



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 10, 2023

Validity Date:

n/a

Model Code/Part Number:

D70B / 75S790-0280

Customer:

TRJ

Document No.:

WI-ENG-PDE-657

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

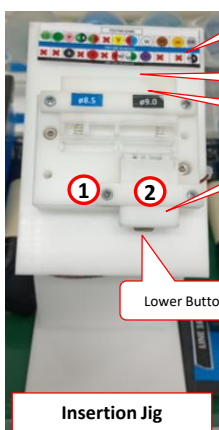


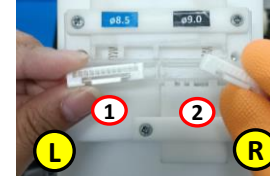
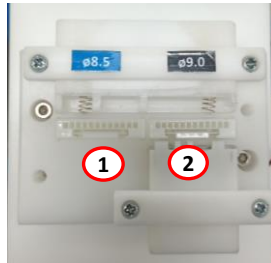
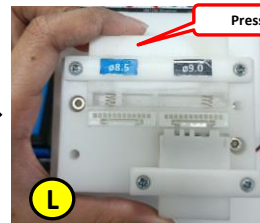

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PARTS:		1. Connector PBVP-12V-S (W) [2pcs]		JIG:	1. Insertion jig
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE
1	P1	Connector setting to insertion jig PBVP-12V-S (W)	<div><div><p>Visual reference</p><p>Upper Button</p><p>Upper guide</p><p>Lower guide</p><p>Lower Button</p><p>1</p><p>2</p><p>Insertion Jig</p></div><div><p>Connector orientation</p></div><div><p>L</p></div><div><p>1</p><p>2</p><p>L</p><p>R</p></div><div><p>1. Get the 2 pcs of PBVP-12V-S connector using left hand tranfer the 1 connector to right hand then insert to insertion jig. <i>Note: Follow the connector orientation.</i></p></div><div><p>1</p><p>2</p></div><div><p>Press</p><p>L</p></div><div><p>L</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> <div><div><p>Safety Instruction</p><p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p></div><div><p>Housekeeping</p><p>1. Maintain and always practice 5's.</p><p>2. Personal things on the workplace is prohibited. Keep it in your locker.</p></div><div><p>Alert level</p><p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p></div></div> <td><div>1. Use the provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div></td>		<div>1. Use the provided jig per model</div> <div>2. No wrong usage of parts</div> <div>3. No wrong orientation of connector</div> <div>4. No damaged connector</div>

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Established Date:	Prepared by:	Reviewed by:	Approved by:	Noted by:
06/10/23	2	Work instruction improvement from Genba check audit. Change from right hand to left hand (Page 4 and 8). Correct the VM tube color (Page 9-10)	D.Castillo	C. Villanueva	A. Arañes	n/a					
05/26/23	1	Change document from pre-launch to masspro. Provide insertion jig for wire insertion process.	D.Castillo	J. Loterte	C. Villanueva	A. Arañes					
03/24/23	0	Initial issue.	D.Castillo	J. Loterte	C. Villanueva	A. Arañes					
								D.Castillo	C. Villanueva	A. Arañes	n/a

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☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:

1. AVSS 0.3 wire LG L=169±2mm; G wire L=169±2mm; P wire L=308±2mm; G/B wire L=308±2mm; LG/R wire L=308±2mm; Y wire L=169±2mm; R/L wire L=308±2mm; W wire L=308±2mm; BR wire L=308±2mm; OR wire L=169±2mm; GR wire L=169±2mm
2. Blue VM tube (Sunprene) Ø8.5 L=125±3mm

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

2

P1

Wire insertion to Connector PBVP-12V-S (W)

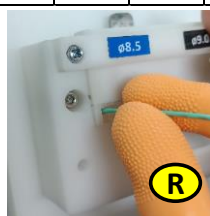
INSERTION SEQUENCE FROM LEFT TO RIGHT



Wire facing

WIRE INSERTION ILLUSTRATION

1	2	3	4	5	6	7	8	9	10	11	12
LG	G	P	G/B	LG/R	X	Y	R/L	W	BR	OR	GR
169	169	308	308	308		169	308	308	308	169	169



1. Get the **LG wire** using right hand then insert to connector. Repeat the process for **G-P-G/B-LG/R-Y-R/L-W-BR-OR-GR 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:

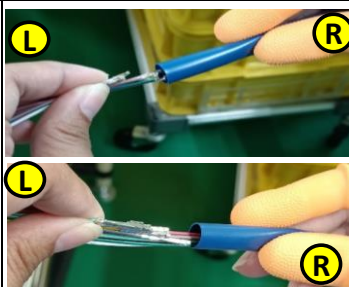
1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.
Do not exert extra force.
2. Please hold the wire near terminal during insertion.
3. Insertion of wire must be from left to right.

Important reminders/Note/s:

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 for Pull-Push procedure.

3

Wire insertion to Blue VM tube (Sunprene) Ø8.5 L=125±3mm



1. Get the **Blue VM tube (Sunprene) Ø8.5 L=125±3mm** using right hand. Hold the wires using left hand and insert the wires using right hand.

n/a

1. No wrong usage of parts
2. No deformed terminal
3. No tangled wires

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☐ PROTOTYPE

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PARTS:

1. AVSS 0.3 B wire L=169±2mm; R wire L=169±2mm; R/W L=169±2mm; W/G wire L=169±2mm; V wire L=169±2mm; GR/B wire L=169±2mm

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

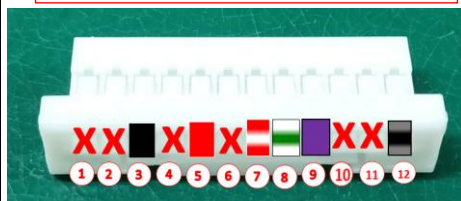
QUALITY POINTERS

4

P1

Wire insertion to Connector PBVP-12V-S (W)

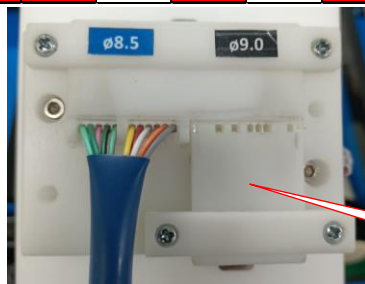
INSERTION SEQUENCE FROM LEFT TO RIGHT



Wire facing

WIRE INSERTION ILLUSTRATION

1	2	3	4	5	6	7	8	9	10	11	12
X	X	B	X	R	X	R/W	W/G	V	X	X	GR/B
		169		169		169	169	169			169



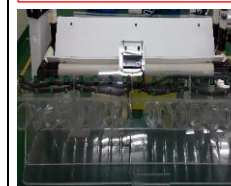
Note: Holes that need to be insert are only open.

Lower guide



1. Get the **B** wire using right hand and insert to connector slot 3. Repeat the process for **R-R/W-W/G-V-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. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
2. Please hold the wire near terminal during insertion.
3. Insertion of wire must be from left to right.

Document reference/s:

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-Push procedure.

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☐ PRE-LAUNCH

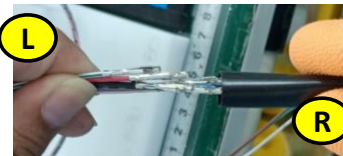
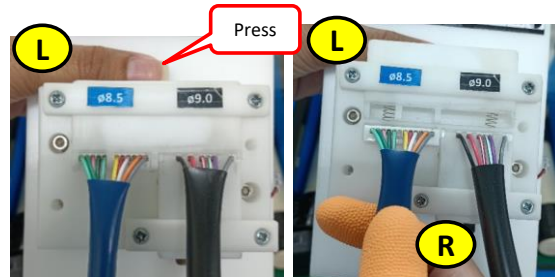
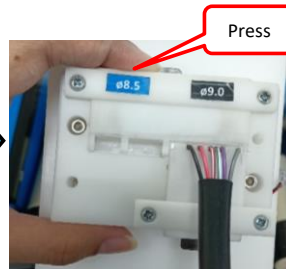
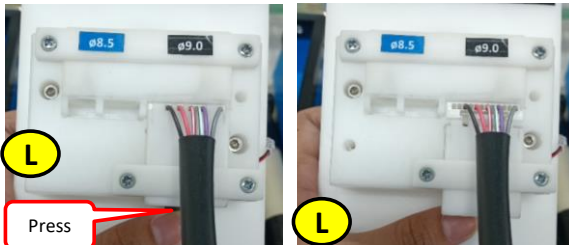
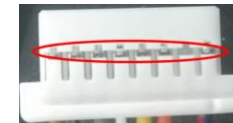
☒ MASSPRO

