

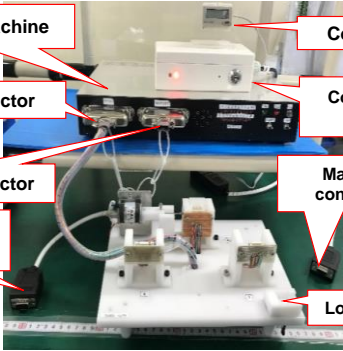


	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>November 15, 2023</b>		
	Process Name/Title: <b>STEERING ELECTRICAL TEST</b>				Validity Date:	n/a		
	Model code/Part number: <b>N/A / STEERING MODEL</b>		Customer: <b>TRJ</b>	Car Model: <b>N/A</b>	Document No.:	<b>WI-ENG-PDE-431</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.:	1 of 7



  

<b>PARTS:</b>	n/a			JIG:	1. Electrical Test Machine
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
1	n/a	<div> <div> <b>ELECTRICAL TEST MACHINE</b>    <b>BACK VIEW</b>    <b>FRONT VIEW</b> </div> <div>  </div> <div>   </div> <div> 1. Plug-in the tester jig connector to machine connector. </div> </div>		<div> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div> <b>Housekeeping</b>            1. Maintain and always practice 5's.            2. Personal things on the workplace is prohibited. Keep it in your locker.         </div> <div> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>	1. No loose attachment of plug.

Revision History						Prepared by	Reviewed by	Approved by	Noted by
11/15/23	2	Inclusion of Important reminders and update Electrical Testing process sequence due to customer claim countermeasure.	D.Castillo	C. Villanueva	A. Arañes	n/a			
06/30/23	1	Updated Template; Inclusion of CAR MODEL; Improve Work procedure illustration (page 4&5, process 4); Inclusion of Process for proper holding of AVSS wire with terminal part number Terminal (SPS-21T-205) and Terminal 115603-2 as countermeasure for customer claim of horn terminal. Refer to <b>ENGDRR-130</b> for the Document revision request.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes			
02/22/22	0	Initial issue	K. Doria	J. Loterte	C. Villanueva	A. Arañes			
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	February 22, 2023	

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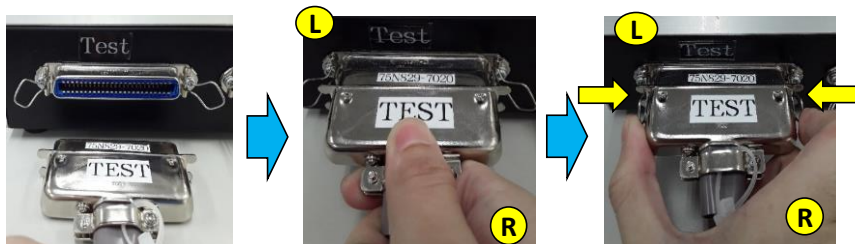


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Revision No.:

**2**

Page No.:

**2 of 7**

<b>PARTS:</b>	n/a			JIG:	1. Electrical Test Machine
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	n/a Machine Set-up (continuation)	<div></div> <div>2. Plug-in the Test Connector then lock both sides using both hands.</div> <div></div> <div>3. Plug-in the Master Connector then lock both sides using both hands.</div>		n/a	<div>1. No loose attachment of plug.</div> <div></div> <div><b>Important reminders/Note/s:</b></div> <div>1. Switch on the PSW, Push upward to Turn-ON the Machine.</div> <div>2. Use Inspection tester jig allocated per model.</div>

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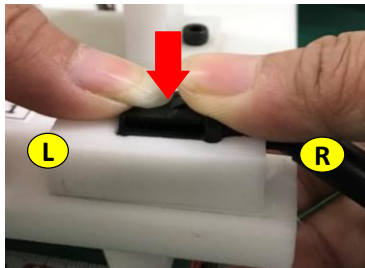
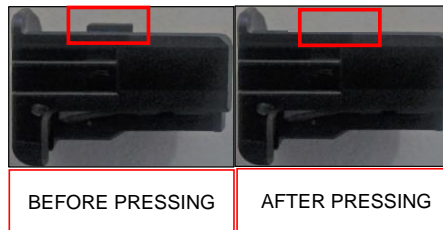

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Revision No.:

**2**

Page No.:

**3 of 7**

PARTS:	1. Assy part			JIG:	1. Electrical Test Machine 2. Locking jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
3	n/a	Connector Lock	<div><div>1. Put the connector into locking jig using right hand then press <b>2x</b> using both hands. Touch the connector lock to check if properly locked.</div></div> <div></div> <div><div>LOCKING JIG</div></div>			1. No unlocked/half-locked connector 2. No damaged lock  <b>Important reminders/note/s:</b> <i>1. Manual locking may cause damaged connector lock</i>

