

**WORK INSTRUCTION**

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

December 12, 2023

Model code/Part number:

YDB / 75S324-0011

Customer:

TRJ

Car Model:

SUZUKI-PALLETE

Document No.:

WI-ENG-PD-764B

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

1

Page No.:

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PARTS:		1. 82711-1B090 (B) [2pcs]				JIG:		1. Assembly jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS	
1	P1	<div> 82711-1B090 (B)</div> <div> 1 2</div> <div>1. Get 2pcs. of clamp 82711-1B090 (B) using right hand then set to clamp location 1 and 2 using both hands.</div>				<div>Safety Instruction Be sure to wear required personal protective equipment during operation (gloves, finger cots, etc.)</div> <div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div> <div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div>		<div>1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position</div> <div>Important reminders/Note/s: 1. Please check the Clamp first before start of assembly to avoid wrong use of clamp.</div>	
Revision History						Prepared by	Reviewed by	Approved by	Noted by
12/12/23	1	Change from Pre-launch to Masspro. Improved assembly jig.				D. Castillo	C. Villanueva	A. Arañes	n/a
11/20/23	0	Initial issue				D. Castillo	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change				Revised	Reviewed	Approved	Noted

Prepared by:
Reviewed by:
Approved by:
Noted by:

Est. Date: November 20, 2023

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☐ PROTOTYPE

☐ PRE-LAUNCH

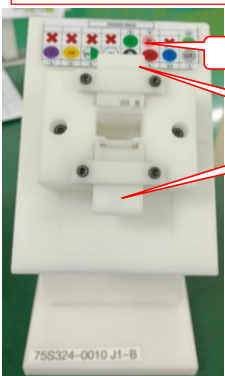
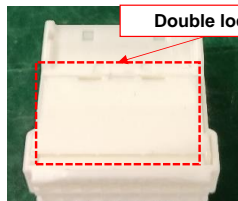
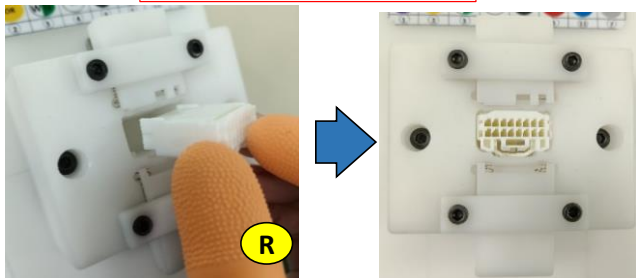
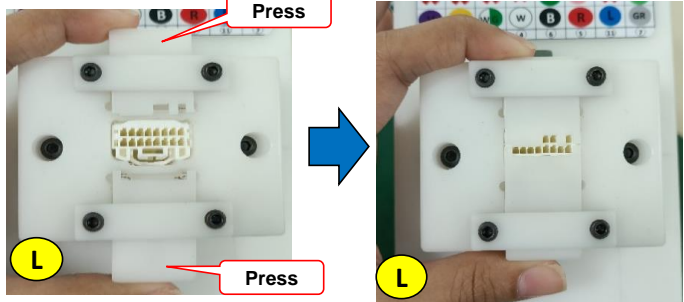
☒ MASSPRO

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PARTS:	1. Connector 7283-7596 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Connector setting to insertion jig 7283-7596 (W)	<div><div>INSERTION JIG</div><div><div>Visual reference</div><div>Upper guide</div><div>Lower guide</div></div><div><div>Double lock</div><div></div><div>Note: Check the connector before insertion.</div></div><div><div>CONNECTOR ORIENTATION</div><div></div><div>1. Get the connector 7283-7596 (W) and insert to insertion jig using right hand. <i>Note: Follow the connector orientation</i></div></div><div><div><div>Press</div><div>Press</div><div>2. Press the upper and lower guide using left hand. Holes that need to be insert are only open.</div></div></div></div> <div>N/A</div> <td><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: <i>1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</i></div></td>	<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: <i>1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</i></div>	

N/A

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PARTS: 1. Connector 7283-7596 (W)

JIG:

1. Insertion jig

NO.

PROCESS NAME

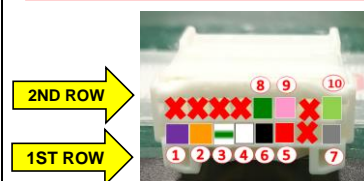
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

P1

Wire insertion to
Connector
7283-7596 (W)INSERTION SEQUENCE FROM LEFT
TO RIGHT

Wire facing

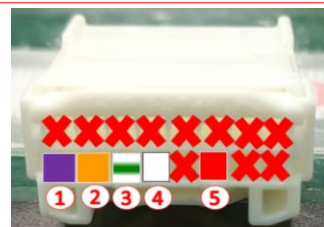
FIRST ROW (LEFT TO RIGHT)



WIRE INSERTION ILLUSTRATION

X	X	X	X	8	9	X	10
				G	P		LG
				186	186		186
1	2	3	4	6	5		7
V	OR	W/G	W	B	R	X	GR
191	191	191	191	186	193		186

N6GR VM tube (Sunprene)



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

1. Insert first the wires from **N6GR VM tube (Sunprene)**. Hold the **V wire** and insert to terminal slot 1 using right hand. Repeat the process for **OR-W/G-W-R wires**.

