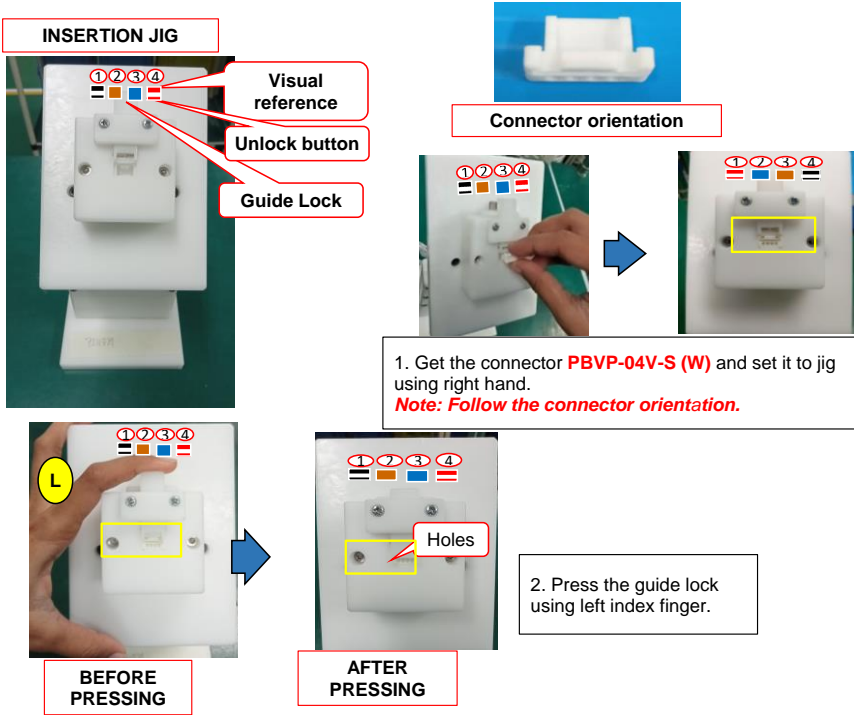
	<b>WORK INSTRUCTION</b> <b>TAPING ASSEMBLY PROCESS</b>				Effectivity Date:	November 9, 2023		
	Process Name/Title:				Validity Date:	n/a		
	Model code/Part number: <b>Y2R/Y2K / 75N829-7020</b>		Customer: <b>TRJ</b>	Car Model: <b>SUZUKI-HUSTLER</b>	Document No.:	<b>WI-ENG-PDE-014</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	6	Page No.:	1 of 10


  

<b>PARTS:</b>	1. Connector PBVP-04V-S (W)			JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
1	P1 Connector setting to insertion jig PBVP-04V-S (W)	 <p>1. Get the connector <b>PBVP-04V-S (W)</b> and set it to jig using right hand.  <b>Note: Follow the connector orientation.</b></p> <p>2. Press the guide lock using left index finger.</p>		<p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<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	Reviewed by	Approved by	Noted by
11/09/23	6	Improved insertion jig; Change connector (PBVP-04V-S) orientation, terminal orientation and color sequence as customer claim countermeasure. Inclusion of connector lock as countermeasure to DCS (DC-0623-115). Change term from White sunprene tube to White VM tube (Sunprene).	D. Castillo	C. Villanueva	A. Arañes	n/a	
11/21/22	5	Improve Quality pointers; Reminders/ notes and references on pages no.2 to 9; Improve work procedure/Illustration on process no.7- Visual/By two's inspection. Additional Visual references on page no.9.	M. Ariola	J.Loterie	C. Villanueva	A. Arañes	
07/06/22	4	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.	D. Castillo	J.Loterie	C. Villanueva	A. Arañes	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

November 9, 2023

Validity Date:

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Model code/Part number: Y2R/Y2K / 75N829-7020

Customer: TRJ

Car Model: SUZUKI-HUSTLER

Document No.:

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Purpose:

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**PARTS:** 1. AVSS 0.3 R/W L=197±2mm; L L=197±2mm; BR L=197±2mm; B/W L=197mm±2mm

JIG:

1. Insertion jig

NO.