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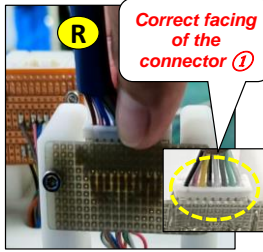
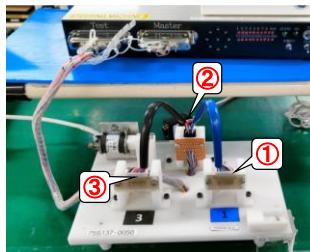
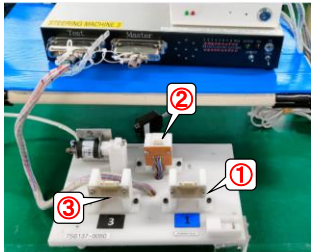
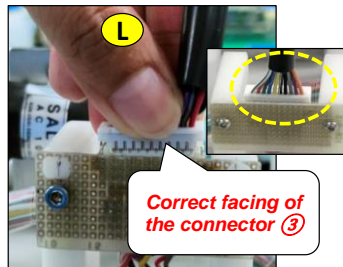
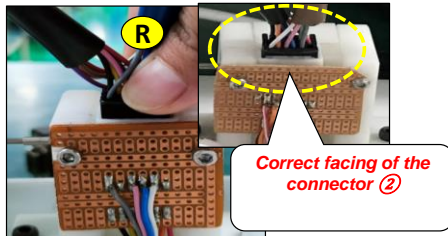
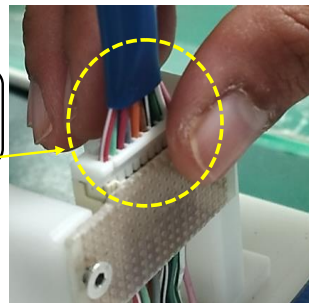
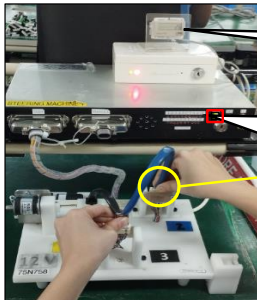

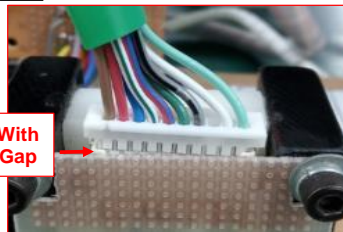
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Revision No.:

2

Page No.:

4 of 7

PARTS:	1. Assy parts		JIG:	1. Electrical Test Machine
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	n/a	<div><div><p>1. Hold the assy part, insert the white connector with VM tube (Sunprene) to location 1. <i>(Tube Color will depends on the model.)</i></p></div><div><p>2. Insert the black connector to <b>location 2</b>.</p></div><div><p>3. Insert the white connector with VM tube (Sunprene) to location 3. <i>(Tube Colors will depends on the model.)</i></p><p>4. <b>Off your fingers</b> from the assy part <b>during testing</b>.</p></div></div>	<div><p>2</p><p><b>Important reminders/note/s:</b></p><p>1. Conduct <b>STOP, CALLL, WAIT</b> if encounter abnormality on electrical tester jig. In case of electrical test <b>NG</b> alarm, leader should check affected unit by visual inspection prior retest.</p><p>2. Check proper insertion of connector to location 1,2, 3. Should have no gap.</p><p>2</p></div>	

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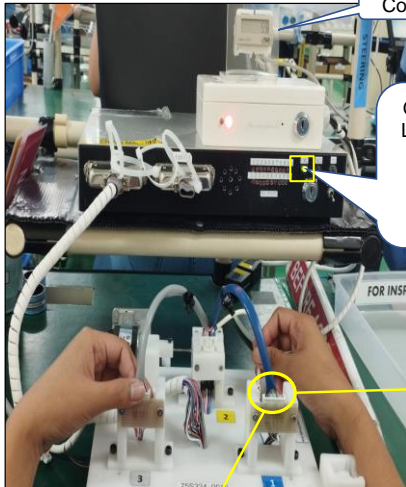
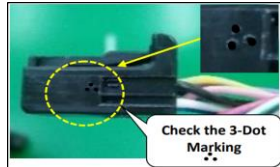
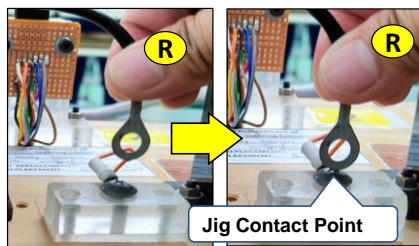
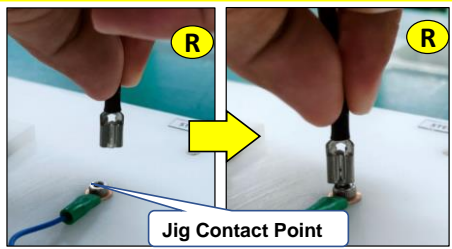
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Revision No.:

2

Page No.:


5 of 7

PARTS:		1. Assy parts		JIG:	1. Electrical Test Machine
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	n/a	<div><div><div><p>Counter</p><p>GREEN LED: Light indicator for good Product</p></div><div><p>Check the 3-Dot Marking</p></div><div><p>(TERMINAL PART NUMBER SPS-21T-205)</p></div><div><div><p>Jig Contact Point</p></div><div><p>(TERMINAL PART NUMBER 115603-2)</p></div></div><div><div><p>Jig Contact Point</p></div><div><p>1. Hold the tube (with AVSS wire) near terminal.</p></div><div><p>2. Place the tip of terminal on the top of the jig contact point. Make sure is on vertical position.</p></div><div><p>3. Check the machine judgement thru LED light indicator.</p></div><div><p>4. Check the Counter if the product is counted.</p></div><div><p>5. Check the PUNCH mark. Make sure it has 3 dots.</p></div><div><p>6. Remove the assy parts from the jig. (Note: Removal sequence is from location 3-2-1)</p></div><div><p>7. Continue the process after finish 1 box.</p></div></div></div><div><p>Electrical Testing (for models with AVSS wires with SPS-21T-205 and 115603-2 terminal)</p></div></div>		<p>1. If the Green LED turns on, this means that the machine judgment is verified correct.</p> <p>2. Should HAVE 3-dots marking appeared on the connector.</p> <p><b>Important reminders/Note/s:</b></p> <p>1. Applicable to models with AVSS wires with terminal part number as follows: a. SPS-21T-205 b. 115603-2</p> <p>2. Conduct <b>STOP, CALLL, WAIT</b> if encounter abnormality on electrical tester jig. In case of electrical test NG alarm, leader should check affected unit by visual inspection prior retest.</p> <p>3. Check proper insertion of connector to location 1,2, 3. Should have no gap.</p> <p>4. Refer to page 4 for proper holding and release of assy part during punch mark. For models with AVSS wires , hold assy parts on AVSS wires and connector 3</p>	

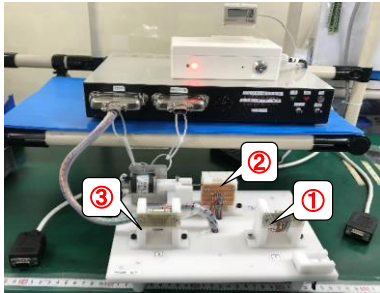
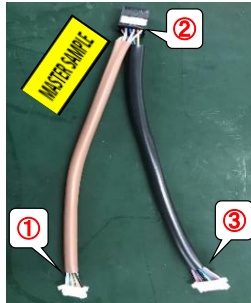
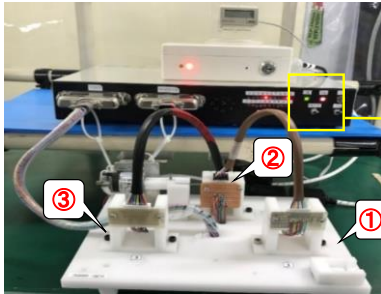


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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	2	Page No.:	6 of 7

PARTS:		n/a		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
5	n/a Verification of GOOD and NG SAMPLE	<div>   <div>1. Test the good sample every change model or start up of the model.</div> </div> <div>   <div>RED LED: Light indicator for NG product</div>  <div>2. Test the NG Dummy. Alarm will be heard.</div> </div>	n/a	1. No wrong facing of connector 2. No wrong insertion sequence  <b>Important reminders/note/s:</b> 1. Tube colors will depends on the model. 2. If the <b>Red LED turns on</b> , this means that the machine judgment is verified correct. 3. Should be <b>NO 3-dot</b> marking appeared on the connector.	

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**WI-ENG-PDE-431**

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Revision No.:

**2**

Page No.:

**7 of 7**

<b>PARTS:</b>	n/a			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
6	n/a	DIS-ASSEMBLE	<div><p>1. Release the lock of Tester connector using left and right thumb and pull to un-plug from the machine.</p><p>2. Release the lock of Master connector using left and right thumb and pull to un-plug from the machine.</p><p>3. Unplug the tester connector and machine connector.</p></div>		<div><p><b>Important reminders/note/s:</b></p><p>1. Switch off the PSW, Push downward to Turn-off the Machine.</p><p>2. DO NOT FORGET TO POWER OFF THE MACHINE BEFORE DISASSEMBLE.</p><p><b>Document reference/s:</b></p><p>1. Please refer to IS-PRO-ASY-041 for Steering Inspection after Electrical test.</p></div>

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