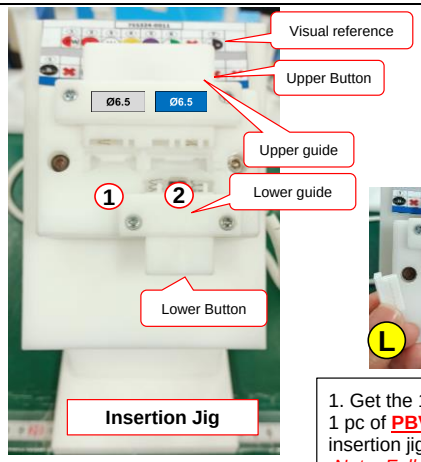
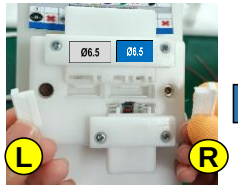
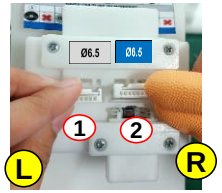
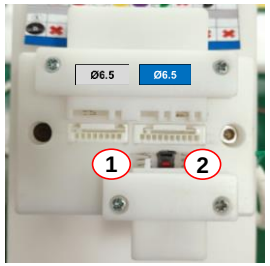
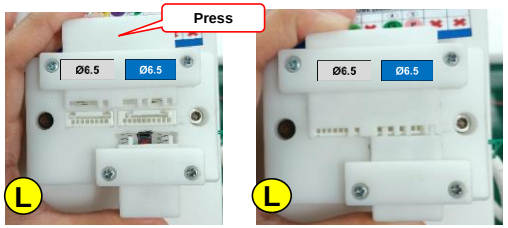
	WORK INSTRUCTION			Effectivity Date:	December 12, 2023	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: YDB / 75S324-0011	Customer: TRJ	Car Model: SUZUKI-PALLETE	Document No.:	WI-ENG-PD-764A	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 1	Page No.:	1 of 8

PARTS:	1. Connector PBVP-08V-S (W) 2. Connector PBVP-10V-S (W)	JIG:	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	Connector setting to insertion jig PBVP-08V-S (W) PBVP-10V-S (W)	 Insertion Jig Connector orientation   1. Get the 1 pc of **PBVP-08V-S** connector using left hand and get 1 pc of **PBVP-10V-S** connector using right hand then insert to insertion jig. *Note: Follow the connector orientation.*   2. Press the upper and lower guide using left hand in same timing. Holes that need to be insert are only open.	**Safety Instruction** Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.) **Housekeeping** 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. **Alert level** For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector

Revision History							Prepared by	Reviewed by	Approved by	Noted by
12/12/23	1	Improved insertion jig; Change connector (PBVP-08V-S and PBVP-10V-S) orientation, terminal orientation and color sequence as customer claim countermeasure. Change Wire length due to minimum dimension.	D. Castillo	C. Villanueva	A. Arañes	n/a				
11/20/23	0	Initial issue	D. Castillo	C. Villanueva	A. Arañes	n/a	D.Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	November 20, 2023		

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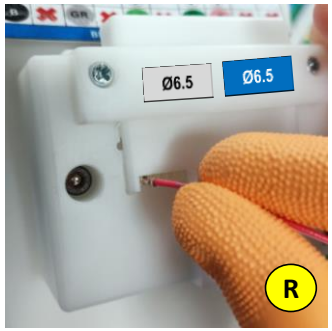
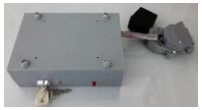
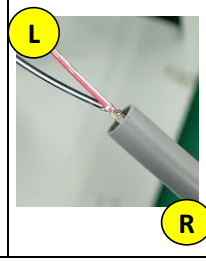
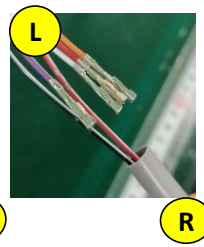
NBC	WORK INSTRUCTION			Effectivity Date:	December 12, 2023
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number:	YDB / 75S324-0011	Customer: TRJ / Car Model: SUZUKI-PALLETE	Document No.:	WI-ENG-PD-764A
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1 / Page No.: 2 of 8

