

	WORK INSTRUCTION				Effectivity Date:	June 3, 2024		
	TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Process Name/Title:				Document No.:	WI-ENG-PDE-373A		
	Model code/Part number: YKC / 7N0034-7020		Customer: TRJ	Car Model: SUZUKI SOLIO	Revision No.:	4	Page No.:	1 of 10
Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO						

PARTS:	4	1. Connector 7283-1020 (W); Connector 4G5400-0000(W); AVSSf 0.3 Y-OR wire L=450±3mm; Black corrugated tube ø7 L=344±3mm (no slit); Black corrugated tube ø5 L=357±1mm (no slit); AVSSf 0.3 B wire L=797±3mm; Black tape	JIG:	1. Insertion jig with switch cover 2. Pushing jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	Table Lay-out	<div style="border: 1px dashed red; padding: 5px;"> <p style="color: red; margin: 0;">Safety Instruction</p> <p style="margin: 0;">Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p style="color: red; margin: 5px 0 0 0;">Housekeeping</p> <p style="margin: 0;">1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p style="color: red; margin: 5px 0 0 0;">Alert level</p> <p style="margin: 0;">For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>	<p style="color: red; margin: 0;">Document reference/s:</p> <p style="color: red; margin: 0;">1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</p> <p style="margin: 10px 0 0 0;">1. No missing parts/tools 2. No excess parts/tools</p>
<div style="border: 1px solid red; padding: 5px; margin: 0 auto; width: 150px;">TABLE LAY-OUT</div>				

Revision History						Prepared by	Reviewed by	Approved by	Noted by	
06/03/24	3	Transfer Wire insertion to COT (assy parts). Wire insertion to connector and Connector lock process to P2 (WI-ENG-PDE-373B) due to process improvement. Inclusion of car model "SUZUKI SOLIO". Update Table lay-out and improved Visual inspection/Quality checkpoints. Aligned COT lenght from cutting ledger. Change COT to terminal dimension from 57±1mm to 58±1mm due to COT change (Customer claim countermeasure).	D.Castillo	C.Villanueva	A. Arañes	N/A	 D. Castillo	 C. Villanueva	 A. Arañes	
06/09/23	3	Inclusion of quality checkpoints.	J.Loterte	C.Villanueva	A. Arañes	n/a				
08/12/22	2	Additional note in process 1 and process 10, procedure 2. Improve work procedure in process 5 and process 12; process 13 procedure 2. Change of taping measurement in process 10 rom 35+3/-3mm to 35+3/-1mm as countermeasure of encountered customer claim. Improve quality pointers and notes.	M.Catapan g	J.Loterte	C.Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted	Est. Date: November 20, 2021

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TAPING ASSEMBLY PROCESS

Effectivity Date:

June 3, 2024

Validity Date:

n/a

Model code/Part number:

YKC / 7N0034-7020

Customer:

TRJ

Car Model:

SUZUKI SOLIO

Document No.:

WI-ENG-PDE-373A

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

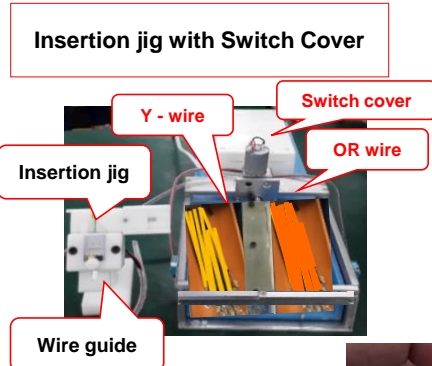

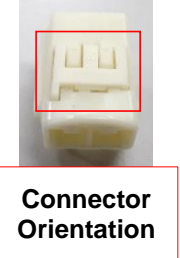
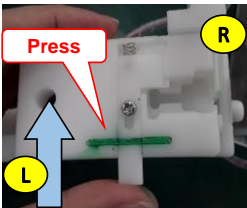
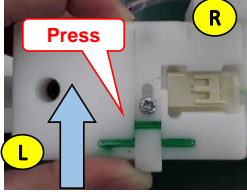

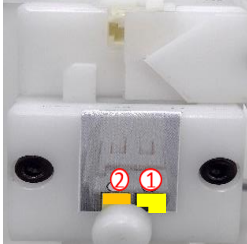
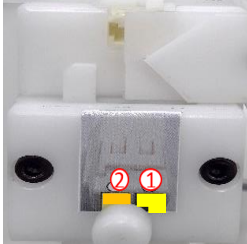


