



WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

November 28, 2024

Model code/Part number:

310D / 628125-0001

Customer: TRJ

Car Model:

TOYOTA-RAV4

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

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PARTS:

1. Connector PARP-03V-E (L); Connector PARP-03V (W); AVSS 0.3 W wire L=399±2mm; AVSS 0.3 P-B wires L=412±2mm; Connector PARP-03V (W); Green VM tube (Sunprene) Ø4.5, L=291±4mm; Black VM tube (Sunprene) Ø4, L=56±3mm; Retainer (PMS-03V-S (W); AVSS 0.3 G-W/G-BR wires L=200±2mm; Connector PBVP-04V-S; Blue VM tube (Sunprene) Ø4.5, L=80±3mm; Connector 4A1330-0000 (W); Black VM tube (Sunprene) Ø6, L=84±3mm

JIG:

1. Insertion jig
2. Paddle switch navigation

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

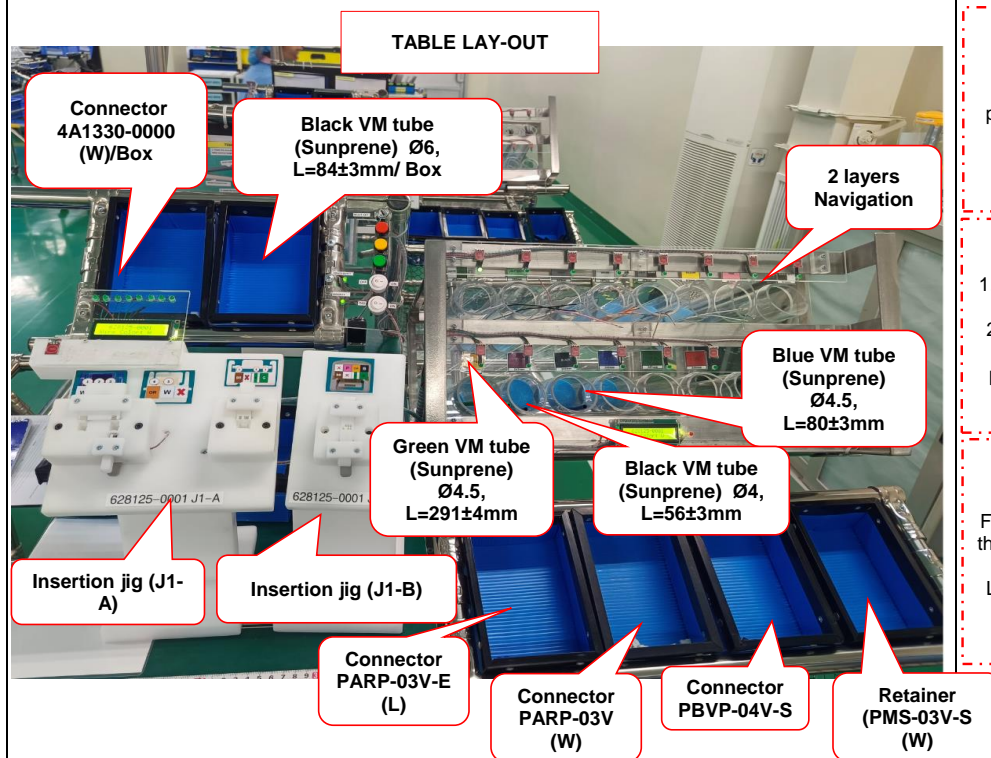
TOOLS/PPE

QUALITY POINTERS

1

P1

Table lay-out

**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. No missing parts/tools
2. No excess parts/tools

Important reminders/Note/s:

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

Document references:

1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

Revision History

Prepared by

Reviewed by

Approved by

Noted by

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	November 15, 2024
11/28/24	1	Change Purpose from Pre-launch to Masspro. Update the Work Procedure/illustration, provide insertion jigs and Steering Navigation; Additional table lay-out.	M. Ariola	C. Villanueva	A.Arañes	n/a		
11/15/24	0	Initial issue.	M. Ariola	C. Villanueva	A.Arañes	n/a		

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PARTS:
1. Connector PARP-03V-E (L)
2. Connector PARP-03V (W)

JIG:

1. Insertion jig
2. Paddle switch navigation

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

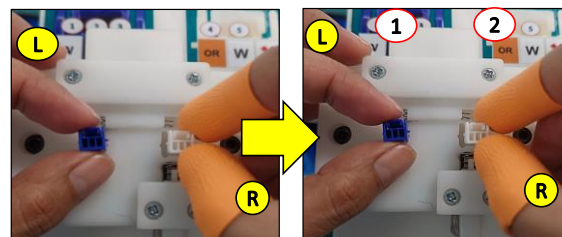
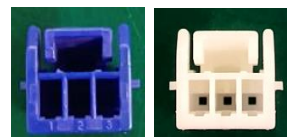
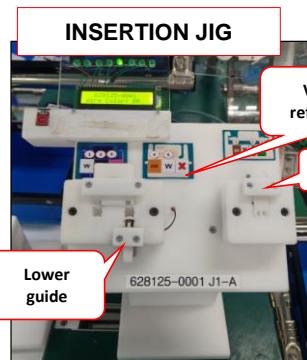
TOOLS/PPE

