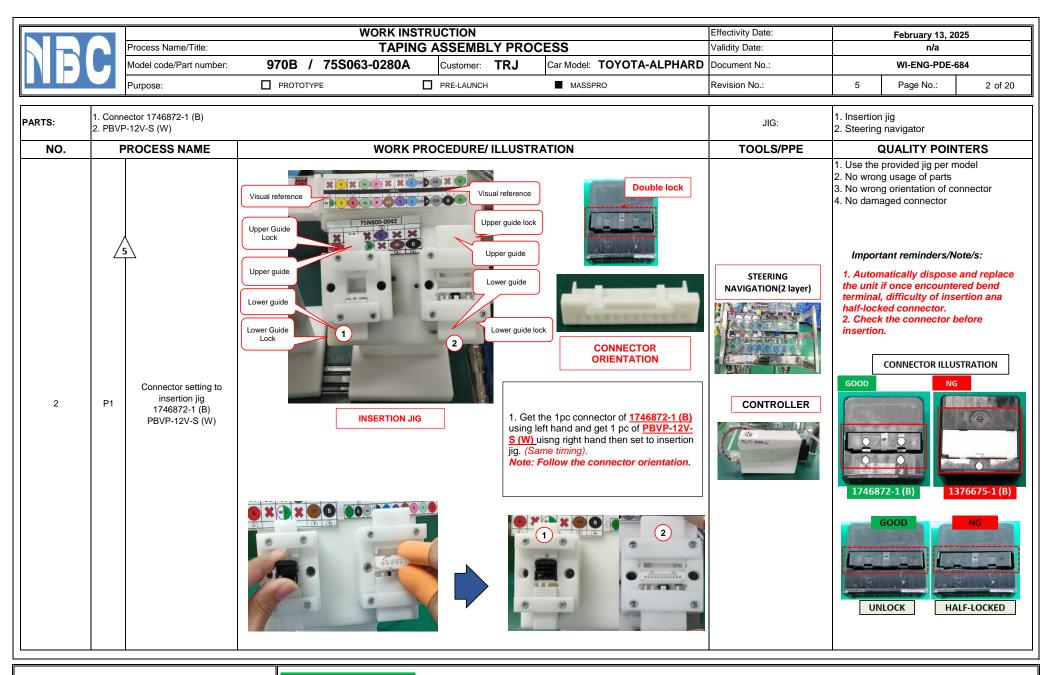
						NSTRUCTION			Effectivity Date:		February 13, 20	25		
		Pro	ocess Name/Title:			ING ASSEME	3LY PROC	CESS			Validity Date:		n/a	
		Mo	odel code/Part number:	970B	/ 75S063-0280	Customer:	TRJ	Car Model:	TOYOTA-AL	.PHARD	Document No.:		WI-ENG-PDE-6	34
		Pu	rpose:	☐ PROTO	TYPE	PRE-LAUNC	СН	MASSF	PRO		Revision No.:	5	Page No.:	1 of 20
PARTS:		08V-S (W); P=354±2mi		2mm; W/G L=184			=196±2mm; A\	/SS 0.3 wire Y			JIG:		n jig g navigator QUALITY POIN	rers.
180	<i>o</i> .	5	OCESS NAME	Connect PBVP-08V Box	ctor Black		Lay-out	ATION	2 La Naviga		Safety Instruction Be sure to wear prescribed persor protective equipm during operation (gloves, finger cot etc.) Housekeeping 1. Maintain and alw practice 5's.	Docum 1. Refer Strip Le	nent reference/s to WI-PRO-CNC-0 ngth Tolerance	:
1		P1	Table lay-out	sample		10 10 10 10 10 10 10 10			Black VM tube (Sunprene) Ø8.5 L= 151±3mm		Personal things the workplace is prohibited. Keep it your locker. Alert level For any trouble, infe	1. No defe 2. No wro	ormed terminal ng usage of parts	
					Insert Jig B Insert Jig J		Connec 1746872- Box	-1 (B)/	Connect PBVP-12V-S Box		the Assembly Assis Supervisor or Lin Leader for immedi corrective action	tant e ate		
				1	Revision Histor	1					Prepared by	Reviewed by	Approved by	Noted by
02/13/25	5	sequence as Inclusion of	s customer claim counterme	easure. Additional number of St	d PBVP-08V-S) orientation nethod to wire bending as d eering Electrical test (WI-Q	ountermeasure to dar	mage lance.	D.Castillo	C. Villanueva A. Ara	rañes n	/a			
12/20/23	4	Correction o	f Work Illustrations (position	n of harness) on pa	ges 11 to 14.			M. Ariola	C. Villanueva A. Ara	rañes n	/a	1/4:14	AMP	
12/14/23	3	customer fee	Work Procedure/Illustration edback (pages 10 to 14).	n (Way of wire foldir	ng and facing of connector);	Additional Quality ch	eckpoints due to	M. Ariola	C. Villanueva A. Ara		/a D. Castillo	C. Villanueva	A. Aranes	n/a
Eff. Date	Rev. No	<u> </u>		Detai	ls of Change			Revised	Reviewed Appro	roved No	ted Est. Date:	May 26, 2023		





