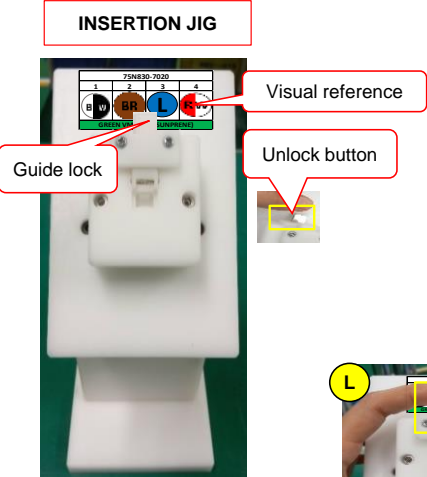
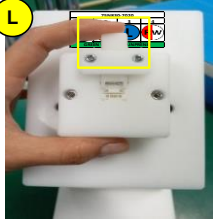
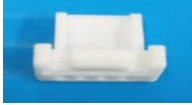
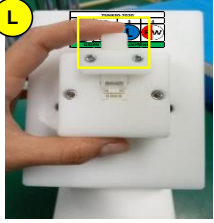
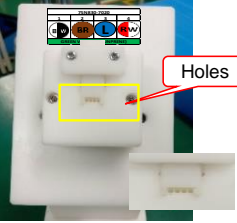
	<b>WORK INSTRUCTION</b>			Effectivity Date:	<b>April 16, 2024</b>		
	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>			Validity Date:	<b>n/a</b>		
	Model code/Part number: <b>Y2R/Y2K / 75N830 - 7020</b>		Customer: <b>TRJ</b>	Car Model: <b>SUZUKI - SOLIO</b>	Document No.: <b>WI-ENG-PDE-015</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		7	Page No.:	1 of 10

<b>PARTS:</b>		1. Connector PBVP-04V-S (W)		JIG:	1. Insertion jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
1	P1  Connector setting to Insertion jig PBVP-04V-S (W)	<div>    </div> <p>1. Get the connector <b>PBVP-04V-S (W)</b> and set it to jig using right hand. <i>Note: Follow the connector orientation.</i></p> <p>2. Press the lock guide using left index finger. You will notice the holes that needs to be inserted are only open.</p> <div>   </div>		<div> <p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the work place is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any troubled found, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective actions.</p> </div>	<p>1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p>	
Revision History				Prepared by	Reviewed by	Approved by
04/16/23	7	Improved insertion jig; Change connector (PBVP-04V-S) orientation, terminal orientation and color sequence as customer claim countermeasure. Inclusion of connector lock as countemeasure to DCS (DC-0623-115).		D.Castillo	C. Villanueva	A. Arañes
04/28/23	6	Inclusion of quality checkpoints; standardize VM tube (Sunprene) term.		J.Loterte	C. Villanueva	A. Arañes
11/18/22	5	Improve Quality Pointers; Reminders/notes and references on pages no.2,4,5,6,7 and 8 due to document improvements; Improve Work Procedure/illustration on process no.7- Visual/ By two's inspection due to process improvement.		M. Ariola	J.Loterte	C. Villanueva
Eff. Date	Rev. No	Details of Change		Revised	Reviewed	Approved
				Noted	Est. Date:	August 17, 2019

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## TAPING ASSEMBLY PROCESS

Effectivity Date:

April 16, 2024

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Model code/Part number:

Y2R/Y2K / 75N830 - 7020

Customer: TRJ

Car Model:

SUZUKI - SOLIO

Document No.:

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## PARTS:

1. AVSS 0.3 Red/White L=197±2mm ; Blue L=197±2mm; Brown L=197±2mm; Black/White L=197±2mm

JIG:

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

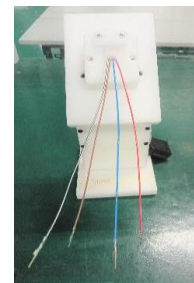
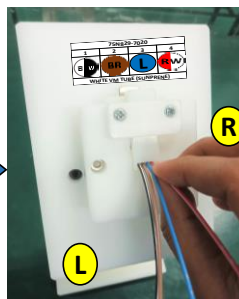
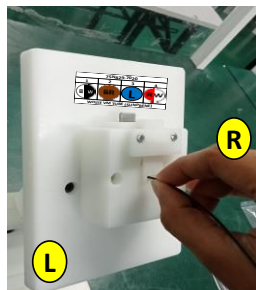
2

P1

Wire insertion to  
Connector  
PBVP-04V-S (W)INSERTION SEQUENCE FROM LEFT  
TO RIGHT

WIRE FACING

1	2	3	4
B/W	BR	L	R/W
197	197	197	197

STEERING  
NAVIGATION

CONTROLLER



1. No removed wires or wrong insertion
2. Must have slight movement after insertion
3. No stuck-up terminal tip
4. No deformed terminal

## Important reminders/Note/s:

1. Insertion of wire must be from left to right.
  2. 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 reference/s:

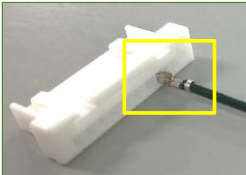
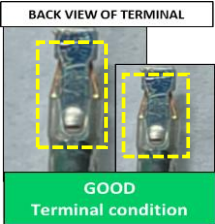
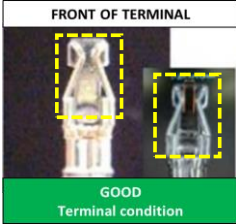

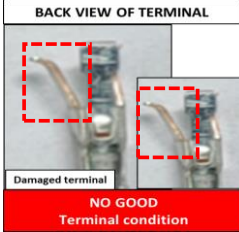
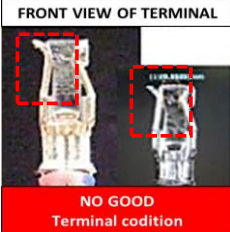
1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
3. Refer to WI-ENG-PDE-044 for steering navigation controller procedure.

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	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>Y2R/Y2K / 75N829-7020</b>		Customer: <b>TRJ</b>	Car Model: <b>SUZUKI-HUSTLER</b>	Document No.:	<b>WI-ENG-PDE-015</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	7	Page No.:	3 of 10

