


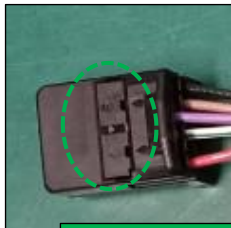

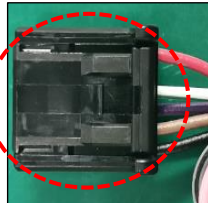







Process Name/Title: <b>REWORK PROCEDURE FOR WIRE FOLDING</b>		Document No:	<b>WI-ENG-PDE-748</b>
WORK INSTRUCTION		Effective Date:	<b>October 20, 2023</b>
Product Code/Name: <b>970B/75S063-0280A</b>	Customer Code: <b>TRJ</b>	Rev.No.: <b>0</b>	Page No.: <b>1 of 5</b>

No.	Work Procedure / Illustration		Records/Remarks/ Quality Pointers
1	Wire folding	<div><div></div><div><p>1. Hold the harness using both hands then conduct folding of harness going to the left side using left hand <i>(as illustrated above)</i></p></div><div></div><div><p>2. After folding, Check the facing and orientation of connector. <i>(See illustration below for the connector orientation)</i></p></div><div><div>CONNECTOR ORIENTATION</div><div><div></div><div></div><div><div>CORRECT FACING</div><div>WRONG FACING</div></div></div></div></div> <td><div>1. No wrong facing 2. No tangled wires</div></td>	<div>1. No wrong facing 2. No tangled wires</div>

								Prepared	Checked	Approved	Noted
10/20/2023	0	Initial issue	M. Ariola	C. Villanueva	A. Aranes	n/a					n/a
Eff./Rev. Date	Rev. No	Details of change	Prepared	Checked	Approved	Noted	Est. date: October 20, 2023				

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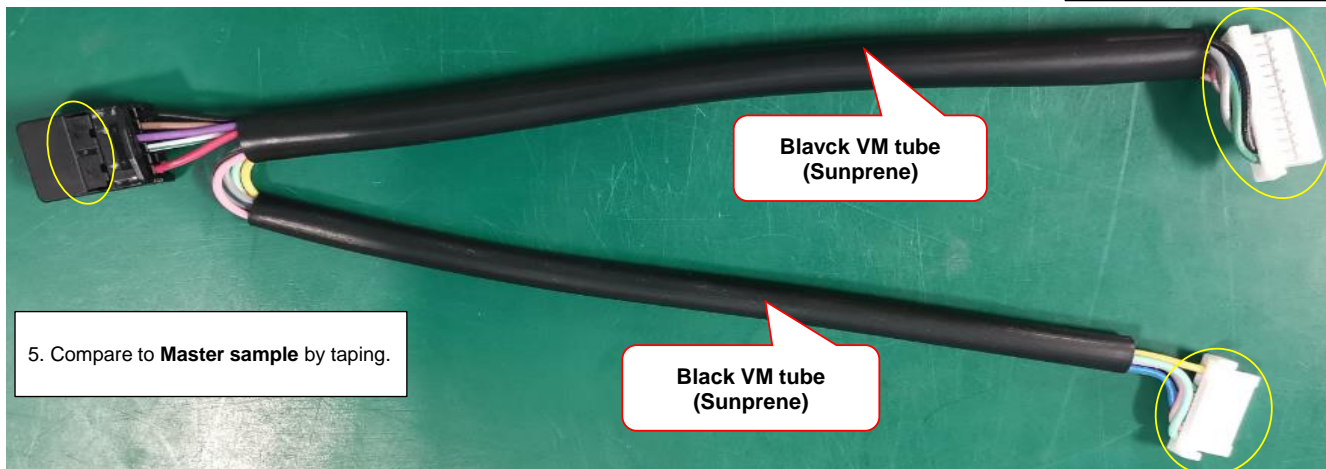
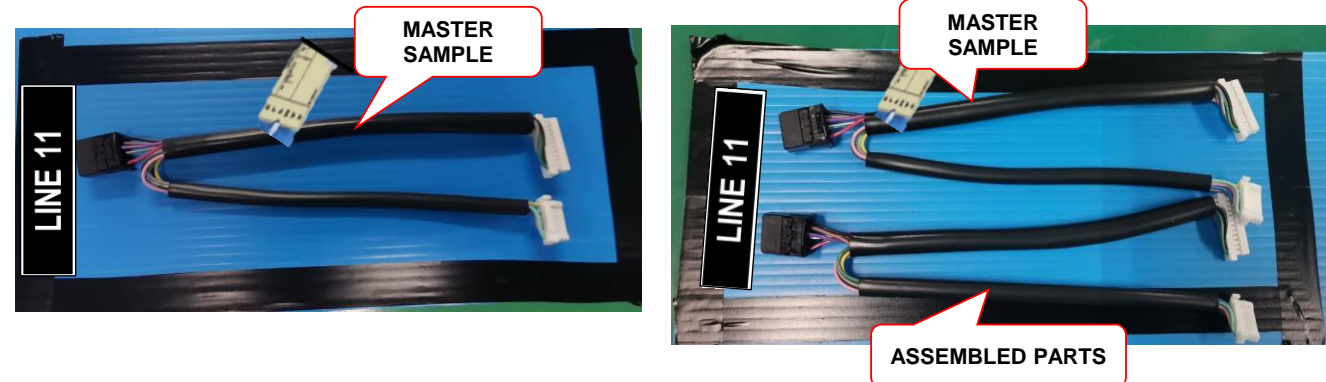



