



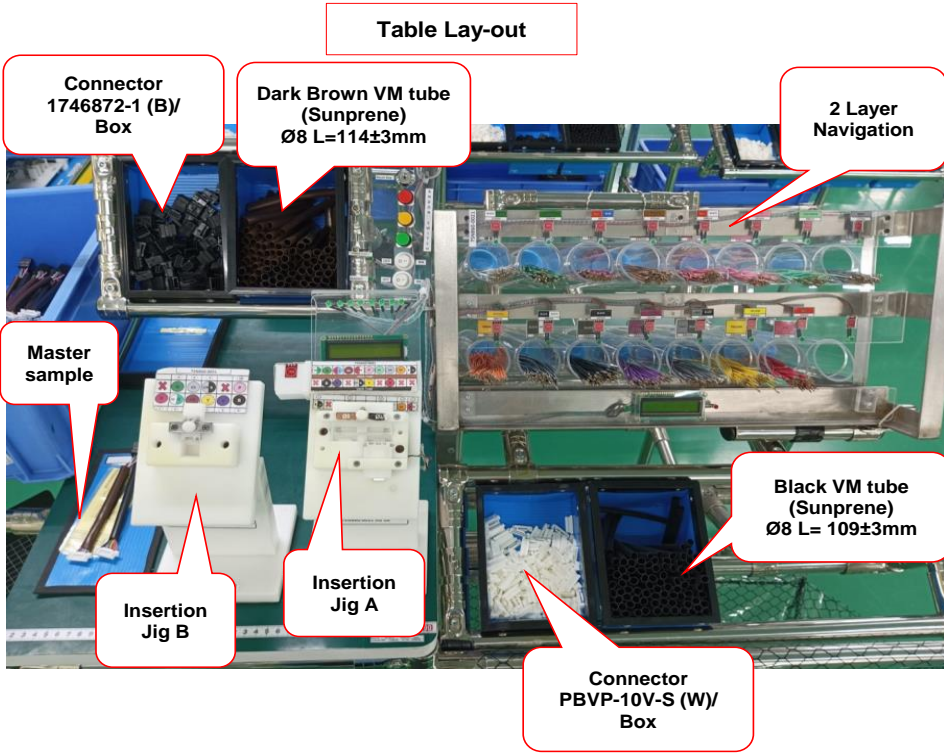
WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

Effectivity Date:	February 21, 2025		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-216		
Revision No.:	9	Page No.:	1 of 18





Process Name/Title: **TAPING ASSEMBLY PROCESS**

Model code/Part number: **800B / 75N860-0021** Customer: **TRJ** Car Model: **LEXUS NX**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. AVSS 0.3 W/G L=157±2mm; G L=157±2mm; R/L L=288±2mm; BR L=157±2mm; R/W L=288±2mm; P L=161±2mm; LG L=288±2mm; GR L=157±2mm; OR L=288±2mm; B/W L=288±2mm; Dark Brown VM tube (Sunprene) Ø8 L=114±3mm; AVSS 0.3 B L=152±2mm; V L=152±2mm; GR/B L=152±2mm; Y L=152±2mm; R L=155±2mm; Black VM tube (Sunprene) Ø8 L=109±3mm; Connector 1746872-1 (B); Connector PBVP-10V-S (W)		JIG:	1. Insertion jig 2. Steering Navigation
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
1	P1 Table lay-out			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.	Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 1. No deformed terminal 2. No wrong usage of parts

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Reviewed	Approved	Est. Date:	Checked by	Reviewed by	Approved by
02/21/25	9	Improved insertion jig; Change connector (PBVP-10V-S) orientation, terminal orientation and color sequence as customer claim countermeasure. Inclusion of Table lay-out. Improved Work procedure of Wire folding, Wire arrangement and Measurement. Change document number of Steering Electrical test (WI-QAD-QAC-252).	D. Castillo	J. Loterte	C. Villanueva	A. Arañes	 D. Castillo	 J. Loterte	 C. Villanueva	 A. Arañes
01/13/24	8	Change wire length from R L=153mm to L=155mm; P L=159mm to L=161mm due to might encounter backing out (Customer request). Update work procedure of process 5.	D.Castillo	C. Villanueva	A. Arañes	n/a				
02/24/23	7	Changed tube color from Brown VM tube (Sunprene) to Dark Brown VM tube (Sunprene).	D.Castillo	J. Loterte	C. Villanueva	A. Arañes				

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TAPING ASSEMBLY PROCESS

Effectivity Date:

February 21, 2025

Model code/Part number:

800B / 75N860-0021

Customer:

TRJ

Car Model:

LEXUS NX

Document No.:

WI-ENG-PDE-216

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

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PARTS:

1. Connector PBVP-10V-S (W) [2pcs]

JIG:

1. Insertion jig
2. Steering Navigation

NO.

