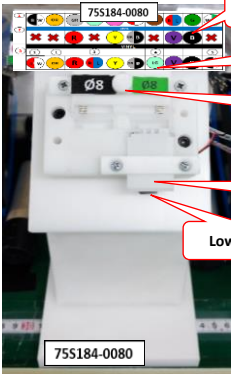
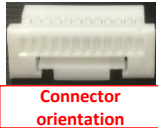
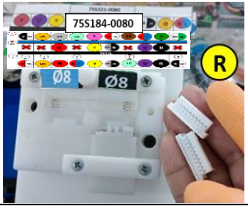
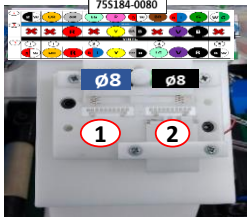
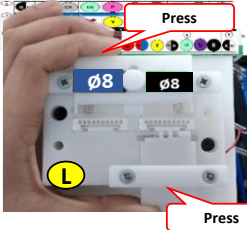




	<b>WORK INSTRUCTION</b>				Effectivity Date:		<b>December 16, 2022</b>	
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		<b>n/a</b>	
	Model Code/Part Number: <b>120D / 75S184-0280</b>		Customer: <b>TRMX</b>		Document No.:		<b>WI-ENG-PDE-598</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		1	Page No.: 1 of 14

<b>PARTS:</b>		1. Connector PBVP-10V-S (W) [2pcs]			JIG:		1. Insertion jig		
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>				<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
1	P1  Connector setting to insertion jig PBVP-10V-S (W)	<div><p>Visual reference</p><p>Upper guide</p><p>Upper Button</p><p>Lower guide</p><p>Lower lever</p></div> <div><p>Connector orientation</p></div> <div><p>1. Get the 2 pcs of <b>PBVP-10V-S (W)</b> connector using right hand then transfer the 1 connector to left hand then insert to insertion jig. <i>Note: Follow the connector orientation.</i></p></div> <div><p>2. Press the upper and lower guide using left hand in same timing. Holes that need to be insert are only open.</p></div> <div><p>Press</p><p>Press</p></div>				<div><p><b>Safety Instruction</b></p><p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p></div> <div><p><b>Housekeeping</b></p><p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p></div> <div><p><b>Alert level</b></p><p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p></div>		<p>1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p>	

Revision History								Prepared by:	Checked by:	Approved by:	Noted by:
12/16/22	1	Change purpose from Pre-Launch to Masspro. Inclusion of Quality checkpoints.									
10/13/22	0	Initial issue.						M. Ariola	J. Loterte	C. Villanueva	A. Arañes
Eff. Date	Rev. No	Details of Change						Revised	Checked	Approved	Noted
Established Date:								October 13, 2022			

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## WORK INSTRUCTION

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### TAPING ASSEMBLY PROCESS

Effectivity Date:

December 16, 2022

Validity Date:

n/a

Model code/Part number: **120D / 75S184-0280**

Customer:

**TRMX**

Document No.:

**WI-ENG-PDE-598**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:


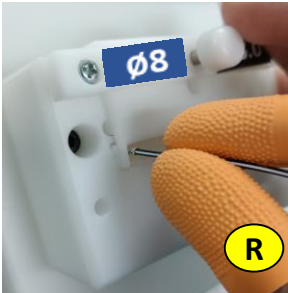
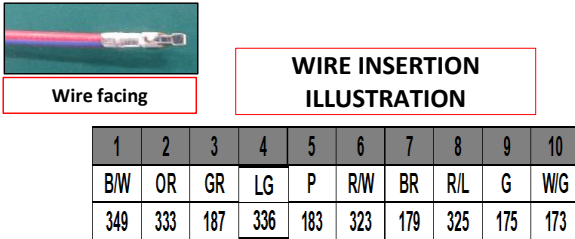
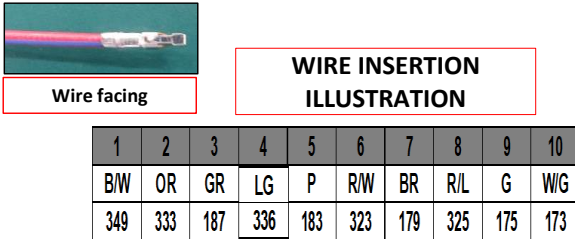
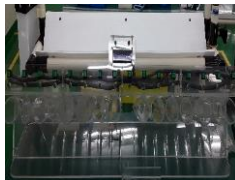