QUALITY POINTERS

2

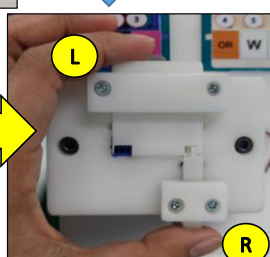
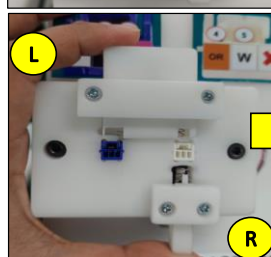
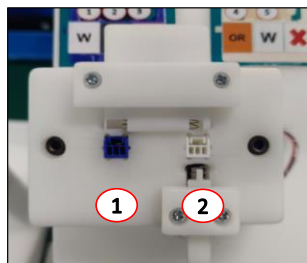
P1

Connector setting to
insertion jig
Connector PARP-03V-E
(L) and
Connector PARP-03V (W)



1. Get 1pc. of connector **PARP-03V-E (L)** using left hand and 1pc. of Connector **PARP-03V (W)** then insert to insertion jig using both hands.

Note: Follow the connector orientation



3. Press the upper and lower guide using left hand in same timing. Holes that need to be insert are only open.

STEERING NAVIGATION
(2 layers)



CONTROLLER



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PROTOTYPE



PRE-LAUNCH



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PARTS:

1. AVSS 0.3 W wire L=399±2mm
2. AVSS 0.3 P-B wires L=412±2mm

JIG:

1. Insertion jig
2. Paddle switch navigation

NO.

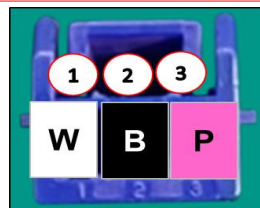
PROCESS NAME

1

WORK PROCEDURE/ ILLUSTRATION

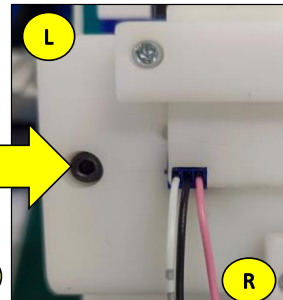
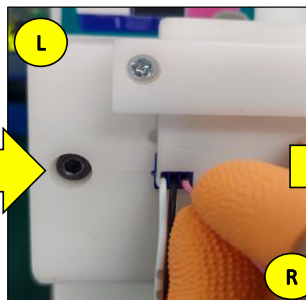
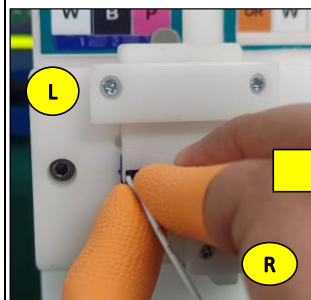
TOOLS/PPE

QUALITY POINTERS

INSERTION SEQUENCE FROM LEFT
TO RIGHTTERMINAL
FACING

WIRE INSERTION ILLUSTRATION

1	2	3
P	B	W
412	412	399



1. Get the **W wire using left hand** and transfer to the right hand then insert to connector Conduct **2x** push pull after wire insertion. Repeat the process to **B and Pink wire**.
Note: Follow the insertion sequence based on the illustration.



2. After insertion, check the terminal tip condition, **must be visible.**

STEERING NAVIGATION
(2 layers)

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.
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.
4. Insertion of wires must be from left to right.

Document references:

1. Refer to WI-PRO-CNC-017
2. Refer to WI-ENG-PDE-044 for the Steering Navigation Controller procedure.
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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PROTOTYPE



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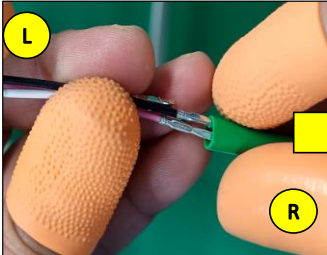
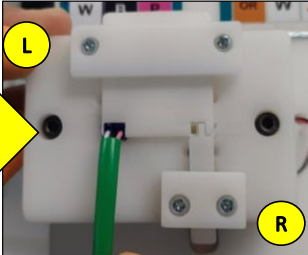
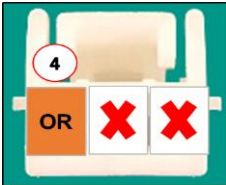
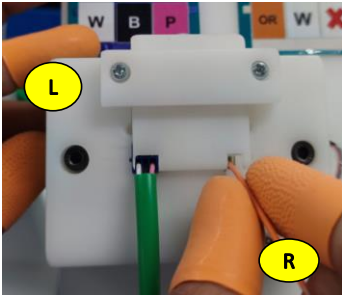


