



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

February 2, 2023

Process Name/Title:

Validity Date:

n/a

Model Code/Part Number: D01L / 75N353-0011

Customer:

TRJ

Document No.:

WI-ENG-PDE-117

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

5

Page No.:

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PARTS:

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

JIG:

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

1

P1

Connector setting to
insertion jig
PBVP-08V-S (W)
PBVP-04V-S (W)

INSERTION JIG



1. Get the connector **PBVP-08V-S (W)** using right hand and set into insertion jig.
Repeat the process for **PBVP-04V-S (W)**.
Note: Follow the connector orientation.



2. Press the guide lock button using left index finger.

Safety Instruction

Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)

Housekeeping

1. Maintain and always practice 5's.
2. Personal things on the workplace is prohibited. Keep it in your locker.

Alert level

For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.

1. Use the provided jig per model
2. No wrong orientation of connector
3. No wrong use of connector
4. No damaged connector

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Prepared by	Reviewed by	Approved by	Noted by
02/03/23	5	Improve work procedure/Illustration on process no.13- Visual/ by two's Inspection. Inclusion of Quality checkpoints on pg.no. 14.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
04/13/22	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.	K. Doria	J. Loterte	C. Villanueva	A. Arañes				
05/28/21	3	Removal of validity date. Apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Est. Date:	March 14, 2019		

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PARTS:

1. AVSS 0.3 BR L=285±2mm; GR/B L=161±2mm; GR L=161±2mm; W/G L=161±2mm; Y L=161±2mm; OR L=161±2mm; R/L L=285±2mm

JIG

1. Insertion jig

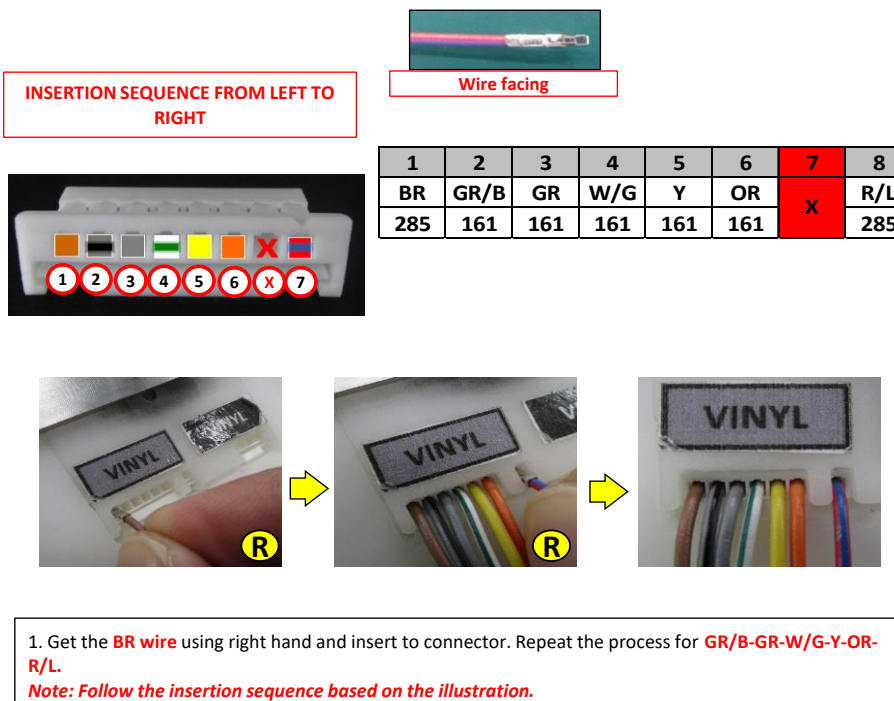
NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