		Process Name/Title:		INSTRUCTION PING ASSEMBLY P	Effectivity Date: Validity Date:	February 13, 2025 n/a			
		Model code/Part number:	970B / 75S063-0280			Document No.:		WI-ENG-PDE-68	84
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	■ MASSPRO	Revision No.:	5	Page No.:	3 of 20
PARTS:	1. AVSS	6 0.3 wire R= 188±2mm; W/G	6 L=184±2mm; BR L=194±2mm; B L=20			JIG:	Insertio Steering	n jig g navigator	
NO.	Р	ROCESS NAME	WOF	RK PROCEDURE/ ILLU	USTRATION	TOOLS/PPE		QUALITY POINT	ΓERS
2	<u>/s</u>	Connector setting to insertion jig 1746872-1 (B) PBVP-12V-S (W) (Continuation)	2. Press the upper and lower guide only open.	R	AFTER PRESSING R iming. Holes that need to be insert are	STEERING NAVIGATION(2 layer)	No wronNo wron	provided jig per mod g usage of parts g orientation of conne ged connector	
3	P1	Wire insertion to connector 1746872-1 (B)	INSERTION SEQUENCE FROM 2ND ROW 1ST ROW 1 2 FIRST ROW (LEFT TO RIGHT)	LEFT TO RIGHT X 1 R 188	X X V X X 196 2 3 4 X W/G X BR B 194 204 1. Get the R wire using right hand and insert to terminal slot 1. Repeat the process for W/G-BR-B wires. Note: Follow the insertion sequence based on the illustration.	CONTROLLER	 No wron No wron No defor No stuck 	vided jig per model g usage of parts g insertion med terminal of terminal tip one insertion.	

			V	WORK INSTRUC	TION		Effectivity Date: February 13, 2025			25
		Process Name/Title:			SEMBLY PRO	CESS	Validity Date:	1	n/a	
		Model code/Part number:	970B / 75S06		ustomer: TRJ	Car Model: TOYOTA-ALPHARD	Document No.:		WI-ENG-PDE-6	34
		Purpose:	PROTOTYPE	☐ PR	RE-LAUNCH	■ MASSPRO	Revision No.:	5	Page No.:	4 of 20
PARTS:	1. AVSS	6 0.3 R L=160±2mm; W/G L=	160±2mm; BR L=160±2mm; B	L=160±2mm; V L=160	0±2mm		JIG:	Insertion Steering	n jig g navigator	
NO.	F	ROCESS NAME		WORK PROCE	EDURE/ ILLUSTR	ATION	TOOLS/PPE		QUALITY POIN	rers
3	P1	Wire insertion to connector 1746872-1 (B) (Continuation		d the wires using righ e connector from jig.	2. Get the V wire using right hand a insert to terminal s. 5. Note: Follow the insertion sequent based on the illustration.	nd slot	STEERING NAVIGATION(2 layer) CONTROLLER	2. No wror 3. No wror 4. No defo 5. No stuc 6. One by Impo 1. Plea during 2. Make inserte Do not 3. Auto the uni termina and ha Docume 1. Refer Pull-Puz 2. Refer Wire an 3. Refer	ct <u>Pull-Push-Pull-</u> on. exert extra force. matically dispose it if once encounte al and difficulty of lf locked connecte ent references: to GL-PRO-ASY-(sh procedure. to WI-PRO-CNC-(d Strip Length To- to WI-ENG-PDE-(g Navigation Cont	ote/s: ear terminal roperly Push after e and replace ered bend i insertion or. 029 for 017 for lerance 044 for

