



# WORK INSTRUCTION

Effectivity Date:

February 22, 2023

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number **D01L / 75N348-0021**

Customer:

TRJ

Document No.:

WI-ENG-PDE-099

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

7

Page No.:

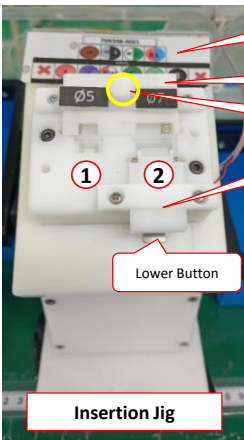
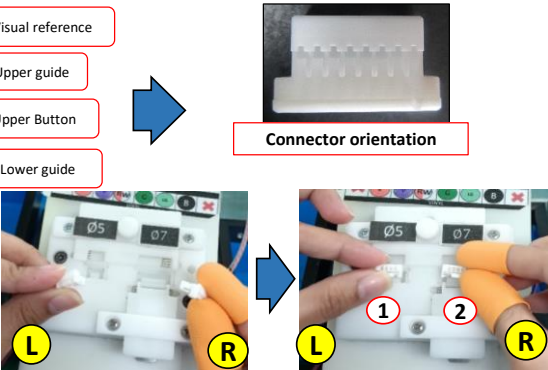
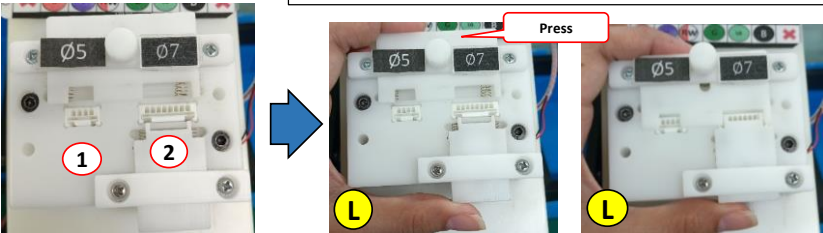
1 of 16

**PARTS:**





1. Connector PBVP-04V-S (W)
2. Connector PBVP-08V-S (W)

JIG:

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1  Connector setting to insertion jig PBVP-04V-S (W) PBVP-08V-S (W)	 <b>Insertion Jig</b>   <p>1. Get the 1 pc of <b>PBVP-04V-S</b> connector using left hand and get 1 pc of <b>PBVP-08V-S</b> connector using right hand then insert to insertion jig. <i>Note: Follow the connector orientation.</i></p> <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><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>	<ol style="list-style-type: none"><li>1. Use the provided jig per model</li><li>2. No wrong usage of parts</li><li>3. No wrong orientation of connector</li><li>4. No damaged connector</li></ol>

## Revision History

02/22/23	7	Improved the insertion jig and procedure. Improved work process/illustration. Update Quality checkpoints.	D. Castillo	C. Villanueva	C. Villanueva	A. Arañes	 D. Castillo	 C. Villanueva	 C. Villanueva	 A. Arañes
02/03/23	6	Inclusion of Quality checkpoints on pg.14. Improve work procedure/illustration on process no.13- Visual/By two's inspection.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
04/19/22	5	Improve process illustration and procedure.	K. Doria	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted				
			Established Date:				October 9, 2019			

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### PARTS:

1. AVSS 0.3 BR L=289±2mm; GR/B L=158±2mm; W/G L=158±2mm; R/L L=289±2mm
2. Black VM tube (Sunprene) Ø5 L=116±3mm

### JIG

1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS												
2	P1	Wire insertion to Connector PBVP-04V-S (W)	<div><div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div><div></div></div> <div><div>WIRE INSERTION ILLUSTRATION</div><table><tr><td>1</td><td>2</td><td>3</td><td>4</td></tr><tr><td>BR</td><td>GR/B</td><td>W/G</td><td>R/L</td></tr><tr><td>289</td><td>158</td><td>158</td><td>289</td></tr></table></div> <div><div><div>Wire facing</div></div><div></div></div> <div><div>1. Get the <b>BR wire</b> using left hand and transfer to right hand then insert to connector. Repeat the process for <b>GR/B-W/G-R/L wires</b>. Check the wire after insertion. <i>Note: Follow the insertion sequence based on the illustration.</i></div></div> <td><div><div>STEERING NAVIGATION</div><div></div></div><div><div>CONTROLLER</div><div></div></div></td> <td><div>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</div><div><b>Important reminders/Note/s:</b> <i>1. Please hold the wire near terminal during insertion.</i>  <i>2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</i></div><div><b>Document References:</b> <i>1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.</i> <i>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i> <i>3. Refer to GL-PRO-ASY-028 for Pull-Push procedure.</i></div></td>	1	2	3	4	BR	GR/B	W/G	R/L	289	158	158	289	<div><div>STEERING NAVIGATION</div><div></div></div> <div><div>CONTROLLER</div><div></div></div>	<div>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</div> <div><b>Important reminders/Note/s:</b> <i>1. Please hold the wire near terminal during insertion.</i>  <i>2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</i></div> <div><b>Document References:</b> <i>1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.</i> <i>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i> <i>3. Refer to GL-PRO-ASY-028 for Pull-Push procedure.</i></div>
		1	2	3	4												
BR	GR/B	W/G	R/L														
289	158	158	289														
3	Wire insertion to Black VM tube (Sunprene) Ø5 L=116±3mm	<div><div><div>L</div></div><div><div>L</div></div></div> <div><div><div>R</div></div><div><div>R</div></div></div> <div><div>1. Get the <b>Black VM tube (Sunprene) Ø5 L=116±3mm</b> using left hand and transfer to right hand. Hold the wires using left hand and insert the wires using right hand.</div></div> <td>N/A</td> <td><div>1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires</div></td>	N/A	<div>1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires</div>													

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### TAPING ASSEMBLY PROCESS

Model Code/Part Number

**D01L / 75N348-0021**

Customer:

**TRJ**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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**3 of 16****PARTS:**

1. AVSS 0.3 wires R L=161±2mm; V L=161±2mm; R/W L=161±2mm; G L=161±2mm; LG L=161±2mm; B L=161±2mm

**JIG**

1. Insertion jig

**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

4

P1

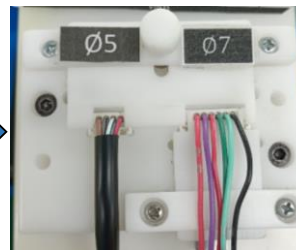
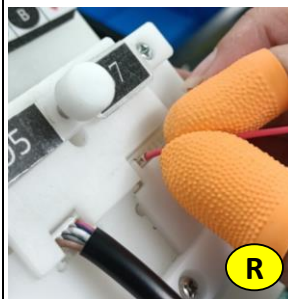
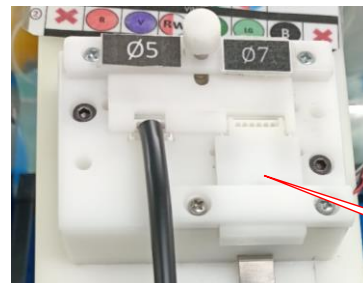
Wire insertion to  
Connector  
PBVP-08V-S (W)**INSERTION SEQUENCE FROM LEFT TO RIGHT****WIRE INSERTION ILLUSTRATION**

1	2	3	4	5	6	7	8
X	R	V	R/W	G	LG	B	X
	161	161	161	161	161	161	

**Wire facing**

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

Lower guide



1. Get the **R wire** using right hand and insert to connector. Repeat the process for **V-R/W-G-LG-B wires**. Check the wire after insertion.

Note: Follow the insertion sequence based on the above illustration.

**STEERING NAVIGATION****CONTROLLER**

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

**Important reminders/Note/s:**

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

**Document References:**

1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
3. Refer to GL-PRO-ASY-028 for Pull-Push procedure.

