



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

February 24, 2023

Process Name/Title:

Model Code/Part Number:

011B

/ 75L175-0300A

Customer:

TRJ

Validity Date:

n/a

Document No.:

WI-ENG-PDE-120

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

8

Page No.:

1 of 14

PARTS:

1. Connector PBVP-10V-S (W) [2pcs]

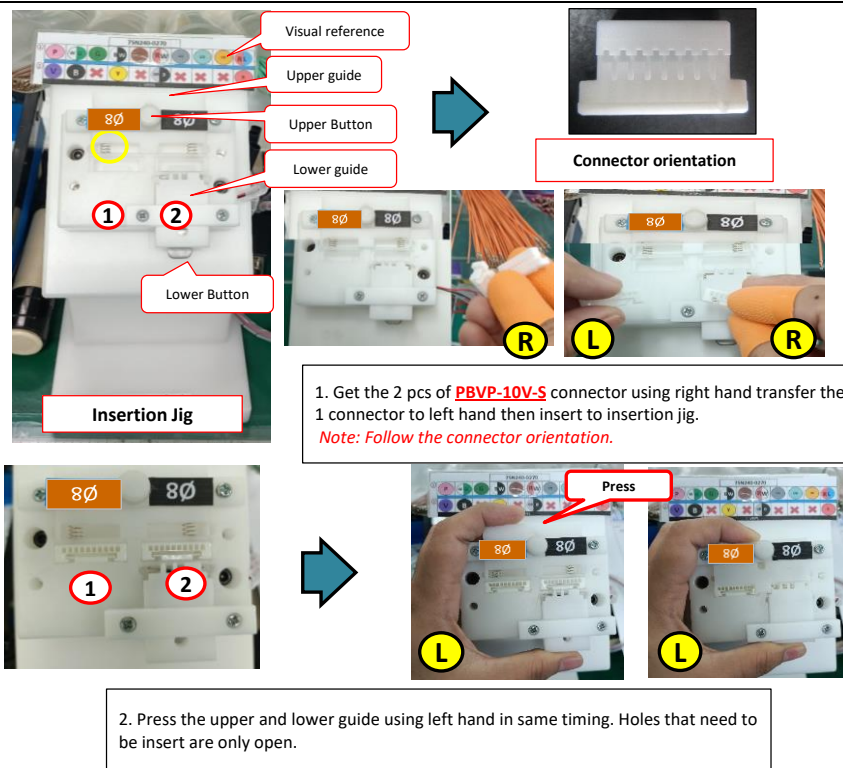
JIG:

1. Insertion jig

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

1

P1

Connector setting to
insertion jig
PBVP-10V-S (W)**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 usage of parts
3. No wrong orientation of connector
4. No damaged connector

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Established Date:	Prepared by:	Reviewed by:	Approved by:	Noted by:
02/24/23	8	Change color of VM tube (Sunprene) from Brown to Dark Brown. Standardize the tube description: VM tube (Sunprene) Inclusion of Quality checkpoints	M. Ariola	J. Loterte	C. Villanueva	A. Arañes					
08/31/22	7	Improved the insertion jig and procedure. Improved visual/by two's inspection.	D.Castillo	J. Loterte	C. Villanueva	A. Arañes					
08/04/22	6	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					
Established Date: September 24, 2018								M. Ariola	J. Loterte	C. Villanueva	A. Arañes

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Revision No.:

8

Page No.:

2 of 14

PARTS:

8

1. AVSS 0.3 LG L=217±2mm; W L=215±2mm; GR L=213±2mm; GR/B L=380±2mm; G L=209±2mm; R/L L=382±2mm; W/G L=386±2mm; L L=203±2mm; R/W L=378±2mm; BR L=384±2mm
2. Dark Brown VM tube (Sunprene) Ø8 L=163±3mm