2

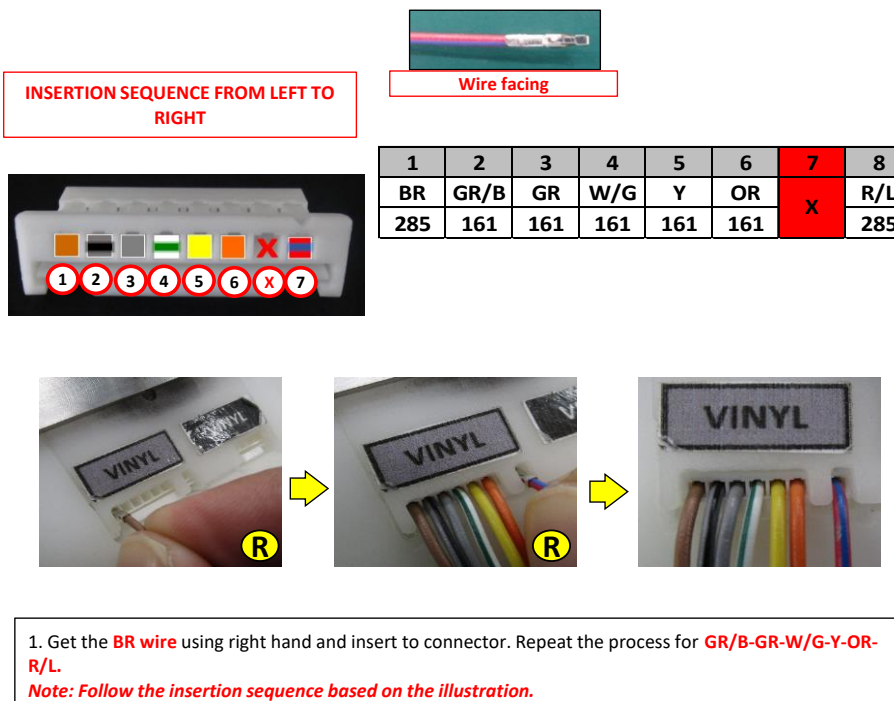
P1

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

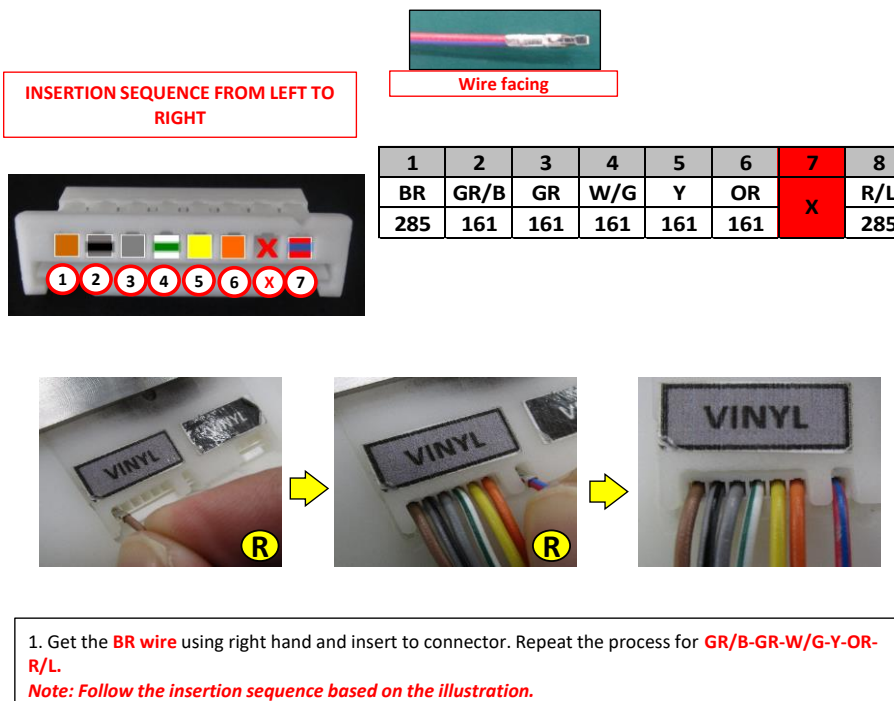
INSERTION SEQUENCE FROM LEFT TO RIGHT



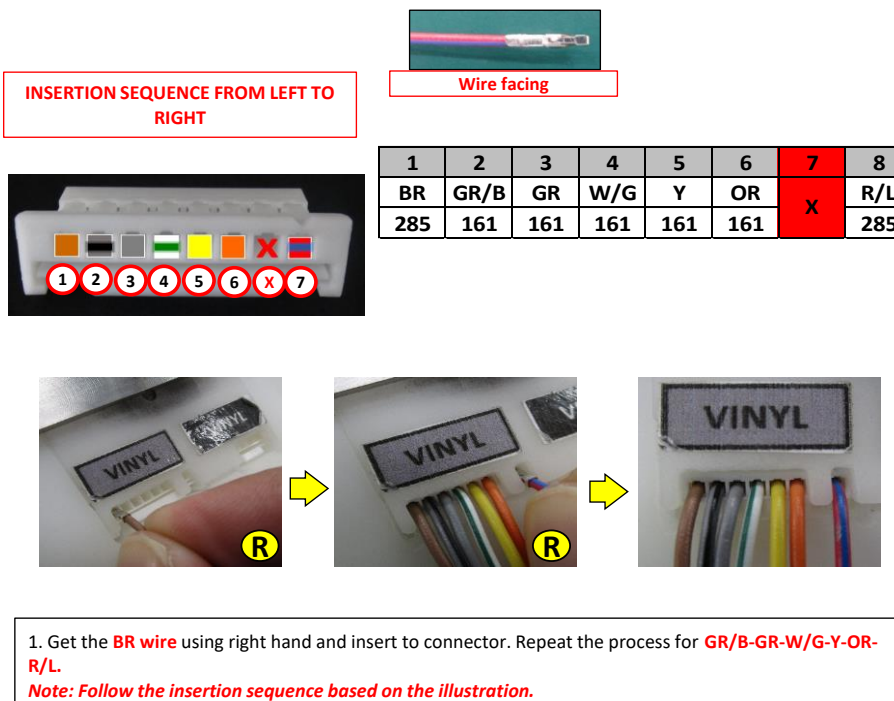
Wire facing



STEERING NAVIGATION



CONTROLLER



1. Get the **BR wire** using right hand and insert to connector. Repeat the process for **GR/B-GR-W/G-Y-OR-R/L**.
Note: Follow the insertion sequence based on the 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. Insertion of wire must be from left to right.
 3. Make sure wires are properly inserted.
- Conduct **Pull-Push-Pull-Push** after insertion.

Document reference/s:

1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
2. Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.
3. Please refer to GL-PRO-ASY-029 for Pull-Push- procedure.

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PARTS:

1. Assy parts