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☐ PROTOTYPE

☐ PRE-LAUNCH

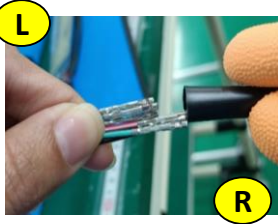
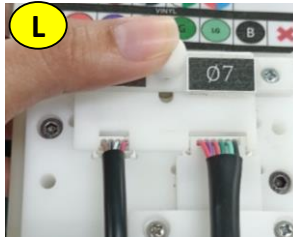
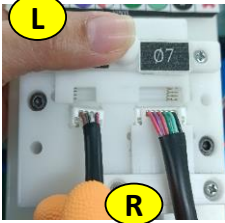

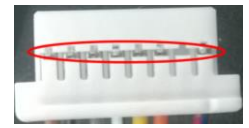
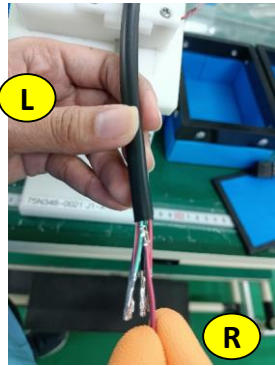

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PARTS:		1. Black VM tube (Sunprene) Ø7 L=119±3mm		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1	<div><div></div><div></div><div></div><div></div></div> <p>1. Get the <b>Black VM tube (Sunprene) Ø7 L=119±3mm</b> using right hand. Hold the wire using left hand then insert the wires.</p> <p>2. Press the Upper button using left hand.</p> <p>3. Remove the 1st connector with inserted wires and <b>Black VM tube (Sunprene)</b> using right hand then press the upper guide using left hand. Check the wire insertion condition.</p> <p>Note: Second connector with inserted wire and Black Sunprene tube will stay in the jig.</p>		N/A	<div><div>1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires</div><div></div><div>Terminal tip must be visible</div><div><b>Document References:</b> 1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.</div></div>
6		<div><div></div><div></div></div> <p>1. Hold the <b>Black VM tube (Sunprene)</b> using left hand and insert the wires from <b>Black VM tube (Sunprene)</b> using right hand.</p>		N/A	<div><div>1. No wrong use of parts 2. No deformed terminal 3. No tangled wires</div></div>

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**PARTS:**

1. Assy parts

**JIG**

1. Insertion jig

**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

7

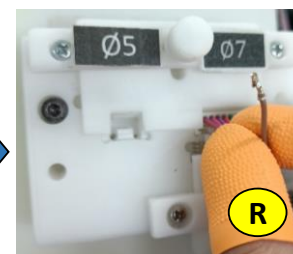
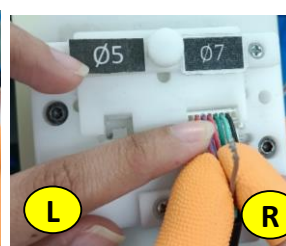
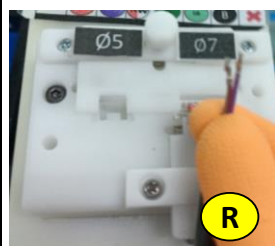
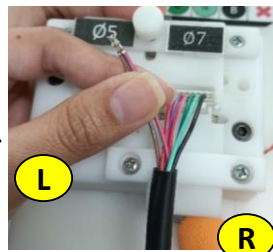
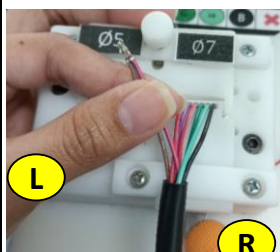
P1

Wire insertion to  
Connector  
PBVP-08V-S (W)**INSERTION SEQUENCE FROM LEFT TO RIGHT****WIRE INSERTION ILLUSTRATION**

1	2	3	4	5	6	7	8
R/L	X	X	X	X	X	X	BR
289							289

**Wire facing**

1. Press the Lower button using right hand. Holes that need to be insert are only open.



2. Hold the **R/L wire** using right hand and support the wire by left index finger then insert to connector using right hand. Repeat the process on **BR wire**. Check the wire after insertion  
*Note: Follow the insertion sequence based on the above illustration.*

**STEERING  
NAVIGATION****CONTROLLER**

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

**Important reminders/Note/s:**

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

**Document References:**

1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
3. Refer to GL-PRO-ASY-028 for Pull-Push procedure.