PARTS: 1	1. AVSS 0.3 wire B/W L=343±2mm; W/G wire L=191±2mm; V wire L=191±3mm; OR wire L=191±2mm; W wire L=191±2mm; R wire L=193±2mm; R/W wire L=343±2mm 2. N6GR VM tube (Sunprene) Ø6.5 L=150±3mm	JIG:	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1	Wire insertion to Connector PBVP-08V-S (W)	**INSERTION SEQUENCE FROM LEFT TO RIGHT** **WIRE INSERTION ILLUSTRATION** 1: R/W 343 2: X 3: R 193 4: W 191 5: OR 191 6: V 191 7: W/G 191 8: B/W 343 **Wire facing**  1. Get the **R/W wire** using left hand and transfer to right hand then insert to connector. Repeat the process for **R-W-OR-V-W/G-B/W wires**. Check the wire after insertion. *Note: Follow the insertion sequence based on the illustration.*	**STEERING NAVIGATION** **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. Please hold the wire near terminal during insertion.* *2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.* *Do not exert extra force.* ***Document References:*** *1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.* *2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance* *3. Refer to GL-PRO-ASY-028 for Pull-Push procedure.*
3		Wire insertion to N6GR VM tube (Sunprene) Ø6.5 L=150±3mm	  1. Get the **N6GR VM tube (Sunprene) Ø6.5 L=150±3mm** using left hand and transfer to right hand. Hold the wires using left hand and insert the wires using right hand.		1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires

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	WORK INSTRUCTION			Effectivity Date:	December 12, 2023		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: YDB / 75S324-0011	Customer: TRJ	Car Model: SUZUKI-PALLETE	Document No.:	WI-ENG-PD-764A		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.:	3 of 8

PARTS: △1	1. AVSS 0.3 P wire L=186±2mm; G wire L=186±2mm; LG L=186±2mm; GR wire L=186±2mm; B wire L=186±2mm	JIG:	1. Insertion jig

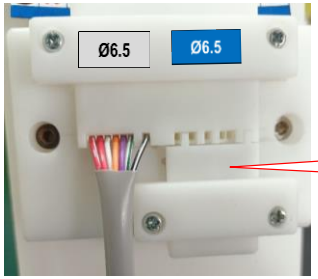
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	△1 P1	Wire insertion to Connector PBVP-10V-S (W)			

INSERTION SEQUENCE FROM LEFT TO RIGHT

Wire facing

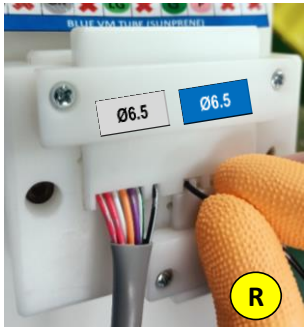
WIRE INSERTION ILLUSTRATION

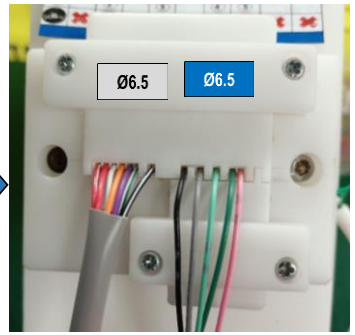
1	2	3	4	5	6	7	8	9	10
B	X	GR	X	LG	X	G	P	X	X
186		186		186		186	186		



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

Lower guide

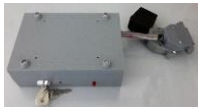




1. Get the **P wire** using right hand and insert to connector. Repeat the process for **G-LG-GR-B wires.** Check the wire after insertion.
Note: Follow the insertion sequence based on the above illustration.