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PARTS:		1. Black VM tube (Sunprene) Ø9 L=125±3mm			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
5	P1	<div><div></div><div><div></div><div></div><div></div></div><p>1. Get the Black VM tube (Sunprene) Ø9 L=125±3mm using right hand. Hold the wire using left hand then insert the wires.</p><p>2. Press the Upper button using left hand. Remove the 1st connector with inserted wires and BlueVM tube (Sunprene) using right hand.</p><p>3. Press the upper guide using left hand. Check the wire insertion condition.</p><p>Note: Second connector with inserted wire and Black VM tube (Sunprene) will stay in the jig.</p><p>4. Press the lower button using left hand. Holes that need to be insert are only open.</p></div>			N/A	<p>1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires</p> <p>Document reference/s:</p> <p>1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.</p> <div></div> <p>Terminal tip must be visible</p>

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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

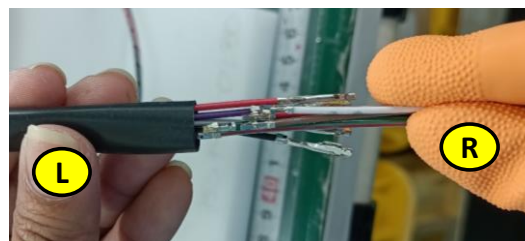
TOOLS/PPE

QUALITY POINTERS

6

P1

Wire insertion to assy parts



1. Hold the **Black VM tube (Sunprene)** using left hand and insert the wires from **Blue VM tube (Sunprene)** using right hand.



N/A

1. No wrong use of parts
2. No deformed terminal
3. No tangled wires

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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 Connector PBVP-12V-S (W)

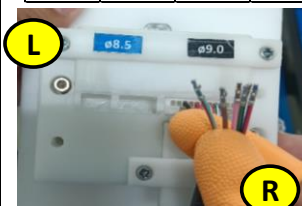
INSERTION SEQUENCE FROM LEFT TO RIGHT



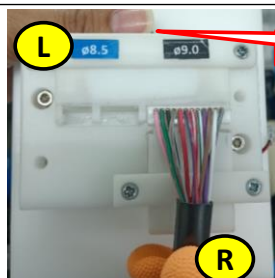
Wire facing

WIRE INSERTION ILLUSTRATION

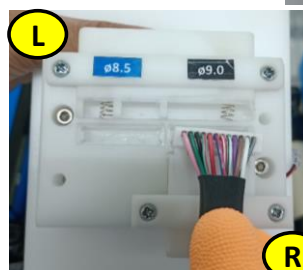
1	2	3	4	5	6	7	8	9	10	11	12
P	G/B	B	LG/R	R	R/L	R/W	W/G	V	BR	W	GR/B
308	308	169	308	169	308	169	169	169	308	308	169



1. Hold the **P** 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 **G/B-LG/R-R/L-BR-W** wires. Check the wire after insertion
Note: Follow the insertion sequence based on the above illustration.



Press



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. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion.
Do not exert extra force.
2. Please hold the wire near terminal during insertion.
3. Insertion of wire must be from left to right.