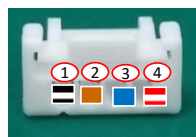
PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

INSERTION SEQUENCE FROM LEFT TO RIGHT



Wire facing

1	2	3	4
B/W	BR	L	R/W
197	197	197	197

STEERING NAVIGATION



CONTROLLER



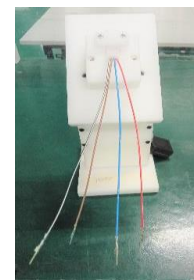
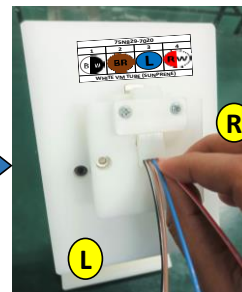
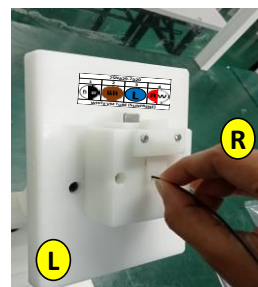
1. No loose insertion
2. No wrong insertion
3. One by one insertion
4. No deformed terminal
5. No wrong wire facing

**Important reminders/Note/s:**

1. Please hold the wire near terminal during insertion.
2. Insertion must be from left to right.
3. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion. Do not exert extra force.

**Document reference/s:**

1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
2. Refer to GL-PRO-ASY-028 for Pull-Push procedure.
3. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance




1. Get the **B/W wire** and insert to terminal slot **1** using right hand. Repeat the process for **BR-L-R/W wires**.

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


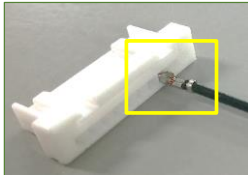

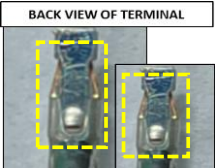
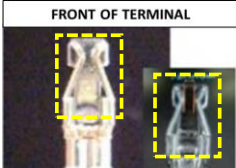
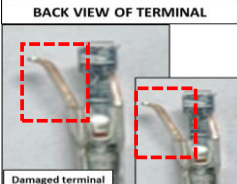
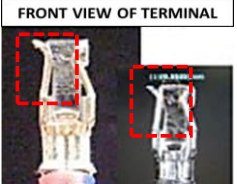
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	<b>WORK INSTRUCTION</b>				Effectivity Date:	November 9, 2023		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>Y2R/Y2K / 75N829-7020</b>		Customer: <b>TRJ</b>	Car Model: <b>SUZUKI-HUSTLER</b>	Document No.:	<b>WI-ENG-PDE-014</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	6	Page No.:	3 of 10

<b>PARTS:</b>	1. AVSS 0.3 R/W L=197±2mm; L L=197±2mm; BR L=197±2mm; B/W L=197mm±2mm			JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
2	P1 Wire insertion to connector PBVP-04V-S (W) (Continuation)	<div style="display: flex; justify-content: space-around;"> <div style="border: 1px solid green; padding: 5px; text-align: center;"> <b>Proper alignment of terminal to connector</b> </div> <div style="border: 1px solid red; padding: 5px; text-align: center;"> <b>Improper alignment of terminal to connector</b> </div> </div> <div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;">   </div> <div style="text-align: center;">  </div> </div> <div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;">  <p><b>GOOD</b> Terminal condition</p> </div> <div style="text-align: center;">  <p><b>GOOD</b> Terminal condition</p> </div> <div style="text-align: center;">  <p><b>Damaged terminal</b> <b>NO GOOD</b> Terminal condition</p> </div> <div style="text-align: center;">  <p><b>NO GOOD</b> Terminal condition</p> </div> </div> <div style="border: 1px solid black; padding: 10px; margin-top: 10px;"> <p>Note:</p> <p><i>*Make sure the terminal was in proper alignment before insert.</i></p> <p><i>*Avoid hitting the terminal into the connector during wire insertion, if encountered abnormality stop the process and call the attention of Immediate superior and Automatically disposed and replace the unit.</i></p> </div>			1. Use provided jig per model 2. No wrong usage of parts 3. No wrong insertion 4. No deformed terminal 5. No stuck of terminal tip 6. One by one insertion  <b>Important reminders/Note/s:</b>  1. <i>Make sure wires are properly inserted. Conduct <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force.</i> 2. <i>Please hold the wires near terminal during insertion.</i> 3. <i>Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</i> 4. <i>Insertion of wires must be from left to right.</i>  <b>Document reference/s:</b>  1. <i>Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</i> 2. <i>Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..</i> 3. <i>Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i> 4. <i>Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</i>