PROCESS NAME

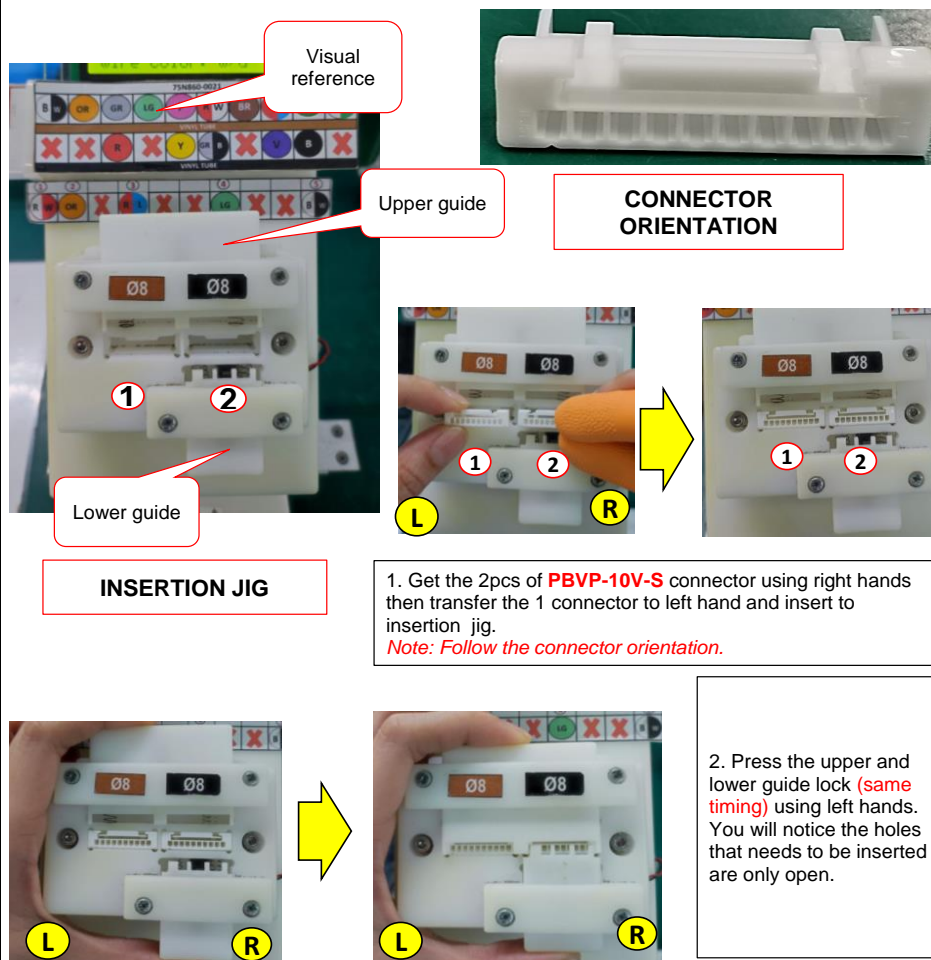
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

P1

Connector setting to
insertion jig
PBVP-10V-S (W)

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WORK INSTRUCTION

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TAPING ASSEMBLY PROCESS

Model code/Part number:

800B / 75N860-0021

Customer:

TRJ

Car Model:

LEXUS NX

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Effectivity Date:

February 21, 2025

Validity Date:

n/a

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PARTS:

1. AVSS 0.3 W/G L=157±2mm; G L=157±2mm; R/L L=288±2mm; BR L=157±2mm; R/W L=288±2mm; P L=161±2mm; LG L=288±2mm; GR L=157±2mm; OR L=288±2mm; B/W L=288±2mm

JIG:

1. Insertion jig
2. Steering Navigation

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

9

3

P1

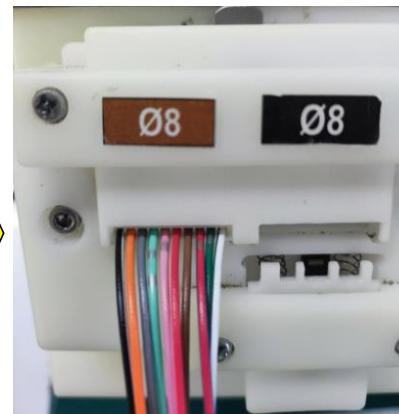
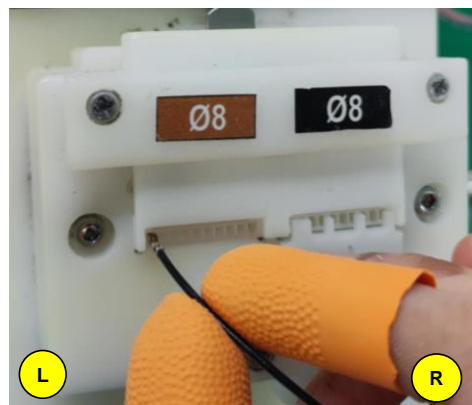
Wire insertion to
Connector
PBVP-10V-S (W)

INSERTION SEQUENCE FROM LEFT TO RIGHT

TERMINAL
FACING

WIRE INSERTION ILLUSTRATION

1	2	3	4	5	6	7	8	9	10
B/W	OR	GR	LG	P	R/W	BR	R/L	G	W/G
288	288	157	288	161	288	157	288	157	157



1. Get the B/W wire using right hand then insert to connector. Repeat the process for OR, GR, LG, P, R/W, BR, R/L, G and W/G wires. Check the wire after insertion.

