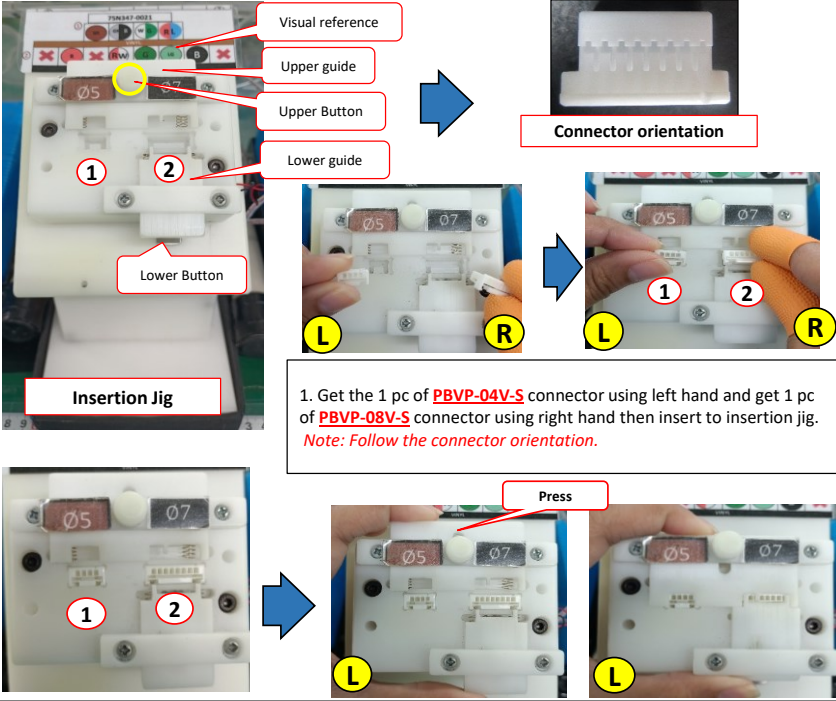
	WORK INSTRUCTION		Effectivity Date:	March 31, 2023	
	Process Name/Title: TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model Code/Part Number D01L / 75N347-0021	Customer: TRJ	Document No.:	WI-ENG-PDE-098	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:	6	Page No.:

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	<div> <div>  <p>Insertion Jig</p> <p>1. Get the 1 pc of PBVP-04V-S connector using left hand and get 1 pc of PBVP-08V-S 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> <div> <p>Connector orientation</p> <p>Press</p> </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. 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>	<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:	Checked by:	Approved by:	Noted by:
03/31/23	6	Improved the insertion jig and procedure. Improved work process/illustration. Change term from sunprene tube to VM tube (Sunprene) and change tube color from Brown to Dark Brown. Inclusion of Quality checkpoints (Page 16).	D.Castillo	J. Loterte	C. Villanueva	A. Arañes			
10/21/22	5	Improve Quality pointers: Reminders/notes and references on page no. 2,3,4,5,6,7,8,9,10,12 and 13. Improve work procedure/ illustration on process no.15- Visual/by two's inspection due to proces improvement.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes			
08/02/22	4	Improve process illustration. Merged P1 and P2 due to the process improvement. Additional quality pointers in wire insertion refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance. Include WI-ENG-PDE-431 for Steering Electrical Test after assembly.	D.Castillo	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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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model Code/Part Number

D01L**/****75N347-0021**

Customer:

TRJ

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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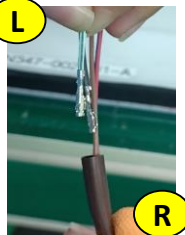


PARTS:

6

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

JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS												
2	<div>6</div> <div>P1</div> <div>Wire insertion to Connector PBVP-04V-S (W)</div>	<div>INSERTION SEQUENCE FROM LEFT TO RIGHT</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>Wire facing</div><div></div></div> <div>1. Get the BR wire using left hand and transfer to right hand then insert to connector. Repeat the process for GR/B-W/G-R/L wires. Check the wire after insertion. <i>Note: Follow the insertion sequence based on the illustration.</i></div>	1	2	3	4	BR	GR/B	W/G	R/L	289	158	158	289	<div>STEERING NAVIGATION</div> <div></div> <div>CONTROLLER</div> <div></div>	<div>1. Use provided jig per model</div> <div>2. No wrong usage of parts</div> <div>3. One by one insertion</div> <div>4. No wrong insertion</div> <div>5. No deformed terminal</div> <div>6. No stuck of terminal tip</div> <div>Important reminders/Note/s:</div> <div>1. Please hold the wire near terminal during insertion.</div> <div>2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</div> <div>Document References:</div> <div>1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.</div> <div>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div> <div>3. Refer to GL-PRO-ASY-028 for Pull-Push procedure.</div>
1	2	3	4													
BR	GR/B	W/G	R/L													
289	158	158	289													
3	<div>6</div> <div>Wire insertion to Dark Brown VM tube (Sunprene) Ø5 L=116±3mm</div>	<div><div>L</div><div>L</div><div></div></div> <div>1. Get the Dark Brown VM tube (Sunprene) Ø5 L=116±3mm using left hand and transfer to right hand. Hold the wires using left hand and insert the wires using right hand.</div>	N/A	<div>1. No wrong usage of parts</div> <div>2. No deformed terminal</div> <div>3. No tangled wires</div>												

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model Code/Part Number

D01L / 75N347-0021

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Effectivity Date:

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3 of 16**PARTS:**

1. AVSS 0.3 wires R 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

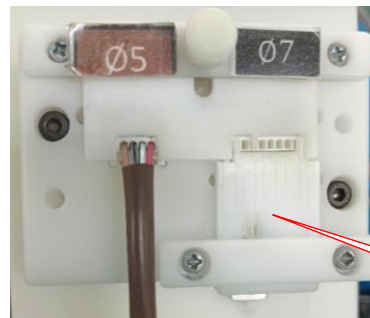
Wire insertion to
Connector
PBVP-08V-S (W)**INSERTION SEQUENCE FROM LEFT TO RIGHT****WIRE INSERTION ILLUSTRATION**

1	2	3	4	5	6	7	8
X	R	X	R/W	G	LG	B	X
	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 **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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Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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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	 Wire insertion to Black VM tube (Sunprene) Ø7 L=119±3mm	<p>1. Get the Black VM tube (Sunprene) Ø7 L=119±3mm 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 Dark Brown VM tube (Sunprene) using right hand then press the upper guide using left hand. Check the wire insertion condition. <i>Note: Second connector with inserted wire and Black Sunprene tube will stay in the jig.</i></p>	N/A	<p>1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires</p> <p>Terminal tip must be visible</p> <p>Document References: 1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.</p>
6	Wire insertion to assy parts	<p>1. Hold the Black VM tube (Sunprene) using left hand and insert the wires from Dark Brown VM tube (Sunprene) using right hand.</p>	N/A	<p>1. No wrong use of parts 2. No deformed terminal 3. No tangled wires</p>

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WORK INSTRUCTION

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Model Code/Part Number **D01L / 75N347-0021**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ 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

7

P1

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

INSERTION SEQUENCE FROM LEFT TO RIGHT

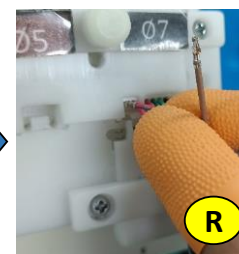
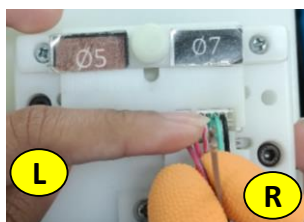
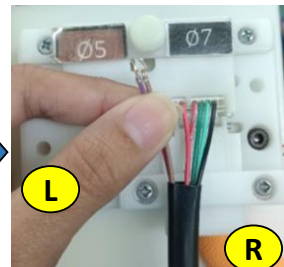
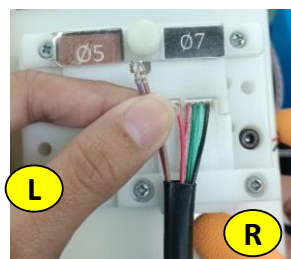


WIRE INSERTION ILLUSTRATION

1	2	3	4	5	6	7	8
R/L	R	X	R/W	G	LG	B	BR
289	161		161	161	161	161	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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Model Code/Part Number **D01L / 75N347-0021**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