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Process Name/Title:

## TAPING ASSEMBLY PROCESS

Validity Date:

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Model code/Part number: Y2R/Y2K / 75N829-7020

Customer: TRJ

Car Model: SUZUKI-HUSTLER

Document No.:

WI-ENG-PDE-014

Purpose:

☐ PROTOTYPE

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PARTS:

6

1. White VM tube (Sunprene)  $\phi 5$  L=165 $\pm$ 3mm
2. Assy parts

JIG:

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

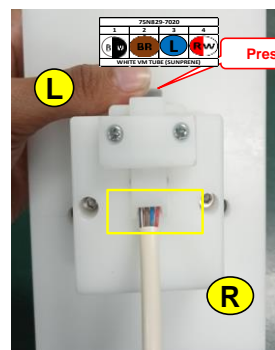
3

P1

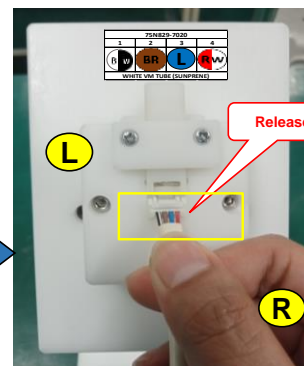
Wire insertion to  
White VM tube (Sunprene)  
 $\phi 5$  L=165 $\pm$ 3mm



1. Get the **White VM tube (Sunprene)  $\phi 5$  L=165 $\pm$ 3mm** using right hand and insert the wires using left hand.



Press



Released

2. Press the unlock button using left thumb to release the lock. Gently pull out the connector from jig using right hand. Check the terminal tip condition.

n/a

1. No wrong usage of parts
2. No deformed terminal



Terminal tip must be visible


Document reference/s:

1. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion

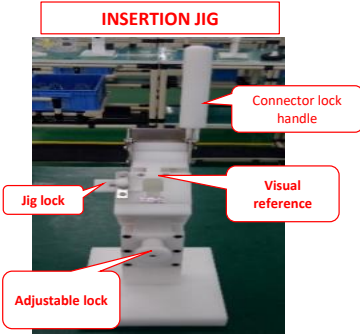
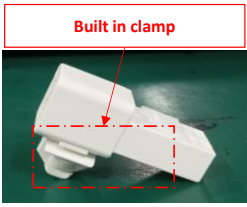
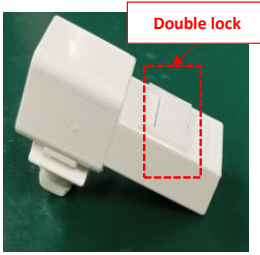

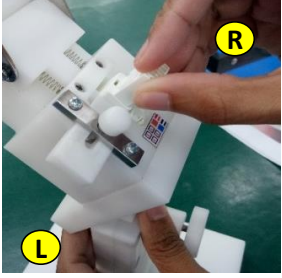
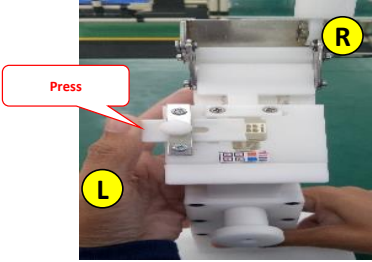