2. Dark Gray VM tube (Sunprene) Ø6.5 L=119±3mm

JIG

n/a

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to Dark Gray VM tube (Sunprene) Ø6.5 L=119±3mm	<div><p>1. Hold the wires using left hand, get the Dark Gray VM tube (Sunprene) Ø6.5 L=119±3mm using right hand then insert the long wires.</p></div> <div><p>2. Continue to insert the short wires.</p></div> <div></div>	n/a	<ol style="list-style-type: none">1. No wrong usage of parts2. No deformed terminal Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

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PARTS:

1. AVSS 0.3 R L=154±2mm; R/W L=154±2mm

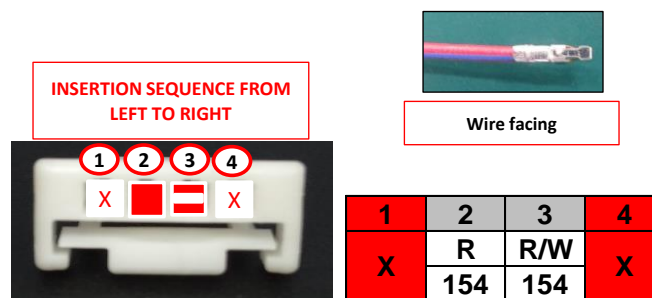
JIG

Insertion jig

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

4

P1

Wire insertion to connector
PBVP-04V-S (W)

1. Get the **R** wire using right hand and insert to connector. Repeat the process for **R/W** wire. Skip the **1st** and **last** terminal slot.