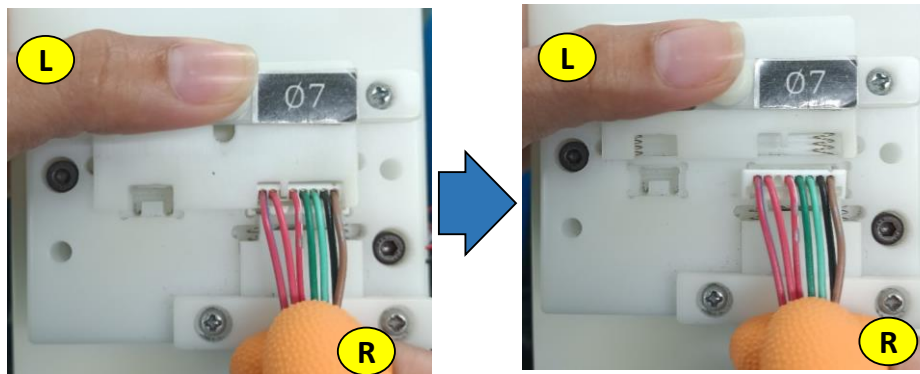
TOOLS/PPE

QUALITY POINTERS

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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WORK INSTRUCTION

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Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:

1. Assy parts

JIG

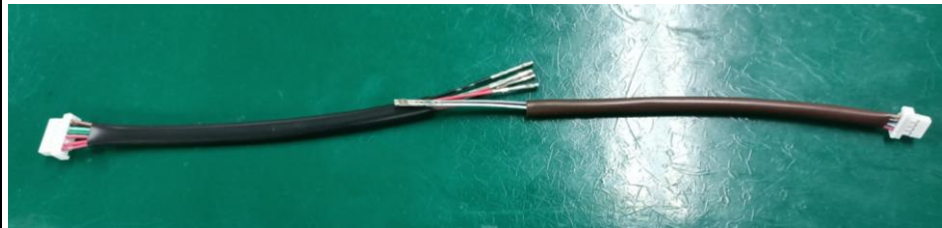
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NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

8

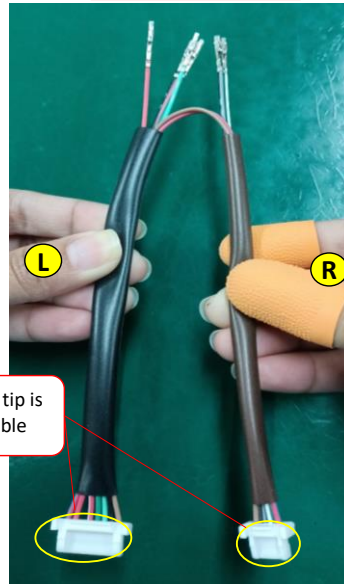
P1

Wire arrangement



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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WORK INSTRUCTION

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TAPING ASSEMBLY PROCESS

Model Code/Part Number **D01L / 75N347-0021**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

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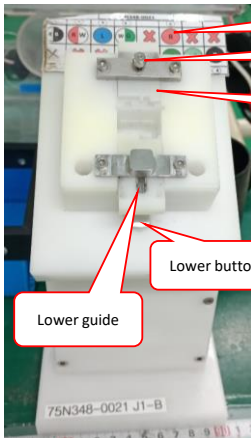
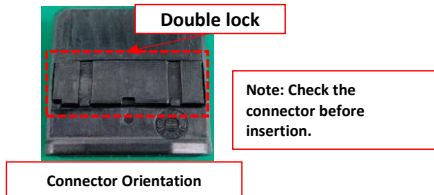


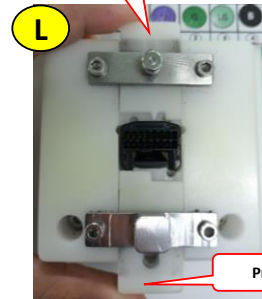





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PARTS:		1. Connector 1318386-2 (B)		JIG	1. Insertion jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1	Connector setting to insertion jig 1318386-2 (B)	<div><div><div><div>Visual reference</div><div>Upper button</div><div>Upper guide</div><div>Lower button</div><div>Lower guide</div></div><div><div>INSERTION JIG</div></div><div><div>Double lock</div><div>Note: Check the connector before insertion.</div><div>Connector Orientation</div></div><div></div><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>2. Press the upper and lower guide using left hand. Holes that need to be insert are only open.</div></div></div><div><div><div>Press</div></div><div><div>Press</div></div></div></div></div> <td>N/A</td> <td><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>Important reminders/Note/s: <i>1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half- locked connector.</i></div><div><div>CONNECTOR LOCK APPEARANCE CHECK</div><div><div><div>GOOD</div></div><div><div>NG</div></div></div><div><div>UNLOCK</div><div>HALF-LOCKED</div></div></div></td>		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>Important reminders/Note/s: <i>1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half- locked connector.</i></div> <div><div>CONNECTOR LOCK APPEARANCE CHECK</div><div><div><div>GOOD</div></div><div><div>NG</div></div></div><div><div>UNLOCK</div><div>HALF-LOCKED</div></div></div>

