

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

December 06, 2024

Validity Date:

n/aModel code/Part number: **Y2R/Y2K / 75N830-7020A**Customer: **TRJ**

Car Model:

SUZUKI - SOLIO

Document No.:

WI-ENG-PDE-1175

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

1 of 11**PARTS:**

1. Connector PBVP-04V-S (W); AVSS 0.3 Red/White L=197±2mm ; Blue L=197±2mm; Brown L=197±2mm; Black/White L=197±2mm

JIG:

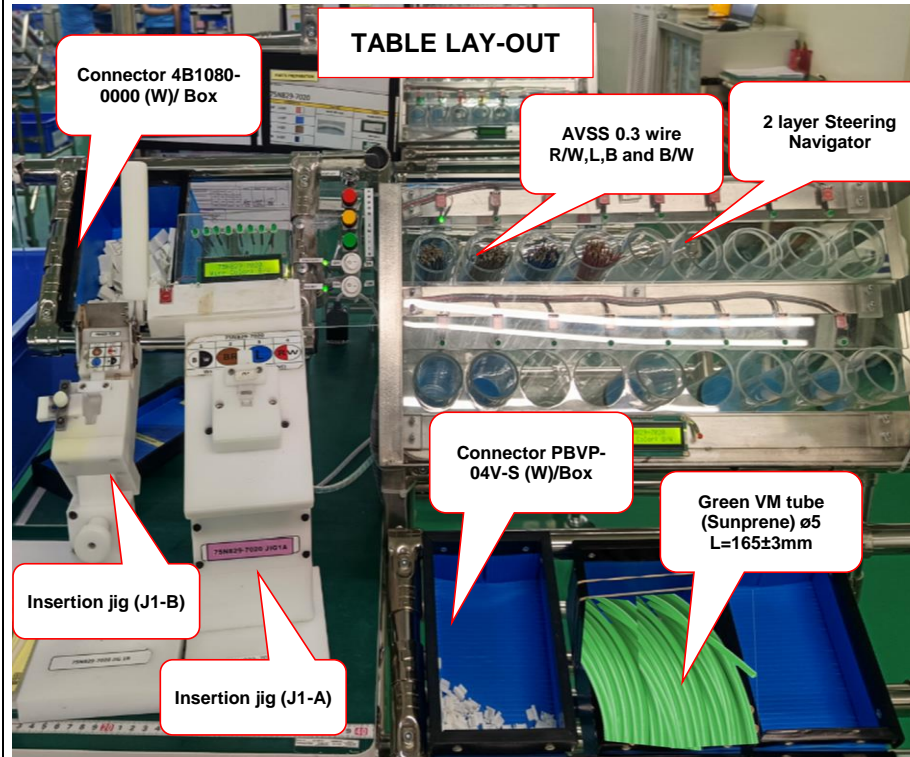
1. Insertion jig
2. Steering Navigation

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

1

P1

Table lay-out



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

Revision History

Prepared by

Reviewed by

Approved by

Noted by

12/06/24 1 Change purpose from Pre-launch to Masspro; Additional table lay-out.

M. Ariola

C. Villanueva

A. Arañes

n/a

11/18/24 0 Initial Issue.

M. Ariola

C. Villanueva

A. Arañes

n/a

Eff. Date

Rev. No

Details of Change

Revised

Reviewed

Approved

Noted

Est. Date:

November 18, 2024

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number: Y2R/Y2K / 75N830-7020A

Customer: TRJ

Car Model: SUZUKI - SOLIO

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

December 06, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1175

Revision No.:

1

Page No.:

2 of 11

PARTS:

1. AVSS 0.3 Red/White L=197±2mm ; Blue L=197±2mm; Brown L=197±2mm; Black/White L=197±2mm

JIG:

1. Insertion jig
2. Steering Navigation

NO.