Note: Follow the insertion sequence based on 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. Insertion of wire must be from left to right.
 3. Make sure wires are properly inserted.
- Conduct **Pull-Push-Pull-Push** after insertion.

Document reference/s:

1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
2. Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.
3. Please refer to GL-PRO-ASY-029 for Pull-Push- procedure.

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PARTS:

1. Assy parts
2. Black VM tube (Sunprene) Ø5.5 L=112±3mm

JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	Wire insertion to Black VM tube (Sunprene) Ø5.5 L=112±3mm	<p>1. Hold the wires using left hand, get the Black VM tube (Sunprene) Ø5.5 L=112±3mm using right hand then insert the wires using left hand.</p> <p>2. Press the unlock button using left thumb.</p> <p>3. Remove the 1st connector with inserted wires Black VM tube (Sunprene). Check the terminal tip condition. Second connector with inserted wire is still on the jig.</p>	n/a	<ol style="list-style-type: none">1. No wrong usage of parts2. No deformed terminal <p>Document reference/s:</p> <p>1. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion</p> <p>Terminal tip must be visible</p>
6	Wire insertion to assy parts	<p>1. Press the guide lock button using left index finger.</p> <p>2. Hold the Black VM tube (Sunprene) using left hand, then insert the wires from Dark Gray VM tube (Sunprene) using right hand.</p>	n/a	<ol style="list-style-type: none">1. No wrong usage of parts2. No deformed terminal

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PARTS:

1. Assy parts

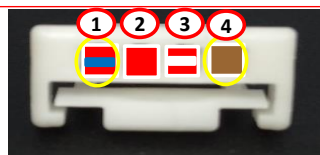
JIG

1. Insertion jig

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

7

P1

Wire insertion to connector
PBVP-04V-S (W)**INSERTION SEQUENCE FROM LEFT TO RIGHT****WIRE FACING**

1	2	3	4
R/L	R	R/W	BR
285	154	154	285



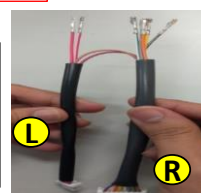
1. Hold the **R/L** wire and insert to terminal slot **1** and **BR** wire to terminal slot **4**.
Note: Follow the insertion sequence on the above illustration.

**BEFORE PRESSING****AFTER PRESSING**

2. Press the guide lock button using left thumb.



3. Hold the assy parts using right hand and gently pull out from jig. Check the terminal tip condition.



4. Slowly fold the harness using both hands.

**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. Insertion of wire must be from left to right.
3. Make sure wires are properly inserted.
Conduct Pull-Push-Pull-Push after insertion.

Document reference/s:

1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
2. Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.
3. Please refer to GL-PRO-ASY-029 for Pull-Push- procedure.