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model Code/Part Number

D01L / 75N347-0021

Customer:

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Purpose:

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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

6

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

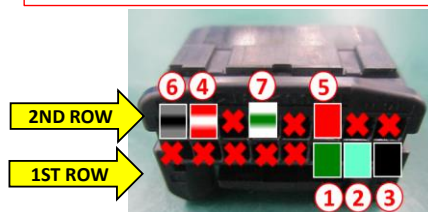
QUALITY POINTERS

10

P1

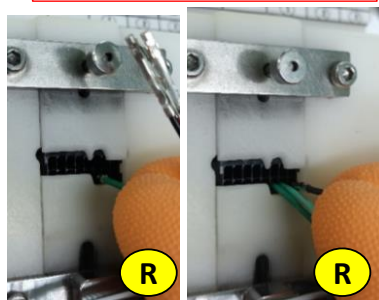
Connector setting to
insertion jig
1318386-2 (B)

INSERTION SEQUENCE FROM LEFT TO RIGHT



Wire facing

FIRST ROW (LEFT TO RIGHT)



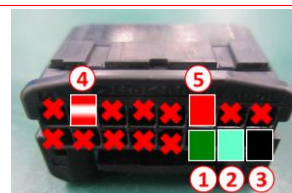
1. Insert first the wires from **Black VM tube (Sunprene)**. Hold the **G wire** and insert to terminal slot 1 using right hand. Repeat the process for **LG-B wires**.
Note: Follow the insertion sequence based on the illustration stated above.

WIRE INSERTION ILLUSTRATION

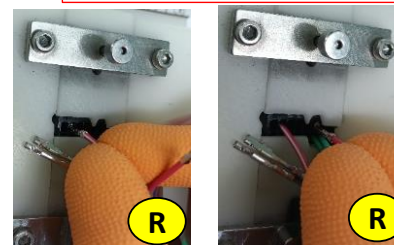
6	4	7	5			
GR/B	R/W	W/G	R	X	X	X
158	161	158	161	1	2	3
X	X	X	X	G	LG	B
				161	161	161

6

Black VM tube (Sunprene)



SECOND ROW (LEFT TO RIGHT)



2. Hold the **R/W wire** and insert to terminal slot 4. 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

/

75N347-0021

Customer:

TRJ

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

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1. Assy parts

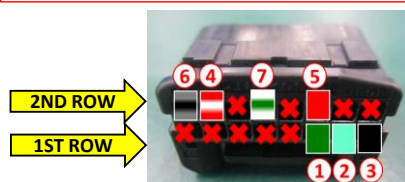
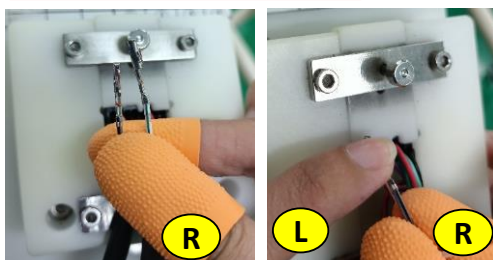
JIG

1. Insertion jig

NO.**PROCESS NAME****6****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

10

P1

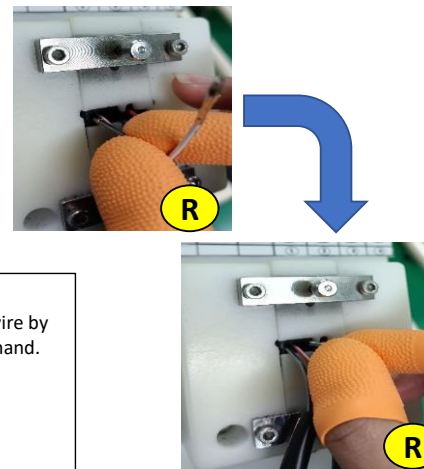
Wire insertion to
Connector
1318386-2 (B)
(Continuation)**INSERTION SEQUENCE FROM LEFT TO RIGHT****Wire facing****FIRST ROW (LEFT TO RIGHT)**

3. Hold the **GR/B wire** using right hand and support the wire by left index finger then insert to terminal **slot 6** using right hand. Repeat the process for **W/G wire**.