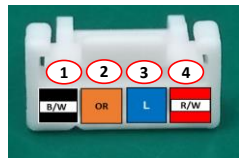
PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

INSERTION SEQUENCE FROM LEFT TO RIGHT



TERMINAL ORIENTATION

WIRE INSERTION ILLUSTRATION

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

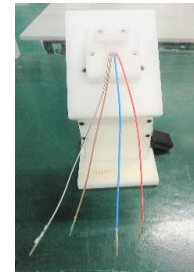
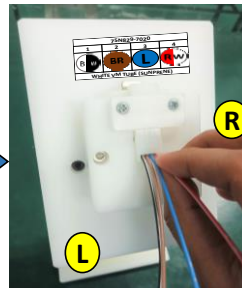
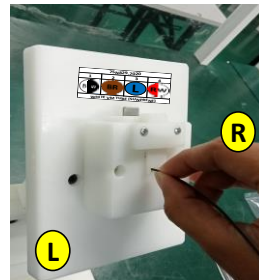
STEERING NAVIGATION



CONTROLLER



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



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.

1. No removed wires or wrong insertion
2. Must have slight movement after insertion
3. No stuck-up terminal tip
4. No deformed terminal

Important reminders/Note/s:

1. Insertion of wire must be from left to right.
 2. 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 reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
3. Refer to WI-ENG-PDE-044 for steering navigation controller procedure.

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

December 06, 2024

Validity Date:

n/a

Model code/Part number: Y2R/Y2K / 75N830-7020A

Customer: TRJ

Car Model: SUZUKI - SOLIO

Document No.:

WI-ENG-PDE-1175

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

3 of 11

PARTS: 1. AVSS 0.3 Red/White L=197±2mm ; Blue L=197±2mm; Brown L=197±2mm; Black/White L=197±2mm

JIG:

1. Insertion jig
2. Steering Navigation

NO.

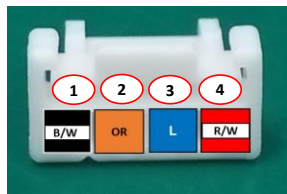
PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

INSERTION SEQUENCE FROM LEFT TO RIGHT



TERMINAL ORIENTATION

WIRE INSERTION ILLUSTRATION

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

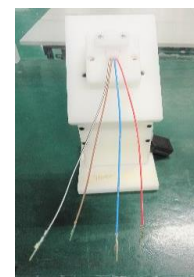
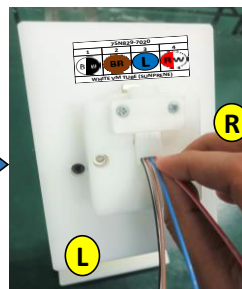
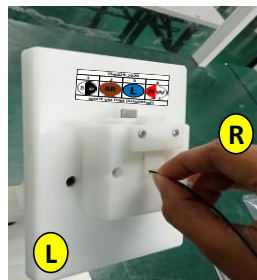
STEERING NAVIGATION



CONTROLLER



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



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.**

1. No removed wires or wrong insertion
2. Must have slight movement after insertion
3. No stuck-up terminal tip
4. No deformed terminal

Important reminders/Note/s:

1. Insertion of wire must be from left to right.
 2. 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 reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
3. Refer to WI-ENG-PDE-044 for steering navigation controller procedure.

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

December 06, 2024

Validity Date:

n/a

Model code/Part number: Y2R/Y2K / 75N830-7020A

Customer: TRJ

Car Model: SUZUKI - SOLIO

Document No.:

WI-ENG-PDE-1175

Purpose:

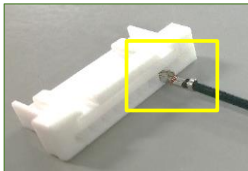
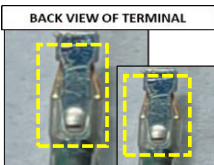
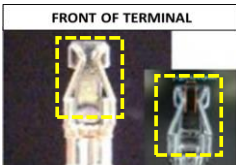

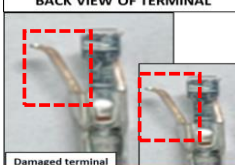
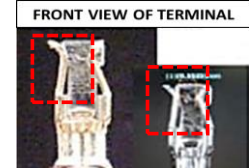
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