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Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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### PARTS:

1. Assy parts

### JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

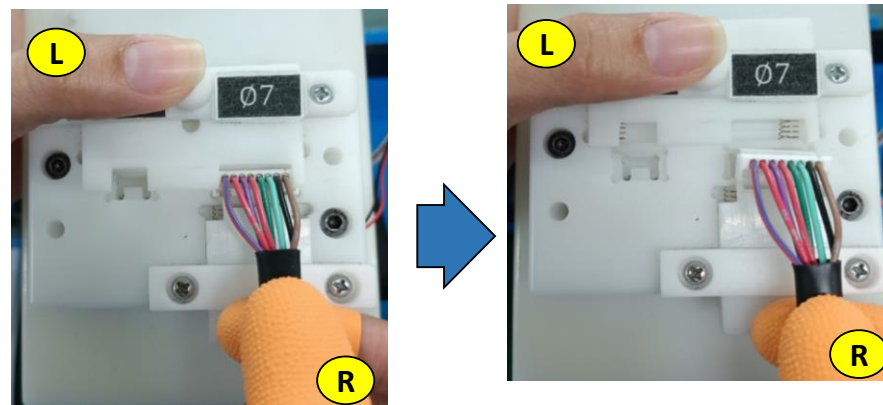
TOOLS/PPE

QUALITY POINTERS

7

P1

Wire insertion to  
Connector  
PBVP-08V-S (W)  
(Continuation)



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

N/A



**Terminal tip must be visible**

#### Document References:

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

1. No deformed terminals
2. No tangled wires
3. No wrong facing

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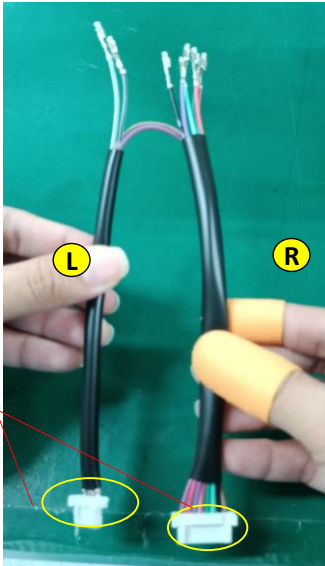
**WI-ENG-PDE-099**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1	Wire arrangement	<div></div> <div>BEFORE FOLDING</div> <div></div> <div>AFTER FOLDING</div> <div>1. Hold the assy parts using both hands then conduct wire arrangement.</div>	n/a	1. No deformed terminals 2. No tangled wires 3. No wrong facing

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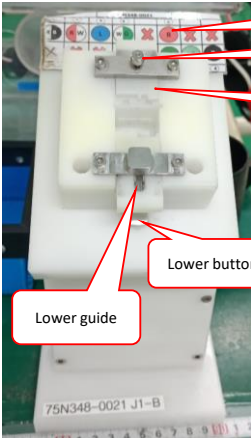
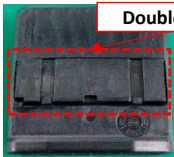