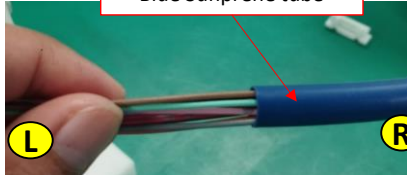

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**PARTS:**

1. AVSS 0.3 wire B/W L=349±2mm; OR wire L=333±2mm; GR wire L=187±3mm; LG wire L=336±2mm; P wire L=183±3mm; R/W wire L=323±3mm; BR wire L=179±2mm; R/L wire L=325±2mm; G wire L=175±2mm; W/G wire L=173±2mm; Blue Sunprene tube ø8 L=133±3mm

**JIG**

1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS																																																											
2	P1	Wire insertion to Connector PBVP-10V-S (W)	<div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div> <div></div> <div></div> <div><table><tr><td>1</td><td>2</td><td>3</td><td>4</td><td>5</td><td>6</td><td>7</td><td>8</td><td>9</td><td>10</td></tr><tr><td>B/W</td><td>OR</td><td>GR</td><td>LG</td><td>P</td><td>R/W</td><td>BR</td><td>R/L</td><td>G</td><td>W/G</td></tr><tr><td>349</td><td>333</td><td>187</td><td>336</td><td>183</td><td>323</td><td>179</td><td>325</td><td>175</td><td>173</td></tr></table></div> <div><table><tr><td>1</td><td>2</td><td>3</td><td>4</td><td>5</td><td>6</td><td>7</td><td>8</td><td>9</td><td>10</td></tr><tr><td>B/W</td><td>OR</td><td>GR</td><td>LG</td><td>P</td><td>R/W</td><td>BR</td><td>R/L</td><td>G</td><td>W/G</td></tr><tr><td>349</td><td>333</td><td>187</td><td>336</td><td>183</td><td>323</td><td>179</td><td>325</td><td>175</td><td>173</td></tr></table></div> <div>1. Get the <b>B/W wire</b> using left hand and transfer to right hand then insert to connector. Repeat the process for <b>OR-GR-LG-P-R/W-BR-R/L-G-W/G wires</b>. Check the wire after insertion. <i>Note: Follow the insertion sequence based on the illustration.</i></div>	1	2	3	4	5	6	7	8	9	10	B/W	OR	GR	LG	P	R/W	BR	R/L	G	W/G	349	333	187	336	183	323	179	325	175	173	1	2	3	4	5	6	7	8	9	10	B/W	OR	GR	LG	P	R/W	BR	R/L	G	W/G	349	333	187	336	183	323	179	325	175	173	<div>STEERING NAVIGATION</div> <div></div> <div>CONTROLLER</div> <div></div>	<p>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</p> <p><b>Important reminders/Note/s:</b></p> <p><b>1. Please hold the wire near terminal during insertion.</b> <b>2. Insertion of Wire must be from left to right.</b> <b>3. Make sure wires are properly inserted.</b> <b>Conduct Pull-Push-Pull-Push after insertion.</b> <b>Do not exert extra force.</b></p> <p><b>Document References:</b></p> <p><b>1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.</b> <b>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b> <b>3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</b></p>
		1	2	3	4	5	6	7	8	9	10																																																						
B/W	OR	GR	LG	P	R/W	BR	R/L	G	W/G																																																								
349	333	187	336	183	323	179	325	175	173																																																								
1	2	3	4	5	6	7	8	9	10																																																								
B/W	OR	GR	LG	P	R/W	BR	R/L	G	W/G																																																								
349	333	187	336	183	323	179	325	175	173																																																								
3	Wire insertion to Blue Sunprene tube ø8 L=133±3mm	<div>Blue Sunprene tube</div> <div></div> <div></div> <div>1. Get the <b>Blue Sunprene tube ø8 L=133±3mm</b> using left hand and transfer to right hand. Hold the wires using left hand and insert the wires using right hand.</div>	N/A	<p>1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires</p>																																																													