4 of 11

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
2	P1 Wire insertion to connector PBVP-04V-S (W) (Continuation)	<div><div>Proper alignment of terminal to connector</div><div></div><div><div>BACK VIEW OF TERMINAL</div><div></div><div>GOOD Terminal condition</div></div><div><div>FRONT OF TERMINAL</div><div></div><div>GOOD Terminal condition</div></div></div> <div><div>Improper alignment of terminal to connector</div><div></div><div><div>BACK VIEW OF TERMINAL</div><div></div><div>Damaged terminal NO GOOD Terminal condition</div></div><div><div>FRONT VIEW OF TERMINAL</div><div></div><div>NO GOOD Terminal condition</div></div></div> <div>Note: <i>*Make sure the terminal was in proper alignment before insert.</i> <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></div>		<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</div> <div>Important reminders/Note/s: <i>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</i> <i>2. Please hold the wires near terminal during insertion.</i> <i>3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</i> <i>4. Insertion of wires must be from left to right.</i></div> <div>Document reference/s: <i>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</i> <i>2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..</i> <i>3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i> <i>4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</i></div>

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

December 06, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number: Y2R/Y2K / 75N830-7020A

Customer: TRJ

Car Model: SUZUKI - SOLIO

Document No.:

WI-ENG-PDE-1175

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH


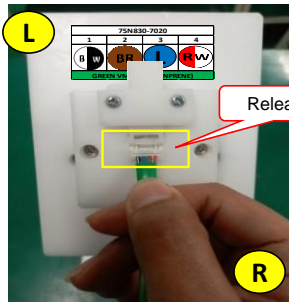
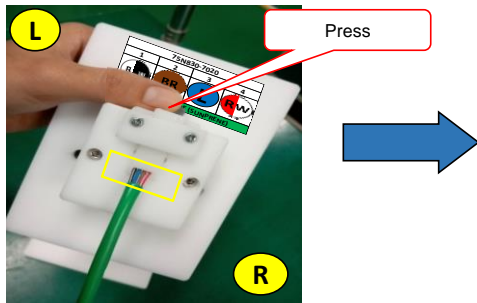

☒ MASSPRO

Revision No.:

1

Page No.:

5 of 11

PARTS:		1. Assy parts 2. Green VM tube (Sunprene) $\phi 5$ L=165 \pm 3mm		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1 Wire insertion to Green VM tube (Sunprene) $\phi 5$ L=165 \pm 3mm	<div><div>1. Get the Green VM tube (Sunprene) $\phi 5$ L=165\pm3mm using right hand and insert the wires.</div></div> <div><div>2. Press the unlock button using left thumb to release the lock guide. Then slowly remove the harness from jig. Check the wire insertion condition.</div></div>		n/a	<div><div>Terminal tip must be visible</div></div> <div>1. No wrong usage of parts 2. No deformed terminal</div>

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number: Y2R/Y2K / 75N830-7020A

Customer: TRJ

Car Model: SUZUKI - SOLIO

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

December 06, 2024

Validity Date:

n/a

Document No.:

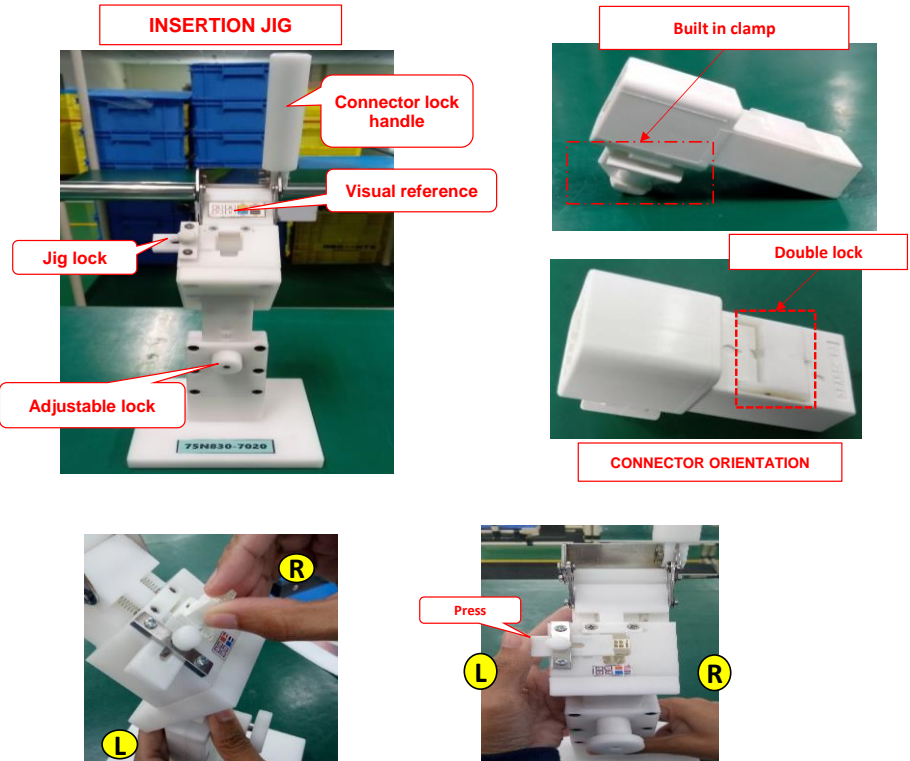
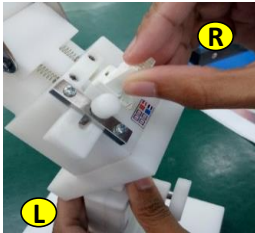
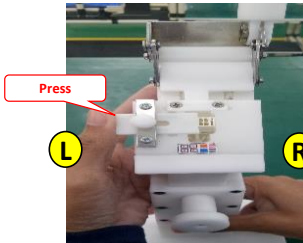


WI-ENG-PDE-1175

Revision No.:

1

Page No.:

6 of 11

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><div>INSERTION JIG</div></div><div><div><p>1. Get the connector 4B1080-0000 (W) and insert to jig using right hand. <i>Note: Follow the connector orientation.</i></p></div><div><p>2. Press the lock using left thumb after insertion.</p></div></div></div>	n/a	<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>Important reminders/Note/s:</div> <div>1. Check the connector before insertion.</div> <div>2. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</div> <div><div>CONNECTOR LOCK APPEARANCE CHECK</div><div><div></div><div></div></div></div>

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Effectivity Date:

December 06, 2024

Process Name/Title:

Validity Date:

n/aModel code/Part number: **Y2R/Y2K / 75N830-7020A**Customer: **TRJ**Car Model: **SUZUKI - SOLIO**

Document No.:

WI-ENG-PDE-1175

Purpose:

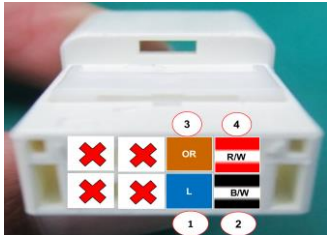

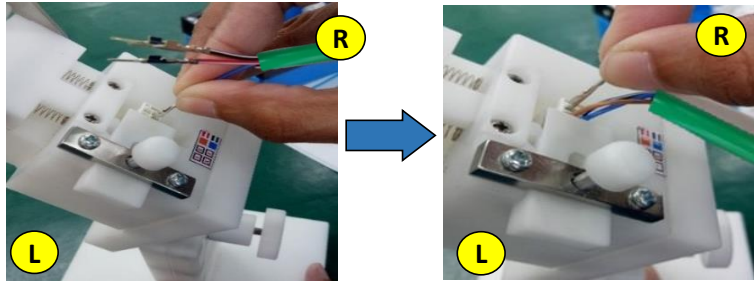
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