JIG

1. Insertion jig

NO.**PROCESS NAME**

8

WORK PROCEDURE/ ILLUSTRATION**TOOLS/PPE****QUALITY POINTERS**

2

P1

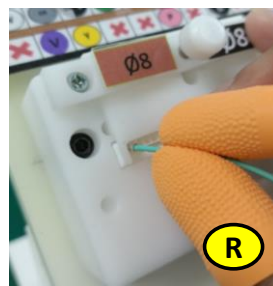
Wire insertion to
Connector
PBVP-10V-S (W)

INSERTION SEQUENCE FROM LEFT TO RIGHT



Wire facing

1	2	3	4	5	6	7	8	9	10
LG	W	GR	GR/B	G	R/L	W/G	L	R/W	BR
217	215	213	380	209	382	386	203	378	384



1. Get the **LG wire** using left hand and transfer to right hand then insert to connector. Repeat the process for **W-GR-GR/B-G-R/L-W/G-L-R/W-BR wires**. Check the wire after insertion.
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:

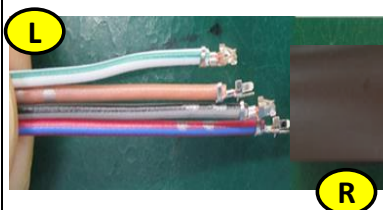
1. Please hold the wire near terminal during insertion.
2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.

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.

3

Wire insertion to
Dark Brown VM Tube
(Sunprene)
Ø8 L=163±3mm



1. Get the **Dark Brown VM Tube (Sunprene) Ø8 L=163±3mm** using left hand and transfer to right hand. Hold the wires using left hand and insert the wires using right hand.

N/A

1. No wrong usage of parts
2. No deformed terminal
3. No tangled wires

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WI-ENG-PDE-120

Revision No.:

8

Page No.:

3 of 14

PARTS:

1. AVSS 0.3 R L=191±2mm; V L=195±2mm; Y L=197±2mm; P L=203±2mm; B L=207±2mm

JIG

1. Insertion jig

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

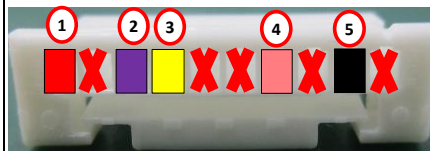
QUALITY POINTERS

4

P1

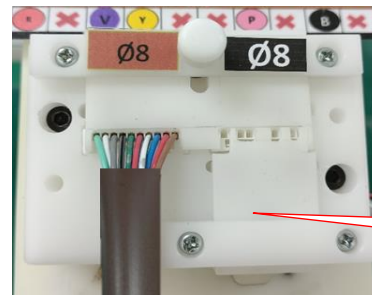
Wire insertion to
Connector
PBVP-10V-S (W)

INSERTION SEQUENCE FROM LEFT TO RIGHT



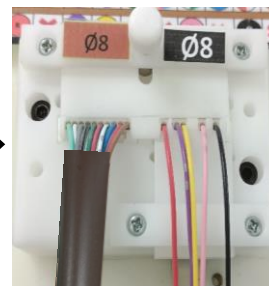
Wire facing

1	2	3	4	5	6	7	8	9	10
R	X	V	Y	X	X	P	X	B	X
191		195	197			203		207	



Lower guide

Note: Holes that need to be insert are only open.



1. Get the **R** wire using right hand and insert to connector. Repeat the process for **V-Y-P-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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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

8

Page No.:

4 of 14

PARTS:

1. Black VM tube (Sunprene) Ø8 L=151±3mm

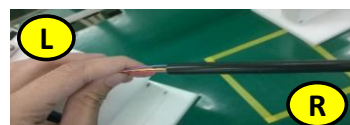
JIG

1. Insertion jig

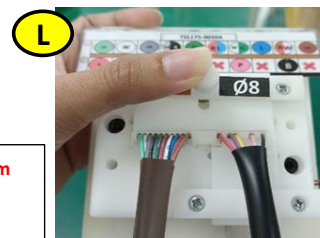
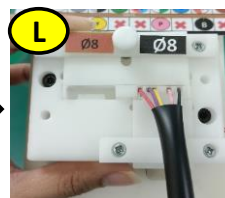
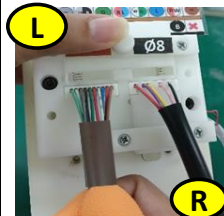
NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

