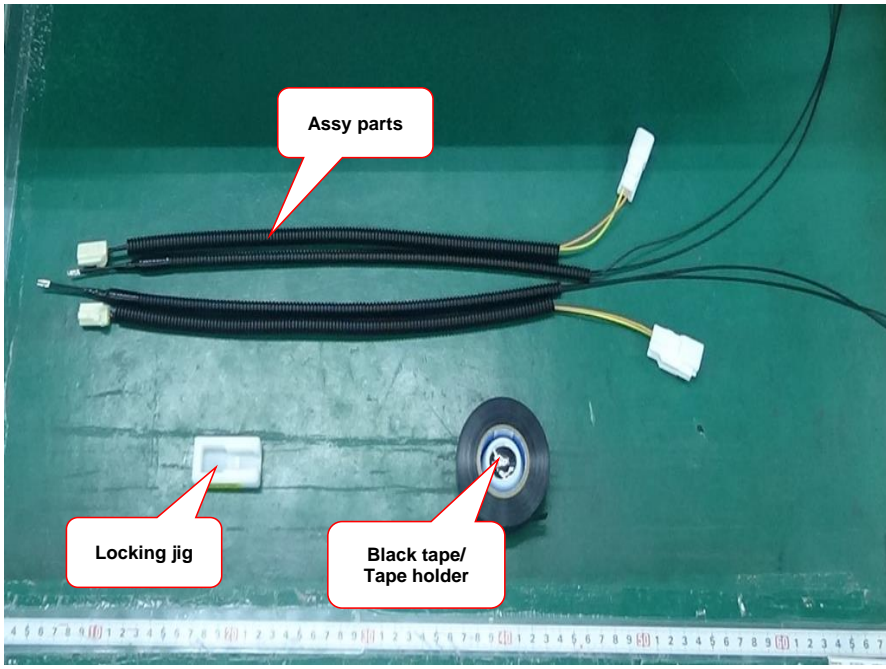



	<b>WORK INSTRUCTION</b> <b>TAPING ASSEMBLY PROCESS</b>				Effectivity Date:	June 3, 2024		
	Process Name/Title:				Validity Date:	n/a		
	Model code/Part number: <b>YKC / 7N0034-7020</b>		Customer: <b>TRJ</b>	Car Model: <b>SUZUKI SOLIO</b>	Document No.:	<b>WI-ENG-PDE-373B</b>		
	Purpose: <input type="checkbox"/>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

PARTS:		1. Assy parts; Black tape		JIG:	1. Locking jig
NO.	PROCESS NAME	3 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
1	P2 Table Lay-out	<div style="border: 1px solid red; padding: 5px; text-align: center; margin-bottom: 10px;">TABLE LAY-OUT</div> 	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <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 style="border: 1px dashed red; padding: 5px;"> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>	<b>Document reference/s:</b> 1. Refer to <b>WI-PRO-CNC-017</b> for Wire and Strip Length Tolerance.  1. No missing parts/tools 2. No excess parts/tools	

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 from P1 (WI-ENG-PDE-373A) and separate clamp assembly to Clamp assembly process due to process improvement. Inclusion of car model "SUZUKI SOLIO". Update Table lay-out and Measurement. Improved Visual inspection/Quality checkpoints.				D.Castillo	C.Villanueva	A. Arañes	N/A	 D. Castillo	 C. Villanueva	 A. Arañes	N/A
06/29/23	2	Inclusion of quality checkpoints. Improve by two's inspection, important reminders and document references.				J.Loterte	C.Villanueva	A. Arañes	n/a				
12/02/21	1	Change from Pre-launch to Masspro; Improve work procedure/illustration and quality pointers; Additional Table lay-out.				K.Doria	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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Process Name/Title:

## TAPING ASSEMBLY PROCESS

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Customer: TRJ

Car Model: SUZUKI SOLIO

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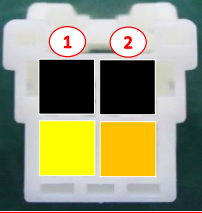