	_		W	ORK INSTRUCTION			Effectivity Date:		February 13, 20	25
	\Box	Process Name/Title:		TAPING ASSEMBL	Y PROC	ESS	Validity Date:		n/a	2.5
		Model code/Part number:	970B / 75S063			Car Model: TOYOTA-ALPHARD	Document No.:		WI-ENG-PDE-6	84
		Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH		MASSPRO	Revision No.:	5	Page No.:	5 of 20
PARTS:		PROCESS NAME	54±2mm; P=354±2mm; L L= 356	WORK PROCEDURE/			TOOLS/PPE	1. Use pro	navigator QUALITY POIN vided jig per mode	
4	P1	Wire insertion to connector PBVP-12V-S (W)	1 2 3 4 G G G G G G G G G G G G G G G G G G		P 354	TERMINAL FACING ISERTION ILLUSTRATION 6		2. No wron 3. No wron 4. No defor 5. No stuck 6. One by o Importa 1. Make inserted, Push aft Do not e 2. Please terminal 3. Auton replace to bend tern and half 4. Inserti left to rig Docum 1. Refer Wire and 2. Refer Steering procedu 3. Refer Pull-Pus 4. Refer 4. Refer	g usage of parts ig insertion rmed terminal to of terminal tip one insertion on the reminders/Note sure wires are properties. Conduct Pull-Puller insertion. The reminders force is a hold the wires in during insertion in attically dispose a the unit if once entitle in the latest of the wires must ght. The procedure of the reference of the reference of the wigation of the reference of	e/s: operly sh-Pull- ear and countered f insertion r. be from 117 for erance. 44 for roller 129 for

			WORK IN:	STRUCTION		Effectivity Date:		February 13, 202	25
		Process Name/Title:	TAPI	NG ASSEMBLY PRO	CESS	Validity Date:		n/a	
		Model code/Part number:	970B / 75S063-0280A	Customer: TRJ	Car Model: TOYOTA-ALPHARD	Document No.:		WI-ENG-PDE-68	34
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	5	Page No.:	6 of 20
PARTS:	1. AVS	0.3 G L=291±2mm; GR L=29)1±2mm; GR/B L=291±2mm; L L=291±2mr	n; P L=291±2mm; LG L=291±2ı	mm; Y L=291±2mm	JIG:	Insertion Steering		
NO.	F	ROCESS NAME	WORK	PROCEDURE/ ILLUSTR	ATION	TOOLS/PPE	C	QUALITY POINT	ΓERS
4	P1	Wire insertion to connector PBVP-12V-S (W) (Continuation)	BACK VIEW OF TERMINAL GOOD Terminal condition Note: *Make sure the terminal was *Avoid hitting the terminal in process and call the attention	FRONT OF TERMINAL GOOD Terminal condition s in proper alignment before the connector during with the connector during the connector durin	Damaged terminal NO GOOD Terminal condition	NO GOOD Terminal codition	2. No wrong 3. No wrong 4. No deforr 5. No stuck 6. One by or 1. Mainsert Push Do no 2. Plee termin 3. Aut replac enco. diffici locker 4. Inst left to Docur 1. Refi Wire a 2. Refi Steerii proce 3. Refi Pull-P 4. Refi	red terminal of terminal of terminal tip me insertion retant reminders/N ke sure wires are red. Conduct <u>Pull-after insertion.</u> It exert extra force as hold the wire mal during insertion and during insertion and termility of insertion and connector. The retained ment reference in the reference of the wire right. The retained bend termility of insertion and connector. The retained bend termility of insertion and the reference of the retained bend termility of insertion and the reference of the retained bend termility. The retained bend termility of the retained bend termility. The retained bend termility of t	properly Push-Pull- e. s near on. se and ninal, nd half- ust be from C-017 for Folerance. E-044 for ntroller Y-029 for