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PARTS:		1. Assy parts 2. Green VM tube (Sunprene) Ø4.5, L=291±4mm 3. Connector PARP-03V (W)		JIG:	1. Insertion jig 2. Paddle switch navigation									
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS									
4	Wire insertion to Green VM tube (Sunprene) Ø4.5, L=291±4mm	<div><div></div><div></div><div>1. Hold the wires using left hand, get the Green VM tube (Sunprene) Ø4.5, L=291±4mm using right hand then insert the wires using left hands</div></div>		n/a	1. No wrong usage of parts. 2. No deformed terminal. 3. No tangled wires.									
5	P1 Wire insertion to Connector PARP-03V (W)	<div><div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div><div></div><div></div><div>WIRE INSERTION ILLUSTRATION</div><div><table><tr><td>1</td><td></td><td></td></tr><tr><td>OR</td><td>X</td><td>X</td></tr><tr><td>177</td><td></td><td></td></tr></table></div><div>1. Get the OR wire using right hand then insert to connector. Conduct 2x push pull after wire insertion. Note: Follow the insertion sequence based on the illustration.</div></div>		1			OR	X	X	177			<div>STEERING NAVIGATION (2 layers)</div> <div></div> <div>CONTROLLER</div> <div></div>	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. 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. 4. Insertion of wires must be from left to right. Document references: 1. Refer to WI-PRO-CNC-017 2. Refer to WI-ENG-PDE-044 for the Steering Navigation Controller procedure. 3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
1														
OR	X	X												
177														

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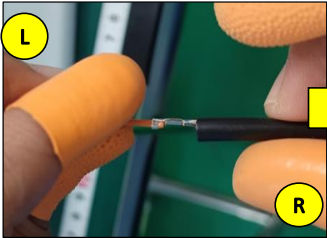
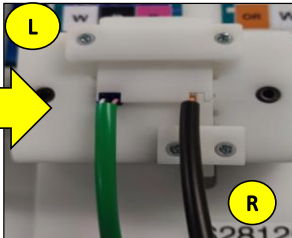
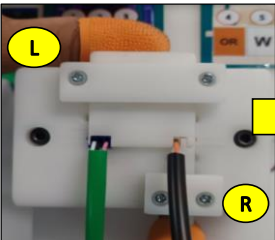
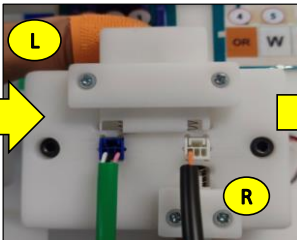
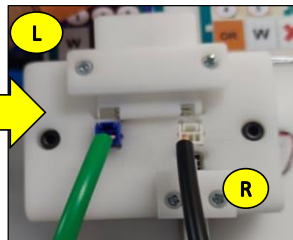
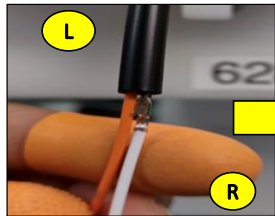
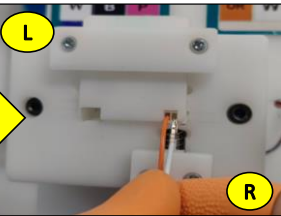
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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) Ø4, L=56±3mm 3. Connector PARP-03V (W)		JIG:	1. Insertion jig 2. Paddle switch navigation
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1 Wire insertion to Black VM tube (Sunprene) Ø4, L=56±3mm	  <p>1. Hold the wires using left hand, get the Black VM tube (Sunprene) Ø4, L=56±3mm using right hand then insert the wires using left hands</p>    <p>2. Press the upper and lower button using both hands. Remove the 1st Connector with inserted wires using right hand. After removal of harness, Press the Upper guide using left hand. Note: Second connector with inserted wire and Black VM tube (Sunprene) should stay on the jig.</p>   <p>3. Hold the Black VM tube (Sunprene) using left hand and insert the wires using right hand.</p>		n/a	1. No wrong usage of parts. 2. No deformed terminal. 3. No tangled wires.

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PARTS:		1. Assy parts		JIG:	1. Insertion jig 2. Paddle switch navigation
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1 Wire insertion to Connector PARP-03V (W) (Continuation)	<div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div> <div></div> <div></div> <div></div> <div></div> <div></div> <div>1. Get the W wire using right hand then insert to connector. Conduct 2x push pull after wire insertion. Note: Follow the insertion sequence based on the illustration.</div> <div></div> <div>2. Press the upper button using left hand. Remove the 2nd connector with inserted wires using right hand.</div> <div></div> <div>3. After insertion, check the terminal tip condition, must be visible.</div>		<div>STEERING NAVIGATION (2 layers)</div> <div></div> <div>CONTROLLER</div> <div></div>	<div>Important reminders/Note/s:</div> <div>1. Please hold the wire near terminal.</div> <div>2. Make sure wires are properly inserted.</div> <div>Conduct Pull-Push-Pull-Push after insertion.</div> <div>Do not exert extra force.</div> <div>3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</div> <div>4. Insertion of wires must be from left to right.</div> <div>Document references:</div> <div>1. Refer to WI-PRO-CNC-017</div> <div>2. Refer to WI-ENG-PDE-044 for the Steering Navigation Controller procedure.</div> <div>3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>

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PARTS:

1. Retainer (PMS-03V-S (W)) [2pcs]
2. Assy parts

JIG:

n/a

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

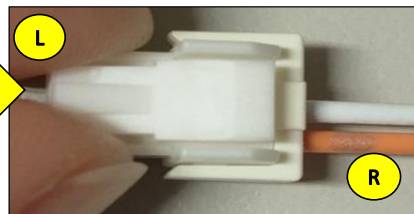
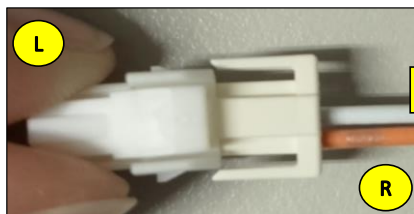
TOOLS/PPE