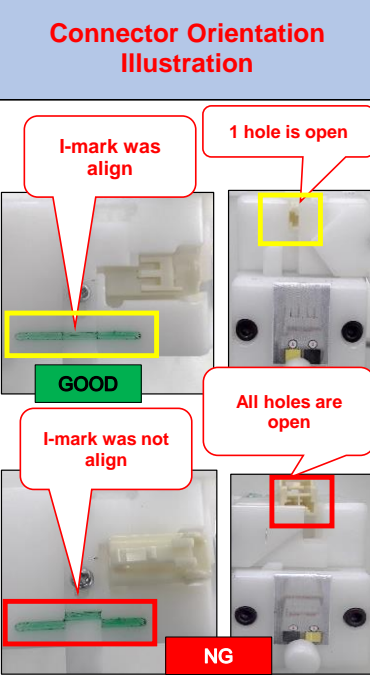
☒ MASSPRO

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PARTS:		1. Connector 7283-1020 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<p>Connector Setting to Insertion Jig 7283-1020 (W)</p>      <p>2. Insert the connector 7283-1020 into jig using right hand and release the lock. Note: Follow the connector orientation</p>  <p>1. Press the lock of insertion jig using left thumb.</p>  <p>3. Check the holes/terminal slot for Y wire.</p>  <p>CONNECTOR ILLUSTRATION</p>  		N/A	 <p>1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector</p>

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

June 3, 2024

Model code/Part number:

YKC / 7N0034-7020

Customer: TRJ

Car Model:

SUZUKI SOLIO

Document No.:

WI-ENG-PDE-373A

Purpose:


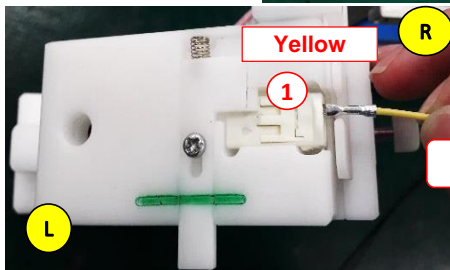
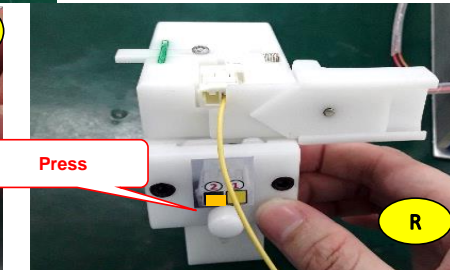
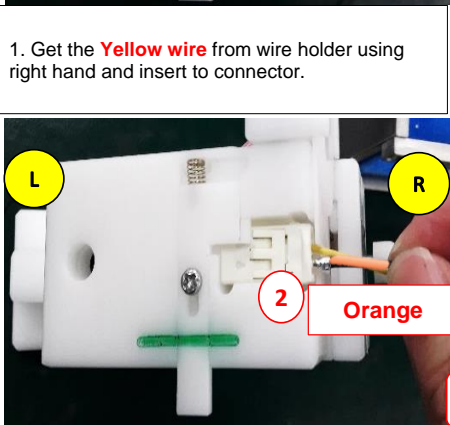
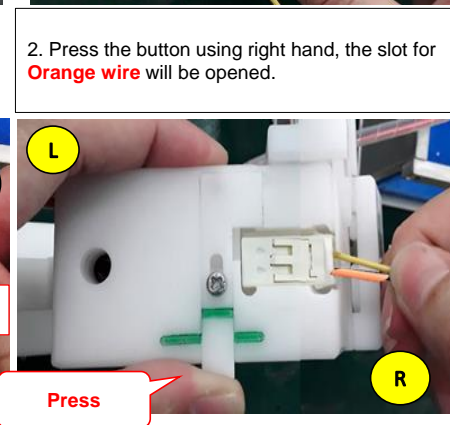
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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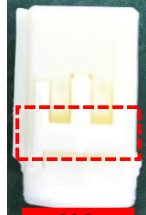
PARTS:		1. Connector 7283-1020 (W) 2. AVSSf 0.3 Y-OR wire L=450±3mm		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to connector 7283-1020 (W)	<div><div><div>Wire facing</div></div><div><div>Yellow</div><div>1</div><div>Press</div><div>1. Get the Yellow wire from wire holder using right hand and insert to connector.</div></div><div><div>2. Press the button using right hand, the slot for Orange wire will be opened.</div></div><div><div>Orange</div><div>2</div><div>Press</div><div>3. Get the Orange wire and insert to connector using right hand.</div></div><div><div>4. After insertion, press the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</div></div></div>		n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>Important reminders/Note/s: <i>1. Please hold the wire near terminal.</i> <i>2. Make sure wires are properly inserted.</i> <i>Conduct Pull-Push-Pull-Push after insertion.</i> <i>Do not exert extra force.</i></div> <div>Document references: <i>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i> <i>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></div>