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

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
					V	G	LG
					161	161	161

6**Dark Brown VM Tube (Sunprene)**

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

Effectivity Date:

March 31, 2023

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number

D01L / 75N347-0021

Customer:

TRJ

Document No.:

WI-ENG-PDE-098

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

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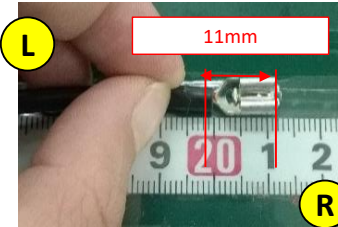



PARTS:

6

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></div> <div><p>1. Get the Blue wire using right hand and insert to Black VM tube (Sunprene) Ø3 L=113±3mm.</p><p>2. Measure the VM tube (Sunprene) up to the tip of the terminal, it should be 11mm.</p></div>	<div></div> <p>MEASURING TAPE</p>	<div></div> <p>Peel-off wire should be covered by Sunprene tube (White)</p> <p>Important Reminder/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p>

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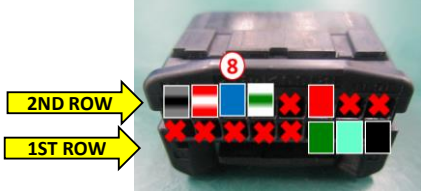

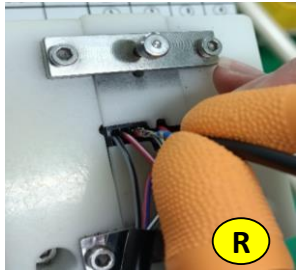
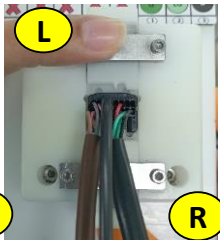
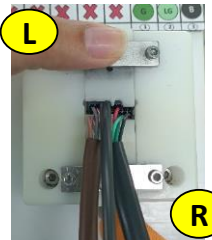
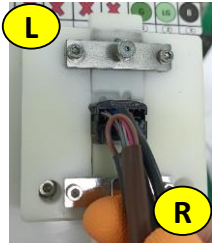
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PARTS:		1. Assy parts			JIG	1. Insertion jig																																																
NO.	PROCESS NAME		6 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS																																																
12	P1	Wire insertion to Connector 1318386-2 (B) (Continuation)	<div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div> <div></div> <div><div>WIRE INSERTION ILLUSTRATION</div><table><tr><td>6</td><td>4</td><td>8</td><td>7</td><td></td><td>5</td><td></td><td></td></tr><tr><td>GR/B</td><td>R/W</td><td>L</td><td>W/G</td><td>X</td><td>R</td><td>X</td><td>X</td></tr><tr><td>158</td><td>161</td><td>129</td><td>158</td><td></td><td>161</td><td></td><td></td></tr><tr><td>X</td><td>X</td><td>X</td><td>X</td><td>X</td><td>1</td><td>2</td><td>3</td></tr><tr><td></td><td></td><td></td><td></td><td></td><td>G</td><td>LG</td><td>B</td></tr><tr><td></td><td></td><td></td><td></td><td></td><td>161</td><td>161</td><td>161</td></tr></table></div> <div></div> <div>Wire facing</div> <div>FIRST ROW (LEFT TO RIGHT)</div> <div></div> <div>4. Get the L wire using right hand and insert to terminal slot 11 using right hand. <i>Note: Follow the insertion sequence based on the above illustration.</i></div> <div><div></div><div></div></div> <div>5. Press the upper guide and lower guide (same timing) using both hands then remove the assy part using right hand.</div>		6	4	8	7		5			GR/B	R/W	L	W/G	X	R	X	X	158	161	129	158		161			X	X	X	X	X	1	2	3						G	LG	B						161	161	161	n/a	<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>Important reminders/Note/s: 1. Please hold the wire near terminal during insertion. 2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</div>
			6	4	8	7		5																																														
GR/B	R/W	L	W/G	X	R	X	X																																															
158	161	129	158		161																																																	
X	X	X	X	X	1	2	3																																															
					G	LG	B																																															
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Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