Note: Follow the insertion sequence based on the illustration.

STEERING
NAVIGATION (2 layer)

CONTROLLER



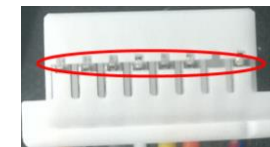
1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

Important reminders/Note/s:

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

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.



Terminal tip must be visible

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WORK INSTRUCTION

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TAPING ASSEMBLY PROCESS

Effectivity Date:

February 21, 2025

Model code/Part number:

800B / 75N860-0021

Customer:

TRJ

Car Model:

LEXUS NX

Document No.:

WI-ENG-PDE-216

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

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PARTS:

1. AVSS 0.3 W/G L=157±2mm; G L=157±2mm; R/L L=288±2mm; BR L=157±2mm; R/W L=288±2mm; P L=161±2mm; LG L=288±2mm;
GR L=157±2mm; OR L=288±2mm; B/W L=288±2mm

JIG:

1. Insertion jig
2. Steering Navigation

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

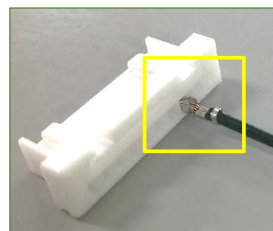
9

3

P1

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

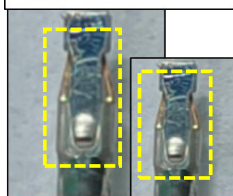
Proper alignment of terminal to connector



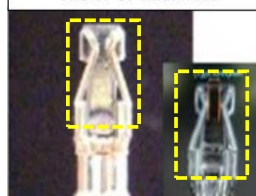
Improper alignment of terminal to connector



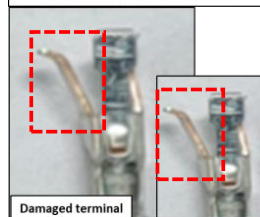
BACK VIEW OF TERMINAL

GOOD
Terminal condition

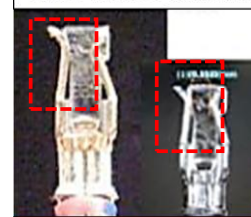
FRONT OF TERMINAL

GOOD
Terminal condition

BACK VIEW OF TERMINAL

Damaged terminal
NO GOOD
Terminal condition

FRONT VIEW OF TERMINAL

NO GOOD
Terminal condition

Note:

***Make sure the terminal was in proper alignment before insert.**

***Avoid hitting the terminal into the connector during wire insertion, if encountered abnormality stop the process and call the attention of Immediate superior and Automatically disposed and replace the unit.**

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

Important reminders/Note/s:

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

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.

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**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**

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n/aModel code/Part number: **800B / 75N860-0021**Customer: **TRJ**Car Model: **LEXUS NX**

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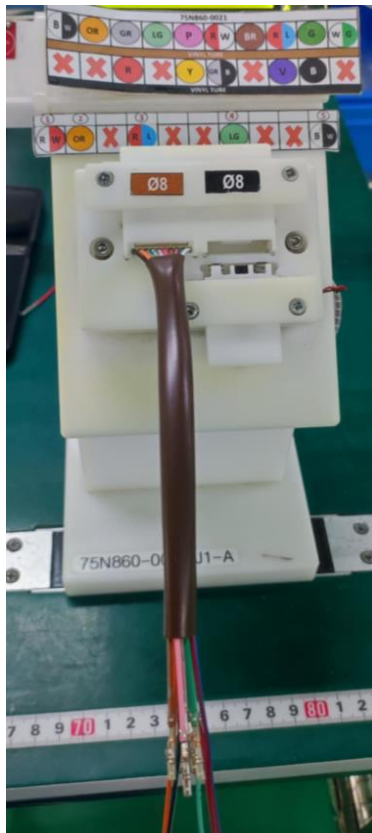
WI-ENG-PDE-216Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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PARTS:		1. Dark Brown VM tube (Sunprene) Ø8 L=114±3mm		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	<div><p>1. Get the Dark Brown VM tube (Sunprene) Ø8 L=114±3mm using left hand and transfer to right hand. Hold the wires using left hand and insert the wires using right hands.</p></div> <div></div>		n/a	1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires

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WORK INSTRUCTION

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TAPING ASSEMBLY PROCESS

Effectivity Date:

February 21, 2025

Model code/Part number:

800B / 75N860-0021

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TRJ

Car Model:

LEXUS NX

Document No.:

WI-ENG-PDE-216

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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PARTS:

1. AVSS 0.3 B L=152±2mm; V L=152±2mm; GR/B L=152±2mm; Y L=152±2mm; R L=155±2mm

JIG:

1. Insertion jig
2. Steering Navigation

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

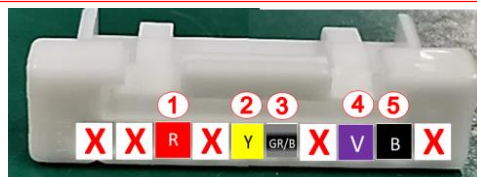
QUALITY POINTERS

5

P1

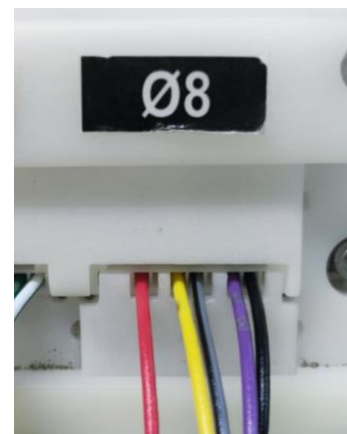
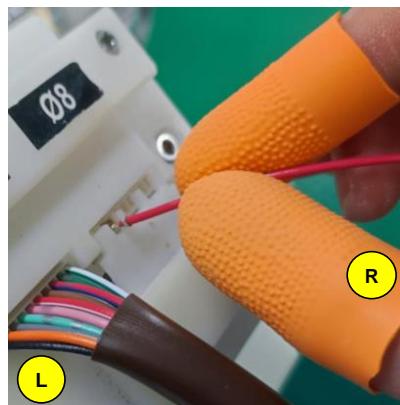
Wire insertion to
Connector
PBVP-10V-S (W)

INSERTION SEQUENCE FROM LEFT TO RIGHT

TERMINAL
FACING

WIRE INSERTION ILLUSTRATION

		1		2	3		4	5	
X	X	R	X	Y	GR/B	X	V	B	X
		155		152	152		152	152	



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

Note: Follow the insertion sequence based on the illustration.

STEERING
NAVIGATION (2 layer)

CONTROLLER



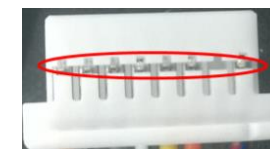
1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

Important reminders/Note/s:

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

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.



Terminal tip must be visible

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WORK INSTRUCTION

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TAPING ASSEMBLY PROCESS

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February 21, 2025

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n/a

Model code/Part number:

800B / 75N860-0021

Customer: TRJ

Car Model:

LEXUS NX

Document No.:

WI-ENG-PDE-216

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

Revision No.:

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PARTS:

1. AVSS 0.3 B L=152±2mm; V L=152±2mm; GR/B L=152±2mm; Y L=152±2mm; R L=155±2mm

JIG:

1. Insertion jig
2. Steering Navigation

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

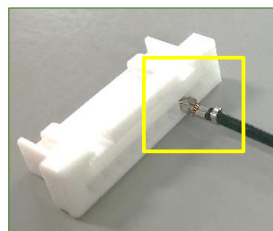
9

5

P1

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

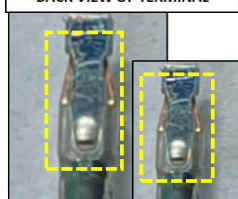
Proper alignment of terminal to connector



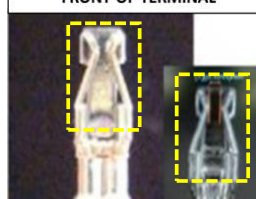
Improper alignment of terminal to connector



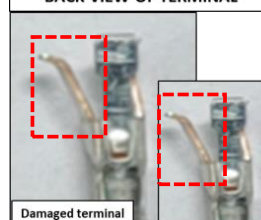
BACK VIEW OF TERMINAL

GOOD
Terminal condition

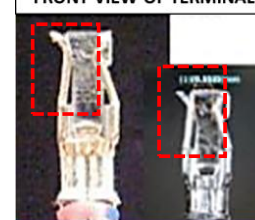
FRONT OF TERMINAL

GOOD
Terminal condition

BACK VIEW OF TERMINAL

NO GOOD
Terminal condition

FRONT VIEW OF TERMINAL

NO GOOD
Terminal condition

Note:

***Make sure the terminal was in proper alignment before insert.**

***Avoid hitting the terminal into the connector during wire insertion, if encountered abnormality stop the process and call the attention of Immediate superior and Automatically disposed and replace the unit.**

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

Important reminders/Note/s:

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

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.