5

P1

Wire insertion to
Black VM tube
(Sunprene)
Ø8 L=151±3mm

1. Get the **Black VM tube (Sunprene) Ø8 L=151±3mm** using right hand. Hold the wire using left hand then insert the wires.

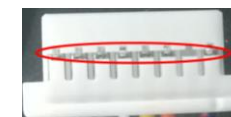


2. Press the
Upper
button using
left hand.

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.
Note: Second connector with inserted wire and Black VM tube (Sunprene) will stay in the jig.

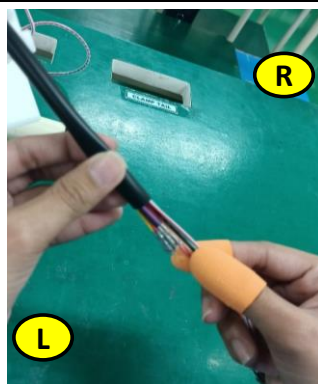
N/A

1. No wrong usage of parts
2. No deformed terminal
3. No tangled wires

**Terminal tip must be visible****Document References:**

1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.

6

Wire insertion to assy
parts

1. Hold the **Black VM tube (Sunprene)** using left hand and insert the wires from **Dark Brown VM tube (Sunprene)** using right hand.

N/A

1. No wrong use of parts
2. No deformed terminal
3. No tangled wires

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☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Document No.:

WI-ENG-PDE-120

Revision No.:

8

Page No.:

5 of 14

PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

7

P1

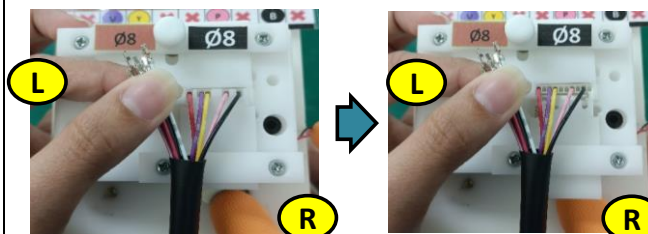
Wire insertion to
Connector
PBVP-10V-S (W)