QUALITY POINTERS

8

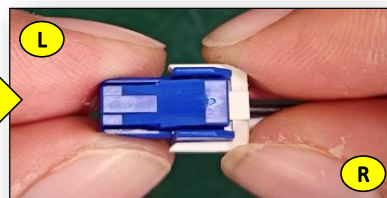
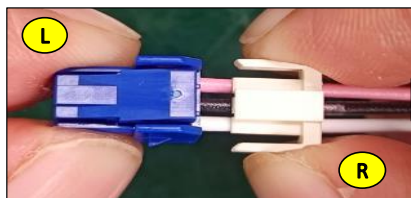
P1

Retainer attachment
(PMS-03V-S (W))



1. Hold the Connector using left hand, get the **Retainer PMS-03V-S (W)** then insert the clamp using right hand.

Note: Sound will be heard if properly inserted.



2. Hold the Connector using left hand, get the **Retainer PMS-03V-S (W)** then insert the clamp using right hand.

**Note: Sound will be heard if properly inserted.
(After insertion, set aside the assy parts)**

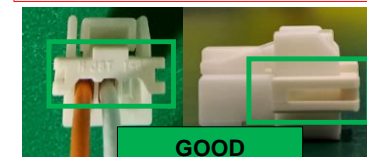


3. After the attachment of retainers, set a side the assy pats

n/a

1. Retainer must be fully inserted
2. No missing retainers
3. No Unlock/halflocked

RETAINER ORIENTATION



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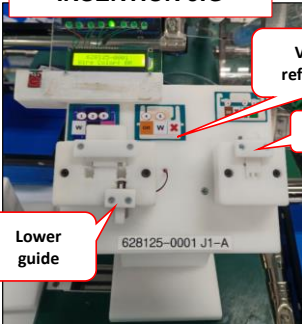
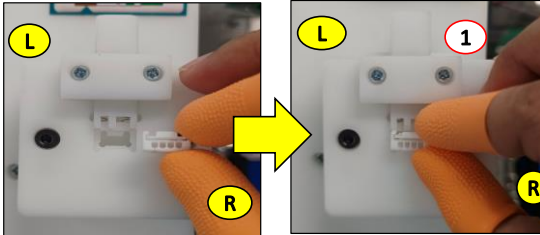
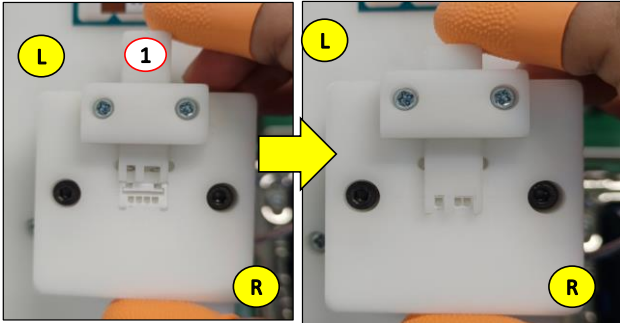

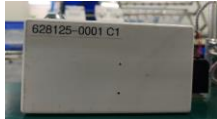
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PARTS:		1. Connector PBVP-04V-S		JIG:	1. Insertion jig 2. Paddle switch navigation
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1 Connector setting Connector PARP-03V (W)	<div><div>INSERTION JIG</div><div></div><div>Visual reference</div><div>Upper guide</div><div>Lower guide</div><div>628125-0001 J1-A</div></div> <div><div>CONNECTOR ORIENTATION</div><div></div><div>1. Get 1pc. of connector PBVP-04V-S using right hand then insert to insertion jig. <i>Note: Follow the connector orientation</i></div></div> <div><div></div><div>2. Press the lower guide using right hand in same timing. Holes that need to be insert are only open.</div></div>		<div>STEERING NAVIGATION (2 layers)</div> <div></div> <div>CONTROLLER</div> <div></div>	1. Use the provided jig per model 2. No wrong usage of parts. 3. No wrong orientation of Connector. 4. No damaged connector.

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PARTS:

- Connector PBVP-04V-S
- AVSS 0.3 G-W/G-BR wires L=200±2mm

JIG:

- Insertion jig
- Paddle switch navigation

NO.

PROCESS NAME

1 WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

10

P1

Wire insertion to
Connector Connector
PBVP-04V-S

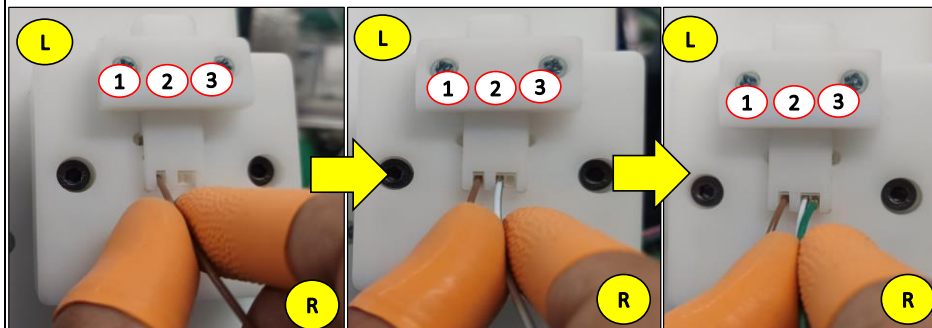
INSERTION SEQUENCE FROM
LEFT TO RIGHT



TERMINAL FACING

WIRE INSERTION ILLUSTRATION

1	2	3	4
BR	X	W/G	G
200	200	200	200



- Get the **B wire** using left hand and transfer to the right hand then insert to connector Conduct **2x** push pull after wire insertion. Repeat the process to **W/G and B wires**.