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**WORK INSTRUCTION**Process Name/Title: **TAPING ASSEMBLY PROCESS**

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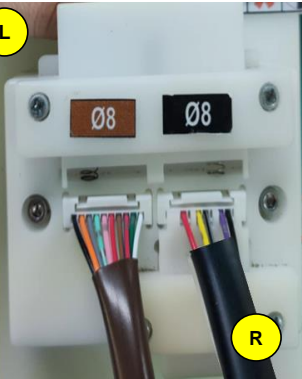
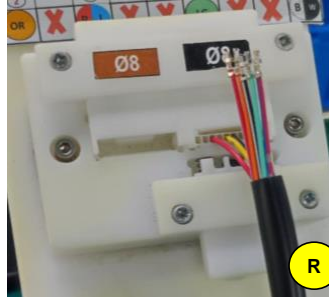
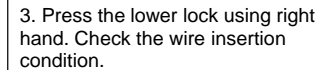

WI-ENG-PDE-216Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) Ø8 L= 109±3mm		JIG:	1. Insertion jig
NO.	PROCESS NAME	9	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1 Wire insertion to Black VM tube (Sunprene) Ø8 L=109±3mm	   	<p>1. Get the Black VM tube (Sunprene) Ø8 L= 109±3mm using right hand. Hold the wires using left hand then insert..</p> <p>2. Press the upper lock button using left thumb. Remove the 1st connector with inserted wires and Dark Brown VM tube (Sunprene) using right hand then press the upper guide using left hand. Note: The 2nd connector with inserted wires (With Black VM tube (Sunprene) remains on the jig.</p> <p>3. Press the lower lock using right hand. Check the wire insertion condition.</p>	n/a	1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires
7	Wire insertion to assy parts		<p>2. Hold the Black VM tube (Sunprene) using left hand and insert the wires from Dark Brown VM tube (Sunprene) using right hand.</p>	n/a	1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:

1. Assy parts

JIG:

1. Insertion jig
2. Steering Navigation

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

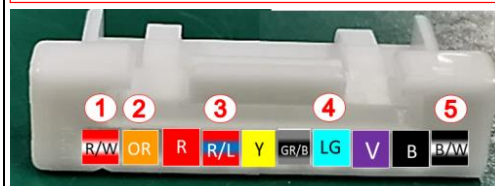
QUALITY POINTERS

8

P1

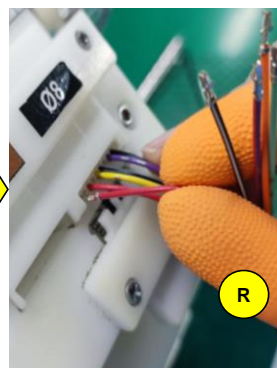
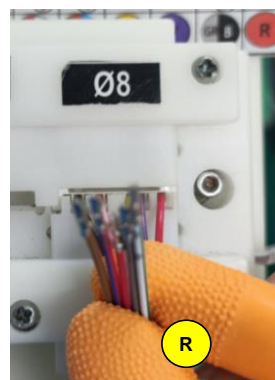
Wire insertion to
Connector
PBVP-10V-S (W)

INSERTION SEQUENCE FROM LEFT TO RIGHT

TERMINAL
FACING

WIRE INSERTION ILLUSTRATION

1	1		3			4			5
R/W	OR	R	R/L	Y	GR/B	LG	V	B	B/W
288	288	152	288	152	152	288	152	152	288



1. Hold the **R/W** wire using right hand and support the wire by left index finger then insert to connector slot 1 using right hand. Repeat the process on **OR**, **R/L**, **LG** and **B/W** wires.
Note: Follow the insertion sequence based on the above illustration.

STEERING
NAVIGATION (2 layer)

CONTROLLER



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

Important reminders/Note/s:

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

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.

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WORK INSTRUCTION

Process Name/Title: TAPING ASSEMBLY PROCESS

Effectivity Date:

February 21, 2025

Model code/Part number: 800B / 75N860-0021

Customer: TRJ

Car Model: LEXUS NX

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-216

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PARTS:

1. Assy parts

JIG:

1. Insertion jig
2. Steering Navigation

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

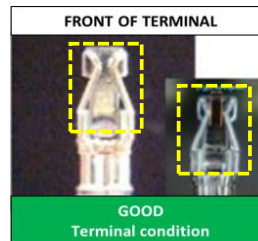
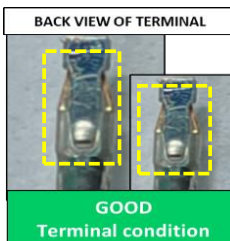
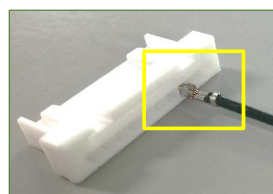
QUALITY POINTERS

8

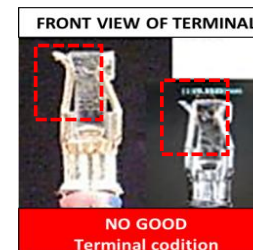
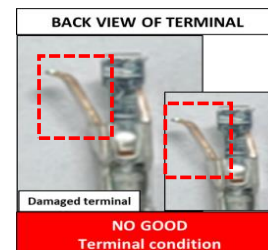
P1