INSERTION SEQUENCE FROM LEFT TO RIGHT

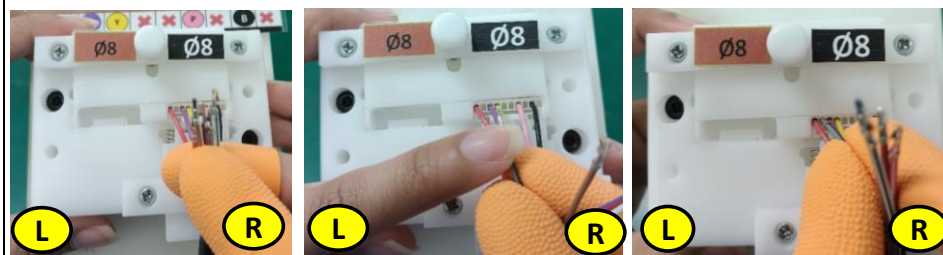


Wire facing

1	2	3	4	5	6	7	8	9	10
R	GR/B	V	Y	R/L	R/W	P	W/G	B	BR
191	380	195	197	382	378	203	386	207	384



1. Press the Lower button
using right hand. Holes that
need to be insert are only
open.



2. Hold the **GR/B** wire using right hand and support the wire by left index finger then insert to connector using right hand. Repeat the process on **R/L-R/W-W/G-BR** 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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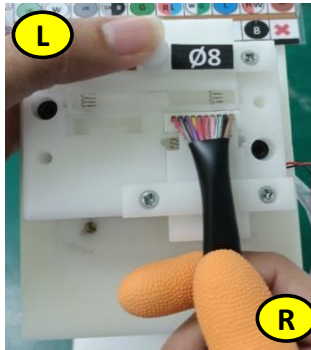
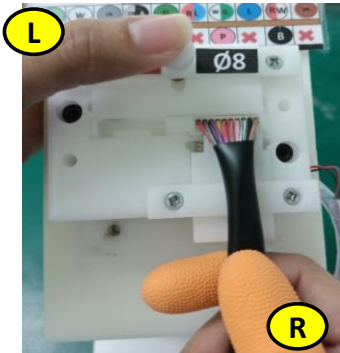
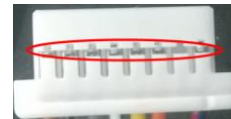
WI-ENG-PDE-120

Revision No.:

8

Page No.:

6 of 14

PARTS:		1. Assy parts			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
7	P1	<div></div> <div>3. Press the Upper button using left hand then remove the assy part using right hand. Check the insertion condition.</div>			N/A	<div></div> <div>Terminal tip must be visible</div> <div>Document References: 1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.</div> <div>1. No deformed terminals 2. No tangled wires 3. No wrong facing</div>

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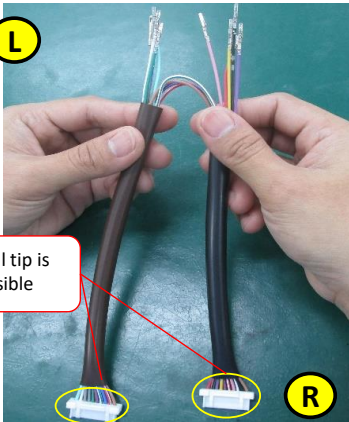
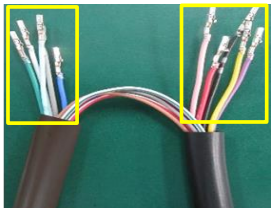

☒ MASSPRO

Revision No.:

8

Page No.:

7 of 14

PARTS:		1. Assy parts			JIG	n/a
NO.	PROCESS NAME		8 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1	Wire arrangement	<div><p>BEFORE FOLDING</p></div> <div><div><div>L</div><p>Terminal tip is not visible</p><div>R</div></div><p>AFTER FOLDING</p></div> <div><p>1. Hold the assy parts using both hands then conduct wire arrangement.</p></div>		n/a	1. No deformed terminals 2. No tangled wires 3. No wrong facing

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Document No.:

WI-ENG-PDE-120

Revision No.:

8

Page No.:

8 of 14

PARTS:

1. Connector 1746872-1 (B)

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

9

P1

Connector setting to
insertion jig
1746872-1 (B)

INSERTION JIG

Visual reference

Upper guide

Upper button

CONNECTOR ORIENTATION

Double lock

Note: Check the connector before insertion.

CONNECTOR LOCK APPEARANCE CHECK

GOOD **NG**

UNLOCK **HALF-LOCKED**

CONNECTOR ILLUSTRATION

GOOD **NG**

1746872-1 (B) **1376675-1 (B)**

1. Get the connector **1746872-1 (B)** and insert to insertion jig using right hand.
Note: Follow the connector orientation

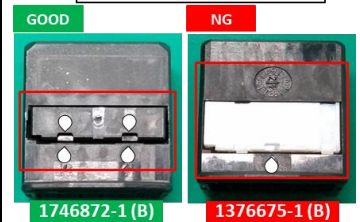
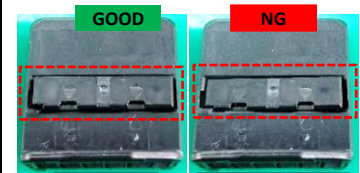
2. Press the upper guide using left hand. Holes that need to be insert are only open.

