mm			JIG:	1. Insertion	n jig	
NO.	F	ROCESS NAME	WORK	PROCEDURE/ ILLUST	RATION	TOOLS/PPE	(QUALITY POINT	ERS
9	P1	Wire insertion to assy parts	755136-	R R	1. Hold the Green VM tube (Sunprene) using left hand and insert the wires from Black VM tube (Sunprene) using right hand.		2. No defor 3. No tangl Term Docum 1. Reference Inspect Insertio 2. Refee	ninal tip must be v	025 for oupler 043 for

PROCESS NAME PARTS: 1. Assy parts NO. PROCESS NAME WORK PROCEDURE/ILLUSTRATION WIRE INSERTION ILLUSTRATION WIRE INSERTION ILLUSTRATION Wire facing STERING NAVIGATION(2 layer) 1. Peace hold the wire name facinines in S. No unique facility inserted. Conduct Pull-Publish and an august the wire by left index Report from the many facing the insert to consection uniquity than Repeat the process on OR1-CR/W-RW wire. Check the wire above illustration. Note: Follow the insertion sequence based on the above illustration. 3. Peace the Upper button using left hand and fine from the many part in and. Repeat the process on OR1-CR/W-RW wire. Check the wire above illustration. 3. Peace the Upper button using left hand and fine from the many part in and. Check the importance of the many part in and. Check the importance of the procedure. 3. Peace the Upper button using left hand and fine from the many part in and. Check the importance of the procedure. 3. Peace the Upper button using left hand and control contr				WORK IN		Effectivity Date:		January 23, 20)25	
PARTS: 1. Assy parts NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS WIRE INSERTION ILLUSTRATION 1. Use provided jig per model 2. No wrong usage of parts 3. One type one insertion 4. No wrong usage of parts 3. One type one insertion 4. No wrong usage of parts 5. No deformed terminal 5. No deformed terminal 6. No worth of the part of the			Process Name/Title:	TAPI	NG ASSEMBLY PROC	CESS	Validity Date:		n/a	
PARTS: 1. Assay parts NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION WIRE INSERTION ILLUSTRATION 1. Use provided jip per model 2. No wrong usage of parts 3. One by one insertion 4. No wrong insertion 5. No deformed terminal 6. No stack of terminal tip 7. The stack of terminal tip 8. No transjed wires 9. No wrong facing Wire facing Wire facing Wire facing Wire facing TOLS/PPE QUALITY POINTERS 1. Use provided jip per model 2. No wrong usage of parts 3. One by one insertion 4. No wrong insertion 5. No deformed terminal 6. No stack of terminal tip 7. No transjed wires 9. No wrong facing Important reminders/Note's: 1. Pease hold the wire near terminal during insertion. Commont 10 PEVP-10V-2 (IV) Read to Use using right hand and support the wire by left index finger then insert to connector using right hand. Repeat the process on 0RL-R-W-M-W vires. Check the wire alter insection Note: Follow the insertion sequence based on the above illustration. 3. Press the Upper button using left hand then romove the asky port using right hand. Check the 3. Press the Upper button using left hand then romove the asky port using right hand. Check the 10 PROCESS NAME Use provided jip or model 2. No wrong usage of parts 3. One by one insertion 4. No wrong issage 6. No stack of terminal 6. No stack of terminal 6. No stack of the wire near terminal 6. No stack of terminal 6. No stack of the wire near terminal 6. No stack of the control of the stack 6. No stack of terminal 6. No stack of the control of the stack 6. No stack of the control of the stack 6. No stack of the stack 6. N			Model code/Part number:	920B / 75S321-0081	Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:		WI-ENG-PDE-1	185
NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION WIRE INSERTION ILLUSTRATION 1. Use provided jip per model 2. No wrong usage of parts 3. One by one insertion 4. No wrong insertion 6. No stuck of terminal to 7. No deformed terminal 8. No tangled wires 9. No wrong facing 9. No wrong facing 9. No wrong facing 1. Use provided jip per model 2. No wrong usage of parts 3. One by one insertion 4. No wrong insertion 6. No stuck of terminal to 7. No deformed terminal 8. No tangled wries 9. No wrong facing 9. No wrong facing 1. Use provided jip per model 2. No wrong usage of parts 3. One by one insertion 6. No stuck of terminal 9. No deformed terminal 9. No deformed terminal 9. No wrong facing 1. No wrong insertion 9. No wrong facing 1. No deformed terminal 9. No