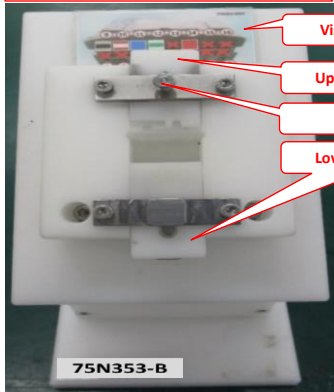



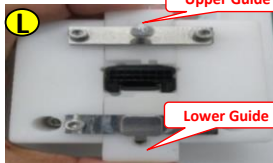



Terminal tip must be visible

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PARTS:	1. Connector 1318386-2 (B)		JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P1 Connector setting to insertion jig 1318386-2 (B)	<div><div><div>INSERTION JIG</div><div></div></div><div><div>Double lock</div><div></div><div>Note: Check the connector before</div><div>CONNECTOR ORIENTATION</div></div><div><div></div><div></div></div><div><div>1. Get the connector <u>1318386-2 (B)</u> using right hand and set to insertion jig. Note: Follow the connector orientation.</div></div><div><div><div><div>Upper Guide</div><div></div><div>BEFORE PRESSING</div></div><div></div><div>BEFORE PRESSING</div></div><div><div>2. Press the upper and lower guide lock using left hand (same timing). You will notice the holes that needs to be inserted are only open.</div></div></div></div>	n/a	<div><div>1. Use the provided jig per model</div><div>2. No wrong usage of parts</div><div>3. No wrong orientation of connector</div><div>4. No damaged connector</div></div> <div><div>CONNECTOR LOCK APPEARANCE CHECK</div><div><div><div>GOOD</div><div></div><div>UNLOCK</div></div><div><div>NG</div><div></div><div>HALF-LOCKED</div></div></div><div>Important reminders/Note/s:</div><div><div>1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</div><div>2. Please check the connector before insertion.</div></div></div>

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PARTS:

1. Assy parts

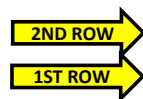
JIG

1. Insertion jig

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

9

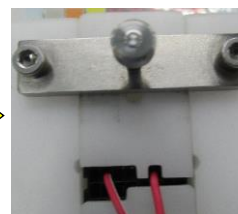
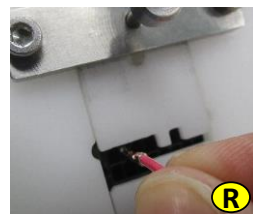
P1

Wire insertion to connector
1318386-2 (B)**INSERTION SEQUENCE FROM LEFT TO RIGHT**

9	10	11	12	13	14	15	16
GR/B	R/W	L	W/G	X	R	X	X
161	154	129	161	X	154	X	X
1	2	3	4	5	6	7	8
GR	OR	Y	X	X	X	X	X
161	161	161	X	X	X	X	X



Wire facing

BLACK SUNPRENE TUBE**SECOND ROW (LEFT TO RIGHT)**

1. Insert the wires from **Black VM tube (Sunprene)**. Get the **R/W wire** and insert to terminal **slot 10** using right hand. Get the **R wire** and insert on terminal **slot 14**.

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

n/a

1. Use the provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
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. Insertion of wire must be from left to right.
 3. Make sure wires are properly inserted.
- Conduct Pull-Push-Pull-Push after insertion.**
4. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.

Document reference/s:

1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
2. Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.
3. Please refer to GL-PRO-ASY-029 for Pull-Push- procedure.

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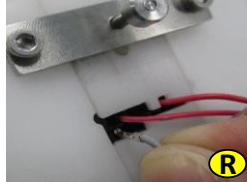
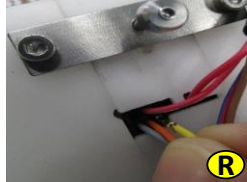
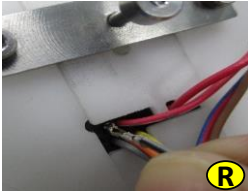
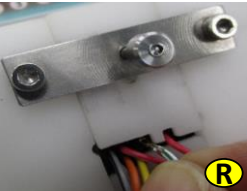

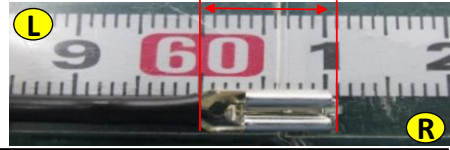

PARTS:

1. Assy parts
2. AVSS 0.5 L L=129±1mm

3. Black VM Tube (Sunprene) Ø3 L=113±3mm

JIG

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	Wire insertion to connector 1318386-2 (B) (Continuation)	<p>GRAY SUNPRENE TUBE</p>  <p>FIRST ROW (LEFT TO RIGHT)</p>   <p>2. Insert the wires from Dark Gray VM Tube (Sunprene). Get the GR wire and insert to terminal slot 1 using right hand. Repeat the process for OR-Y wires. <i>Note: Follow the insertion sequence based on the illustration stated above.</i></p> <p>SECOND ROW (LEFT TO RIGHT)</p>   <p>3. Get the GR/B wires using right hand and then insert to terminal slot 9 and W/G wire on terminal slot 12. <i>Note: Follow the insertion sequence based on the illustration stated above.</i></p>	n/a	<ol style="list-style-type: none">1. Use the provided jig per model2. No wrong usage of parts3. No wrong orientation of connector4. No wrong insertion5. No deformed terminal6. No stuck of terminal tip <p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Make sure wires are properly inserted.2. Conduct Pull-Push-Pull-Push after insertion.3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.
10	Wire insertion to Black VM tube (Sunprene) Ø3 L=113±3mm	 <p>1. Get the Blue wire using left hand and Black VM tube (Sunprene) Ø3 L=113±3mm using right hand and then insert the wire using left hand.</p>  <p>2. Measure from end of Black VM tube (Sunprene) up to the tip of the terminal 11mm.</p>	<p>MEASURING TAPE</p> 	<ol style="list-style-type: none">1. No wrong use of parts2. No deformed terminal <p>Important reminders/Note/s:</p> <ol style="list-style-type: none">1. Please use calibrated/verified measuring tape when getting the measurement.2. Peel-off wire should be covered by sunprene tube. (Black)

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PARTS:

1. Assy parts

JIG

1. Insertion jig

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

11

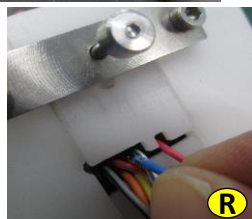
P1

Wire insertion to
connector
1318386-2 (B)INSERTION SEQUENCE FROM LEFT
TO RIGHT

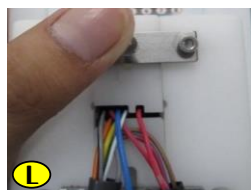
Wire facing

Wire Insertion Illustration

9	10	11	12	13	14	15	16
GR/B	R/W	L	W/G	X	R	X	X
161	154	129	161		154		
1	2	3	4	5	6	7	8
GR	OR	Y		X	X	X	X
161	161	161		X	X	X	X



1. Get the **L wire** with inserted tube and insert to connector on **slot 11** using right hand.



2. Press the unlock button and press the unlock lever using left thumb

3. Hold the wires using right hand and gently pull out the connector from jig using right hand.

n/a

1. Use the provided jig per model
2. No wrong usage of parts
3. No wrong orientation of connector
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. Insertion of wire must be from left to right.
3. Make sure wires are properly inserted.
- Conduct **Pull-Push-Pull-Push** after insertion.
4. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.

Document reference/s:

1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
2. Please refer to WI-PRO-CNC-017 for Wire and Strip length tolerance.
3. Please refer to GL-PRO-ASY-029 for Pull-Push- procedure.

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PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

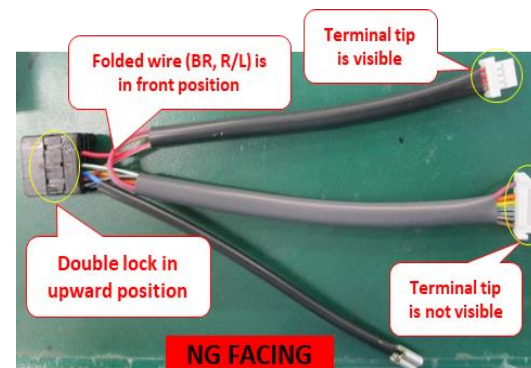
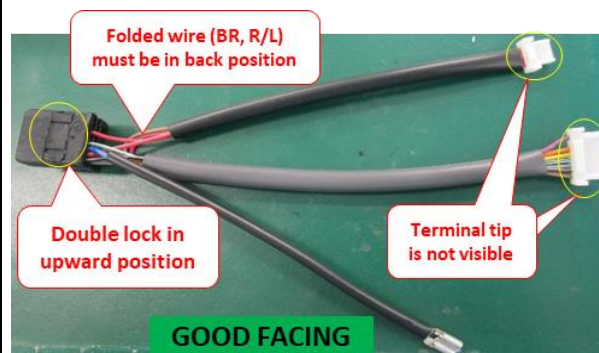
12