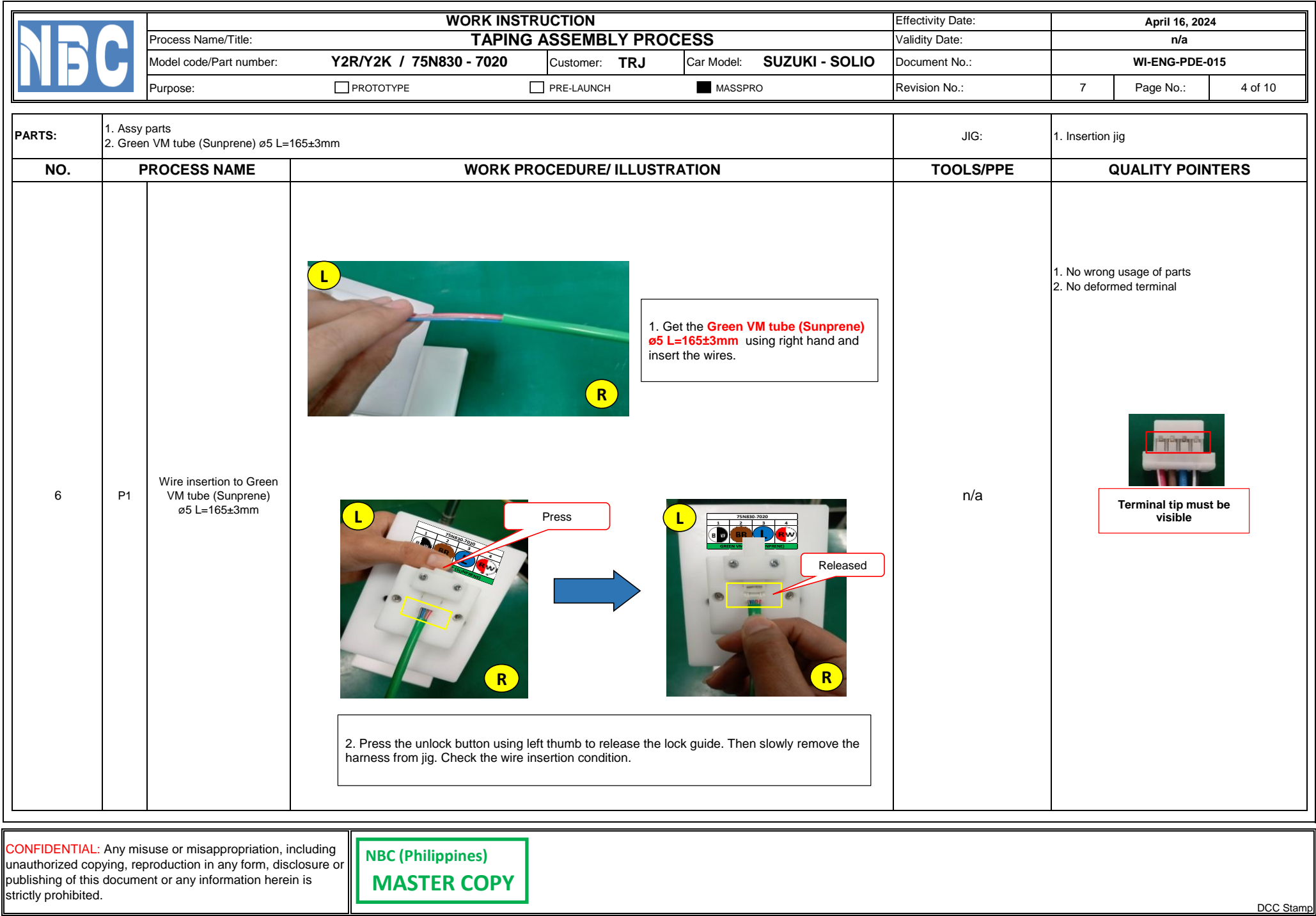
<b>PARTS:</b>	1. AVSS 0.3 R/W L=197±2mm; L L=197±2mm; BR L=197±2mm; B/W L=197mm±2mm		JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	P1 Wire insertion to connector PBVP-04V-S (W) (Continuation)	<div><div>Proper alignment of terminal to connector</div><div>BACK VIEW OF TERMINAL</div><div>GOOD Terminal condition</div><div>FRONT OF TERMINAL</div><div>GOOD Terminal condition</div></div> <div><div>Improper alignment of terminal to connector</div><div>BACK VIEW OF TERMINAL</div><div>Damaged terminal NO GOOD Terminal condition</div><div>FRONT VIEW OF TERMINAL</div><div>NO GOOD Terminal condition</div></div> <div>Note: <i>*Make sure the terminal was in proper alignment before insert.</i> <i>*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.</i></div>		<div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong insertion 4. No deformed terminal 5. No stuck of terminal tip 6. One by one insertion</div> <div>Important reminders/Note/s:</div> <div><i>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</i> <i>2. Please hold the wires near terminal during insertion.</i> <i>3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</i> <i>4. Insertion of wires must be from left to right.</i></div> <div>Document reference/s:</div> <div><i>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</i> <i>2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..</i> <i>3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i> <i>4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</i></div>