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	Model code/Part number: YKC / 7N0034-7020		Customer: TRJ	Car Model: SUZUKI SOLIO	Document No.:	WI-ENG-PDE-373A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	4	Page No.:	4 of 10


PARTS:	1. Assy parts			JIG:	1. Pushing jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	<div><div>LOCKING SEQUENCE</div><div></div><div>1. Place the connector on the table while holding using left hand. Get the pushing jig using right hand and start the sequential locking based on above illustration. Push the lower part of the connector lock first and then push the upper part <i>Position of pushing jig during locking must be slant.</i></div><div><div></div><div><div>AFTER LOCKED CONDITION</div><div></div><div>GOODNG</div></div></div></div>		<div><div>PUSHING JIG</div></div>	1. No unlocked/half-locked connector 2. No damage connector

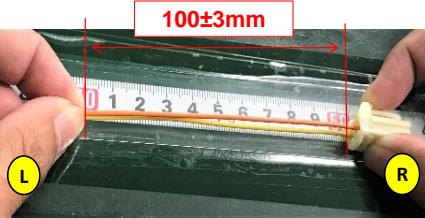
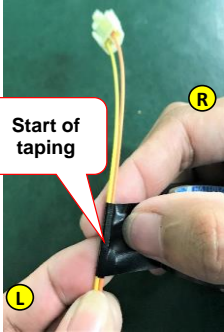
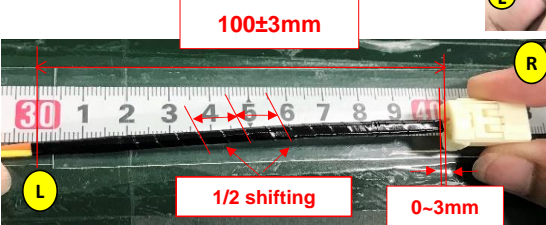
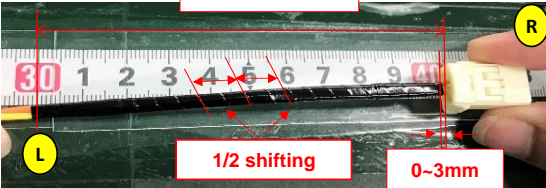


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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	4	Page No.:	5 of 10

PARTS:	1. Assy parts 2. Black tape 3.Black corrugated tube ø7 L=344±3mm (no slit)			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1 Half wrap taping	<div>   </div> <div>2. Get the Black tape then start taping process. Make 1/2 shifting of tape using both hands. Repeat the process until the end of wire near connector. Make 3 windings and then cut the tape using both hands.</div> <div>3. After taping, check the measurement and taping condition.</div>		<div>Measuring Tape</div> 	Important reminders/Note/s: <i>1. Please use calibrated/verified measuring tape when getting the measurement.</i> 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape
6	Wire insertion to Black corrugated tube (no slit) ø7 L=344±3mm	<div></div> <div>1. Get the corrugated tube ø7 L=344±3mm (no slit) using right hand then insert the Y-OR wires using left hand.</div>		N/A	1. No wrong usage of parts 2. No deformed terminal

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Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Connector 4G5400-0000 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1 Connector Setting to Insertion Jig 4G5400-0000 (W)	<div><div><div>Insertion Jig</div><div><div>I-mark</div><div>Lock</div><div>Visual reference</div><div>Button</div><div>Lower guide</div></div><div>Insertion jig Orientation</div><div>Connector Orientation</div></div><div><div><div>L</div><div>Press</div></div><div><div>R</div><div>Press</div></div><div><div>R</div><div>Release</div></div></div><div><div><div>Lower guide</div><div>Hole</div></div><div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 4G5400-0000 (W) using left hand then release the lock using left thumb. Note: Follow the connector orientation.</div><div><div>3. Push the lower guide using right thumb the slot for Yellow wire will be opened.</div></div></div></div></div>	N/A	1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector