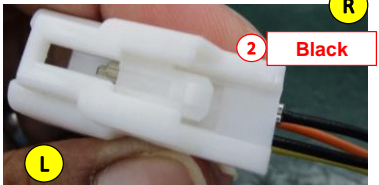
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PARTS:	1. Assy parts 2. Connector 4G5400-0000 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	3  Wire insertion to Black corrugated tube(no slit) Ø7 L=344±3mm (Assy parts)	 <div>1. Get the assy parts then hold the COT (no slit) Ø7 L=344±3mm using left hand then insert the B-B wires (assy parts) using right hand.</div>		1. No wrong usage of parts 2. No deformed terminal tip
3	P2  Wire insertion to connector 4G5400-0000 (W)	  <div>Visual Reference</div>   <div>1. Hold the connector 4G5400-0000 (W) using left hand, get the 1st Black wire then insert to terminal slot 1 using right hand. <b>Note: Insertion of wire must be from left to right.</b></div>  <div>2. Hold the 2nd Black wire then insert to terminal slot 2 using right hand.</div>	N/A	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  <b>Important reminders/Note/s:</b> 1. Please hold the wire near terminal. 2. Make sure wires are properly inserted.  Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.  <b>Document references:</b> 1. Refer to <b>GL-PRO-ASY-029</b> for Pull-Push procedure.

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Effectivity Date:

**June 3, 2024**

Model code/Part number:

**YKC / 7N0034-7020**

Customer:

**TRJ**

Car Model:

**SUZUKI SOLIO**

Document No.:

**WI-ENG-PDE-373B**

Purpose:

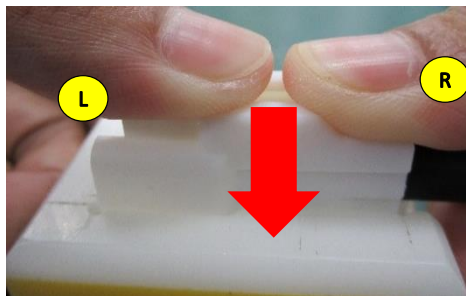
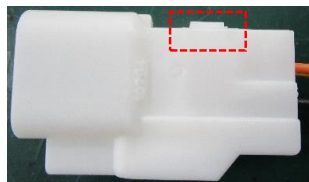
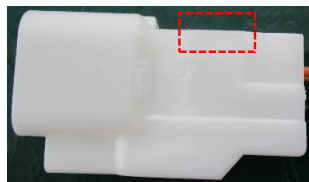
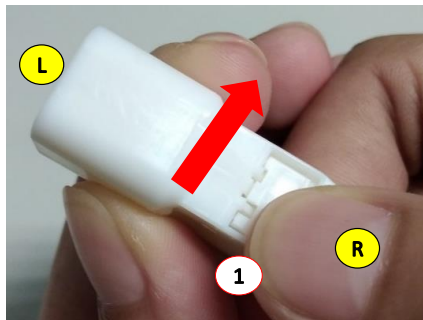
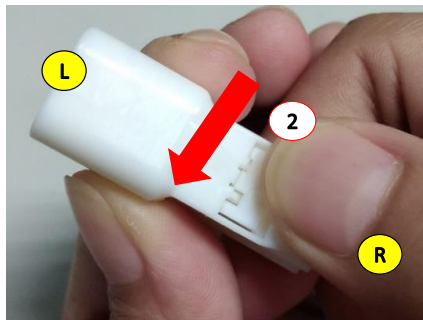

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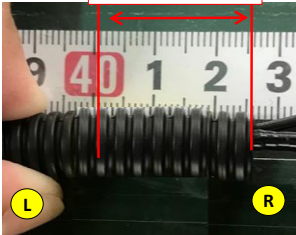
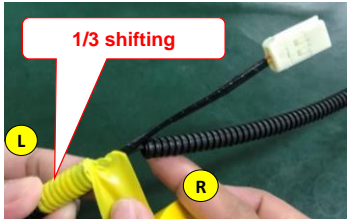
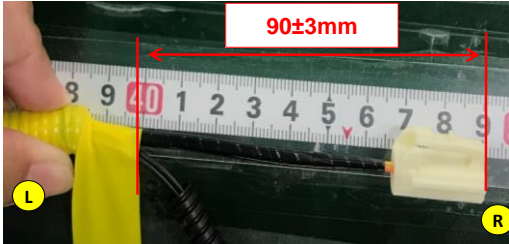
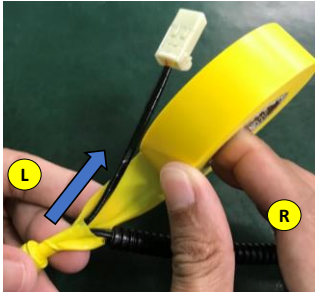
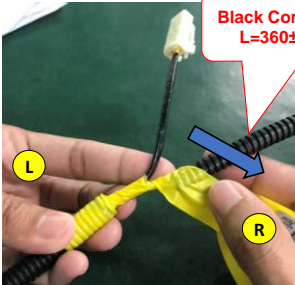

PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2 <div>3</div> Connector lock	<div><div></div><div> BEFORE PRESSING</div><div> AFTER PRESSING</div><div></div><div></div><div>1. Put the connector into locking jig using both hands then press <b>2x</b> using both hands. Touch the connector lock if properly lock.</div><div>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</div></div>		<div>Locking jig</div> 	<b>Important reminders/Note/s:</b> <b>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR.</b>  1. Use provided jig tool per model to avoid damaged lock. 2. No unlock/half-locked connector

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

<b>PARTS:</b>	1. Assy parts 2. Black tape			JIG:	N/A	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
5	P2	Y- taping	<div><div><p>25±3mm</p></div><div><p>1/3 shifting</p></div><div><p>90±3mm</p></div><div><p>Black Corrugated tube ø5 L=360±3mm (no slit)</p></div><div></div></div> <div><p>1. Measure from <b>Black Corrugated tube ø7 L=344±3mm (no slit)</b> up to end of corrugated tube <b>25±3mm</b> then start the taping process using both hands.</p><p>2. Fix the side of COT with connector. Wind the tape 1/3 shifting until reach the end of corrugated tube then combined the wires <b>(must be tape width)</b>.</p><p>3. Measure end of tape up to end of connector <b>90±3mm</b> then start taping process using both hands.</p><p>4. Wind the tape in the middle of two (2) wires up to other side of <b>Black Corrugated tube ø5 L=360±3mm (no slit)</b>.</p></div> <div><p><b>Measuring tape</b></p></div> <div><p><b>Important reminders/note/s:</b></p><p>1. Please use <u>calibrated/verified measuring tape</u> when getting the measurement.</p><p>2. Use <u>YELLOW TAPE</u> for easy visualization of shifting lines but actual should be <u>BLACK TAPE</u>.</p><p>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</p></div>			

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## WORK INSTRUCTION

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## TAPING ASSEMBLY PROCESS

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YKC / 7N0034-7020

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Car Model:

SUZUKI SOLIO

Purpose:

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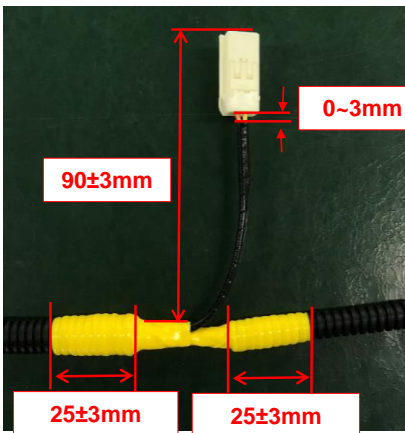
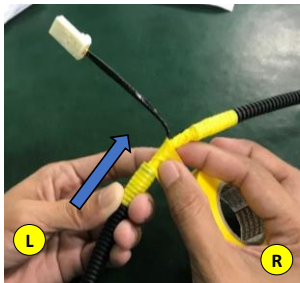
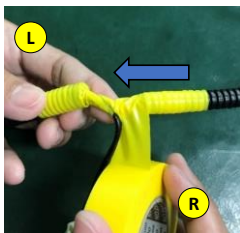
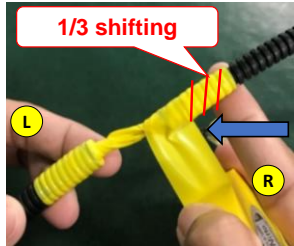
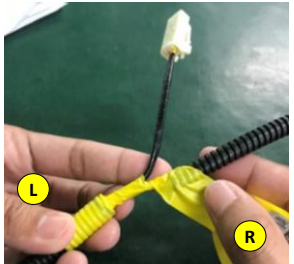