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## WORK INSTRUCTION

Process Name/Title:

### TAPING ASSEMBLY PROCESS

Model code/Part number: **120D / 75S184-0280**

Customer:

**TRMX**

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

**December 16, 2022**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-598**

Revision No.:

**1**

Page No.:

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#### PARTS:

1. AVSS 0.3 R wire L=169±2mm; Y wire L=173±2mm; GR/B L=175±2mm; V wire L=179±2mm; B wire L=181±2mm

#### JIG

1. Insertion jig

#### NO.

#### PROCESS NAME

#### WORK PROCEDURE/ ILLUSTRATION

#### TOOLS/PPE

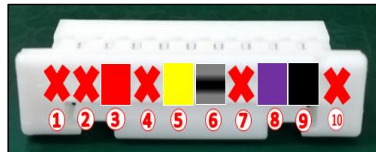
#### QUALITY POINTERS

4

P1

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

#### INSERTION SEQUENCE FROM LEFT TO RIGHT



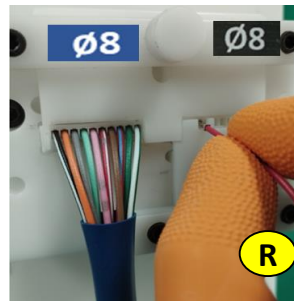
#### Wire facing

1	2	3	4	5	6	7	8	9	10
X	X	R	X	Y	GR/B	X	V	B	X
		169		173	175		179	181	



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

Lower guide



1. Get the **R wire** using right hand and insert to connector. Repeat the process for **Y-GR/B-V-B wires**. Check the wire after insertion.

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

#### STEERING NAVIGATION



#### CONTROLLER



#### Important reminders/Note/s:

1. Please hold the wire near terminal during insertion.
2. Insertion of Wire must be from left to right.
3. 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-029 for Pull-Push procedure.

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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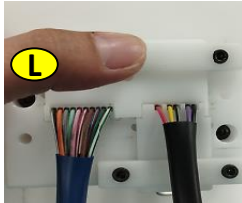
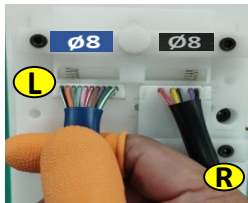


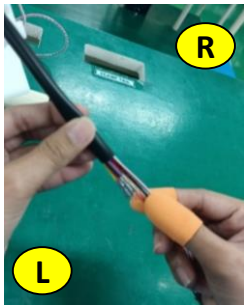

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**PARTS:**

1. Assy parts
2. Black sunprene tube  $\varnothing 8$  L=129 $\pm$ 3mm

**JIG**

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1 Wire insertion to Black sunprene tube $\varnothing 8$ L=129 $\pm$ 3mm	    <p>1. Get the <b>Black Sunprene tube</b> <math>\varnothing 8</math> L=129<math>\pm</math>3mm using right hand. Hold the wire using left hand then</p> <p>2. Press the Upper button using left hand.</p> <p>3. Remove the 1st connector with inserted wires and <b>Blue Sunprene tube</b> using right hand then press the upper guide using left hand. Check the wire insertion condition.</p> <p>Note: Second connector with inserted wire and Black Sunprene tube will stay in the jig.</p>	n/a	<ol style="list-style-type: none"><li>1. No wrong usage of parts</li><li>2. No deformed terminal</li><li>3. No tangled wires</li></ol>  <p>Terminal tip must be visible</p> <p><b>Document References:</b></p> <ol style="list-style-type: none"><li>1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.</li></ol>
6	P1 Wire insertion to Black sunprene tube (Assy parts)	  <p>1. Hold the <b>Black Sunprene tube</b> using left hand and insert the wires from <b>Blue Sunprene tube</b> using right hand.</p>	n/a	<ol style="list-style-type: none"><li>1. No wrong use of parts</li><li>2. No deformed terminal</li><li>3. No tangled wires</li></ol>

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## TAPING ASSEMBLY PROCESS

Effectivity Date:

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Process Name/Title:

Validity date

n/a

Model Code/Part Number: 120D / 75S184-0280

Customer: TRMX

Document No.:

WI-ENG-PDE-598

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

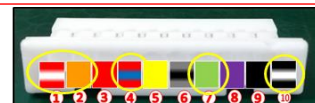
QUALITY POINTERS

7

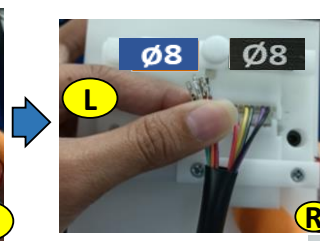
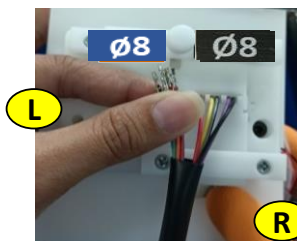
P1

Wire insertion to PBVP-10V-S (W) (Assy parts)

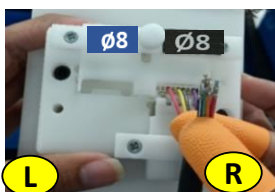
#### INSERTION SEQUENCE FROM LEFT TO



#### VISUAL REFERENCE



1. Press the Lower button using right hand. Holes that need to be insert are only open.



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

#### WIRE INSERTION ILLUSTRATION

1	2	3	4	5	6	7	8	9	10
R/W	OR	R	R/L	Y	GR/B	LG	V	B	B/W
323	333	169	325	173	175	336	179	181	349

#### STEERING NAVIGATION



#### CONTROLLER



1. No wrong use of parts
2. No deformed terminal

#### 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-029 for Pull-Push procedure.

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Effectivity Date:

December 16, 2022

Process Name/Title:

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n/a

Model Code/Part Number: 120D / 75S184-0280

Customer: TRMX

Document No.:

WI-ENG-PDE-598

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

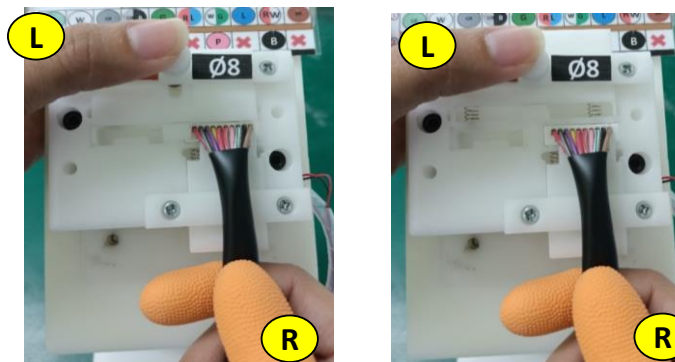
TOOLS/PPE

QUALITY POINTERS

7

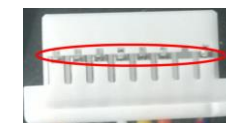
P1

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



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

n/a



Terminal tip must be visible

### Document References:

1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.

1. No deformed terminals
2. No tangled wires
3. No wrong facing

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**TAPING ASSEMBLY PROCESS**

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**n/a**Model Code/Part Number: **120D / 75S184-0280**

Customer:

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Document No.:

**WI-ENG-PDE-598**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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**7 of 14****PARTS:**

1. Assy parts

**JIG**

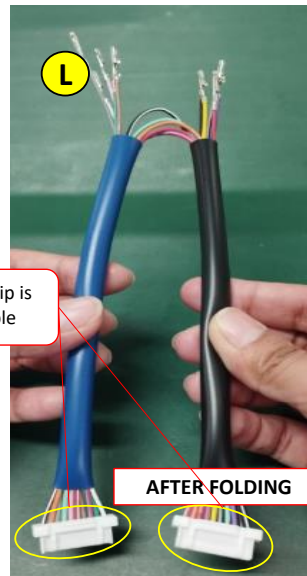
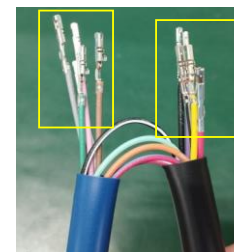
n/a