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YKC / 7N0034-7020

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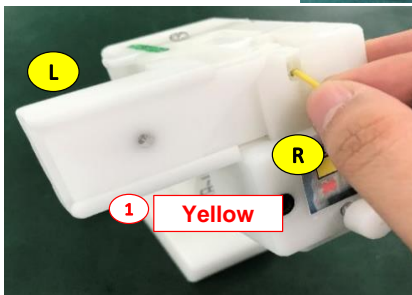
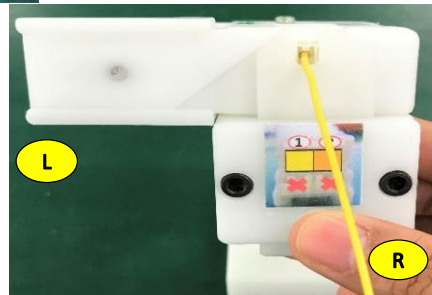
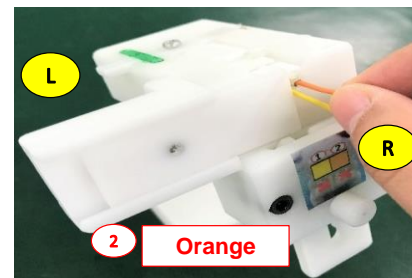
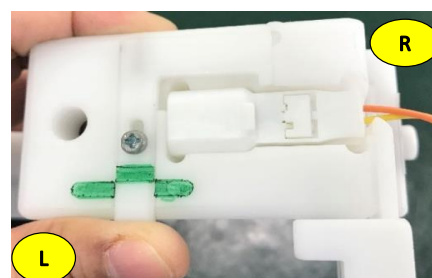
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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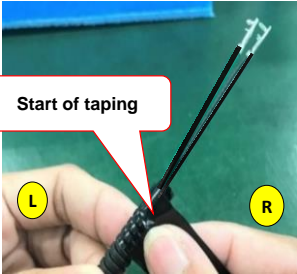
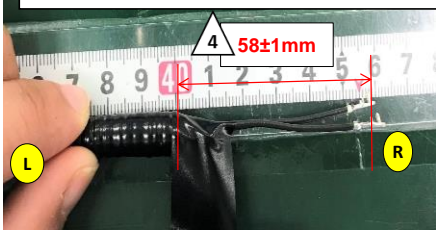

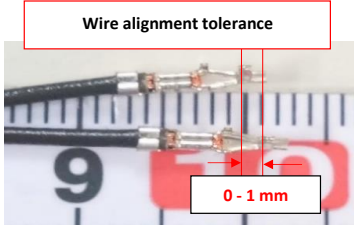
PARTS:		1. Assy parts 2. Connector 4G5400-0000 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1 Wire insertion to connector 4G5400-0000 (W)	<div><div><p>Wire Facing</p></div><div><p>1. Hold the insertion jig using left hand, get Yellow wire then insert to terminal slot 1 using right hand.</p></div><div><p>2. Press the button using right thumb, slot for Orange wire will be opened.</p></div><div><p>3. Get the Orange wire then insert to terminal slot 2 using right hand.</p></div><div><p>4. After insertion, push the lock using left thumb then hold the wires and gently pull out the connector from jig using right hand.</p></div></div>		N/A	<div>1. No wrong orientation of connector 2. No wrong use of connector 3. No damaged connector 4. No wrong insertion of wires 5. No loose insertion 6. No wrong insertion 7. One by one insertion 8. No deformed terminal 9. No wrong wire facing</div> <div>Important reminders/Note/s: <i>1. Please hold the wire near terminal.</i> <i>2. Make sure wires are properly inserted.</i> <i>Conduct Pull-Push-Pull-Push after insertion.</i> <i>Do not exert extra force.</i></div> <div>Document references: <i>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i></div>