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PARTS:		1. Assy parts 2. Black tape		JIG:	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P2 Y-Taping (Continuation)	<div></div> <p>5. Wind the tape 1/3 shifting until reach the corrugated tube then measure end of corrugated tube up to end of tape <b>25±3mm</b> and one COT to another COT <b>30±3mm</b> then continue the taping process using both hands. Make 2 windings.</p> <p>6. Wind the tape backward <b>1/3 shifting</b>.</p> <p>7. Wind the tape in the middle of two (2) wires up to other side of corrugated tube.</p> <p>8. Wind the tape 1/3 shifting going to middle then cut the tape after 2 windings. After taping, check the condition of tape.</p>		<div><b>Measuring tape</b></div> 	<p><b>Important reminders/note/s:</b></p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>2. Use <b>YELLOW TAPE</b> for easy visualization of shifting lines but actual should be <b>BLACK TAPE</b>.</p> <p>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</p>


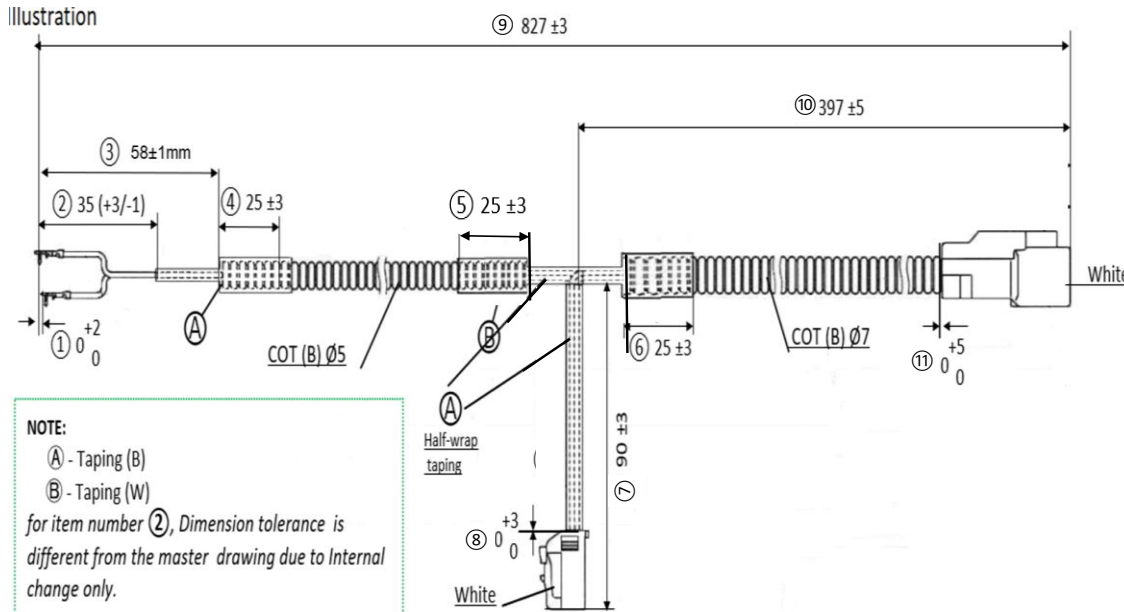
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	Model code/Part number: <b>YKC / 7N0034-7020</b>		Customer: <b>TRJ</b>	Car Model: <b>SUZUKI SOLIO</b>	Document No.:		<b>WI-ENG-PDE-373B</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		3	Page No.:

<b>PARTS:</b>		1. Assy parts		<b>JIG:</b>		n/a	
<b>NO.</b>	<b>PROCESS NAME</b>	<div style="border: 1px solid black; padding: 2px; display: inline-block;">3</div> <b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>			
6	P1	Measurement	<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> <b>MEASURING TAPE</b> </div>   <div style="border: 1px solid green; padding: 5px; margin-top: 10px;"> <b>NOTE:</b>          (A) - Taping (B)          (B) - Taping (W)          for item number (2), Dimension tolerance is different from the master drawing due to Internal change only.       </div>	<div> <b>Important reminders and note/s:</b>            1. Please use calibrated/verified measuring tape when getting the measurement.            2. For Hatsumono, Nakamono and Owarimono.         </div> <div> <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>			