Press

R **L**

N/A

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



Important reminders/Note/s:

1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.

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☐ PRE-LAUNCH

☒ MASSPRO

Revision No.:

8

Page No.:

9 of 14

PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

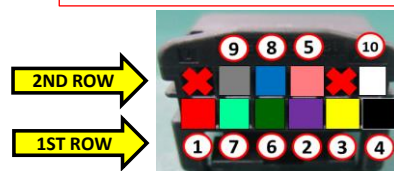
QUALITY POINTERS

10

P1

Wire insertion to
Connector
1746872-1 (B)

INSERTION SEQUENCE FROM LEFT TO RIGHT



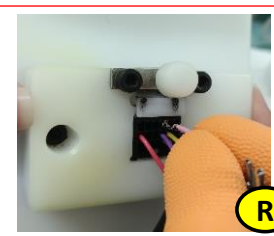
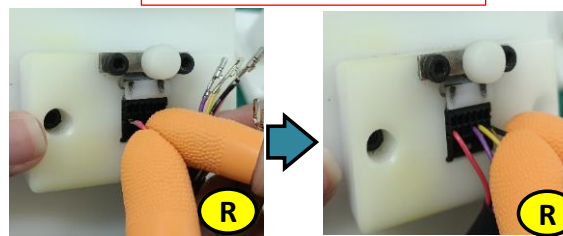
X	9	8	5	X	10
	GR	L	P		W
	213	203	203		215
1	7	6	2	3	4
R	LG	G	V	Y	B
191	217	209	195	197	207

BLACK VM tube (Sunprene)



FIRST ROW (LEFT TO RIGHT)

SECOND ROW (LEFT TO RIGHT)



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

2. Hold the **P wire** and insert to terminal slot 5.
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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8

Page No.:

10 of 14

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1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

8

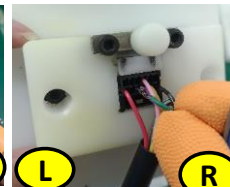
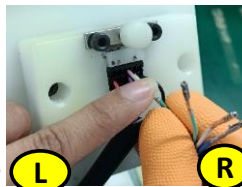
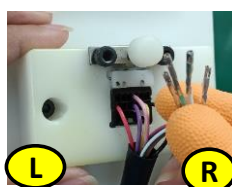
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

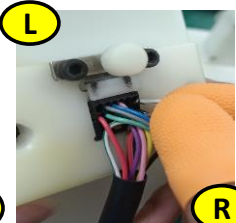
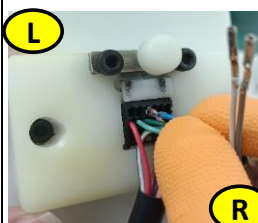
QUALITY POINTERS

10

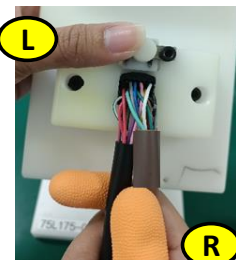
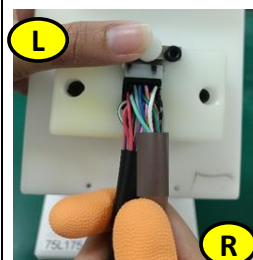
P1

Wire insertion to
Connector
1746872-1 (B)
(Continuation)DARK BROWN VM
TUBE (SUNPRENE)

3. Hold the **G 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 **LG wire**.
Note: Follow the insertion sequence based on the above illustration.



4. Hold the **L wire** and insert to terminal **slot 8** using right hand. Repeat the process for **GR-W wires**.
Note: Follow the insertion sequence based on the illustration.