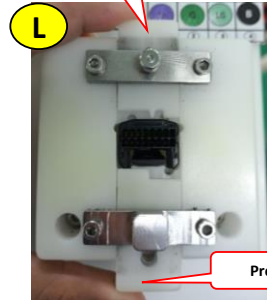

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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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	<div><div>INSERTION JIG</div><div></div><div></div><div>Connector Orientation</div><div></div><div></div><div>1. Get the connector <b>1318386-2 (B)</b> and insert to insertion jig using right hand. <i>Note: Follow the connector orientation</i></div><div></div><div>Press</div><div></div><div>Press</div><div>2. Press the upper and lower guide using left hand. Holes that need to be insert are only open.</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> <i>1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half- locked connector.</i></div> <div>CONNECTOR LOCK APPEARANCE CHECK</div> <div><div>GOOD</div><div>UNLOCK</div></div> <div><div>NG</div><div>HALF-LOCKED</div></div>

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**PARTS:**

1. Assy parts

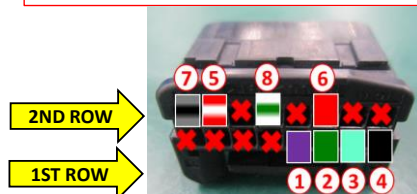
**JIG**

1. Insertion jig

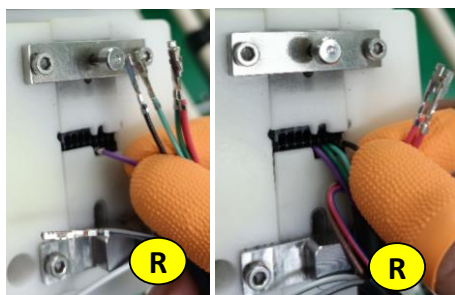
**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

10

P1

Connector setting to  
insertion jig  
1318386-2 (B)**INSERTION SEQUENCE FROM LEFT TO RIGHT**

Wire facing

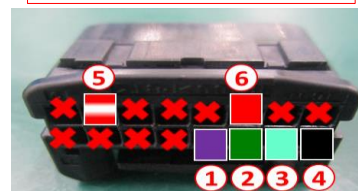
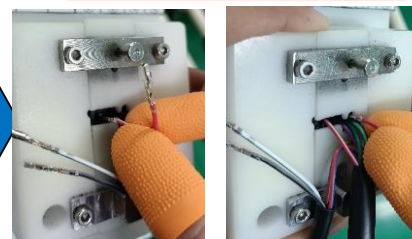
**FIRST ROW (LEFT TO RIGHT)**

1. Insert first the wires from **Black VM tube (Sunprene)**. Hold the **V wire** and insert to terminal slot 1 using right hand. Repeat the process for **G-LG-B wires**.

*Note: Follow the insertion sequence based on the illustration stated above.*

**WIRE INSERTION ILLUSTRATION**

7	5		8		6		
GR/B	R/W	X	W/G	X	R	X	X
158	161		158		161		
X	X	X	X	1	2	3	4
				V	G	LG	B
				161	161	161	161

**Black VM tube (Sunprene)****SECOND ROW (LEFT TO RIGHT)**

2. Hold the **R/W wire** and insert to terminal slot 5. Repeat the process for **R wire**.

*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. 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.
3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.

**Document References:**

1. Refer to GL-PRO-ASY-028 for Pull-Push procedure.
2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

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## WORK INSTRUCTION

Process Name/Title:

### TAPING ASSEMBLY PROCESS

Model Code/Part Number

**D01L****/****75N348-0021**

Customer:

**TRJ**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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**February 22, 2023**

Validity Date:

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Document No.:

**WI-ENG-PDE-099**

Revision No.:

**7**

Page No.:

**10 of 16****PARTS:**

1. Assy parts

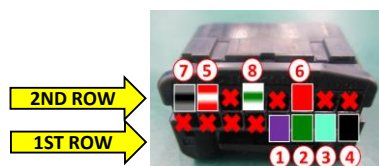
**JIG**

1. Insertion jig

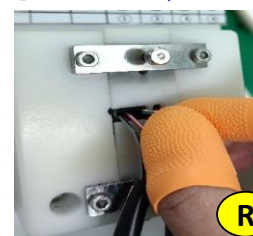
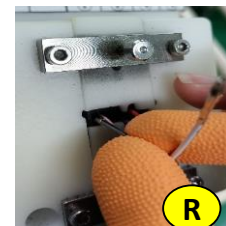
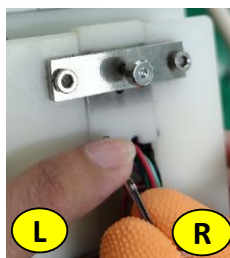
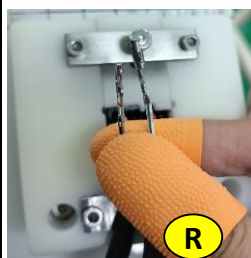
**NO.****PROCESS NAME****7****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

10

P1

Wire insertion to  
Connector  
1318386-2 (B)  
(Continuation)**INSERTION SEQUENCE FROM LEFT TO RIGHT****Wire facing****WIRE INSERTION ILLUSTRATION**

7	5	8	6
GR/B	R/W	W/G	R
158	161	158	161
X	X	X	X
1	2	3	4
V	G	LG	B
161	161	161	161

**Black VM Tube (Sunprene)****FIRST 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 7** using right hand. Repeat the process for **W/G wire**.

*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. 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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## WORK INSTRUCTION

### TAPING ASSEMBLY PROCESS

Process Name/Title:

Model Code/Part Numbe

**D01L****/****75N348-0021**

Customer:

**TRJ**

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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**7**



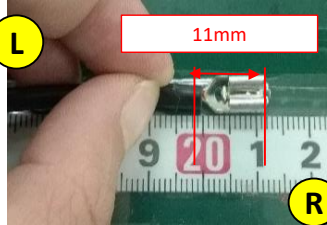




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**11 of 16****PARTS:**

1. AVSS 0.5 wire L=129mm
2. Black VM tube (Sunprene) L=113±3mm

**JIG**

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
11	P1  Wire insertion to Black VM tube (Sunprene) Ø3 L=113±3mm	<div></div> <div></div> <div><p>1. Get the <b>Blue wire</b> using right hand and insert to <b>Black VM tube (Sunprene) Ø3 L=113±3mm</b>.</p></div> <div></div> <div></div> <div><p>2. Measure the VM tube (Sunprene) up to the tip of the terminal, it should be <b>11mm</b>.</p></div> <div></div>	<div><b>MEASURING TAPE</b></div> <div></div>	<div></div> <div><p>Peel-off wire should be covered by Sunprene tube (White)</p></div> <div><p><b>Important Reminder/Note/s:</b></p><p><b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></p></div>

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## WORK INSTRUCTION

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Model Code/Part Number

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**12 of 16****PARTS:**

1. Assy parts

**JIG**

1. Insertion jig

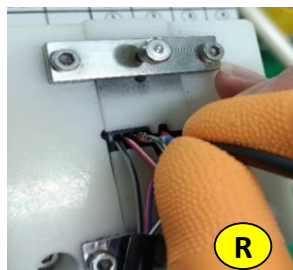
**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

12

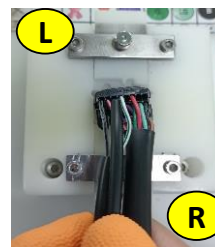
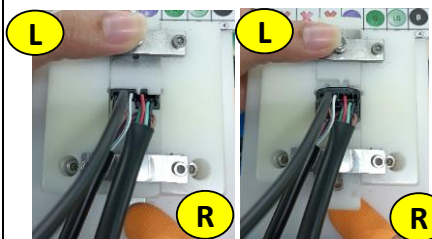
P1

Wire insertion to  
Connector  
1318386-2 (B)  
(Continuation)**INSERTION SEQUENCE FROM LEFT TO RIGHT****WIRE INSERTION ILLUSTRATION**