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

Proper alignment of terminal to connector



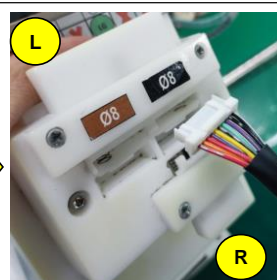
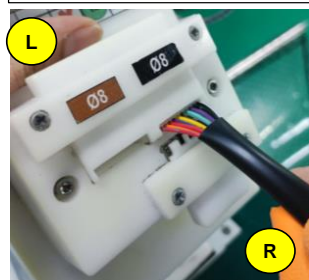
Improper alignment of terminal to connector



Note:

**Make sure the terminal was in proper alignment before insert.*

**Avoid hitting the terminal into the connector during wire insertion, if encountered abnormality stop the process and call the attention of Immediate superior and Automatically disposed and replace the unit.*



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

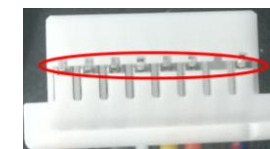
1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

Important reminders/Note/s:

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

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.




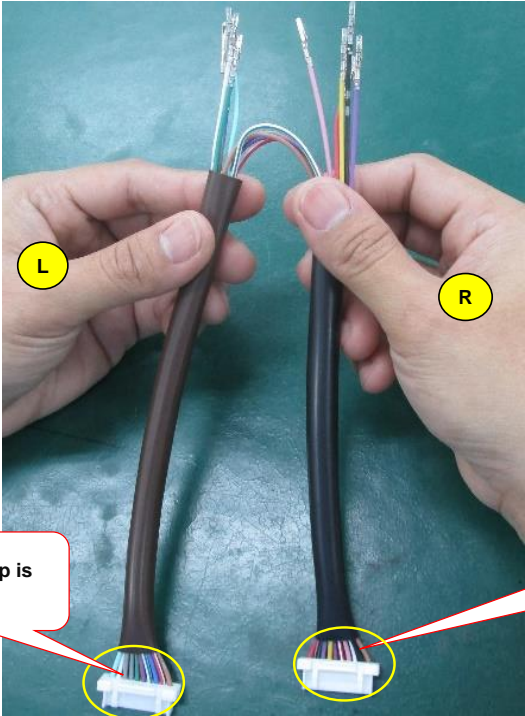
Terminal tip must be visible

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	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: 800B / 75N860-0021		Customer: TRJ	Car Model: LEXUS NX	Document No.: WI-ENG-PDE-216		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	9	Page No.:	11 of 18

PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME		9 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P1	Wire folding	<div>  <div> 1. Hold the Assy parts using both hands and gently fold it. </div> </div>	n/a	1. No wrong orientation of connector 2. No deformed terminal 3. No wrong terminal facing 4. No damage lance 5. No wrong folding of position



WORK INSTRUCTION

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800B / 75N860-0021

Customer:

TRJ

Car Model:

LEXUS NX

Document No.:

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☐ 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

10

P1

Connector setting to
insertion jig
1746872-1 (B)

INSERTION JIG

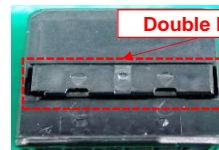


Visual reference

Upper guide

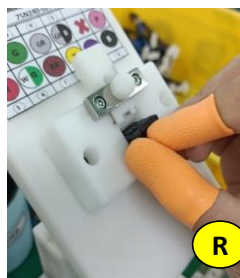
Upper button

Double lock



Note: Check the
connector before
insertion.

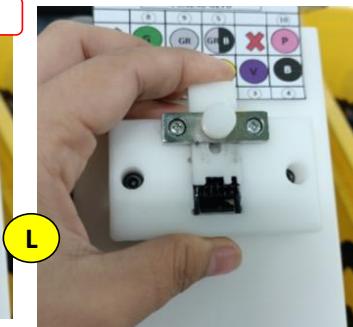
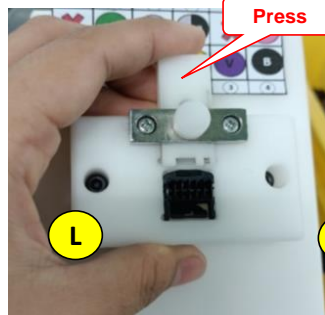
CONNECTOR ORIENTATION



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

Note: Follow the connector orientation

Press



2. Press the upper
guide using left hand.
Holes that need to be
insert are only open.

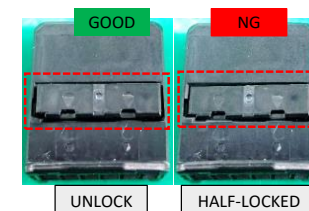
n/a

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

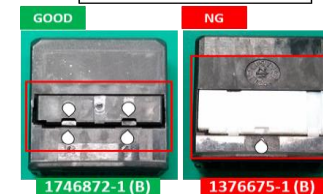
Important reminders/Note/s:

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

CONNECTOR LOCK APPEARANCE CHECK



CONNECTOR ILLUSTRATION



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Purpose:



PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Assy parts

JIG:

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

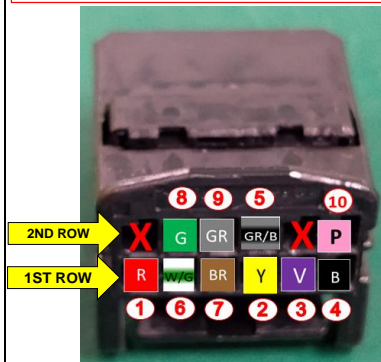
QUALITY POINTERS

11

P1

Wire insertion to
Connector
1746872-1 (B)

INSERTION SEQUENCE FROM LEFT TO RIGHT



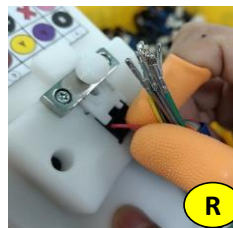
WIRE INSERTION ILLUSTRATION

	8	9	5		10
X	G	GR	GR/B	X	P
	157	157	152		161
1	6	7	2	3	4
R	W/G	BR	Y	V	B
155	157	157	152	152	152

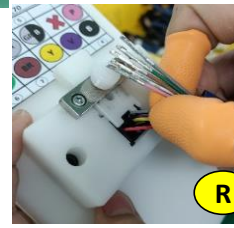
BLACK VM TUBE (SUNPRENE)



FIRST ROW (LEFT TO RIGHT)



SECOND ROW (LEFT TO RIGHT)



1. Insert first the wires from **Black VM tube (Sunprene)**. Hold the **R wire** and insert to terminal **slot 1** using right hand. Repeat the process for **Y-V-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. **Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.**
2. **Please hold the wires near terminal during insertion.**
3. **Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.**
4. **Insertion of wires must be from left to right.**

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.
2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
3. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.

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Purpose:



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PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
11	P1 Wire insertion to Connector 1746872-1 (B) (Continuation)	<div><div>DARK BROWN VM TUBE (SUNPRENE)</div><div></div><div><div>3. Hold the W/G wire using right hand and support the wire by left index finger then insert to terminal slot 6 using right hand. Repeat the process for BR wire. <i>Note: Follow the insertion sequence based on the above illustration.</i></div><div><div>4. Hold the G wire and insert to terminal slot 8 using right hand. Repeat the process for GR-P wires. <i>Note: Follow the insertion sequence based on the illustration.</i></div><div><div>5. Press the Upper button using left hand then remove the assy part using right hand.</div></div></div></div><div>n/a</div><div><div><div>1. Use provided jig per model</div><div>2. No wrong usage of parts</div><div>3. One by one insertion</div><div>4. No wrong insertion</div><div>5. No deformed terminal</div><div>6. No stuck of terminal tip</div></div><div>Important reminders/Note/s: <div>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div><div>2. Please hold the wires near terminal during insertion.</div><div>3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</div><div>4. Insertion of wires must be from left to right.</div></div><div>Document reference/s: <div>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</div><div>2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div><div>3. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</div></div></div></div>		

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PROTOTYPE



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PARTS:

1. Assy parts

JIG:

n/a

NO.**PROCESS NAME**

9

WORK PROCEDURE/ ILLUSTRATION**TOOLS/PPE****QUALITY POINTERS**

12

P1

Wire Arrangement

Folding at the
backTerminal tip is
Not visible**GOOD FACING**Terminal tip is
visible**NG FACING****GOOD FACING****NG FACING**

1. Hold the harness
using both hands.
Arrange the wire
properly to avoid
tangled wires.

Connector
Lock

Folding

Double
lock

Folding

n/a

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

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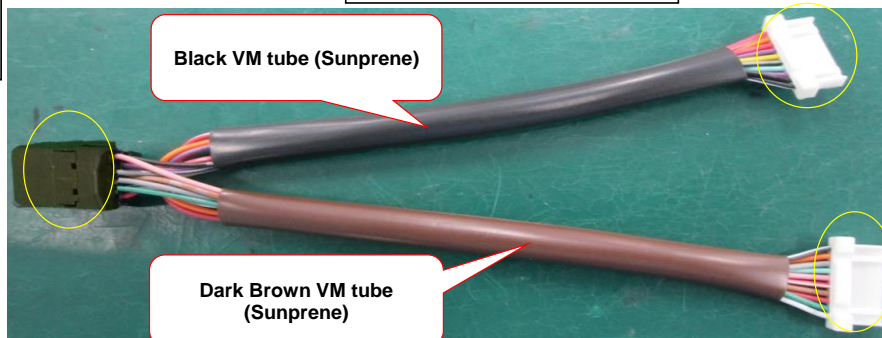