STEERING NAVIGATION

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

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

Document References:

1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.

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

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

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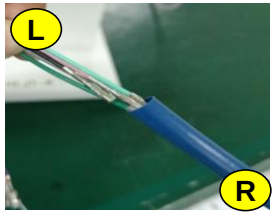
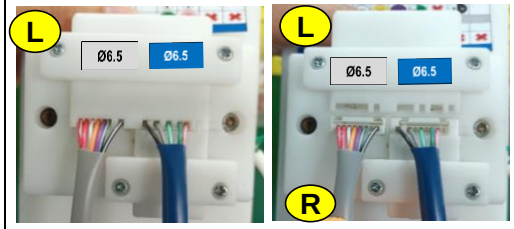
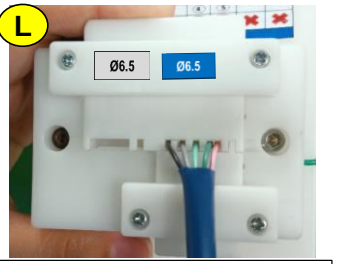
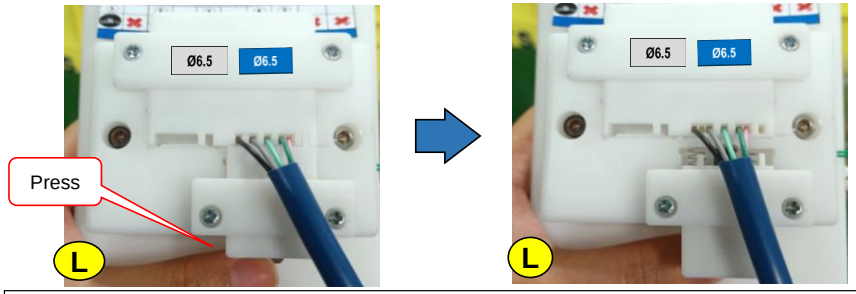
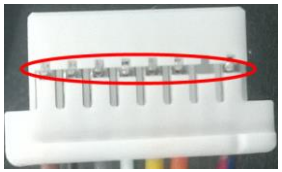
PARTS:	1. Blue VM tube (Sunprene) Ø6.5 L=143±2mm		JIG:	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1	Wire insertion to Blue VM tube (Sunprene) Ø6.5 L=143±2mm	 1. Get the **Blue VM tube (Sunprene) Ø6.5 L=143±2mm** using right hand. Hold the wire using left hand then insert the wires.  2. Press the Upper button using left hand. Remove the 1st connector with inserted wires and N6GR VM tube (Sunprene) using right hand.  3. Press the upper guide using left hand. Check the wire insertion condition. Note: Second connector with inserted wire and Blue VM tube (Sunprene) will stay in the jig.  4. Press the Lower button using right hand. Holes that need to be insert are only open.		 **Terminal tip must be visible** ***Document References:*** *1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.* 1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires

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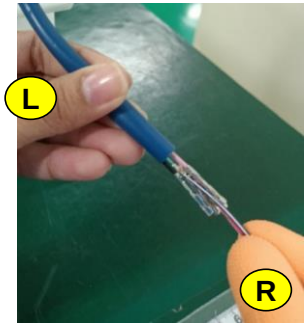
	WORK INSTRUCTION			Effectivity Date:	December 12, 2023		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: YDB / 75S324-0011	Customer: TRJ	Car Model: SUZUKI-PALLETE	Document No.:	WI-ENG-PD-764A		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.:	5 of 8

PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
5	P1	Wire insertion to assy parts	 1. Hold the **Blue VM tube (Sunprene)** using left hand and insert the wires from **N6GR VM tube (Sunprene)** using right hand.	N/A	1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires

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	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.:	6 of 8