Document reference/s:

1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

8

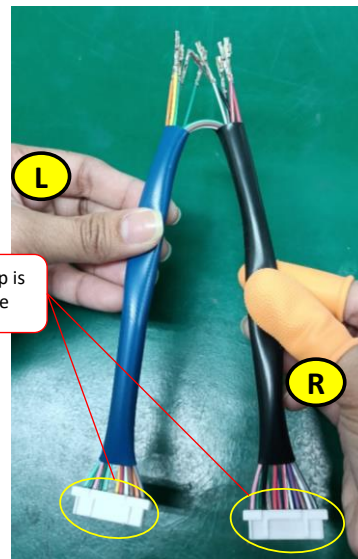
P1

Wire folding



BEFORE FOLDING

AFTER FOLDING



Terminal tip is not visible

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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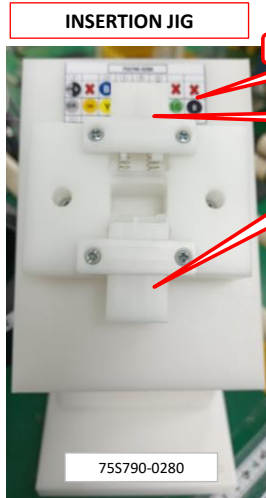
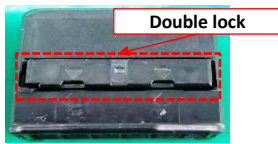
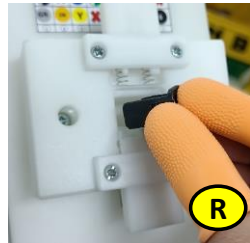
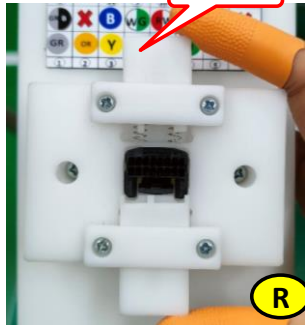
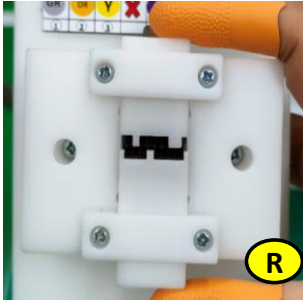
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PARTS:		1. Connector 1318386-2 (B)		JIG	1. Insertion jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1	Connector setting to insertion jig 1318386-2 (B)	<div><div>INSERTION JIG</div><div><div>75S790-0280</div></div><div><div>Visual reference</div><div>Upper guide</div><div>lower guide</div><div>CONNECTOR ORIENTATION</div><div></div><div><div>R</div></div><div><div>Press</div><div>R</div><div><div>R</div></div><div><div>1. Get the connector 1318386-2 (B) and insert to insertion jig using right hand. <i>Note: Follow the connector orientation</i></div></div><div><div>2. Press the upper and lower guide using hand hand (same timing). Holes that need to be insert are only open.</div></div></div><div>N/A</div><div><div>1. Use the provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div><div><div>CONNECTOR LOCK APPEARANCE CHECK</div><div><div>GOOD</div><div>UNLOCK</div></div><div><div>NG</div><div>HALF-LOCKED</div></div></div><div><div>Important reminders/Note/s:</div><div>1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</div><div>2. Check the connector before insertion.</div></div></div></div></div>			

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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

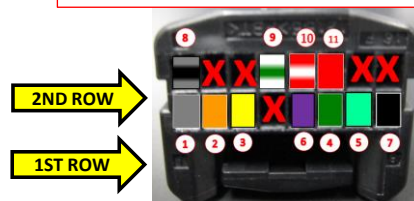
QUALITY POINTERS

10

P1

Wire insertion to Connector
1318386-2 (B)

INSERTION SEQUENCE FROM LEFT TO RIGHT



WIRE INSERTION ILLUSTRATION

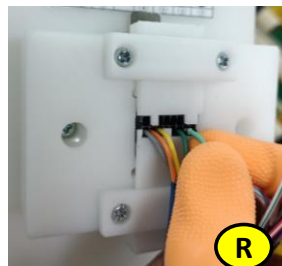
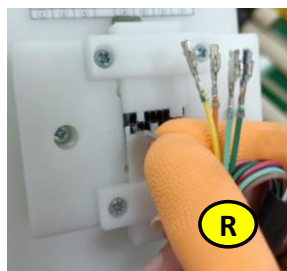
8				9	10	11		
GR/B	X	X		W/G	R/W	R	X	X
169				169	169	169		
1	2	3		6	4	5	7	
GR	OR	Y		V	G	LG	B	
169	169	169		169	169	169	169	