7	5	9	8		6		
GR/B	R/W	L	W/G	X	R	X	X
158	161	129	158		161		
X	X	X	X	1	2	3	4
				V	G	LG	B
				161	161	161	161

**Wire facing****FIRST ROW (LEFT TO RIGHT)**

4. Get the **L wire** using right hand and insert to terminal **slot 11** 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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Model Code/Part Number: **D01L / 75N348-0021**Customer: **TRJ**

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**PARTS:**

1. Assy parts

**JIG**

n/a

**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

13

P1

Wire Arrangement



1. Hold the harness using both hands. Arrange the wire properly to avoid tangled wires.  
*Refer to below illustration for Good wire arrangement and facing.*

GOOD ARRANGEMENT OF WIRES

CORRECT FACING

n/a

1. No wrong orientation of connector  
2. No tangled wires  
3. No wrong harness facing

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Purpose:

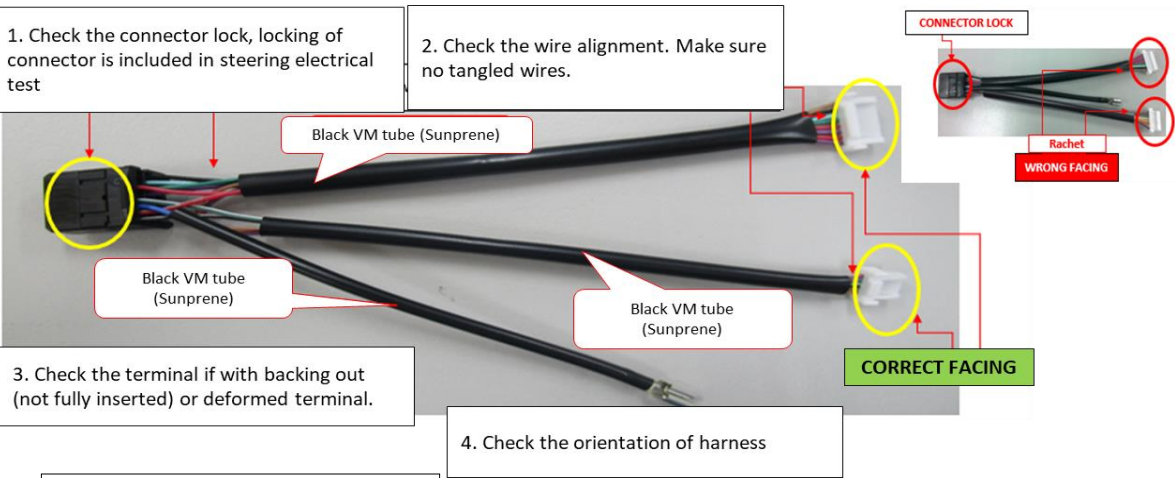
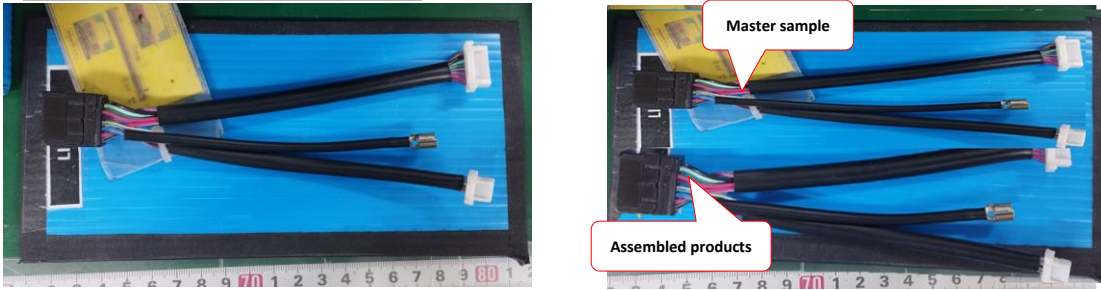