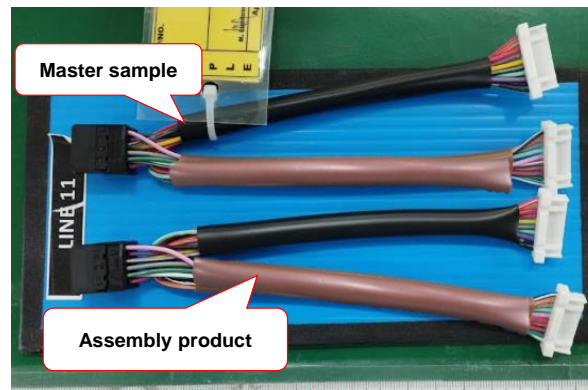

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Master sample		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
13	P1	Visual/By Two's Inspection	<div>1. Check the connector lock, locking of connector is included in Steering electrical test.</div> <div>2. Check the wire alignment. Make dure no tangled wires.</div> <div>3. Check the terminal if with backing -out(Or not fully inserted) no deformed terminal.</div> <div>4. Check the orientation of harness.</div> <div><p>Black VM tube (Sunprene)</p><p>Dark Brown VM tube (Sunprene)</p></div> <div>5. Compare to Master sample by tapping.</div> <div></div> <div><p>Master sample</p><p>Assembly product</p></div>	<div>9</div> <div>Document reference/s:</div> <div>1. Refer to WI-QAD-QAC-252 Steering Electrical Test</div> <div>MASTER SAMPLE</div> <div></div> <div>1. No skip checking during inspection</div>	

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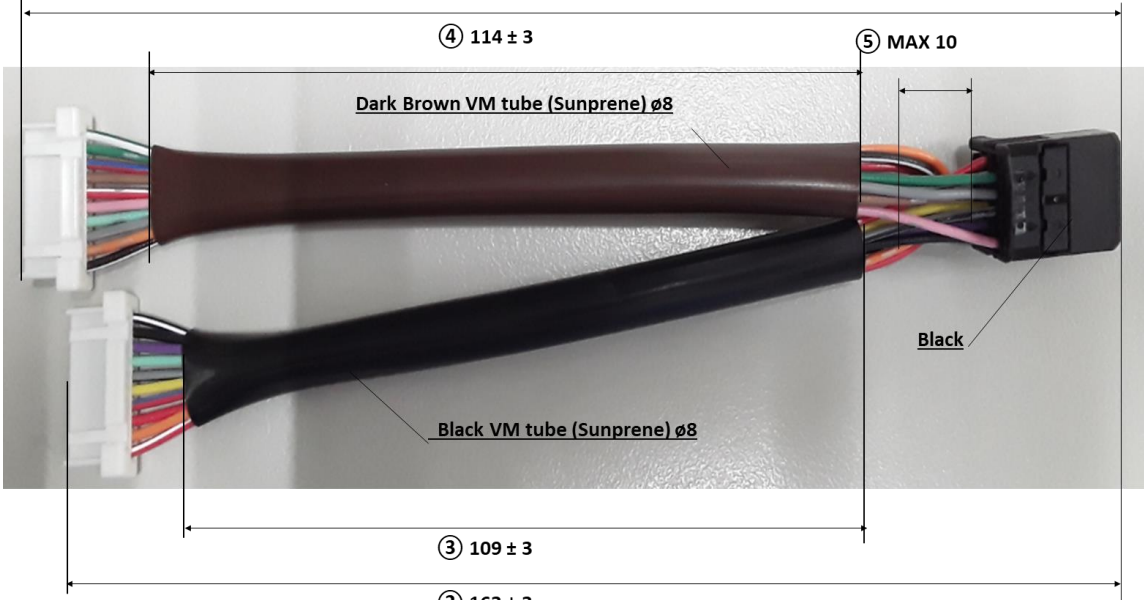
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME		<div>9</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
14	P1	Measurement	<div><div>MEASURING TAPE</div></div> <div><div>① 168 ± 3</div><div>④ 114 ± 3</div><div>⑤ MAX 10</div><div>③ 109 ± 3</div><div>② 163 ± 3</div><div>Dark Brown VM tube (Sunprene) ø8</div><div>Black VM tube (Sunprene) ø8</div><div>Black</div></div> <div>NOTE: *Unit of dimension is in millimeter (mm)</div>		<div>1. No wrong dimension.</div> <div><div>Important reminders and note/s:</div><div>1. Please use calibrated/verified measuring tape when getting the measurement.</div><div>2. For Hatsumono, Nakamono and Owarimono.</div></div> <div><div>Document reference/s:</div><div>1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div></div>

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Purpose:



PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

75N860-0021

1. Check the connector lock, should be unlock.

Black VM tube (Sunprene)

GOOD FACING

Brown VM tube (Sunprene)

GOOD FACING

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

3. Check the orientation of harness.

4. Check if no missing parts.

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

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