				ISTRUCTION	0500	Effectivity Date:		February 13, 20	25
		Process Name/Title: Model code/Part number:	970B / 75S063-0280A	NG ASSEMBLY PRO Customer: TRJ	Car Model: TOYOTA-ALPHARD	Validity Date: Document No.:		n/a WI-ENG-PDE-6	84
		Purpose:	☐ PROTOTYPE	□ PRE-LAUNCH	■ MASSPRO	Revision No.:	5	Page No.:	7 of 20
PARTS:	1. Assy 2. Black	parts VM tube (Sunprene) Ø8.5 L:	/\			JIG:	Insertion Steering	n jig g navigator	
NO.	P	ROCESS NAME	5 WORK	PROCEDURE/ ILLUST	RATION	TOOLS/PPE	(QUALITY POIN	ΓERS
5	P1	Wire insertion to Black VM tube (Sunprene) Ø8.5 L=151±3mm	1. Hold the wires using left hand, get the L=151±3mm using right hand then inser		2. Press the lower guide lock using right hand. Holes that need to be insert are only open.		2. No defor	Today Car	
6		Wire insertion to Black VM tube (Sunprene) Ø8.5 L=151±3mm (Assy Parts)	Hold the Black VM tube (Sunpren hand and get the assy part then inseusing right hand.	ne) using left ert the wires	Connector facing and position of connector should be on the left side of harness.	n/a		g usage of parts med terminal	

				RK INSTRUCTI				Effectivity Date:	February 13, 2025		
		Process Name/Title:		TAPING ASSI	EMBLY PRO	CESS		Validity Date:		n/a	
		Model code/Part number:	970B / 75S063-0	280A Cust	omer: TRJ	Car Model: To	OYOTA-ALPHARD	Document No.:		WI-ENG-PDE-6	84
		Purpose:	☐ PROTOTYPE	☐ PRE-I	LAUNCH	MASSPRO		Revision No.:	5	Page No.:	8 of 20
PARTS:	1. Assy	parts PROCESS NAME	V	ORK PROCED	OURE/ ILLUSTF	RATION		JIG: TOOLS/PPE		navigator	
7	P1	Wire insertion to connector PBVP-12V-S (W)	INSERTION SEQUENCE INSERTION SEQUENCE B GR GR/B G B GR GR/B 358 204 358 358 1. Hold the W/G wire using connector at slot 1 using rig Note: Follow the insertion	WIRE WIRE WIRE WIRE R WIRE WIR	INSERTION ILLU 3 BR P 194 354 ppport the wire by the process for R	USTRATION LG R 354 188	FACING Y W/G 366 184 er then insert to	STEERING NAVIGATION(2 layer) CONTROLLER	2. No wror 3. No wror 4. No defo 5. No stuci 6. One by Importa 1. Make inserted Push aft Do not e 2. Pleas terminal 3. Autor replace bend teri and half 4. Insert left to rig Docum 1. Refer Wire and 2. Refer Steering procedu 3. Refer Pull-Pus 4 Refe	ent reference/s: to WI-PRO-CNC-0 d Strip Length Tol to WI-ENG-PDE-0 Navigation Conti re to GL-PRO-ASY-0 h procedure. r to GL-PRO-ASY on Standard for c	e/s: roperly ush-Pull- near and ncountered of insertion or. t be from 017 for derance. 044 for roller 029 for