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

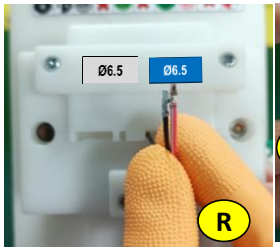
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1	Wire insertion to Connector PBVP-10V-S (W)			

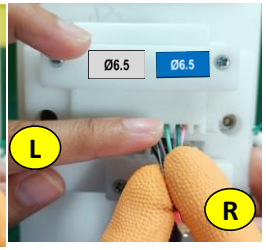
INSERTION SEQUENCE FROM LEFT TO RIGHT

Wire facing

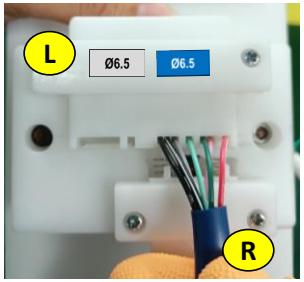
WIRE INSERTION ILLUSTRATION

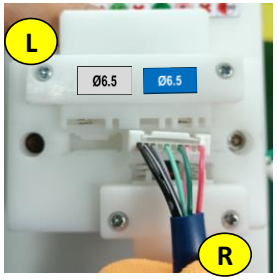
1	2	3	4	5	6	7	8	9	10
B	B/W	GR	X	LG	X	G	P	X	R/W
186	343	186		186		186	186		343





1. 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 **B/W wire**. Check the wire after insertion
Note: Follow the insertion sequence based on the above illustration.

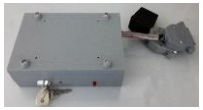




2. Press the Upper button using left hand then remove the assy part using right hand. Check the insertion condition.

STEERING NAVIGATION

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

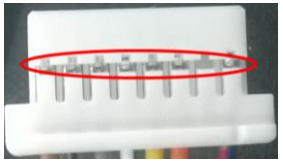
2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.
Do not exert extra force.

Document References:
1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.

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

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

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



Terminal tip must be visible

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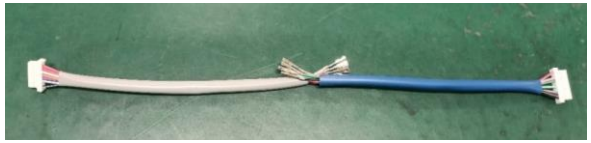
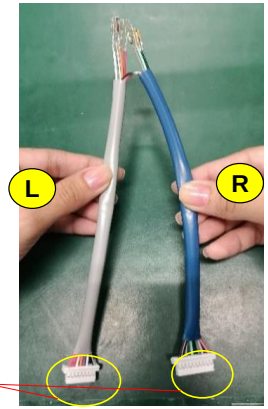
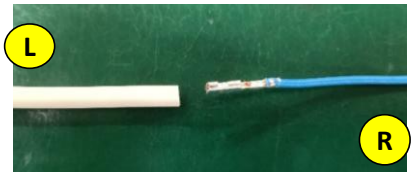
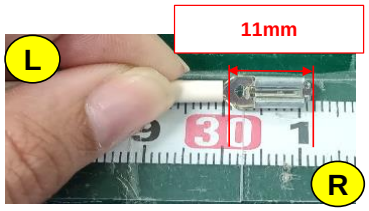
	Model code/Part number: YDB / 75S324-0011	Customer: TRJ	Car Model: SUZUKI-PALLETE	Document No.:	WI-ENG-PD-764A
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.: 1	Page No.: 7 of 8