Note: Follow the insertion sequence based on the illustration.

STEERING NAVIGATION
(2 layers)



CONTROLLER

**Important reminders/Note/s:**

- Please hold the wire near terminal.**
- Make sure wires are properly inserted.**
- Conduct Pull-Push-Pull-Push after insertion.**
- Do not exert extra force.**
- Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.**
- Insertion of wires must be from left to right.**

Document references:

- Refer to WI-PRO-CNC-017
- Refer to WI-ENG-PDE-044 for the Steering Navigation Controller procedure.
- Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

November 28, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

310D / 628125-0001

Customer: TRJ

Car Model: TOYOTA-RAV4

Document No.:

WI-ENG-PDE-1155A

Purpose:



PROTOTYPE



PRE-LAUNCH



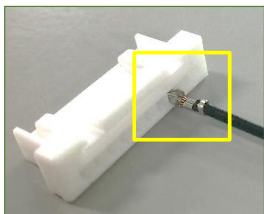

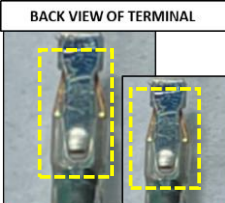
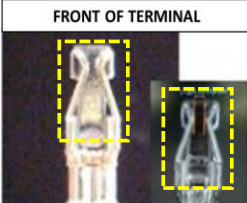
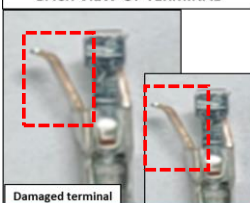

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PARTS:		1. Assy parts		JIG:	1. Insertion jig 2. Paddle switch navigation
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	P1	<div>Proper alignment of terminal to connector</div>  <div>Improper alignment of terminal to connector</div>  <div>BACK VIEW OF TERMINAL</div>  <div>GOOD Terminal condition</div> <div>FRONT OF TERMINAL</div>  <div>GOOD Terminal condition</div> <div>BACK VIEW OF TERMINAL</div>  <div>Damaged terminal NO GOOD Terminal condition</div> <div>FRONT VIEW OF TERMINAL</div>  <div>NO GOOD Terminal condition</div> <div>Note: *Make sure the terminal was in proper alignment before insert. *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.</div>			<div>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.</div> <div>Important reminders/Note/s:</div> <div>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 2. Please hold the wires near terminal during insertion. 3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector. 4. Insertion of wires must be from left to right.</div> <div>Document reference/s:</div> <div>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</div>

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Process Name/Title:

Model code/Part number:

310D / 628125-0001

Customer: TRJ

Car Model: TOYOTA-RAV4

Purpose:



PROTOTYPE



PRE-LAUNCH



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Effectivity Date:

November 28, 2024

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n/a

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PARTS:

1. Assy parts
2. Blue VM tube (Sunprene) Ø4.5, L=80±3mm

JIG:

1. Insertion jig
2. Paddle switch navigation

NO.

PROCESS NAME

1 WORK PROCEDURE/ ILLUSTRATION

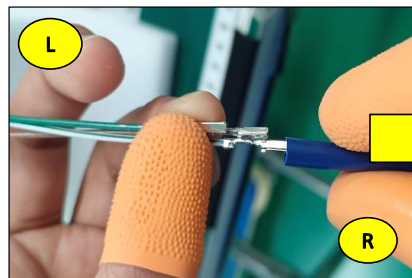
TOOLS/PPE

QUALITY POINTERS

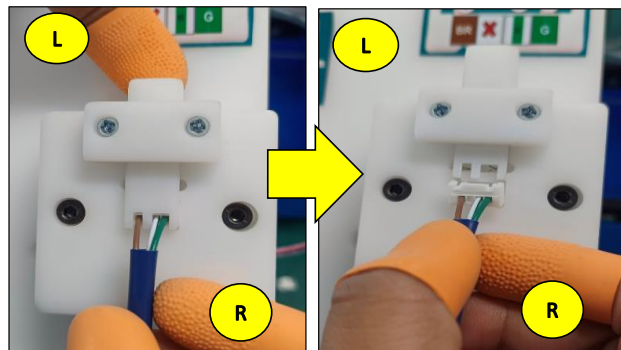
11

P1

Wire insertion to
Blue VM tube (Sunprene)
Ø4.5, L=80±3mm



1. Hold the wires using left hand, get the **Blue VM tube (Sunprene) Ø4.5, L=80±3mm** using right hand then insert the wires using left hands.



2. After insertion, Press the Upper button using left hand then remove the assy parts using right hand. Check the insertion condition.

n/a

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

**Terminal tip must be visible.****Important reminders/Note/s:**

1. Refer to GL-PRO-ASY-025 for inspection Standard for Coupler Insertion.
2. Refer to GL-PRO-ASY-043 for verification of Fully inserted wires.