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PARTS:		1. Assembled parts 2. Master sample	JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
14	P1  Visual/By Two's Inspection	<div>1. Check the connector lock, locking of connector is included in steering electrical test</div> <div>2. Check the wire alignment. Make sure no tangled wires.</div> <div>3. Check the terminal if with backing out (not fully inserted) or deformed terminal.</div> <div>4. Check the orientation of harness</div> <div>5. Compare to <b>Master sample</b> by tapping.</div>  		<div><b>MASTER SAMPLE</b></div>  <div>1. No skip checking during inspection.</div> <div><b>Document References:</b> 1. Refer to WI-ENG-PDE-431 for Steering Electrical Test after assembly.</div>

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Model Code/Part Number: **D01L / 75N348-0021**

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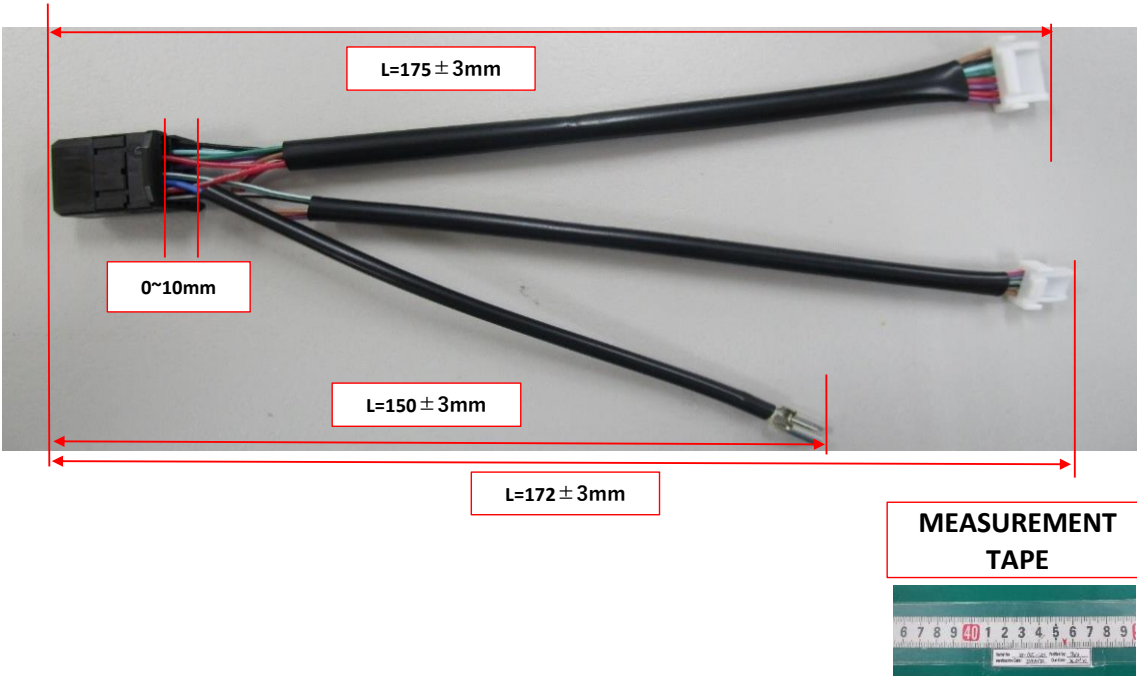
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		n/a		JIG	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
15	P1	Measurement	<div></div>		<p><b>Important reminders/Notes/:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. For Hatsumono and Owarimono.</p> <p>1. No wrong dimension</p>

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PARTS:

n/a

JIG

n/a



## QUALITY CHECKPOINTS

### 75N348-0021

1. Check the connector lock, should be unlock.

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

Black VM Tube (Sunprene)

Black VM Tube (Sunprene)

Black VM Tube (Sunprene)

FOLDED WIRES  
MUST BE IN  
BACK POSITION

3. Check the orientation of harness.

4. Check if no missing parts.

5. Check the terminal if with backing out (no fully inserted) or deformed terminal

6. Compare to master sample.

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