PARTS:	1. Assy parts 2. White VM tube (Sunprene) Ø3 L=110±3mm 3. AVSS 0.5 L L=131±2mm	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1	Wire arrangement	 **BEFORE FOLDING** 1. Hold the assy parts using both hands then conduct wire arrangement. **AFTER FOLDING**  Terminal tip is not visible	n/a	1. No deformed terminals 2. No tangled wires 3. No wrong facing
8		Wire insertion to White VM tube (Sunprene) Ø3 L=110±3mm	 1. Get the **Blue wire** using right hand and insert to **White VM tube (Sunprene) Ø3 L=110±3mm**  2. Measure the VM tube (Sunprene) up to the tip of the terminal, it should be 11mm. 	**MEASURING TAPE** 	 **Peel-off wire should be covered by Sunprene tube (White)** ***Important Reminder/Note/s:*** *1. Please use calibrated/verified measuring tape when getting the measurement.*

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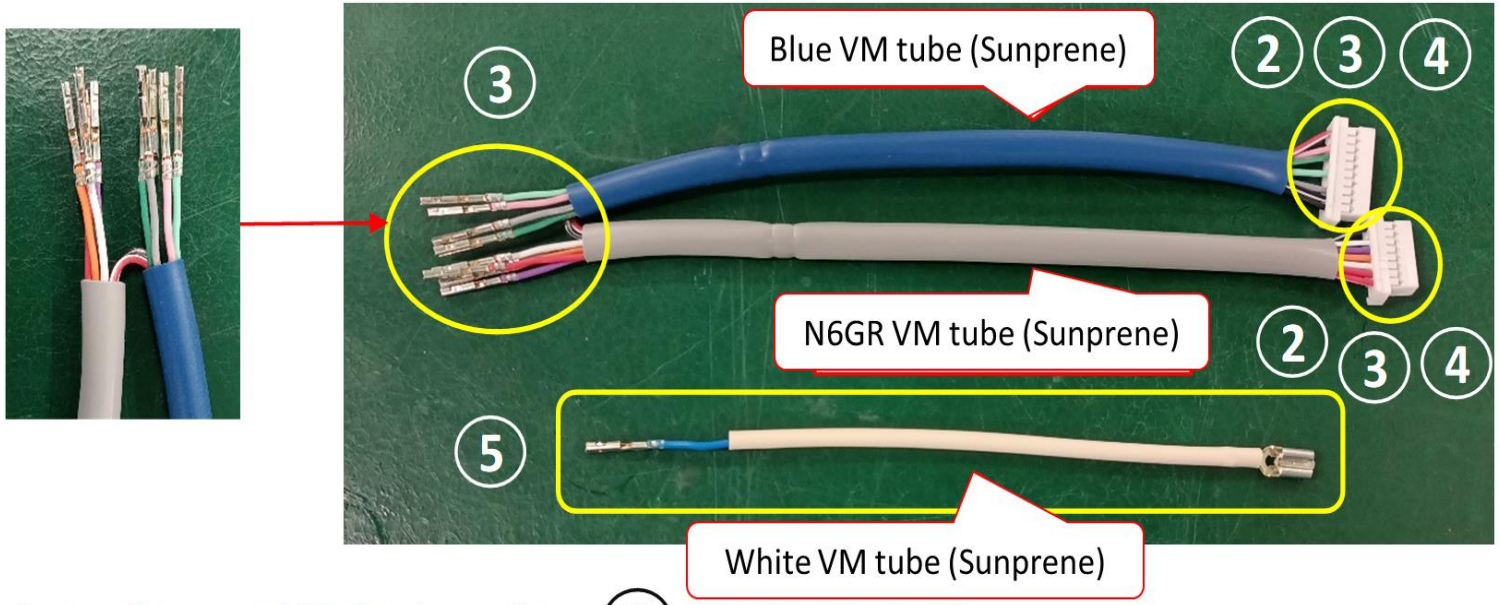
PARTS:	n/a	JIG:	n/a

QUALITY CHECKPOINTS

P1 75S324-0011



1. No Interchange of VM tube color
2. No Wrong Insert
3. No Tangled wires
4. No Backing out of terminal
5. No Missing Blue wire with Sunprene tube (W)

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DCC Stamp