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Car Model: TOYOTA-RAV4

Validity Date:

n/a

Purpose:



PROTOTYPE



PRE-LAUNCH



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PARTS:	1. Assy parts 2. Connector 4A1330-0000 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
12	P1 Connector setting to insertion jig 4A1330-0000 (W)	<div><div><div>INSERTION JIG</div><div>Visual reference</div><div>Upper button</div><div>Upper guide</div><div>Lower guide</div><div>Lower button</div></div><div><div>Double lock</div><div>CONNECTOR ORIENTATION</div></div><div><div>1. Get the Connector 4A1330-0000 (W) and insert to insertion jig using right hand. Note: Follow the connector orientation.</div></div><div><div><div>L</div><div>R</div></div><div><div>2. Press the upper and lower guide (same timing) using left hand. Holes to be insert are only open.</div></div></div></div>	n/a	<div>1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector.</div> <div>Important reminders/Note/s: 1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector. 2. Follow the connector orientation 3. Check the Connector before insertion.</div>

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TRJ

Car Model:

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Purpose:



PROTOTYPE



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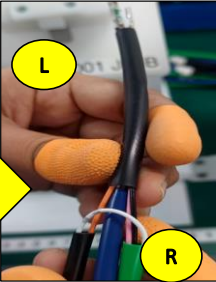
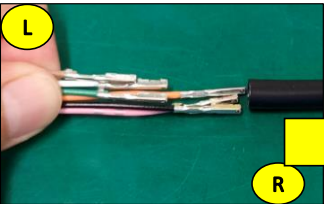
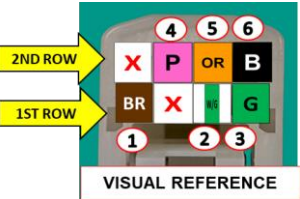
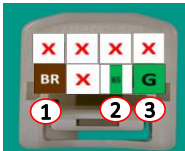
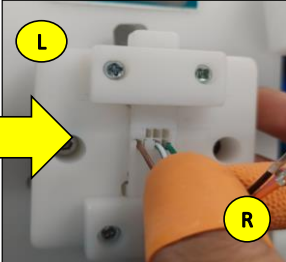
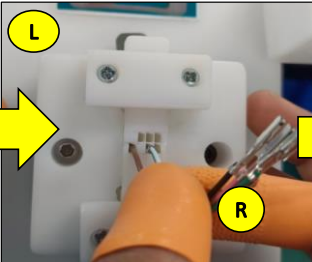
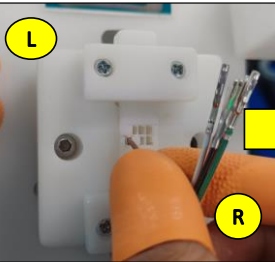
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Revision No.:

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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) Ø6, L=84±3mm		JIG:	1. Insertion jig																								
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS																								
13	Wire insertion Black VM tube (Sunprene) Ø6, L=84±3mm	<div></div> <div>1. Hold the wires using right hand, get the Black VM tube (Sunprene) Ø6, L=84±3mm using left hand then insert the wires (Assy parts) using both hands.</div>		n/a	<div>1. Use provided jig per model.</div> <div>2. No wrong usage of parts</div> <div>3. One by one insertion</div> <div>4.No wrong insertion.</div> <div>5. No deformed terminal</div> <div>6. No stuck of terminal tip.</div>																								
14	P1 Wire insertion to Connector 4A1330-0000 (W)	<div><div><p>2ND ROW</p><p>1ST ROW</p><p>VISUAL REFERENCE</p></div><div><p>INSERTION SEQUENCE FROM LEFT TO RIGHT</p><table><tr><td></td><td>5</td><td>6</td><td>7</td></tr><tr><td>x</td><td>P</td><td>OR</td><td>B</td></tr><tr><td>412</td><td>177</td><td>412</td><td></td></tr><tr><td>1</td><td>2</td><td>3</td><td></td></tr><tr><td>BR</td><td>x</td><td>W/G</td><td>G</td></tr><tr><td>200</td><td>200</td><td>200</td><td>200</td></tr></table></div><div><p>FIRST ROW (LEFT TO RIGHT)</p></div><div></div><div>1. Insert the wires from Blue VM tube (Sunprene). Hold the R wire and insert to terminal slot no.1 using right hand. Repeat the process for W/G and G wires.</div></div>			5	6	7	x	P	OR	B	412	177	412		1	2	3		BR	x	W/G	G	200	200	200	200	n/a	<div>1. Use provided jig per model.</div> <div>2. No wrong usage of parts</div> <div>3. One by one insertion</div> <div>4.No wrong insertion.</div> <div>5. No deformed terminal</div> <div>6. No stuck of terminal tip.</div> <div>Important reminders/Note/s: 1. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force. 2. Please hold the wires near terminal during insertion. 3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector. 4. Insertion of wires must be from left to right.</div> <div>Document reference/s: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</div>
	5	6	7																										
x	P	OR	B																										
412	177	412																											
1	2	3																											
BR	x	W/G	G																										
200	200	200	200																										

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WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

November 28, 2024

Process Name/Title:

Model code/Part number:

310D / 628125-0001

Customer: TRJ

Car Model: TOYOTA-RAV4

Validity Date:

n/a

Document No.:

WI-ENG-PDE-1155A

Purpose:



PROTOTYPE



PRE-LAUNCH



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Revision No.:

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Page No.:

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PARTS: 1. Assy parts

JIG:

1. Insertion jig

NO.