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
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	<b>WORK INSTRUCTION</b>				Effectivity Date:	<b>November 9, 2023</b>		
	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	<b>n/a</b>		
	Model code/Part number: <b>Y2R/Y2K / 75N829-7020</b>		Customer: <b>TRJ</b>	Car Model: <b>SUZUKI-HUSTLER</b>	Document No.:	<b>WI-ENG-PDE-014</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	6	Page No.:	5 of 10

PARTS:		1. Connector 4B1080-0000 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
4	P1 Connector setting to insertion jig 4B1080-0000 (W)	<div>       <div> <p>1. Get the connector <b>4B1080-0000 (W)</b> and insert to jig using right hand.  <i>Note: Follow the connector orientation.</i></p> <p>2. Press the lock using left thumb after insertion.</p> </div> </div>	n/a	<p>1. Use the provided jig per model</p> <p>2. No wrong usage of parts</p> <p>3. No wrong orientation of connector</p> <p>4. No damaged connector</p> <p><b>Important reminders/Note/s:</b></p> <p><i>1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</i></p> <p><i>2. Check the connector before insertion.</i></p> <div> <p><b>CONNECTOR LOCK APPEARANCE CHECK</b></p> <div>   <div> <p>UNLOCK</p> <p>HALF-LOCKED</p> </div> </div> </div>	

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**WORK INSTRUCTION**

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**n/a**Model code/Part number: **Y2R/Y2K / 75N829-7020**Customer: **TRJ**Car Model: **SUZUKI-HUSTLER**

Document No.:

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Purpose:

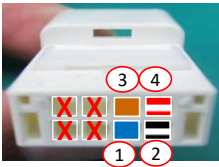

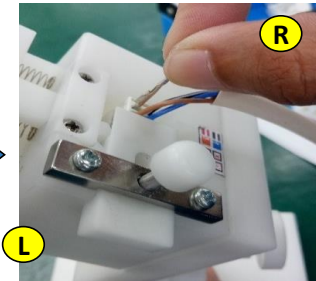

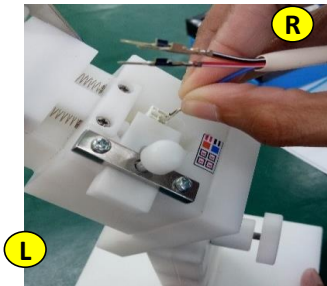
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. Assy parts		JIG:	1.Insertion jig																								
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS																								
5	P1 Wire insertion to connector 4B1080-0000 (W)	<div>INSERTION SEQUENE FROM LEFT TO RIGHT</div> <div><table><tr><td></td><td></td><td>3</td><td>4</td></tr><tr><td>X</td><td>X</td><td>BR</td><td>R/W</td></tr><tr><td></td><td></td><td>197</td><td>197</td></tr><tr><td></td><td></td><td>1</td><td>2</td></tr><tr><td>X</td><td>X</td><td>L</td><td>B/W</td></tr><tr><td></td><td></td><td>197</td><td>197</td></tr></table><div>Wire facing</div><div></div><div>1. Get the <b>L wire</b> and insert to terminal slot <b>1</b> using right hand. Repeat the process for <b>B/W-BR-R/W wires</b>. <b>Note: Follow the insertion sequence based on the illustration.</b></div></div>			3	4	X	X	BR	R/W			197	197			1	2	X	X	L	B/W			197	197	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:</div> <div>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 <b>Pull-Push-Pull-Push</b> after insertion. Do not exert extra force. 4. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector</div> <div>Document reference/s:</div> <div>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance 2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>
		3	4																									
X	X	BR	R/W																									
		197	197																									
		1	2																									
X	X	L	B/W																									
		197	197																									

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Customer: TRJ

Car Model: SUZUKI-HUSTLER

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Purpose:



PROTOTYPE



PRE-LAUNCH




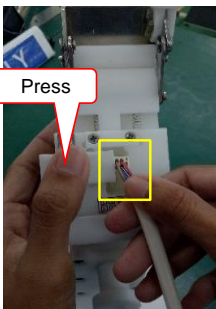
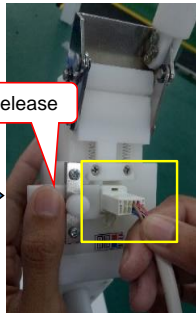