7 of 11

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></div> <div><div>WIRE INSERTION ILLUSTRATION</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> <div></div> <div>TERMINAL ORIENTATION</div> <div></div> <div>1. Get the L wire and insert to terminal slot 1 using right hand. Repeat the process for B/W-BR-R/W wires. Note: Follow the insertion sequence based on the illustration.</div>			3	4	X	X	BR	R/W			197	197			1	2	X	X	L	B/W			197	197	n/a	<div>1. No removed wires or wrong insertion 2. Must have slight movement after insertion 3. No stuck-up terminal tip 4. No deformed terminal</div> <div>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.</div> <div>Document reference/s: 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																									

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp

**WORK INSTRUCTION****TAPING ASSEMBLY PROCESS**

Effectivity Date:

December 06, 2024

Process Name/Title:

Validity Date:

n/aModel code/Part number: **Y2R/Y2K / 75N830-7020A**Customer: **TRJ**Car Model: **SUZUKI - SOLIO**

Document No.:

WI-ENG-PDE-1175

Purpose:

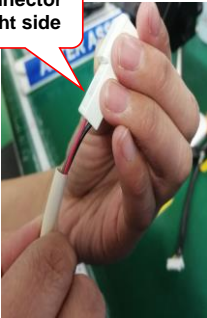
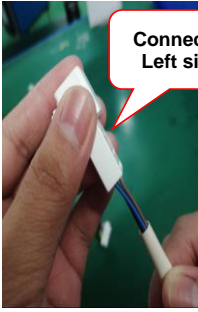
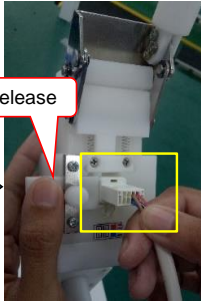
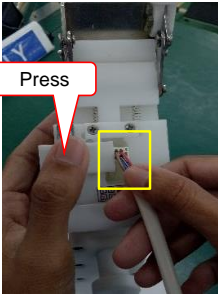
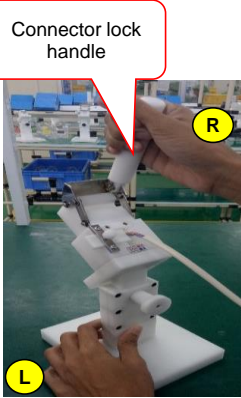

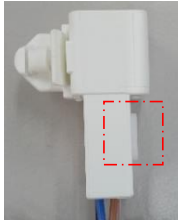
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

8 of 11

PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1	Connector lock	<div><p>1. Pull down the handle using right hand to lock the connector.</p><p>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.</p><p>3. Conduct visual checking of lock from side to side (Left to right).</p></div>	n/a	<p>1. Use the provided jig tool to lock the connector. 2. No unlock/half-locked connector</p> <p>Important reminders/Notes/:</p> <p>1. Manual locking may cause damaged connector lock.</p> <div><p>BEFORE</p><p>AFTER</p></div>

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number: Y2R/Y2K / 75N830-7020A

Customer: TRJ

Car Model: SUZUKI - SOLIO

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

December 06, 2024

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1175

Revision No.:

1

Page No.:

9 of 11

PARTS:

1. Assembled parts
2. Master sample

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

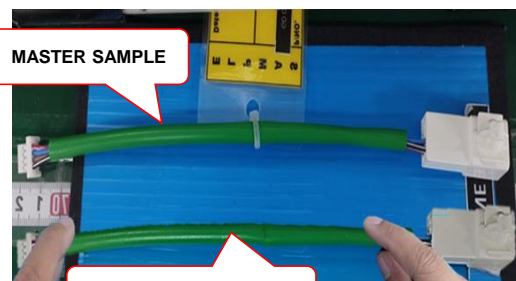
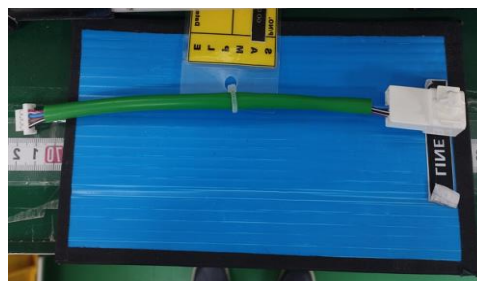
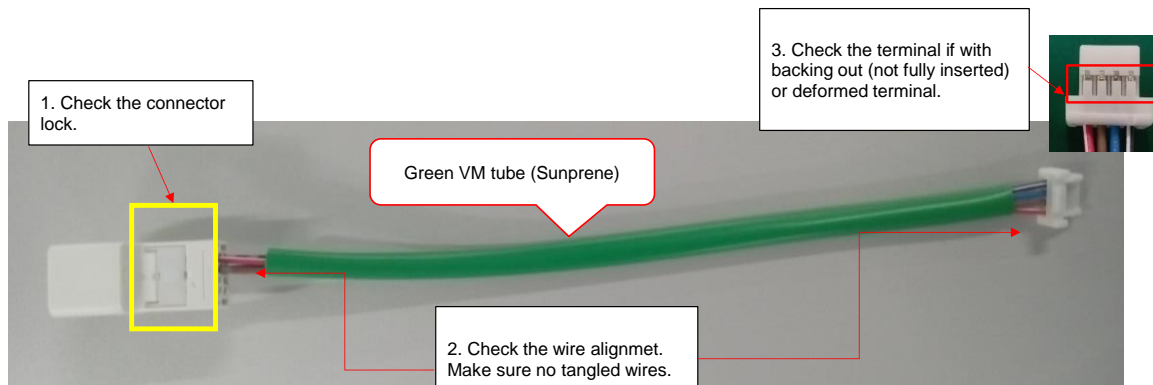
TOOLS/PPE

QUALITY POINTERS

7

P1

Visual Inspection/By Two's inspection



MASTER SAMPLE



1. No skip checking during inspection.

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp



WORK INSTRUCTION

Effectivity Date:

December 06, 2024

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number: Y2R/Y2K / 75N830-7020A

Customer: TRJ

Car Model: SUZUKI - SOLIO

Document No.:

WI-ENG-PDE-1175

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

10 of 11

PARTS:

n/a

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

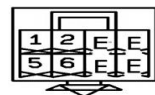
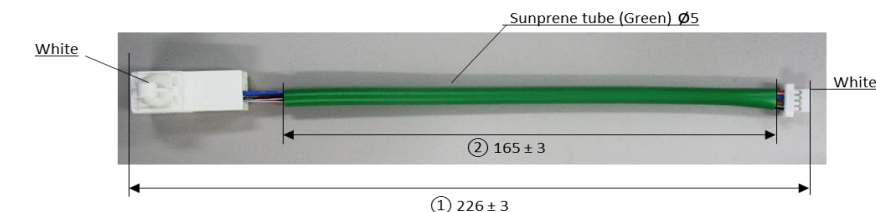
TOOLS/PPE

QUALITY POINTERS

8

P1

Measurement



R/W	BR		
B/W	L		

1	6	2	5
R/W	L	BR	B/W

WIRE TYPE TABLE		
No	Color	Wire Type
1	R/W	AVSS 0.3
2	BR	AVSS 0.3
5	B/W	AVSS 0.3
6	L	AVSS 0.3
E	EMPTY	



Important reminders and note/s:

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

Document reference/s:

1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection

1. No wrong dimension.

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp



WORK INSTRUCTION

Process Name/Title: TAPING ASSEMBLY PROCESS

Effectivity Date:

December 06, 2024

Validity Date:

n/a

Model code/Part number: Y2R/Y2K / 75N830-7020A

Customer: TRJ

Car Model: SUZUKI - SOLIO

Document No.:

WI-ENG-PDE-1175

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

1

Page No.:

11 of 11

PARTS:

n/a

JIG:

n/a

QUALITY CHECKPOINTS

75N830-7020A

1. Check the connector lock.

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

Green VM tube (Sunprene)

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

CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.

NBC (Philippines)
MASTER COPY

DCC Stamp