<u></u>			WORK	NCTRUCTION		T# - 10 th - Date:		
		Process Name/Title:		INSTRUCTION PING ASSEMBLY PRO	PECC	Effectivity Date: Validity Date:	February 13, 2025 n/a	
		Model code/Part number:	970B / 75S063-0280			Document No.:	WI-ENG-PDE-684	
	V		□ PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:		0 -1 00
		Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	5 Page No.:	9 of 20
PARTS:	1. Assy	parts				JIG:	Insertion jig Steering navigator	
NO.		PROCESS NAME	WOR	K PROCEDURE/ ILLUSTR	ATION	TOOLS/PPE	QUALITY POINTER	S
	2	5	Proper alignment of the second	FRONT OF TERMINAL	nal to connector	1. Use provided jig per model 2. No wrong usage of parts 3. No wrong insertion 4. No deformed terminal 5. No stuck of terminal tip 6. One by one insertion Important reminders/Note/ 1. Make sure wires are pro inserted. Conduct Pull-Pus Push after insertion. Do not exert extra force. 2. Please hold the wires ne terminal during insertion. 3. Automatically dispose all replace the unit if once	perly <u>h-Pull-</u> ar nd	
7	P1	Wire insertion to connector PBVP-12V-S (W) (Continuation)	Note: *Make sure the terminal was in *Avoid hitting the terminal into call the attention of Immediate: L R	the connector during wire ins	ertion, if encountered abnormality st	3. Gently pull out the connector from jig then check the terminal tip condition.	encountered bend terminal difficulty of insertion and h locked connector. 4. Insertion of wires must be left to right. Document reference/s: 1. Refer to WI-PRO-CNC-01' Wire and Strip Length Toler 2. Refer to WI-ENG-PDE-04- Steering Navigation Control procedure. 3. Refer to GL-PRO-ASY-02- Pull-Push procedure. 4. Refer to GL-PRO-ASY-02- Inspection Standard for connector insertion.	alf- pe from for ance. for for

				K INSTRUCTION		Effectivity Date:		February 13, 20	25
		Process Name/Title:		APING ASSEMBLY PRO		Validity Date:		n/a	
	7	Model code/Part number:	970B / 75S063-028		Car Model: TOYOTA-ALPHARD	Document No.:		WI-ENG-PDE-6	
		Purpose:	PROTOTYPE	☐ PRE-LAUNCH	MASSPRO	Revision No.:	5	Page No.:	10 of 20
PARTS:	1. Assy	parts				JIG:	n/a		
NO.	ı	PROCESS NAME	WC	ORK PROCEDURE/ ILLUST	RATION	TOOLS/PPE		QUALITY POIN	TERS
8	P1	Wire bending 1	1. Hold the 2 connectors by both	hand and arrange the wire. AFTER BENDING 3. Check the terminal tip condition	2. Hold the assy part by left hand and place the index finger of right hand to wire then slightly bend the wire. Note: Follow the illustration.	n/a	No tangle	med terminal	

		Process Name/Title:	WORK INS	CESS	Effectivity Date: Validity Date:		February 13, 20 n/a	25	
		Model code/Part number:	970B / 75S063-0280A	NG ASSEMBLY PRO Customer: TRJ	Car Model: TOYOTA-ALPHARD	Document No.:		WI-ENG-PDE-6	 84
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	■ MASSPRO	Revision No.:	5	Page No.:	11 of 20
PARTS:	1. Assy 2. Black	parts VM tube (Sunprene) Ø6 L=1	46±3mm			JIG:	n/a		
NO.	P	ROCESS NAME	WORK	PROCEDURE/ ILLUST	RATION	TOOLS/PPE		QUALITY POIN	ΓERS
9	P1	Wire insertion to Black VM tube (Sunprene) Ø6 L=146±3mm	2. After insertion, check the t	erminal appearance and the	1. Get the Black VM tube (Sunprene) Ø6 L=146±3mm using right hand then insert the wires using left hand. R en set aside the assy parts.	n/a	2. No deform 3. No tangle	g usage of parts med terminal ed wires	

Process Name/Title: Model code/Part number: 970B / 75S063-0280A Customer: TRJ Car Model: TOYOTA-ALPHARD Document No.: Purpose: PROTOTYPE PRE-LAUNCH MASSPRO Revision No.: 5 PARTS: 1. Connector PVBVP-08V-S (W) WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE O	n/a WI-ENG-PDE-68 Page No.:	12 of 20
Purpose: PROTOTYPE PRE-LAUNCH MASSPRO Revision No.: 5 PARTS: 1. Connector PVBVP-08V-S (W) JIG: 1. Insertion	Page No.:	
PARTS: 1. Connector PVBVP-08V-S (W) JIG: 1. Insertion		12 of 20
	n jig	
NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE		
	QUALITY POINT	ΓERS
10 P1 Connector setting to insertion jig PVBVP-08V-S (W) Connector setting to insertion jig PVBVP-08V-S (W) INSERTION JIG R 2. No wrong 4. No deform 5. No stuck	vided jig per model g usage of parts	IERS