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

8

P1

Wire arrangement

**BEFORE FOLDING****AFTER FOLDING****R**

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

n/a

1. No deformed terminals
2. No tangled wires
3. No wrong facing

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Customer:

TRMX

Document No.:

WI-ENG-PDE-598

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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PARTS: 1. Connector 1746872-1 (B)

JIG

1. Insertion jig

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE



QUALITY POINTERS

9

P1

Connector setting to  
insertion jig  
1746872-1 (B)

### INSERTION JIG

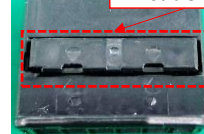


Visual reference

Upper guide

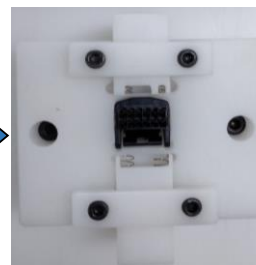
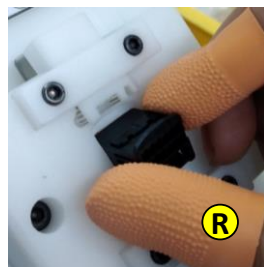
Lower guide

### Double lock



Note: Check the  
connector before  
insertion.

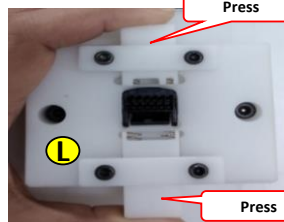
### CONNECTOR ORIENTATION



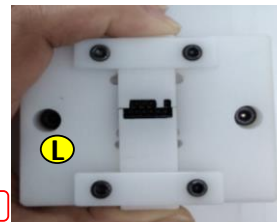
1. Get the connector **1746872-1 (B)** and insert to insertion jig  
using right hand.

Note: Follow the connector orientation

Press



Press

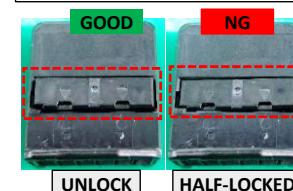


2. Press the upper and lower  
guide (same timing) using left  
hand. Holes that need to be  
insert are only open.

N/A

1. Use the provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
4. No damaged connector

### CONNECTOR LOCK APPEARANCE CHECK



UNLOCK

HALF-LOCKED

### CONNECTOR ILLUSTRATION



### Important reminders/Note/s:

1. Automatically dispose and  
replace the unit if once  
encountered bend terminal,  
difficulty of insertion and half-  
locked connector.

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# WORK INSTRUCTION

Effectivity Date:

December 16, 2022

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Validity date

n/a

Model Code/Part Number:

120D / 75S184-0280

Customer:

TRMX

Document No.:

WI-ENG-PDE-598

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE



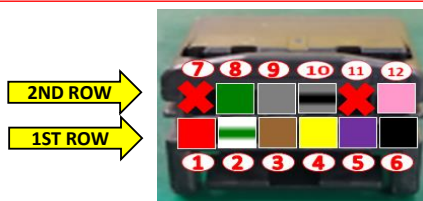
QUALITY POINTERS

10

P1

Wire insertion to  
Connector  
1746872-1 (B)

INSERTION SEQUENCE FROM LEFT TO RIGHT



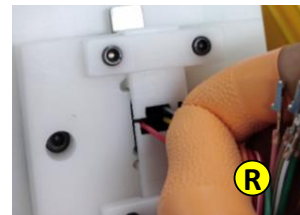
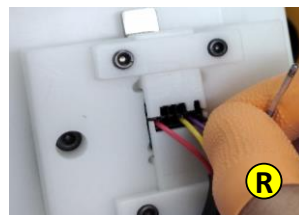
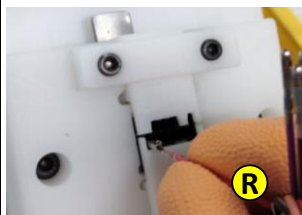
WIRE INSERTION ILLUSTRATION

7	8	9	10	11	12
X	G	GR	GR/B	X	P
1	2	3	4	5	6
R	W/G	BR	Y	V	B
169	173	179	173	179	181



Wire facing

BLACK SUNPRENE TUBE



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 **GR/B wire** and insert to terminal slot 5.  
*Note: Follow the insertion sequence based on the illustration stated above.*