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Model Code/Part Number:

D01L / 75N347-0021

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TRJ

Document No.:

WI-ENG-PDE-098

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

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

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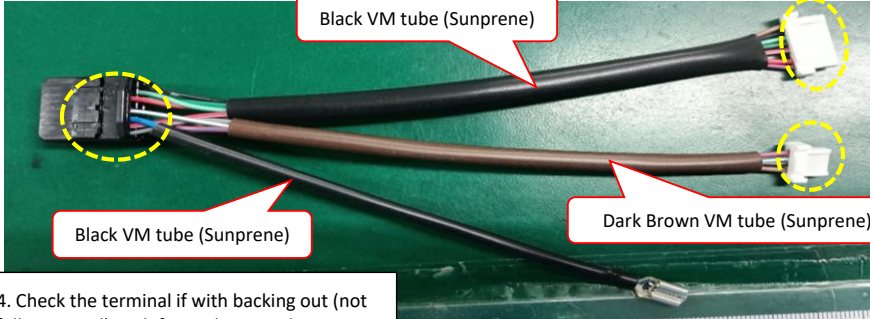



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Model Code/Part Number: D01L / 75N347-0021		Customer: TRJ	Validity Date:	n/a
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.:	WI-ENG-PDE-098	
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PARTS:		1. Assy 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 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>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></div>	n/a	<div>Document References: 1. Refer to WI-ENG-PDE-431 for Steering Electrical Test after assembly.</div> <div>MASTER SAMPLE</div> <div></div>

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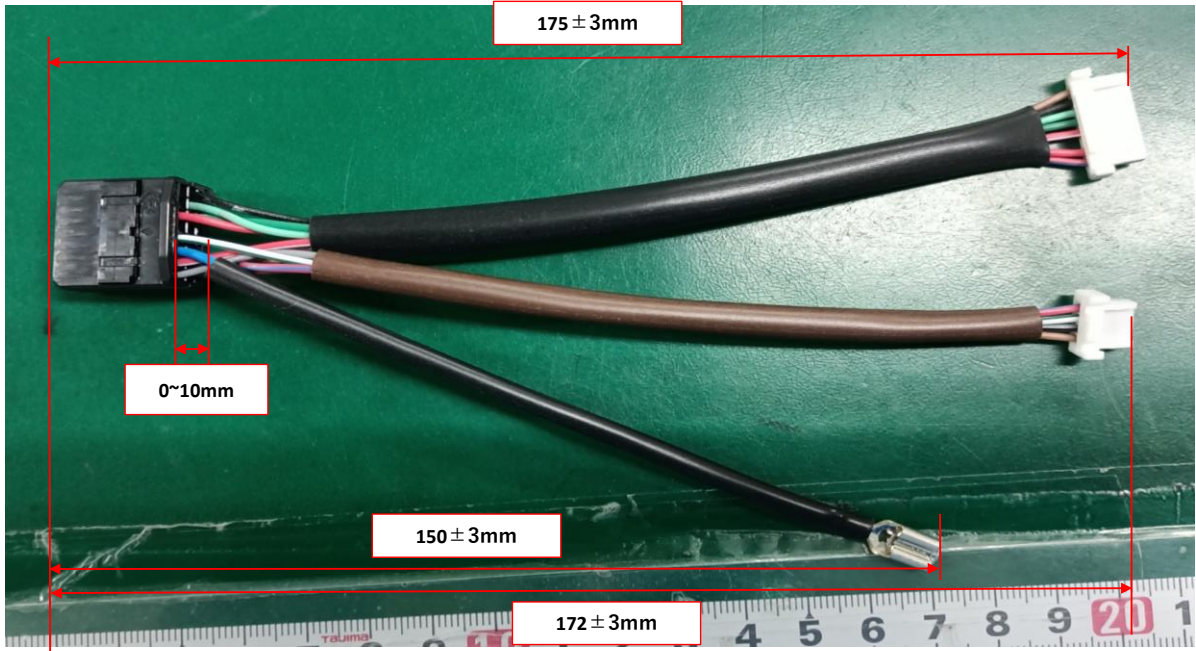
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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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>MEASUREMENT TAPE</div></div>		<p>Important reminders/Notes/:</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

6

QUALITY CHECKPOINTS

75N347-0021

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)

Dark Brown VM Tube (Sunprene)

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.



**FOLDED WIRES
MUST BE IN
BACK POSITION**

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