deformed terminal 9. No wrong facing 1. No wrong insertion 9. No deformed terminal 9. No wrong facing 1. No wrong insertion 9. No deformed terminal 9. No wrong facing 1. No wrong insertion 9. No deformed terminal 9. No wrong facing 1. No wrong insertion 9. No wrong facing 1. No wrong insertion 9. No deformed terminal 9. No wrong facing 1. No wrong insertion 9. No deformed terminal 9. No wrong facing 1. No wrong insertion 9. No wrong facing 1. No wrong insertion 9. No deformed terminal 9. No wrong facing 1. No wrong insertion 9. No wrong facing 1. No wrong insertion 9. No deformed terminal 9. No wrong facing 1. No wrong insertion 9. No deformed terminal 9. No wrong facing 1. No wrong insertion 9. No wrong facing 1.			Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	1	Page No.:	9 of 18
Wire insertion to Connector PBVP-10V-S (W) P1 Wire insertion to Connector PBVP-10V-S (W) 2. Hold the R/L. wire using right hand and support the wire by left index finger then insert to connector using right hand. Repeat the process on Note: Follow the insertion sequence based on the above illustration. Wire facing Wire facing 1. Use provided jig per model 2. No wrong uses of parts 3. One by one insertion 4. No wrong usertion 4. No wrong usertion 5. No deformed terminal to 6. No stuck of terminal tip 7. No deformed terminals 8. No tangled wires 9. No wrong facing Wire facing Wire facing Wire facing Wire facing Wire facing Wire facing STERING NAVIGATION[2 layer) I. Use provided jig per model 2. No wrong uses on 5. One the vire of terminal tip 6. No stuck of terminal tip 7. No deformed terminal 6. No stuck of terminal tip 7. No deformed terminal 6. No stuck of terminal tip 7. No deformed terminal 6. No stuck of terminal tip 7. No deformed terminal 6. No stuck of terminal tip 7. No deformed terminal 6. No stuck of terminal tip 7. No deformed terminal 6. No stuck of terminal tip 7. No deformed terminal 6. No stuck of terminal tip 7. No deformed termi	PARTS:	1. Assy	parts				JIG:	1. Insertion	jig	
2. No wrong usage of parts 3. One by one insertion 4. No wrong insertion 4. No wrong insertion 6. No stuck of terminal tip 7. No deformed terminal 8. No tangled wires 9. No wrong facing Wire facing Wire facing Wire insertion to Connector PBVP-10V-S (W) 2. Hold the R/L wire using right hand and support the wire by left index finger then insert to connector using right hand. Repeat the process on OR-Le-RW-PR wires. Check the wire after insertion. Note: Follow the insertion sequence based on the above illustration. 3. No tangled wires 9. No wrong facing Important reminders/Note/s: 1. Please hold the wire near terminal during insertion. Controller Controller Controller R CONTROLLER Refer to Wire-Cont-Or for the Wire and Sing Larger Tolerance and Sing Larger Tolerance and Sing Larger Tolerance Refer to Wire-Co-CN-C-0r for Wire and Sing Larger Tolerance and Sing Larger Tolerance Refer to Wire-CN-S-Y-028 for Puli-Fush procedure. 3. Press the Upper button using left hand then remove the assy part uping right hand. Repeat the process on open the procedure.	NO.	F	PROCESS NAME	WORK	PROCEDURE/ ILLUSTR	ATION	TOOLS/PPE	(QUALITY POIN	TERS
Terminal tip must be visible			Wire insertion to Connector	2. Hold the R/L wire using right hand finger then insert to connector using OR-LG-R/W-B/W wires. Check the v	WIRE 1 2 3 R/L OR LG G 297 297 297 1 297 297 297 1 297 297 1 297 297 297 1 297 297 1 297 297 1 297 297 1 297 297 1 297 297 1 297 297 1 297 297 1 298 298 298 298 298 298 298 298 298 298	INSERTION ILLUSTRATION 4 5 6 7 8 9 10 SR R/W BR B/W G W/G P 62 297 162 297 162 162 162 Wire facing Wire facing Press the Upper button using left and then remove the assy part ing right hand. Check the	STEERING NAVIGATION(2 layer) CONTROLLER	1. Use prov 2. No wron 3. One by 0 4. No wron 5. No defoi 6. No stuck 7. No defoi 8. No tangl 9. No wron Importal 1. Please during in: 2. Make: Conduct insertion. Do not ex Docume 1. Refer Steering 2. Refer i and Strip 3. Refer i Push pro	vided jig per mode g usage of parts one insertion g insertion med terminal a cof terminal tip med terminals ed wires g facing at reminders/Note thought the wire new sertion. Sure wires are propull-Pull-Pull-Pull-Push-Pull-Pull-Push-Pull-Pull-Pull-Pull-Pull-Pull-Pull-Pul	e/s: ar terminal operly inserted. ush after 044 for oller procedure. 017 for Wire 9028 for Pull-