N/A

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

### Important reminders/Note/s:

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

### Document References:

1. Refer to GL-PRO-ASY-028 for Pull-Push procedure.

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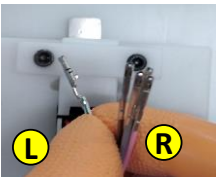
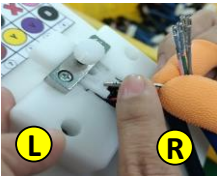
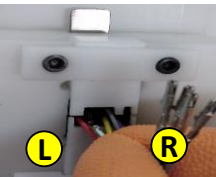
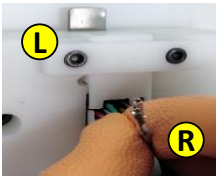
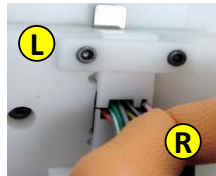
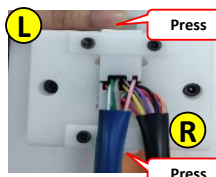
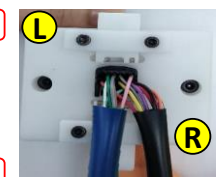
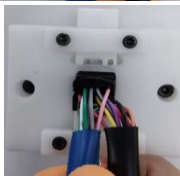
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## PARTS:

1. Assy parts
2. Connector 1746872-1(W)

## JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	P1 Wire insertion to Connector 1746872-1 (B) (Continuation)	<p><b>GREEN SUNPRENE TUBE</b></p>     <p>3. Insert the wires from <b>Blue sunprene tube</b>, hold the <b>W/G wire</b> using right hand and support the wire by left index finger then insert to terminal <b>slot 6</b> using right hand. Repeat the process for <b>BR wire</b>. <i>Note: Follow the insertion sequence based on the above illustration.</i></p>   <p>4. Hold the <b>G wire</b> and insert to terminal <b>slot 8</b> using right hand. Repeat the process for <b>GR-P wire</b>. <i>Note: Follow the insertion sequence based on the illustration.</i></p>   <p>5. Press the upper and lower lever guide (same timing) using both hands.</p>  <p>6. Remove the assy parts using right hand.</p>	n/a	<ol style="list-style-type: none"><li>1. Use provided jig per model</li><li>2. No wrong usage of parts</li><li>3. One by one insertion</li><li>4. No wrong insertion</li><li>5. No deformed terminal</li><li>6. No stuck of terminal tip</li></ol> <p><b>Important reminders/Note/s:</b></p> <ol style="list-style-type: none"><li>1. Please hold the wire near terminal during insertion.</li><li>2. Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</li><li>3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</li></ol> <p><b>Document References:</b></p> <ol style="list-style-type: none"><li>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</li></ol>

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# WORK INSTRUCTION

## TAPING ASSEMBLY PROCESS

Effectivity Date:

December 16, 2022

Process Name/Title:

Model Code/Part Number: 120D / 75S184-0280

Customer: TRMX

Validity date

n/a

Document No.:

WI-ENG-PDE-598

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

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PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

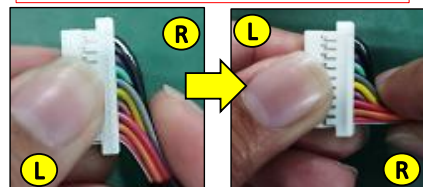
QUALITY POINTERS

11

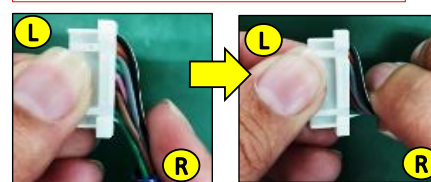
P1

Wire folding

BLACK SUNPRENE TUBE



BLACK SUNPRENE TUBE



1. Hold the connector PBVP-10V-S(W) using left hand and slightly fold the wires from Black sunprene tube (as shown in illustration above) using right . Repeat the process for Blue sunprene tube.