P1

Wire arrangement



1. Hold the harness using both hands and conduct wire arrangement.



Document reference/s:

1. Refer to WI-ENG-PDE-171 for Electrical Test

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

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DCC Stamp



WORK INSTRUCTION

Effectivity Date:

February 2, 2023

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model Code/Part Number:

D01L / 75N353-0011

Customer:

TRJ

Document No.:

WI-ENG-PDE-117

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

5

Page No.:

12 of 14

PARTS:

n/a

JIG:

n/a

NO.

PROCESS NAME

5

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

13

P1

Visual/By Two's Inspection

1. Check the connector lock, locking of connector is included in electrical test.

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

3. Check the terminal if with backing out (not fully inserted) or deformed terminal.

Black VM tube (Sunprene)

Dark Gray VM tube (Sunprene)

Black VM Tube (Sunprene)

4. Check the orientation of harness.

5. Compare to **Master sample** by tapping.

MASTER SAMPLE



1. No skip checking during inspection.



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Page No.:

13 of 14**PARTS:**

n/a

JIG:

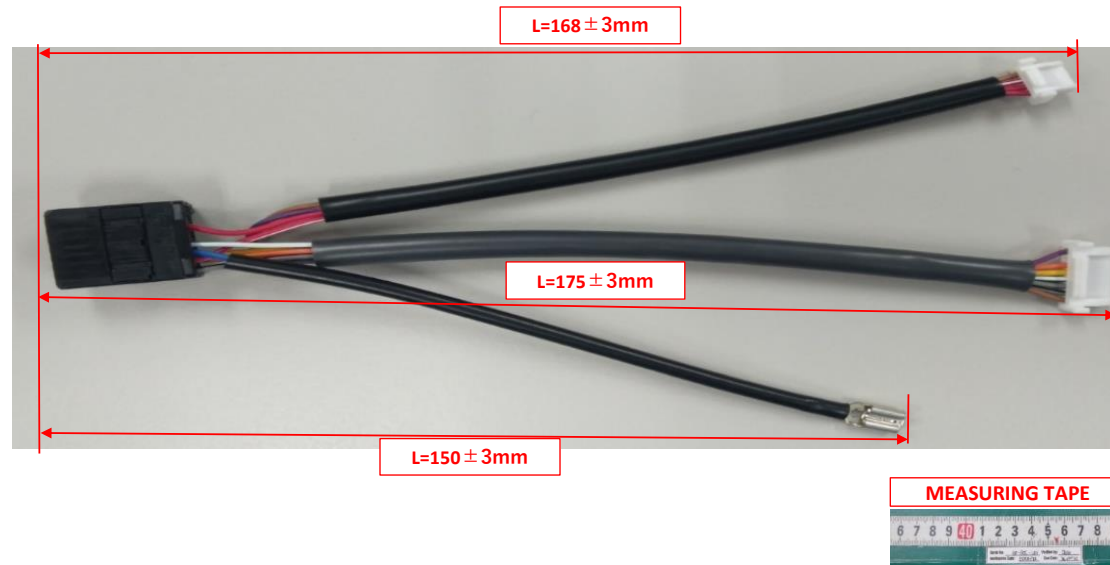
n/a

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

14

P1

Measurement



1. No wrong facing of harness
2. No Tangled wires
3. No missing parts

Important reminders/Note/s:

1. Please use calibrated/verified measuring tape when getting the measurement.
2. For Hatsumono and Owarimono.

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☐ PROTOTYPE

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n/a

JIG:

n/a



QUALITY CHECKPOINTS

75N353

6. Compare to master sample.

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

1. Check the
connector lock.

CORRECT FACING

Dark Gray VM tube (Sunprene)

Black VM tube (Sunprene)

Black 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

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