				NSTRUCTION		Effectivity Date:		February 13, 20	25
		Process Name/Title:	TAP	ING ASSEMBLY PRO	DCESS	Validity Date:		n/a	
		Model code/Part number:	970B / 75S063-0280A	A Customer: TRJ	Car Model: TOYOTA-ALPHARD	Document No.:		WI-ENG-PDE-6	84
		Purpose:	☐ PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	5	Page No.:	13 of 20
PARTS:	1. Assy	parts				JIG:	1. Insertior	ı jig	
NO.	F	PROCESS NAME	WORK	K PROCEDURE/ ILLUST	RATION	TOOLS/PPE	(QUALITY POIN	TERS
NO.	P1		1 2 3	WIFE VIENT TO RIGHT VIENT TO	### WIRE FACING	N/A	1. Use pro 2. No wron 3. No wron 4. No defor 5. No stuck 6. One by o Importa 1. Make inserted Push aft Do not e 2. Please terminal 3. Auton replace to bend ten and half 4. Inserti left to rig Docum 1. Refer Wire and 2. Refer Steering procedu 3. Refer Pull-Pus 4. Refer	vided jig per mode g usage of parts g insertion rmed terminal t of terminal tip one insertion Int reminders/Note sure wires are pr Conduct Pull-Pu er insertion. The textra force. The hold the wires in during insertion. The textra force er minal, difficulty of clocked connecto for of wires must ght. The wife of the wires in the unit if once er minal, difficulty of clocked connecto for of wires must ght. The wife of the wires to WI-PRO-CNC-CO Strip Length Tol to WI-ENG-PDE-O Navigation Continge. The GL-PRO-ASY-Ch procedure.	e/s: coperly sh-Pull- ear and countered f insertion r. be from 117 for erance. 44 for coller 129 for

			WORK INC	STRUCTION		T#o ativity Data			
		Process Name/Title:		IG ASSEMBLY PRO	ress.	Effectivity Date: Validity Date:	February 13, 2025 n/a		
		Model code/Part number:	970B / 75S063-0280A	Customer: TRJ	Car Model: TOYOTA-ALPHARD	Document No.:	WI-ENG-PDE-684		
		Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	MASSPRO	Revision No.:	5 Page No.:	14 of 20	
	1	l					<u> </u>		
PARTS:	1. Ass	parts				JIG:	1. Insertion jig		
NO.		PROCESS NAME	TOOLS/PPE	QUALITY POINTE	RS				
			Proper alignment of te	Proper alignment of terminal to connector Improper alignment of terminal to connector					
		5			 3. No wrong insertion 4. No deformed terminal 5. No stuck of terminal tip 6. One by one insertion Important reminders/Note/s: 				
	P1	Wire insertion to connector	GOOD Terminal condition Note: *Make sure the terminal was in pro	FRONT OF TERMINAL GOOD Terminal condition per alignment before inser	Damaged terminal NO GOOD Terminal condition	NO GOOD Terminal codition	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.		
11		PBVP-08V-S (W) (Continuation)		connector during wire inse	ertion, if encountered abnormality st	op the process and	Document reference/s:		
			ha	Hold the wires using right and and then press the nlock button using left umb.	R	3. Gently pull out the connector from jig then check the terminal tip condition.	1. Refer to WI-PRO-CNC-0 Wire and Strip Length Tol. 2. Refer to WI-ENG-PDE-0 Steering Navigation Contr procedure 3. Refer to GL-PRO-ASY-0 Pull-Push procedure. 4. Refer to GL-PRO-ASY-0 Inspection Standard for connector insertion.	erance. 44 for roller 029 for	