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No.	Work Procedure / Illustration		Records/Remarks/ Quality Pointers
2	Wire arrangement	<p>Double lock in upward position</p> <p>Terminal lance is visible</p> <p>Terminal lance is not visible</p> <p><b>CORRECT FACING</b></p> <p>Double lock in upward position</p> <p>Terminal lance is visible</p> <p>Terminal lance is visible</p> <p><b>WRONG FACING</b></p> <p><b>SIDE VIEW OF THE HARNESS</b></p>	1. No wrong facing 2. No tangled wires

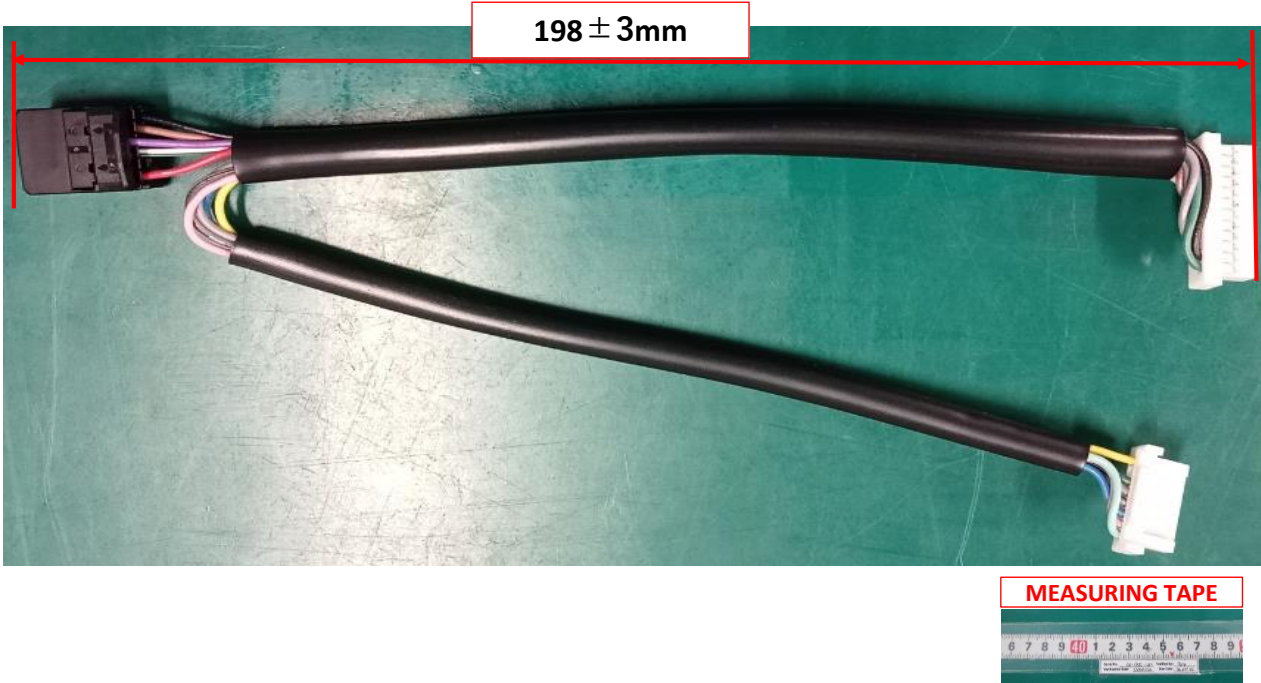


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No.	Work Procedure / Illustration		Records/Remarks/ Quality Pointers
3	Visual/By two's inspection	<div><div>1. Check the connector lock, lock of connector lock is included in electrical test.</div><div>2. Check the wire alignment. Make sure no tangled 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 taping.</div><div></div><div></div></div> <div><div>1. No wrong facing of harness.