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PARTS:	<div>4</div> <div>1. Assy parts</div> <div>2. Black Corrugated tube (no slit) ø5 L=357±1mm</div> <div>3. Black tape</div> <div>4. AVSSf 0.3 B wire L=797±3mm [2pcs]</div>	JIG:	N/A	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	<div>4</div> <div>Wire insertion to Black corrugated tube (no slit) ø5 L=357±1mm</div>	<div></div> <div>1. Hold the wires using left hand, get the Corrugated tube (no slit) ø5 L=357±1mm using right hand then insert the B-B wires using left hand.</div>	N/A	<div>1. No wrong usage of parts</div> <div>2. No deformed terminal</div> <div>Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</div>
10	<div>P1</div> <div>4</div> <div>Taping 1 Black corrugated tube to wire near terminal</div>	<div><div>Start of taping</div></div> <div>1. Hold the corrugated tube using left hand then start pre-taping between COT and wire using right hand.</div> <div><div>NOTE: Avoid adjusting of COT ø5 during taping process to prevent the compression of assy part and disregard the good appearance of taping</div></div> <div>2. Measure from end of COT up to terminal pointed tip 58±1mm then continue the taping process using both hands.</div>	<div>Measuring Tape</div> 	<div><div>Wire alignment tolerance</div></div> <div>0 - 1 mm</div> <div>1. No flip-out tape</div> <div>2. No peel-off tape</div> <div>3. No loose tape</div> <div>4. No missing tape</div> <div>5. No wrong dimension</div> <div>6. No wrong use of tape</div> <div>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</div>

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Car Model: SUZUKI SOLIO

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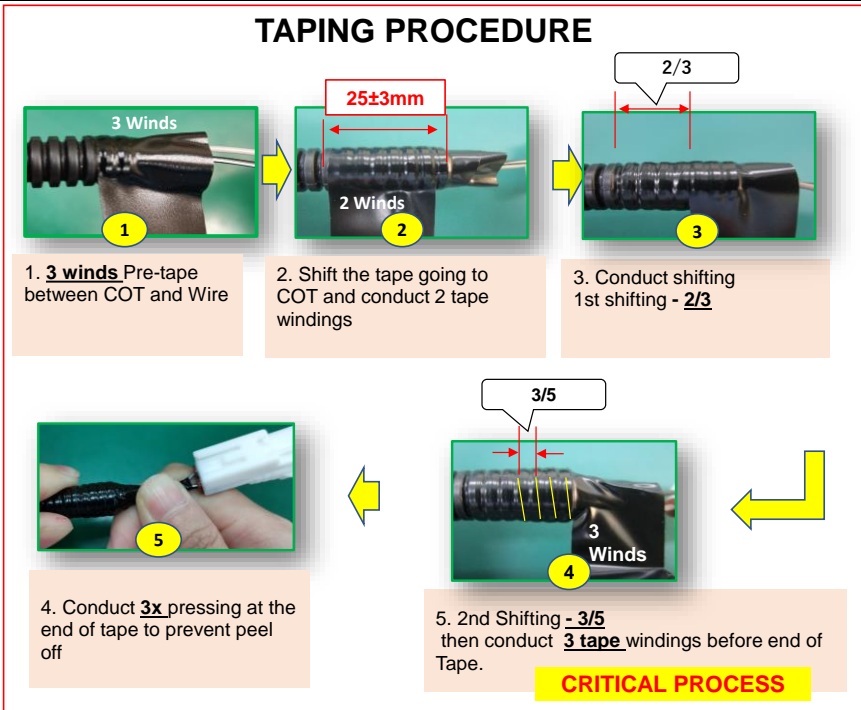
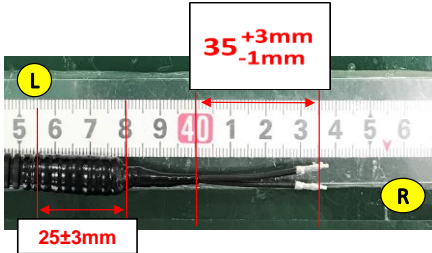

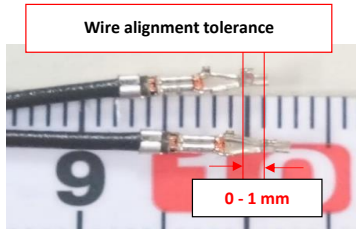
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PARTS:		1. Assy parts 2. Black tape	JIG:	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	P1 Taping 1 Black corrugated tube to wire near terminal (Continuation)	<p>TAPING PROCEDURE</p>   <p>3. After taping, check the measurement and terminal appearance.</p>	<p>Measuring Tape</p> 	<p>Wire alignment tolerance</p>  <ul style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong dimension6. No wrong use of tape <p>Important reminders/Note/s:</p> <ul style="list-style-type: none">1. Please use calibrated/verified measuring tape when getting the measurement.2. Sample harness in Taping procedure is taping reference only not same harness.