			WORK IN	ISTRUCTION		Effectivity Date:		January 23, 20)25	
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		Model code/Part number:	920B / 75S321-0081	Customer: TRMX	Car Model:	TOYOTA-TACOMA	Document No.:		WI-ENG-PDE-1	185
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSP	PRO	Revision No.:	1	Page No.:	10 of 18
PARTS:	1. Assy	parts					JIG:	n/a		
NO.	P	ROCESS NAME	WORK	PROCEDURE/ ILLUST	RATION		TOOLS/PPE	(QUALITY POIN	TERS
11	P1	Wire arrangement	Terminal tip is not visible	BEFORE FOLDING 1. Hold to then contains the	the assy parts aduct wire arra	using both hands ngement.	N/A	1. No defo 2. No tang 3. No wron	rmed terminals led wires ig facing	

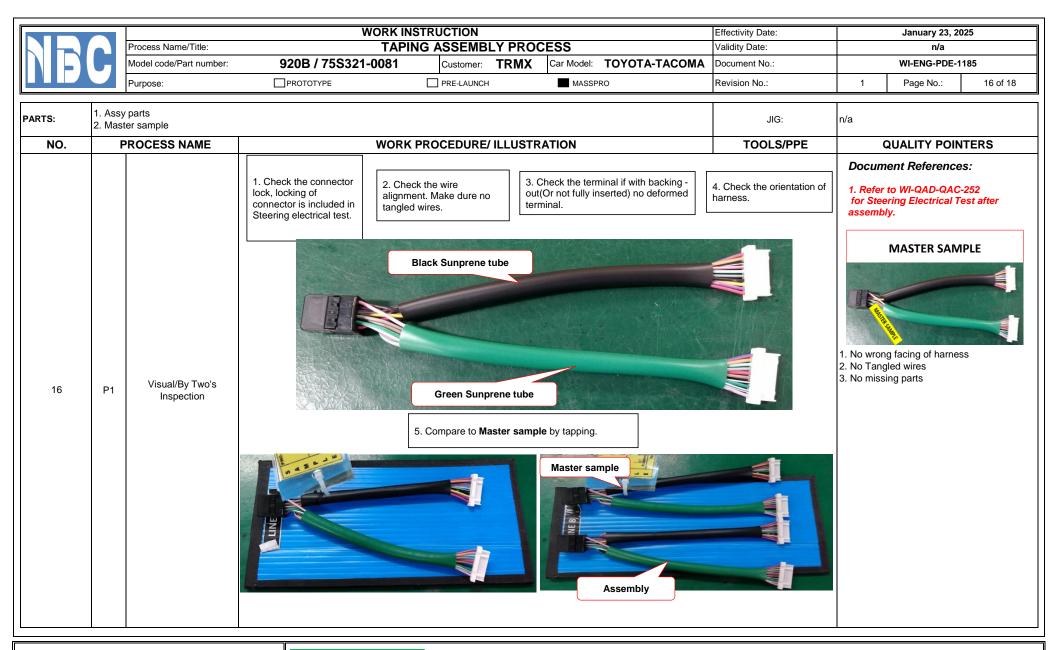
			WORK I	INSTRUCTION			Effectivity Date:		January 23, 20	25
		Process Name/Title:		PING ASSEMBLY PRO	CESS		Validity Date:		n/a	
	H	Model code/Part number:	920B / 75S321-0081	Customer: TRMX		TOYOTA-TACOMA	Document No.:		WI-ENG-PDE-1	185
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSP	RO	Revision No.:	1	Page No.:	11 of 18
PARTS:		nector 1746872-1 (B)					JIG:	1. Insertior		
NO.	F	PROCESS NAME	WOR	K PROCEDURE/ ILLUSTF	RATION		TOOLS/PPE		QUALITY POIN	
12	P1	Connector setting to insertion jig 1746872-1 (B)	INSERTION JIG Upp Low 1. Get the connector 1746872 Note: Follow the connector or	d lower guide (same timing) using the same timing) using the same timing) using the same timing the same time time time time time time time ti	Double local control of the control	Note: Check the connector before insertion.		1. Use the 2. No wron 3. No wron 4. No dam (AF (AF (Import 1. Autor unit if oult connect 2. Folloo 2. Folloo (Interpretation of the connect 2. Folloo 2. No wron 3. No wron 4. No dam (Interpretation of the connect 2. Folloo 3. No wron 4. No dam (Interpretation of the connect 2. Folloo 3. No wron 4. No dam (Interpretation of the connect 2. Folloo 3. No wron 4. No dam (Interpretation of the connect 2. Folloo 3. No wron 4. No dam (Interpretation of the connect 2. Folloo 3. No wron 4. No dam (Interpretation of the connect 4	provided jig per mg usage of parts g orientation of coaged connector CONNECTOR LOCAPEARANCE CHI GOOD NLOCK HA CONNECTOR ILLUS NG 13 tant reminders matically dispose a coce encountered by of insertion and h	INTERPLET IN THE PROPERTY OF T