5. Press the Upper button using left hand then remove the assy part using right hand.

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

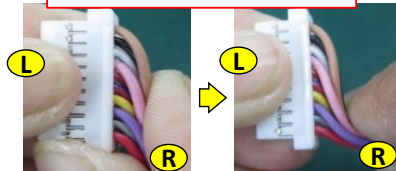
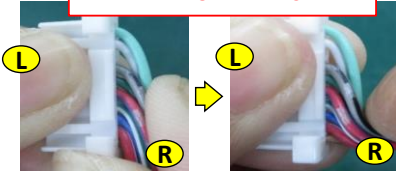








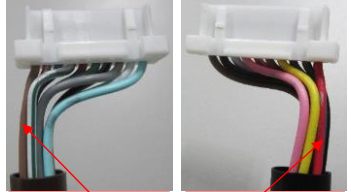
TAPING ASSEMBLY PROCESS

Effectivity Date:	February 24, 2023		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-120		
Revision No.:	8	Page No.:	11 of 14

Process Name/Title: **TAPING ASSEMBLY PROCESS**

Model Code/Part Number **011B / 75L175-0300A** Customer: **TRJ**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Assy parts		JIG	n/a
NO.	PROCESS NAME	8 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
11	P1	<div><div><div>BLACK VM TUBE (SUNPRENE)</div><div></div></div><div><div>DARK BROWN VM TUBE</div><div></div></div><div>1. Hold the connector PBVP-10V-S (W) using left hand and slightly fold the wires from Black VM tube (Sunprene) <i>(as shown in illustration above)</i> using right hand. Repeat the process for connector of Dark Brown VM tube (Sunprene)</div><div><div><div>BEFORE FOLDING</div><div></div></div><div><div>AFTER FOLDING</div><div></div></div><div><div><div>Double lock/ folded wires in upward</div><div></div><div>CORRECT FACING</div></div><div><div><div>Double lock in upward position</div><div></div><div>WRONG FACING</div></div><div><div>Folded wires under position</div><div></div></div><div><div>Terminal tip is not visible</div><div></div></div><div><div>Terminal tip is visible</div><div></div></div><div><div>Terminal tip is not visible</div><div></div></div></div></div><div><div><div>WIRE FOLDING APPEARANCE CHECK</div><div></div><div><div>DBR wire must be straight</div><div>R wire must be straight</div></div><div>1. No wrong orientation of connector 2. No tangled wires 3. No terminal backing out 4. No wrong facing 5. No tangled wires</div></div></div><td>n/a</td></div></div>		n/a	

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Model Code/Part Number

011B / 75L175-0300A

Customer:

TRJ

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

February 24, 2023

Validity Date:

n/a

Document No.:

WI-ENG-PDE-120

Revision No.:

8

Page No.:

12 of 14

PARTS:

n/a

JIG:

n/a

NO.

PROCESS NAME

8

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

12

P1

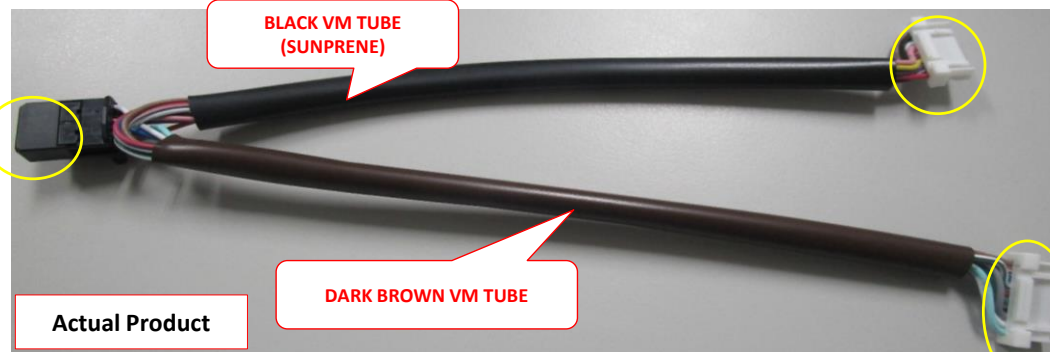
Visual/By two's inspection

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

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

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

4. Check the orientation of harness.



Actual Product

5. Compare to Master Sample by tapping.



Master Sample

Assembly product

Document References:

1. Refer to WI-ENG-PDE-431 for Steering Electrical Test after assembly.

MASTER SAMPLE



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WORK INSTRUCTION

Process Name/Title: **TAPING ASSEMBLY PROCESS**

Model Code/Part Number **011B / 75L175-0300A**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

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Document No.:


WI-ENG-PDE-120

Revision No.:

8

Page No.:

13 of 14

PARTS:		n/a			JIG:	n/a	
NO.	PROCESS NAME		8 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE		QUALITY POINTERS
13	P1	Measurement				1. No wrong dimension Important Reminder/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumuno and Owarimono	

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WORK INSTRUCTION

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Model Code/Part Number **011B / 75L175-0300A**

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Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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WI-ENG-PDE-120

Revision No.:

8

Page No.:

14 of 14

PARTS:

n/a

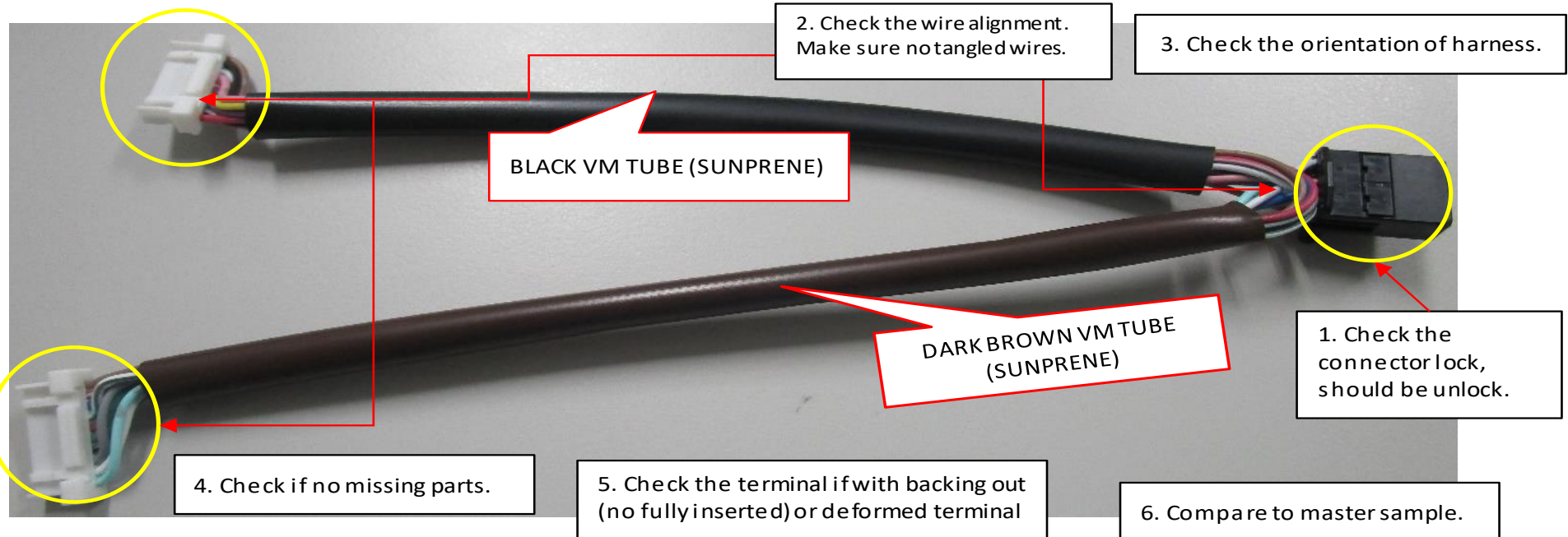
JIG:

n/a



QUALITY CHECKPOINTS

75L175



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