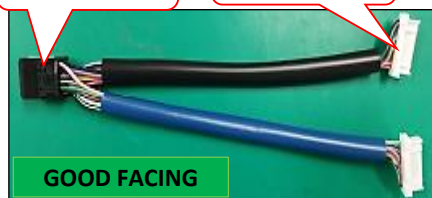
BEFORE FOLDING



AFTER FOLDING

Double lock in upward position

Terminal tip is not visible



GOOD FACING

Double lock is upward position

Terminal tip is visible



WRONG FACING

Terminal tip is not visible

n/a

1. No wrong orientation of connector.  
2. No tangled wires.  
3. Terminal backing out.

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Document No.:

**WI-ENG-PDE-598**

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

12

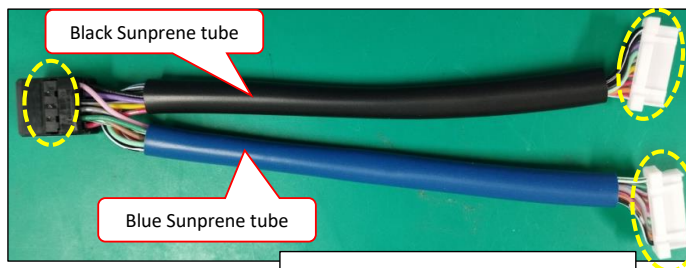
P1

Visual/By two's inspection

1. Check the Connector lock, locking of connector is included to Steering electrical test.

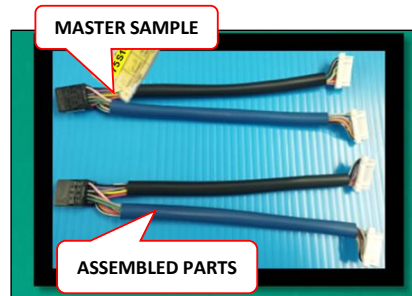
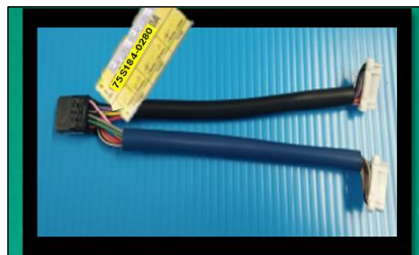
2. Check the wire alignment. Make sure no tangled wires.

3. Check the terminal if with backing out (not fully inserted) or deformed terminal.



4. Check the orientation of harness.

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



n/a

1. No skip checking during inspection.

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Purpose:



PROTOTYPE



PRE-LAUNCH



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**PARTS:**

1. Assy parts

**JIG**

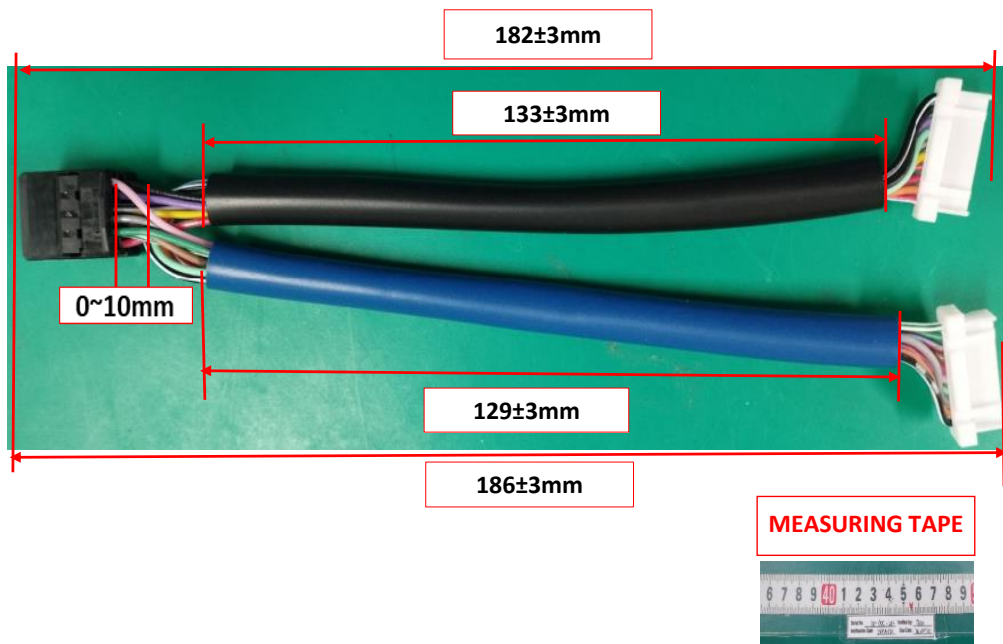
n/a

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

13

P1

Measurement



1. No wrong dimension.

**Important reminders/Note/s:**

1. Please use calibrated /verified measuring tape when getting the measurement.
2. For Hatsumono and Owarimono.

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Purpose:



PROTOTYPE



PRE-LAUNCH



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### PARTS:

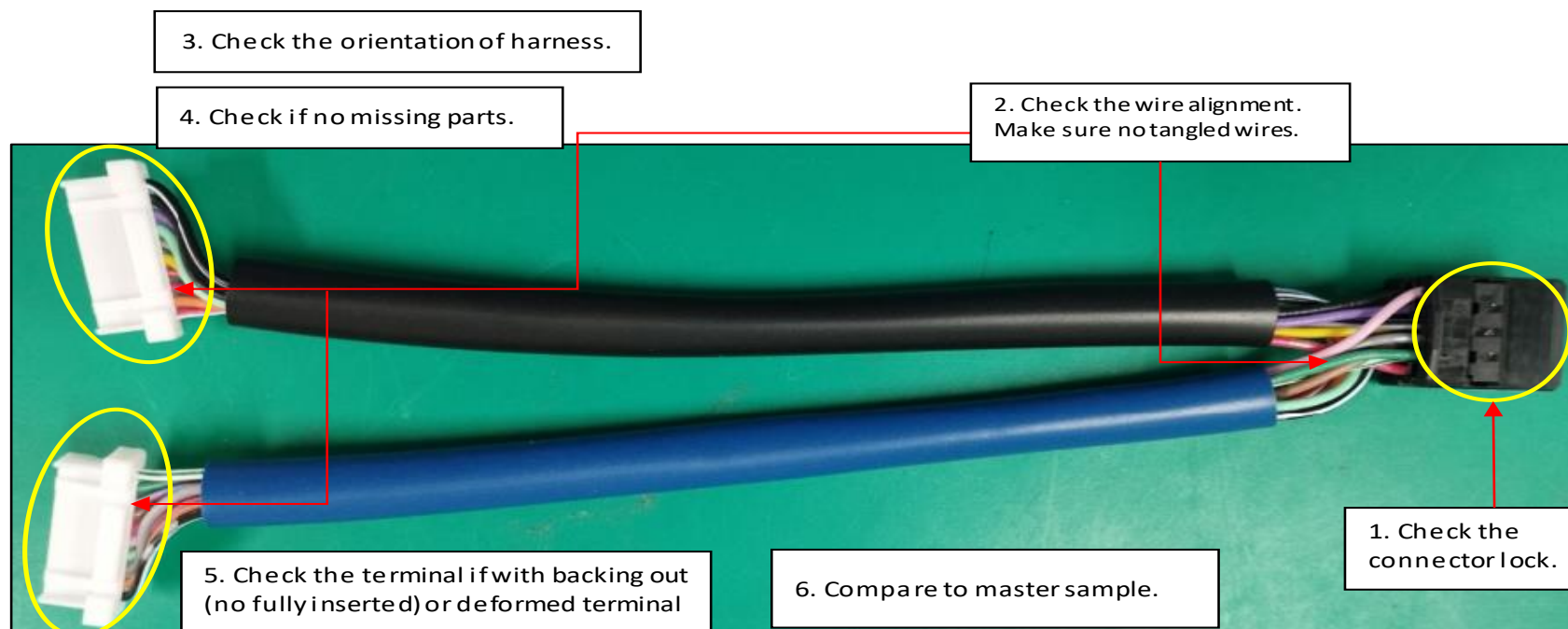
1. Assy parts

JIG

n/a

### QUALITY CHECKPOINTS

## 75S184-0080



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