BLUE VM TUBE (SUNPRENE)



FIRST ROW (LEFT TO RIGHT)



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

Document reference/s:

1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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TAPING ASSEMBLY PROCESS

Effectivity Date:

June 10, 2023

Model Code/Part Number:

D70B / 75S790-0280

Customer:

TRJ

Document No.:

WI-ENG-PDE-657

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

2

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
1318386-2 (B)
(Continuation)

2

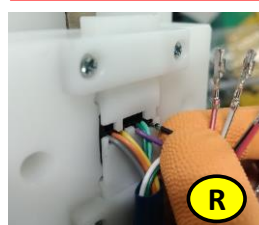
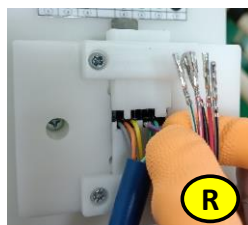
BLACK VM TUBE (SUNPRENE)



WIRE INSERTION ILLUSTRATION

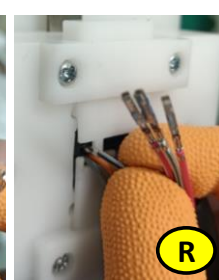
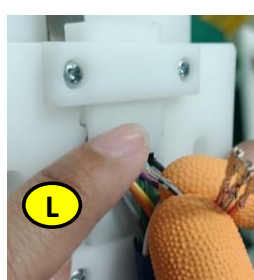
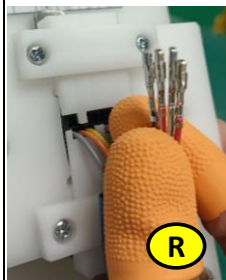
8			9	10	11		
GR/B	X	X	W/G	R/W	R	X	X
169			169	169	169		
1	2	3		6	4	5	7
GR	OR	Y	X	V	G	LG	B
169	169	169		169	169	169	169

FIRST ROW (LEFT TO RIGHT)



2. Hold the **V 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 **B wire**.
Note: Follow the insertion sequence based on the above illustration.

SECOND ROW (LEFT TO RIGHT)



3. Hold the **GR/B wire** using right hand and support the wire by left index finger then insert to terminal **slot 8** using right hand. Repeat the process for **W/G-R/W-R wires**.
Note: Follow the insertion sequence based on the above illustration.

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

Document reference/s:

1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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WORK INSTRUCTION

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TAPING ASSEMBLY PROCESS

Validity date	
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n/a

Model Code/Part Number: **D70B / 75S790-0280**

Customer: TRJ

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Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:

1. Assy parts

2. Brown (DBR) VM tube (Sunprene) Ø3 L=113±3mm

3. AVSS 0.5 L L=129±2mm

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

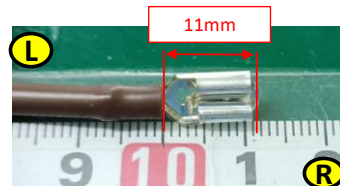
11

P1

Wire insertion to
Brown (DBR) VM tube
(Sunprene)
Ø3 L=113±3mm



1. Get the **Blue wire** using right hand and insert to **Brown (DBR) VM tube (Sunprene) Ø3 L=113±3mm.**



2. Measure the VM tube (Sunprene) up to the tip of the terminal, it should be **11mm**.



**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.**

n/a

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Purpose: ☐ PROTOTYPE

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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

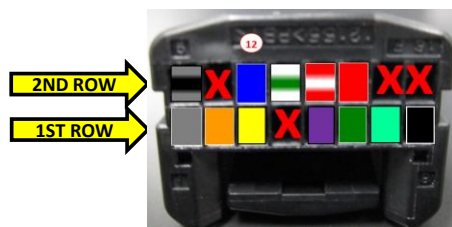
QUALITY POINTERS

10

P1

Wire insertion to connector
1318386-2 (B)
(Continuation)