			WORK IN	STRUCTION			Effectivity Date:		January 23, 20	25
		Process Name/Title:	TAPI	NG ASSEMBLY PRO	CESS		Validity Date:		n/a	
		Model code/Part number:	920B / 75S321-0081	Customer: TRMX		TOYOTA-TACOMA	Document No.:		WI-ENG-PDE-1	185
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSP	PRO	Revision No.:	1	Page No.:	12 of 18
PARTS:	1. Assy	parts					JIG:	Insertion jig	9	
NO.	F	PROCESS NAME	WORK	PROCEDURE/ ILLUST	RATION		TOOLS/PPE	(QUALITY POIN	TERS
13	P1	Connector setting to insertion jig 1746872-1 (B)	1. Insert first the wires from Black Sur R wire and insert to terminal slot 1 usi the process for V-Y-B wires. Note: Follow the insertion sequence b illustration stated above.	TO THE PROPERTY OF THE PROPERT	8 9 G GR 62 162 2 3 WG BR 62 162 162 162 162 162 162 162 162 162	DN ILLUSTRATION 10 11 12 GR/B X P 160 162 4 5 6 Y V B 160 160 160 Wire facing B wire and insert to einsertion sequence ustration stated above.		2. No wrong 3. One by co 4. No wrong 5. No defor 6. No stuck Importa 1. Automonistic on difficulty connected 2. Make Conduct insertion Do not expended ouring in 4. Follow the illustrial property of the pro	ant reminal to of terminal to of terminal tip ant reminders, matically dispose a ce encountered b of insertion and h or. sure wires are propull-Push-Pull-Push-Pull-Push-Pull-Push-Pull-Push or textra force. The hold the wire newsertion. The translation sequential to the contract of	Note/s: Ind replace the end terminal, alf-locked Independ to the end terminal end terminal Independent terminal end to the end terminal end termi