</div><div>2. No tangled wires</div><div>3. No missing parts.</div><div></div><div><b>Document reference/s:</b>  <b>1. Refer to WI-ENG-PDE-431 For steering electrical test after assembly.</b></div></div>	



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No.	Work Procedure / Illustration		Records/Remarks/ Quality Pointers
4	Measurement	 <p><b>198 ± 3mm</b></p> <p><b>MEASURING TAPE</b></p>	<p>1. No wrong dimension</p> <p><b>Important Reminders/Note/s:</b></p> <p><b>1. Please use calibrated/verified measuring tape when getting the measurement.</b></p> <p><b>2. For Hatsumono and</b></p>





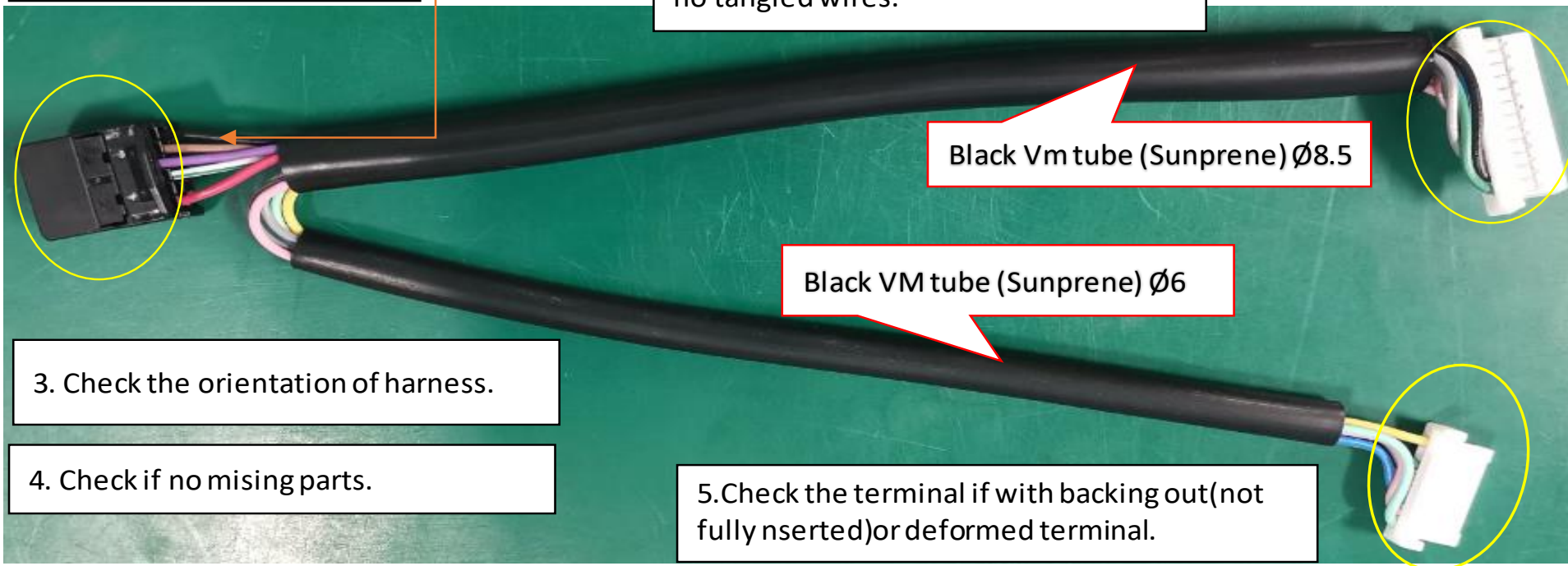
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No.	Work Procedure / Illustration	Records/Remarks/ Quality Pointers
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## 75S063-0280A

1. Check the connector lock.

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.