INSERTION SEQUENCE FROM LEFT TO RIGHT



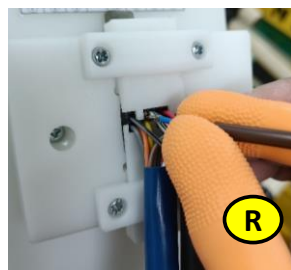
WIRE INSERTION ILLUSTRATION

8		12	9	10	11		
GR/B	X	L	W/G	R/W	R	X	X
169		129	169	169	169		
1	2	3		6	4	5	7
GR	OR	Y	X	V	G	LG	B
169	169	169		169	169	169	169

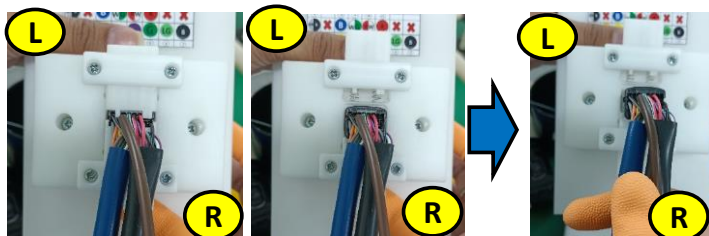


Wire facing

SECOND ROW (LEFT TO RIGHT)



4. Get the **L wire** using right hand and insert to terminal **slot 12** using right hand.
Note: Follow the insertion sequence based on the above illustration.



5. Press the upper guide and lower guide (same timing) using both hands then remove the assy part using right hand.

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.

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Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

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PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

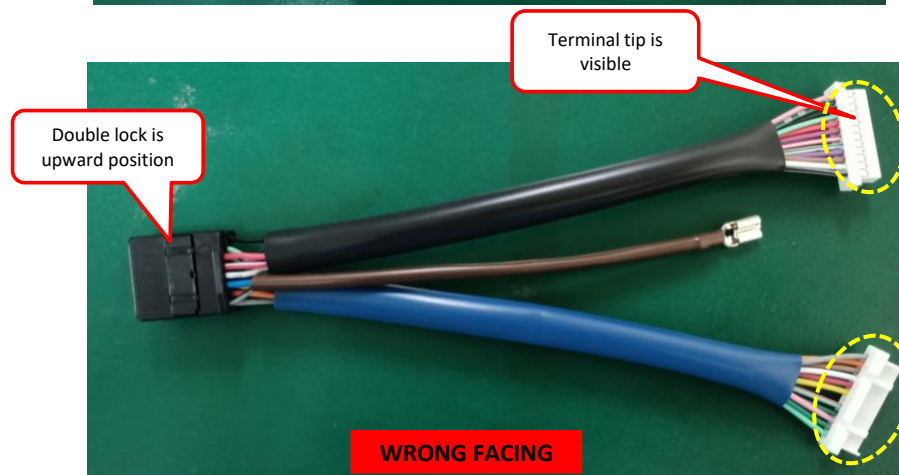
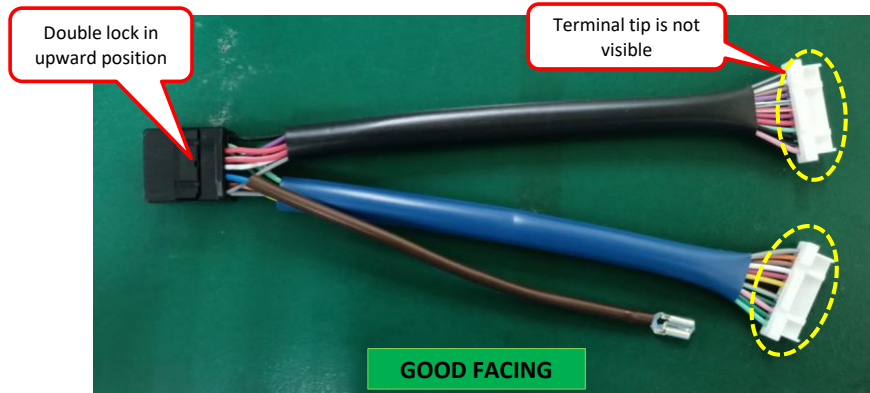
TOOLS/PPE