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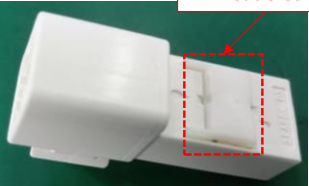
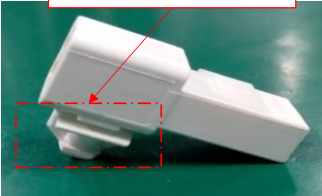
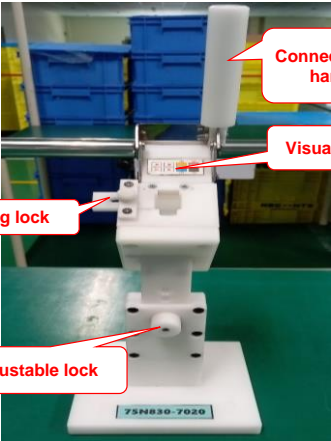
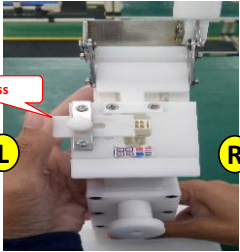
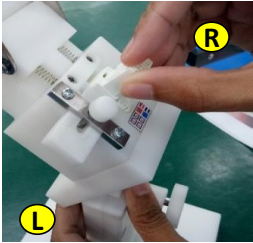


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	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a				
	Process Name/Title:		Model code/Part number: <b>Y2R/Y2K / 75N830 - 7020</b>		Customer: <b>TRJ</b>	Car Model: <b>SUZUKI - SOLIO</b>		Document No.:	<b>WI-ENG-PDE-015</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		7	Page No.:	5 of 10	

<b>PARTS:</b>		1. Connector 4B1080-0000 (W)		JIG:	1. Insertion jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>		
4	P1  Connector setting to insertion jig 4B1080-0000 (W)	<div><div><b>INSERTION JIG</b></div><div><b>Built in clamp</b></div><div><b>Double lock</b></div><div><b>CONNECTOR ORIENTATION</b></div><div><b>Press</b></div><div>1. Get the connector <b>4B1080-0000 (W)</b> and insert to jig using right hand. <b>Note: Follow the connector orientation.</b></div><div>2. Press the lock using left thumb after insertion.</div></div>	n/a	<div>1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</div> <div><b>Important reminders/Note/s:</b></div> <div>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.</div> <div><b>CONNECTOR LOCK APPEARANCE CHECK</b></div> <div><div><b>GOOD</b>      <b>NG</b></div><div><b>UNLOCK</b>      <b>HALF-LOCKED</b></div></div>		

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Model code/Part number:

Y2R/Y2K / 75N830 - 7020

Customer: TRJ

Car Model:

SUZUKI - SOLIO

Purpose:

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☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

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### PARTS:

1. Assy parts

JIG:

1. Insertion jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

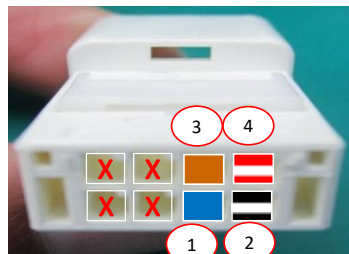
### TOOLS/PPE

### QUALITY POINTERS

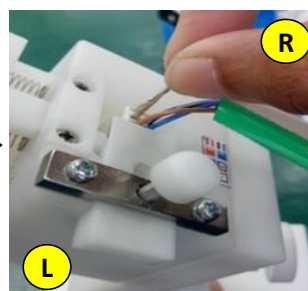
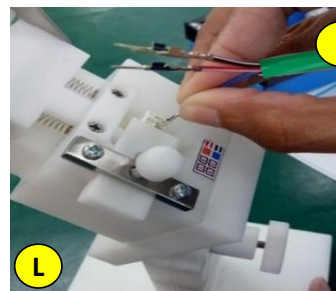
5

P1

Wire insertion to connector  
4B1080-0000 (W)



		3	4
X	X	BR	R/W
		197	197
		1	2
X	X	L	B/W
		197	197



1. Get the **L** wire and insert to terminal slot **1** using right hand.  
Repeat the process for **B/W-BR-R/W** wires.  
**Note: Follow the insertion sequence based on the illustration.**

n/a

1. No removed wires or wrong insertion
2. Must have slight movement after insertion
3. No stuck-up terminal tip
4. No deformed terminal

### Important reminders/Note/s:

1. Please hold the wire near terminal during insertion.
  2. Make sure wires are properly inserted.
- Conduct **Pull-Push-Pull-Push** after insertion.  
Do not exert extra force.