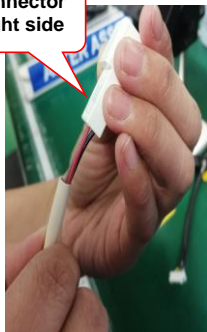


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PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1	<div><div><div>Connector lock handle</div><div></div></div><div><div>1. Pull down the handle using right hand to lock the connector.</div></div><div><div><div>Press</div><div></div></div><div><div>Release</div><div></div></div><div><div>2. Press the unlock button to release the lock using left thumb. Then slowly remove the harness from jig. Check the lock if properly pressed.</div></div><div><div><div>Connector Left side</div><div></div></div><div><div>Connector Right side</div><div></div></div><div><div>3. Conduct visual checking of lock from side to side (Left to right).</div></div></div></div></div>	n/a	<div>1. Use the provided jig tool to lock the connector.</div> <div>2. No unlock/half-locked connector</div> <div><b>Important reminders/Notes/:</b></div> <div>1. Manual locking may cause damaged connector lock.</div> <div><div></div><div>BEFORE</div><div></div><div>AFTER</div></div>

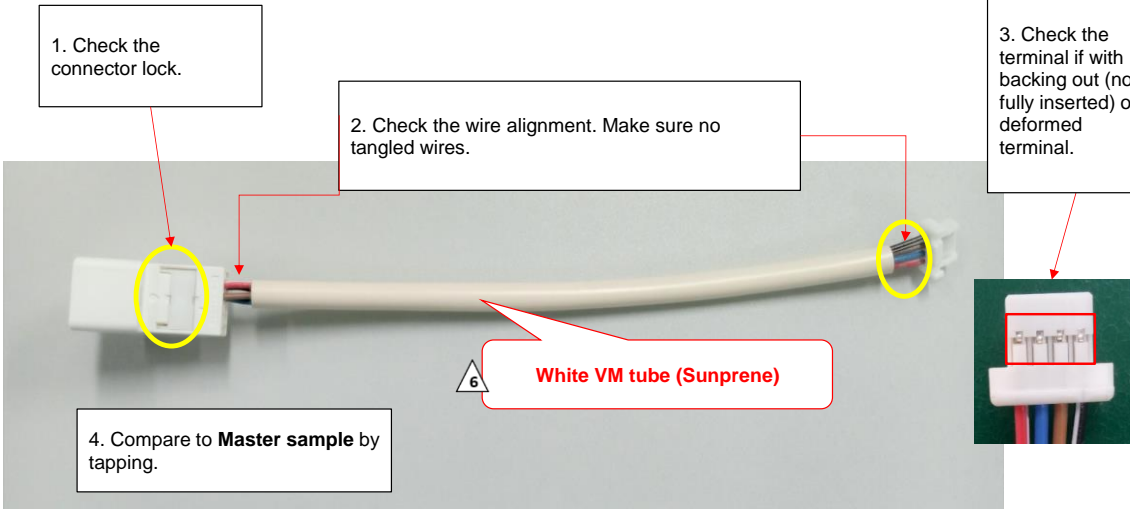
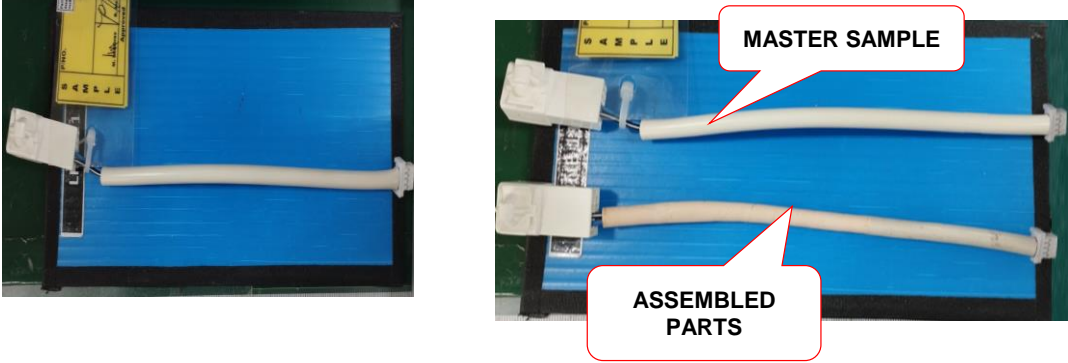