QUALITY POINTERS

11

P1

Wire arrangement



n/a

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

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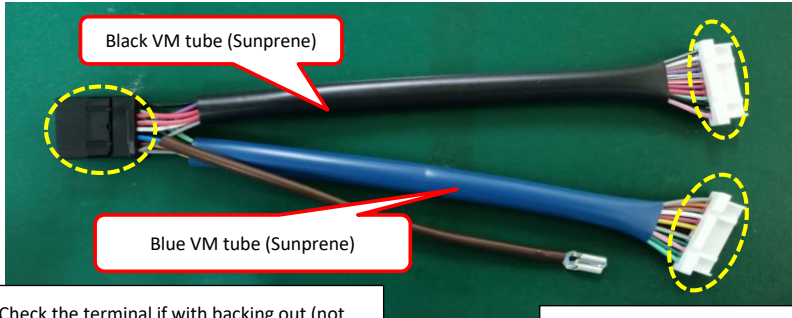
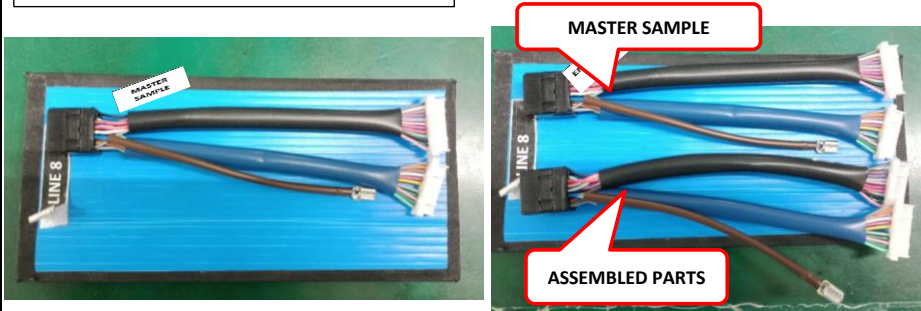

WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

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

Model Code/Part Number: **D70B / 75S790-0280** Customer: **TRJ**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

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	<div>1. Check the Connector lock, locking of connector is included to Steering electrical test.</div> <div>2. Check the wire alignment. Make sure no tangled wires.</div> <div>3. Check the presence of clamp attachment and band clamp cut condition.</div> <div></div> <div>4. Check the terminal if with backing out (not fully inserted) or deformed terminal.</div> <div>5. Check the orientation of harness.</div> <div>6. Compare to Master sample by tapping.</div> <div></div>			n/a	<p>Document References: 1. Refer to WI-ENG-PDE-431 for Steering Electrical Test after assembly.</p> <div>MASTER SAMPLE</div> 

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WORK INSTRUCTION

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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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2

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PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

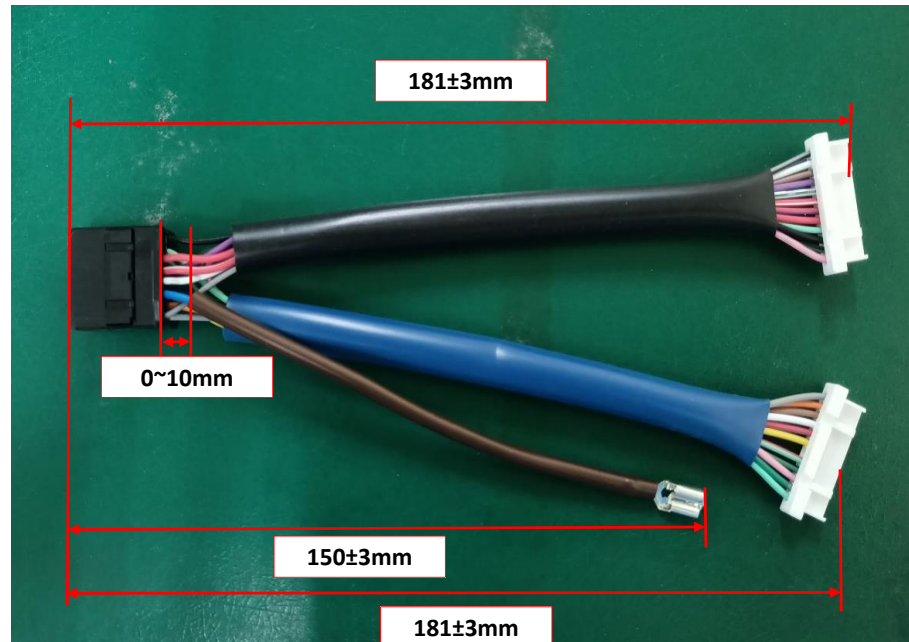
TOOLS/PPE

QUALITY POINTERS

13

P1

Measurement



Measuring tape



Important reminders/Note/s:

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

1. No wrong dimension.

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WORK INSTRUCTION
TAPING ASSEMBLY PROCESS

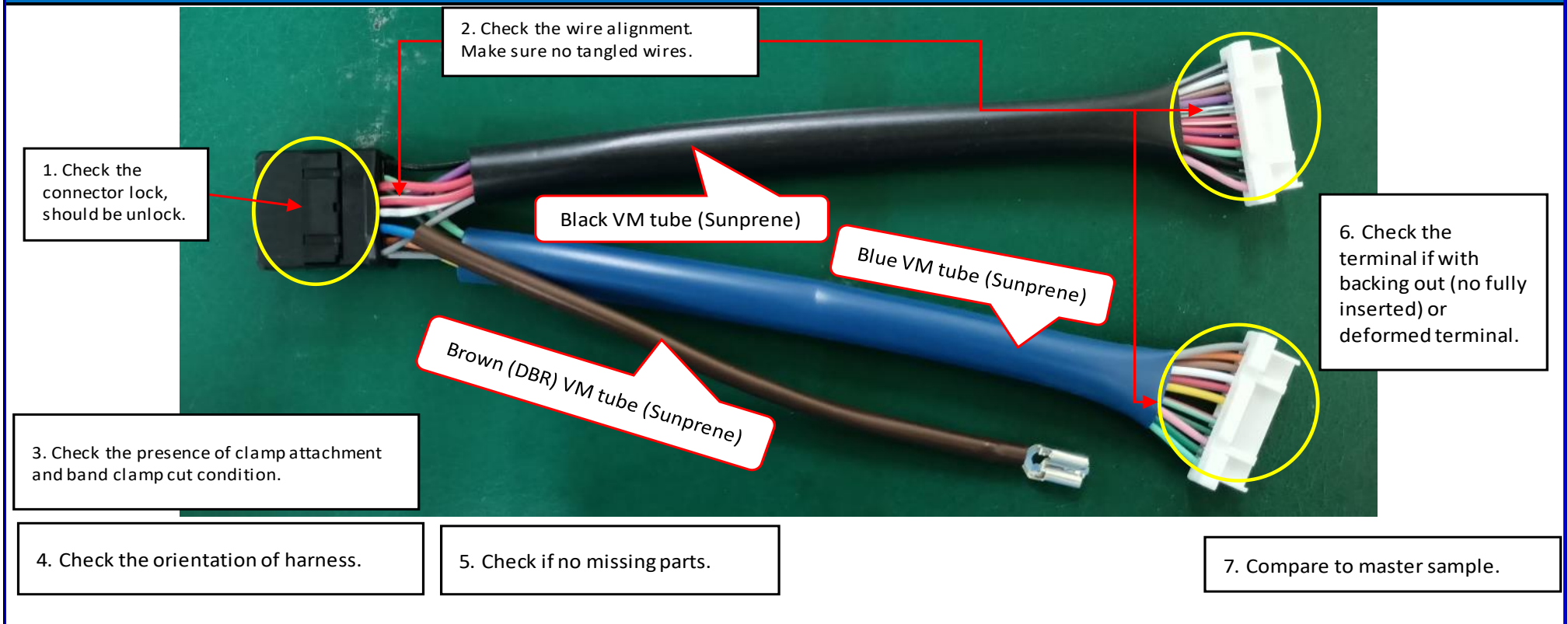
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Process Name/Title:	TAPING ASSEMBLY PROCESS		
Model Code/Part Number	D70B / 75S790-0280	Customer:	TRJ
Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		

PARTS:	n/a	JIG	n/a
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QUALITY CHECKPOINTS

75S790-0280



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