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☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:

1. Assy parts

JIG:

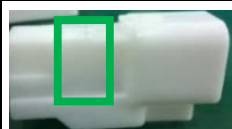
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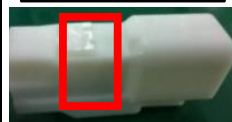
VISUAL INSPECTION/ QUALITY CHECKPOINTS

P1

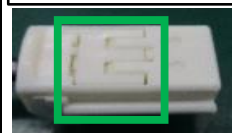
7N0034-7020



GOOD



NO GOOD



GOOD



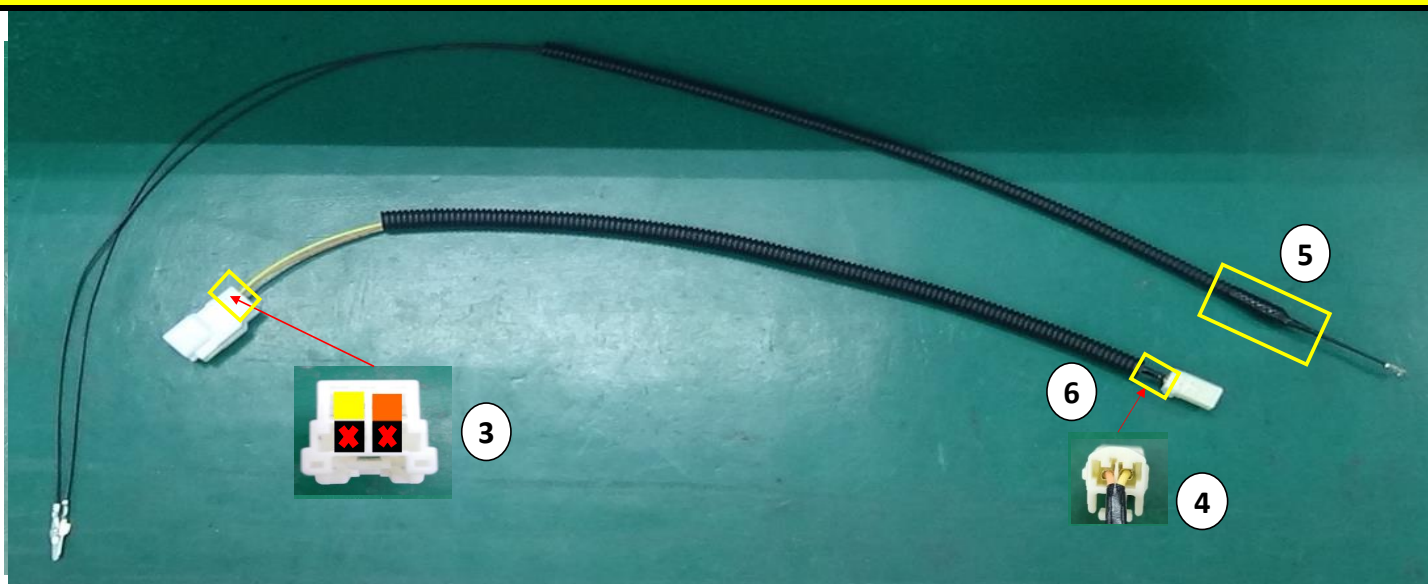
NO GOOD

① ② No Unlock/Halflocked Connector

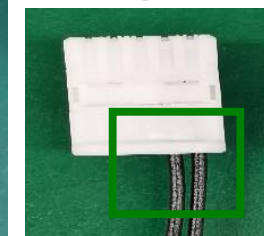
③ ④ No Wrong Insert

⑤ ⑥ No Missing Tape

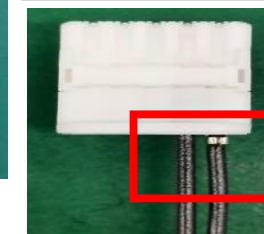
⑦ No Terminal Backing Out



⑦



GOOD



NO GOOD

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