			WORK IN	Effectivity Date:		January 23, 2025						
		Process Name/Title:		Validity Date:	n/a							
		Model code/Part number:	920B / 75S321-0081	Customer: TRMX	Car Model: To	OYOTA-TACOMA	Document No.:		WI-ENG-PDE-1	185		
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO		Revision No.:	1	Page No.:	13 of 18		
PARTS:	1. Assy	·							1. Insertion jig			
NO.	F	PROCESS NAME	WORK	PROCEDURE/ ILLUST	RATION		TOOLS/PPE	(QUALITY POIN	ITERS		
14	P1	Wire insertion to Connector 1746872-1 (B) (Continuation)	3. Insert the wires from Green sunpreby left index finger then insert to termi Note: Follow the insertion sequence by R	A. Hold t using right hand. Fased on the above illustration of the abo	Repeat the process on. the G wire and insempth hand. Repeat the obliow the insertion s	ert to terminal slot 8 lee process for GR-P sequence based on ver lever guide ands.	N/A	2. No wron 3. One by 4. No wron 5. No defo 6. No stuck Import 1. Make Conduct insertio Do not e 2. Pleas terminal 3. Follow the about	exert extra force. The hold the wire new during insertion. The insertion secure illustration. The insertion secure illustration. The insertion secure illustration.	/Note/s: operly inserted. Push after ar quence based on		

			WORK INS	Effectivity Date:	January 23, 2025					
		Process Name/Title:		Validity Date:		n/a				
	H	Model code/Part number:	920B / 75S321-0081		LY PROCESS TRMX Car Model:	TOYOTA-TACOMA	Document No.:		WI-ENG-PDE-1	185
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSF	PRO	Revision No.:	1	Page No.:	14 of 18
PARTS:	1. Assy	parts					JIG:	n/a		
NO.	F	ROCESS NAME	WORK	PROCEDURE	/ ILLUSTRATION		TOOLS/PPE	(QUALITY POIN	TERS
15	P1	Harness arrangement		R	Hold the assy parts conduct harness facing	using both hands then g arrangement.	n/a	2. No tang	g orientation of co led wires g wire folding	nnector

			WORK IN	Effectivity Date:		January 23, 2025				
		Process Name/Title:	TAPII	Validity Date: n/a						
		Model code/Part number:	920B / 75S321-0081	Customer: TRM)		TOYOTA-TACOMA	Document No.:		WI-ENG-PDE-1	185
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSP	PRO	Revision No.:	1	Page No.:	15 of 18
PARTS:	1. Assy						JIG:	n/a		
NO.	F	PROCESS NAME	WORK	PROCEDURE/ ILLUS	TRATION		TOOLS/PPE		QUALITY POIN	TERS
15	P1	Harness arrangement (Continuation)	GOOD FACING Folding in the front NG FACING GOOD FACING Connector Lock Folding	NG	Terminal visible NG FAC	le	n/a	2. No tang	ng orientation of co led wires ng wire folding	onnector



			January 23, 2025								
		Process Name/Title:	TAPING ASSEMBLY PROCESS Validity Date:					n/a			
		Model code/Part number:	920B / 75S321-0081	Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:		WI-ENG-PDE-11	85		
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	1	Page No.:	17 of 18		
PARTS:	1. Assy	parts				JIG:	n/a				
NO.	P	ROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	(QUALITY POINT	TERS		
17	P1	Measurement	Note: Please use calibrated/verified measuring tape when getting the measurement.		172±3mm		Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono. Document reference/s: 1. Refer to WI-PRO-ASY-056 for Subassembly Hatsumono Nakamono Owarimono Inspection 1. No wrong dimension				

			STRUCTION		Effectivity Date:		January 23, 20	25	
	Process Name/Title:	TAPII	Validity Date:		n/a				
	Model code/Part number:	920B / 75S321-0081	Customer: TRMX	Car Model: TOYOTA-TACOMA	Document No.:		WI-ENG-PDE-1	185	
	Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	1	Page No.:	18 of 18	
PARTS: n/a			QUALITY CHE	CADOINTS	JIG:	n/a			
			QUALITY CHE	CKPOINTS				· ·	
P1			75S321- 0	0081					
1. Check the connector lock. 2. Check the wire alignment. Make sure no tangled wires. Black Sunprene Tube Green Sunprene Tube FOLDED WIRES MUST BE IN BACK POSITION 4. Check if no missing parts.									