			WORK IN	Effectivity Date:	February 13, 2025 n/a				
		Process Name/Title:	TAPI	Validity Date:					
		Model code/Part number:	970B / 75S063-0280A	Customer: TRJ	Car Model: TOYOTA-ALPHARD	Document No.:		WI-ENG-PDE-68	34
		Purpose:	PROTOTYPE	☐ PRE-LAUNCH	MASSPRO	Revision No.:	5	Page No.:	15 of 20
PARTS:	1. Assy			JIG:	n/a				
NO.	ا	PROCESS NAME WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	(QUALITY POINT	TERS
12	<u>/</u>	Wire bending 2	2. Check	1. Hold the assy part by r hand and place the index of left hand to wire then shend the wire. Note: Follow the illustration AFTER BENDING k the terminal tip condition.	slightly	n/a	3. No tangle	med terminal	

			Effectivity Date:							
		Process Name/Title:			LY PROCESS		Validity Date:	n/a		
	7	Model code/Part number:	970B / 75S063-0280A	Customer:	TRJ Car Mod	E TOYOTA-ALPHARD	Document No.:		WI-ENG-PDE-6	84
		Purpose:	PROTOTYPE	☐ PRE-LAUNCH	H ■ MA	SSPRO	Revision No.:	5	Page No.:	16 of 20
PARTS:	1. Assy				JIG:	n/a QUALITY POINTERS				
NO.	F	ROCESS NAME	WORK	PROCEDURE/	/ ILLUSTRATION		TOOLS/PPE	(QUALITY POIN	TERS
13	P1	Wire folding/ Wire arrangement	1. Hold the Connector PBVP-12V-S uhand and slightly fold the Wire from Blatube (Sunprene) ø8.5 L=151±3mm (aillustrated above) using right hand.	fold it.		PBVP-8V-S using right ne wire from Black VM=146±3mm (as	n/a	W/G wir stra 1. No dama 2. No defora 3. No tangle 4. No wrong 5. No wrong 6. No wrong Importa 1. DON pulling, 2. Extra "Damas	ge lance med terminal	ectors te/s: ce, as like connector e cause of ince"

			Effectivity Date:	February 13, 2025						
		Process Name/Title:	Validity Date: n/a							
		Model code/Part number:	970B / 75S063-0280A	Customer: TRJ	Car Model: TOYOTA-ALPHARD	Document No.:		WI-ENG-PDE-6	84	
		Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	MASSPRO	Revision No.:	5	Page No.:	17 of 20	
PARTS:	1. Assy			JIG: TOOLS/PPE	n/a					
NO.	F	PROCESS NAME WORK PROCEDURE/ ILLUSTRATION					(QUALITY POIN	TERS	
13	P1	Wire folding/ Wire arrangement (Continuation)	CORRECT FACING Double lock upward WRONG FACING	Terminal tip is no	Terminal tip is visible Out visible Terminal tip is not visible	n/a	3. No tangle 4. No wrong 5. No wrong	med terminal	ectors	

		WORK INSTRUCTION Effectivity Date:						February 13, 2025				
		Process Name/Title:		ASSEMBLY PROC			Validity Date:	n/a				
		Model code/Part number:	970B / 75S063-0280A	Customer: TRJ	Car Model: TOYO	TA-ALPHARD	Document No.:		WI-ENG-PDE-6	84		
		Purpose:	☐ PROTOTYPE ☐	PRE-LAUNCH	MASSPRO		Revision No.:	5	Page No.:	18 of 20		
PARTS:	1. Assy parst JIG:									n/a		
NO.	PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE						TOOLS/PPE	(QUALITY POIN	TERS		
			1. Check the connector lock, locking of connector is included in 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 deformed terminal.	MASTER SAMPLE								
		Visual/By Two's	ACTUAL PRODUCT	Black VM tube		tube (Sunprene		1. Refer Steering	nent reference/s: to WI-QAD-QAC- g Electrical Test			
12	P1	Visual/By Two's Inspection	harness. tappin	mpare to Master sample by	ASSEMB PARTS			1. No wron 2. No Tang 3. No miss	ig facing of harnes gled wires ing parts	S		