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	Model code/Part number: <b>Y2R/Y2K / 75N829-7020</b>		Customer: <b>TRJ</b>	Car Model: <b>SUZUKI-HUSTLER</b>	Document No.:	<b>WI-ENG-PDE-014</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	6	Page No.:	8 of 10


  

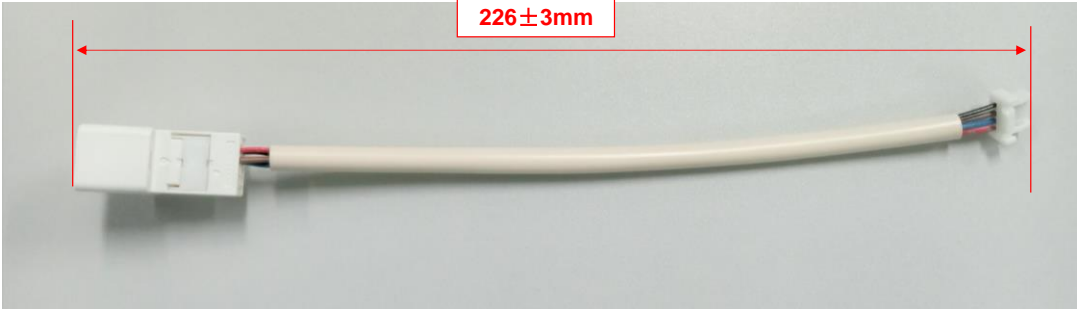

<b>PARTS:</b> 1. Assy parts 2. Master sample		JIG: n/a	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>
7	P1 Visual/By Two's Inspection	<div> <div>1. Check the connector lock.</div> <div>2. Check the wire alignment. Make sure no tangled wires.</div> <div>3. Check the terminal if with backing out (not fully inserted) or deformed terminal.</div> <div>4. Compare to <b>Master sample</b> by tapping.</div> <div>  </div> <div>  </div> </div>	<div>  </div> <div> <p>1. No skip checking during inspection.</p> <p><b>Document reference/s:</b></p> <p>1. Refer to WI-ENG-PDE-431 for Steering Electrical Test after assembly.</p> </div>

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	Process Name/Title: <b>TAPING ASSEMBLY PROCESS</b>				Validity Date:	n/a		
	Model code/Part number: <b>Y2R/Y2K / 75N829-7020</b>		Customer: <b>TRJ</b>	Car Model: <b>SUZUKI-HUSTLER</b>	Document No.:	<b>WI-ENG-PDE-014</b>		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	6	Page No.:	9 of 10

<b>PARTS:</b>	n/a			JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
8	P1 Measurement	<div><div>MEASURING TAPE</div></div>			<div>1. No wrong dimension.</div> <div><b>Important reminders and note/s:</b> 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono 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>

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# WORK INSTRUCTION

Process Name/Title:

## TAPING ASSEMBLY PROCESS

Effectivity Date:

November 9, 2023

Validity Date:

n/a

Model code/Part number: Y2R/Y2K / 75N829-7020

Customer: TRJ

Car Model: SUZUKI-HUSTLER

Document No.:

WI-ENG-PDE-014

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

6

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10 of 10

PARTS:

n/a

JIG:

n/a

### QUALITY CHECKPOINTS

75S829-7020

3. Check the terminal if with backing out (no fully inserted) or deformed terminal.

1. Check the connector lock.

6 White VM tube (Sunprene)

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

4. Compare to master sample.

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