### Document 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.

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Effectivity Date:

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Model code/Part number:

**Y2R/Y2K / 75N830 - 7020**Customer: **TRJ**Car Model: **SUZUKI - SOLIO**

Document No.:

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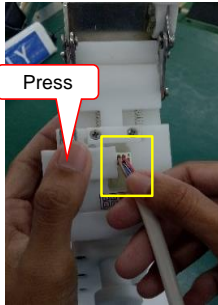
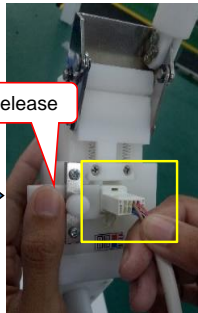
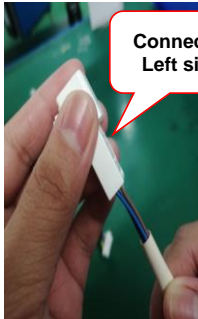



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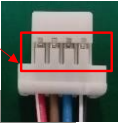
PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1  Connector lock	<div><div><div><div><div>Connector lock handle</div><div></div></div></div><div><div><div>Press</div><div></div></div><div><div><div>Release</div><div></div></div></div></div><div><div><div>1. Pull down the handle using right hand to lock the connector.</div></div><div><div><div>2. Press the unlock button to release the lock using left thumb. Then slowly remove the harness from jig. Check the lock if properly pressed.</div></div></div></div><div><div><div><div>7</div><div>Connector Left side</div><div></div></div><div><div><div>Connector Right side</div><div></div></div></div><div><div><div>3. Conduct visual checking of lock from side to side (Left to right).</div></div></div></div></div><div>n/a</div><div><div><div>1. Use the provided jig tool to lock the connector.</div><div>2. No unlock/half-locked connector</div></div><div><div>Important reminders/Notes/:</div><div>1. Manual locking may cause damaged connector lock.</div></div><div><div><div></div><div></div></div><div><div>BEFORE</div><div>AFTER</div></div></div></div></div></div>		

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	<b>Process Name/Title: TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>Y2R/Y2K / 75N830 - 7020</b>		Customer: <b>TRJ</b>	Car Model: <b>SUZUKI - SOLIO</b>	Document No.:	<b>WI-ENG-PDE-015</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	7	Page No.:	8 of 10

<b>PARTS:</b>		1. Assembled parts 2. Master sample		JIG:	N/A	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
7	P1 Visual Inspection/By Two's inspection	<div><div>1. Check the connector lock.</div><div>Green VM tube (Sunprene)</div><div>2. Check the wire alignmet. Make sure no tangled wires.</div><div>3. Check the terminal if with backing out (not fully inserted) or deformed terminal.</div><div></div></div> <div><div>MASTER SAMPLE</div><div>ASSEMBLED PARTS</div></div>			1. No skip checking during inspection.	


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	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Model code/Part number: <b>Y2R/Y2K / 75N830 - 7020</b>		Customer: <b>TRJ</b>	Car Model: <b>SUZUKI - SOLIO</b>	Document No.:		<b>WI-ENG-PDE-015</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		7	Page No.: 9 of 10

<b>PARTS:</b>		N/A		<b>JIG:</b>		N/A	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
8	Measurement	<div><div>226±3mm</div></div>				<div><b>Important reminders and note/s:</b> 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono and Owarimono.  <b>Document reference/s:</b> 1. Refer to <b>WI-PRO-ASY-056</b> for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension.</div>	
	P1						

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

April 16, 2024

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Model code/Part number:

Y2R/Y2K / 75N830 - 7020

Customer:

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Car Model:

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PARTS:

n/a

JIG:

n/a

### QUALITY CHECKPOINTS

## 75N830-7020

1. Check the connector lock.

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

Green VM tube (Sunprene)

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

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