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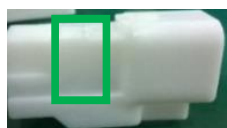
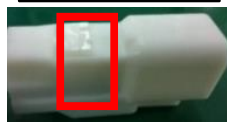
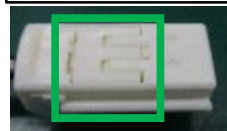
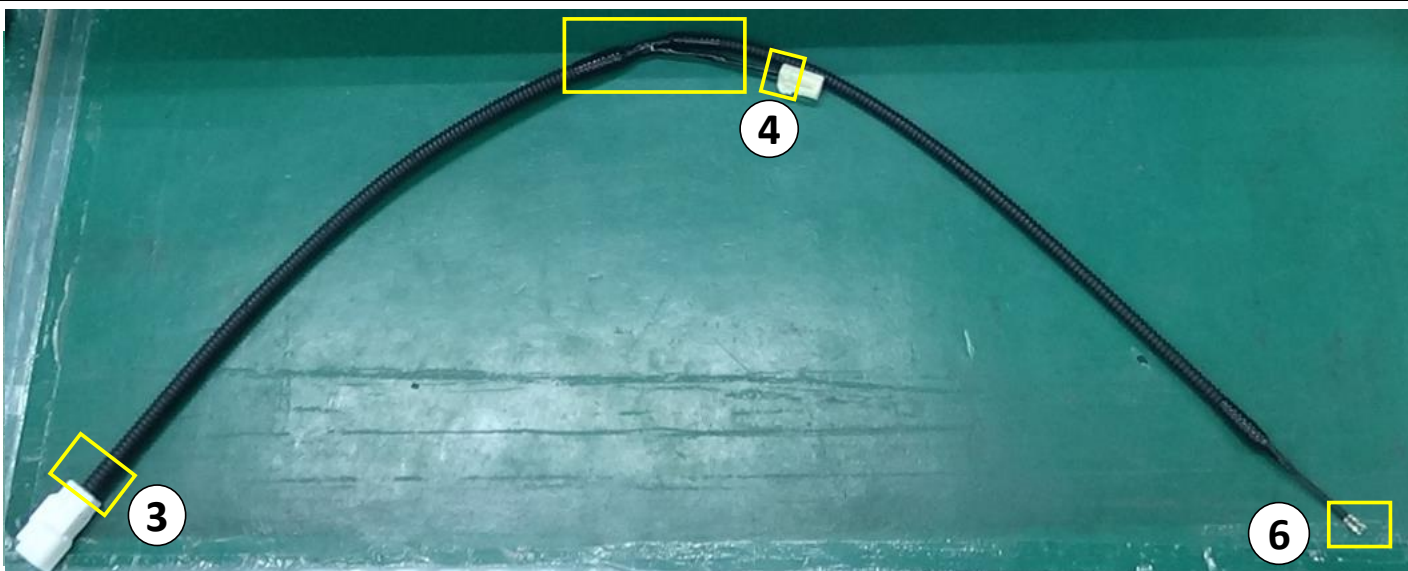
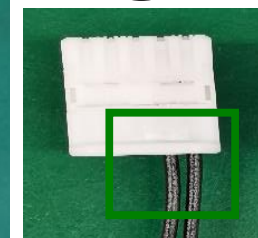
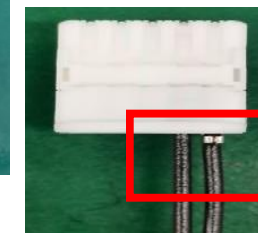
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**PARTS:**

1. Assy parts

JIG:

N/A

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****P2****7N0034-7020****GOOD****NO GOOD****GOOD****NO GOOD****1** **2** No **Unlock/Halflocked**  
**Connector****3** **4** No **Wrong Insert****5** No **Missing Tape****6** No **Deformed Terminal****7** No **Terminal Backing Out****7****GOOD****NO GOOD**

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