PROCESS NAME

1 WORK PROCEDURE/ ILLUSTRATION

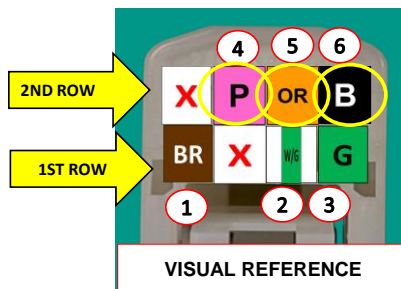
TOOLS/PPE

QUALITY POINTERS

14

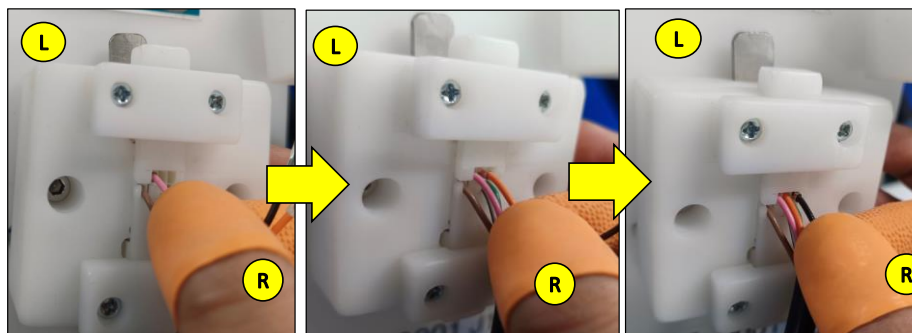
P1

Wire insertion to
Connector
4A1330-0000 (W)
(Continuation)



INSERTION SEQUENCE FROM LEFT TO RIGHT

	5	6	7
X	P	OR	B
	412	177	412
1		2	3
BR	x	W/G	G
200		200	200



2. Hold the **P** wire and insert to terminal **slot no.4** using right hand. Repeat the process for **OR** and **B** wires.

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.
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.
4. Insertion of wires must be from left to right.

Document references:

1. Refer to WI-PRO-CNC-017
2. Refer to WI-ENG-PDE-044 for the Steering Navigation Controller procedure.
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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

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310D / 628125-0001

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Validity Date:

n/a

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Purpose:



PROTOTYPE



PRE-LAUNCH



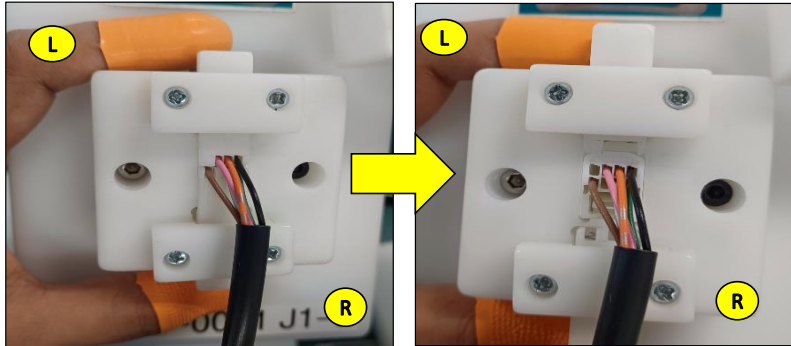
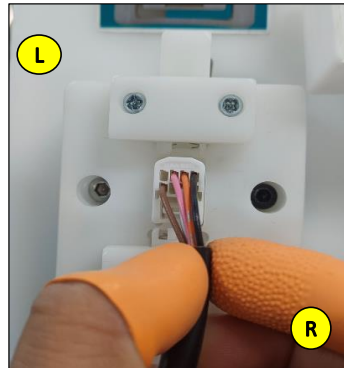
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PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
14	P1 Wire insertion to Connector 4A1330-0000 (W) (Continuation)	<div></div> <div>3. Press the upper and lower button (same timing) using both hands.</div> <div></div> <div>4. Remove the assy parts using right hand and check if the connector is totally locked.</div>		n/a	<div>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.</div> <div>Important reminders/Note/s: 1. Please hold the wire near terminal. 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. 4. Insertion of wires must be from left to right.</div> <div>Document references: 1. Refer to WI-PRO-CNC-017 2. Refer to WI-ENG-PDE-044 for the Steering Navigation Controller procedure. 3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>

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310D / 628125-0001

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Purpose:



PROTOTYPE



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Document No.:

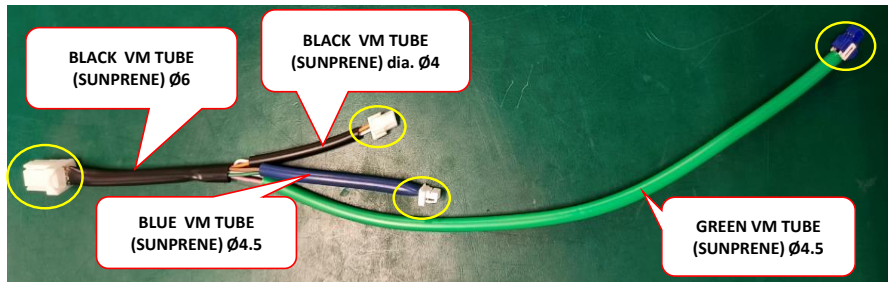
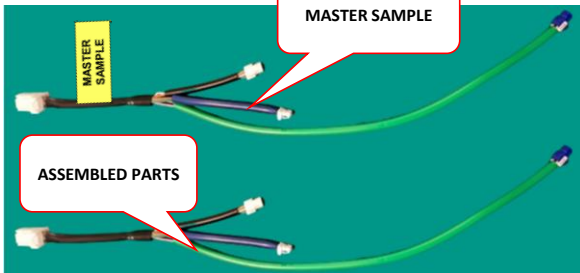

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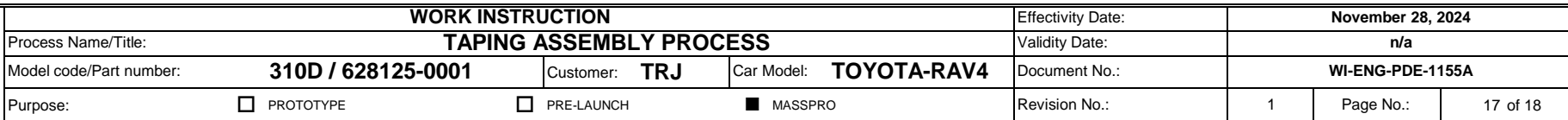
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PARTS:		1. Assembled parts 2. Master sample		JIG:	n/a
NO.	PROCESS NAME	1 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
15	P1	Visual/By two's Inspection	<div>1. Check the connector lock. Locking of connector is included in Steering Electrical test.</div> <div>2. Check the wire alignment. Must be no tangled wires.</div> <div>3. Check the Terminal if with Backing out (Not fully inserted) or no deformed terminal.</div> <div></div> <div><div>4. Check the orientation of harness.</div><div>5. Compare to Master sample by tapping</div><div></div></div>	n/a	<div>1. No skip process during inspection.</div> <div>Document reference/s: <i>1. Refer to WI-QAD-QAC-252 Steering Electrical Test</i></div> <div>MASTER SAMPLE</div> <div></div>

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

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PROTOTYPE



PRE-LAUNCH



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PARTS:

n/a

JIG:

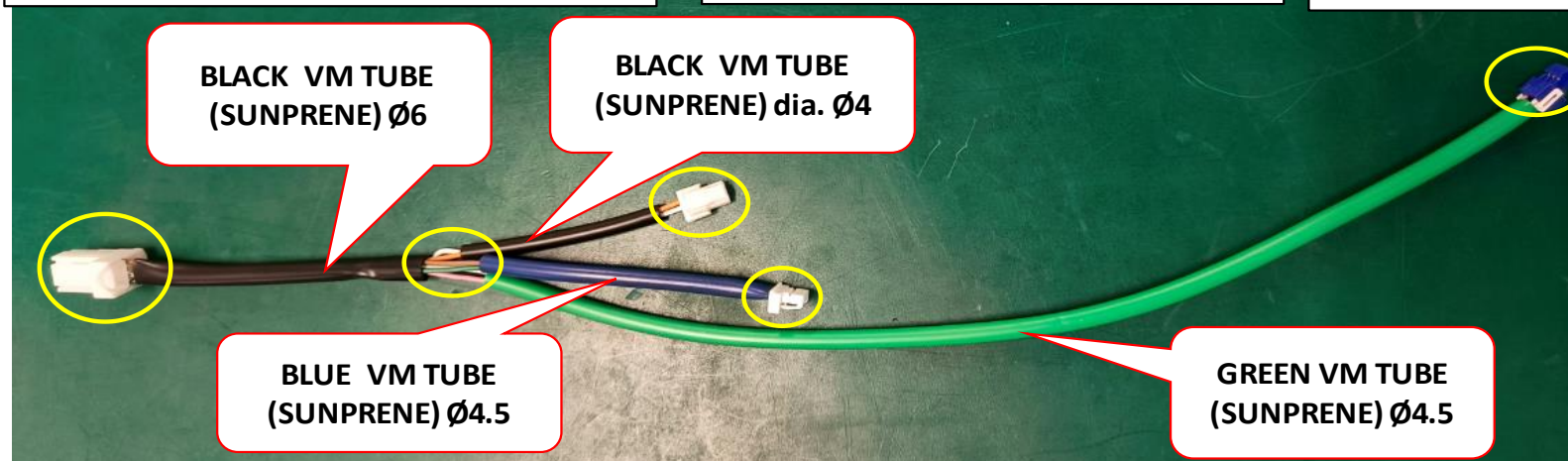
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**VISUAL INSPECTION/ QUALITY CHECKPOINTS****PADDLE SWITCH****628125-0001**

1. Check the connector lock. Locking of connector is included in Steering

2. Check the wire alignment. Must be no tangled wires.

3. Check the Terminal if with Backing out (Not fully inserted) or no deformed terminal.



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

4. No missing tape (Black tape)

5. Check the orientation of harness.

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