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

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PARTS:

1. Assy parts

JIG:

Insertion jig

NO.

PROCESS NAME

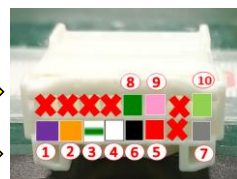
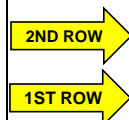
WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

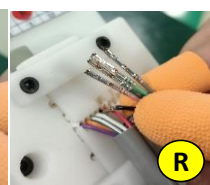
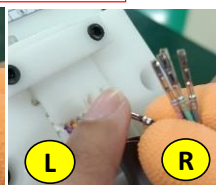
4

P1

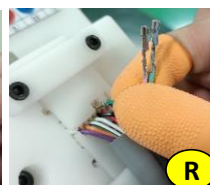
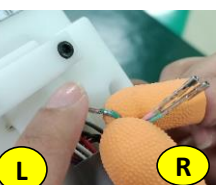
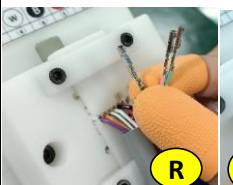
Wire insertion to
Connector
7283-7596 (W)
(Continuation)INSERTION SEQUENCE FROM LEFT
TO RIGHT

Wire facing

FIRST ROW (LEFT TO RIGHT)



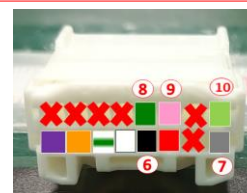
SECOND ROW (LEFT TO RIGHT)



WIRE INSERTION ILLUSTRATION

X	X	X	X	8	9	X	10
				G	P		LG
				186	186		186
1	2	3	4	6	5		7
V	OR	W/G	W	B	R	X	GR
191	191	191	191	186	193		186

Blue VM Tube (Sunprene)



2. Hold the **B 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 **GR wire**.
Note: Follow the insertion sequence based on the above illustration.

3. Hold the **G wire** and insert to terminal **slot 8** using right hand. Repeat the process for **P-LG wires**.
Note: Follow the insertion sequence based on the illustration.

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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PARTS:

1. Assy parts

JIG:

1. Insertion jig

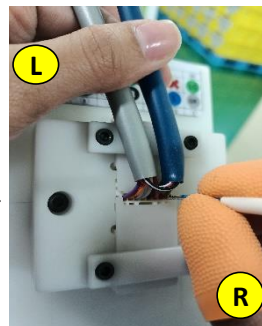
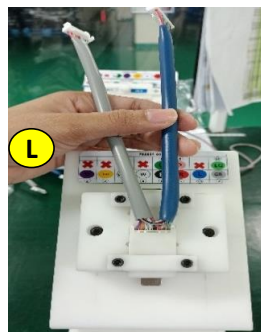
NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

5

P1

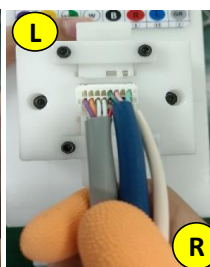
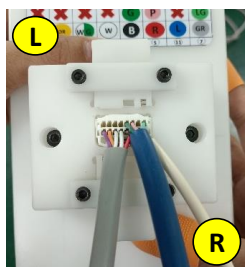
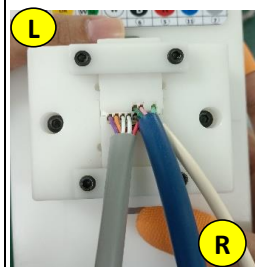
Wire insertion to
Connector
7283-7596 (W)
(Continuation)**INSERTION SEQUENCE FROM LEFT
TO RIGHT**2ND ROW
1ST ROW**WIRE INSERTION ILLUSTRATION**

X	X	X	X	8	9	X	10
186	186	186	186	G	P	X	LG
1	2	3	4	6	5	11	7
V	OR	W/G	W	B	R	L	GR
191	191	191	191	186	193	131	186

**Wire facing****FIRST ROW (LEFT TO RIGHT)**

4. Lift up the harness using left hand and get the **L wire** using right hand and insert to terminal **slot 11** using right hand.

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



5. Press the upper guide and lower guide (same timing) using both hands 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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6 of 11**PARTS:**

1. Assy parts

JIG:

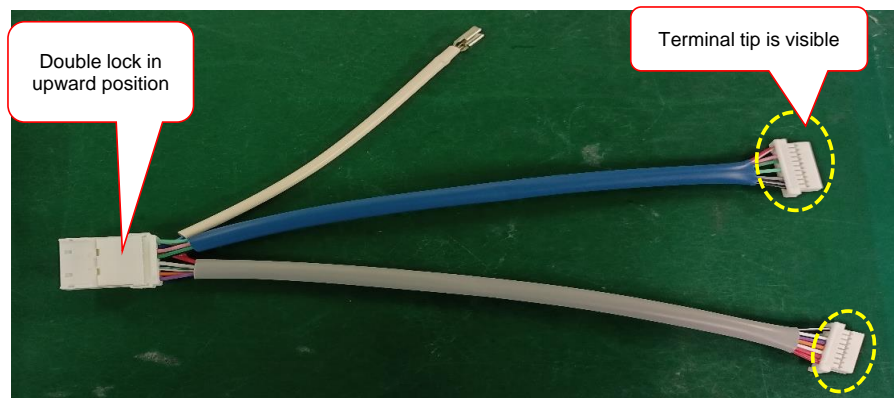
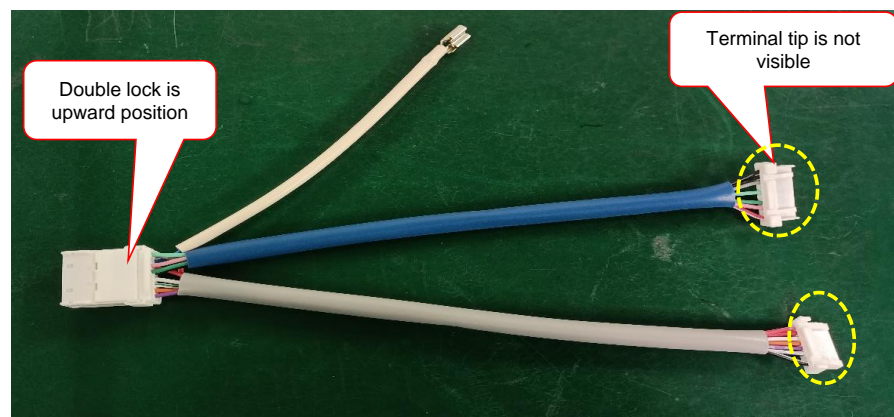
n/a

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

6

P1

Wire arrangement

**GOOD FACING****WRONG FACING**


N/A

1. No wrong orientation of connector.
2. No tangled wires.
3. Terminal backing out.

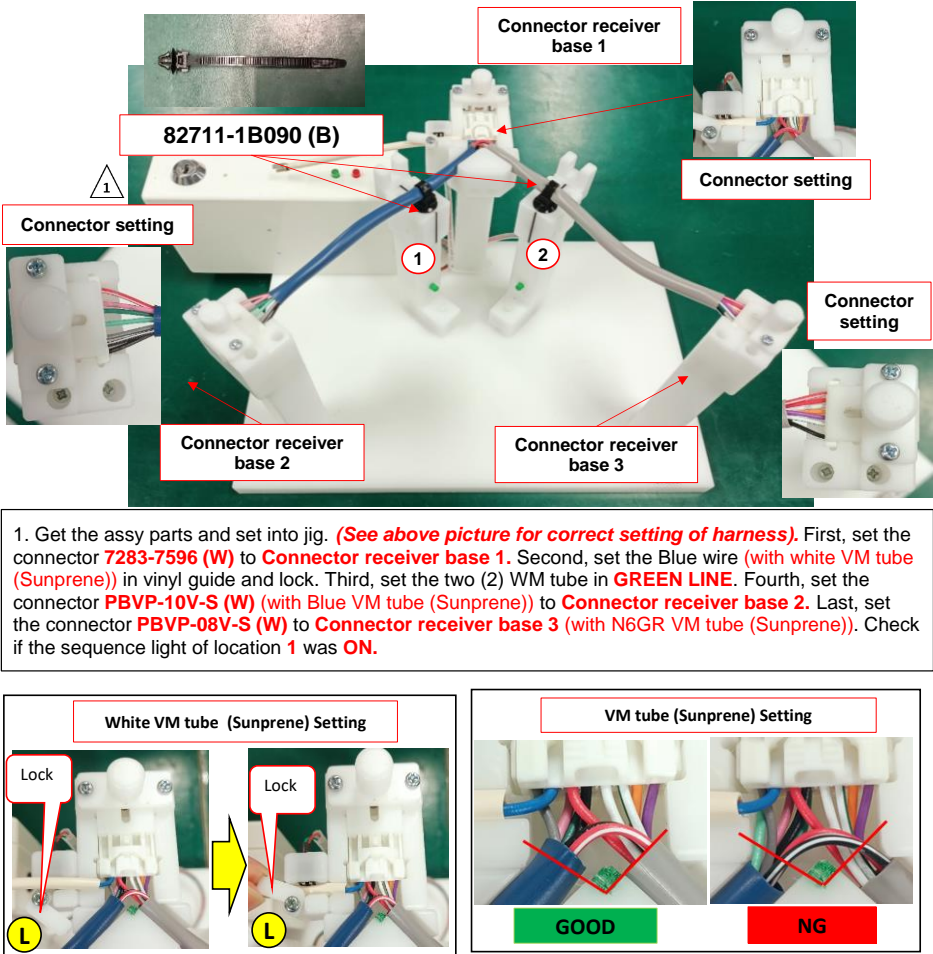
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PARTS:		1. Assy parts		JIG:	1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
7	P1	Clamp Assembly		N/A	1. No damaged clamp 2. No wrong use of clamp 3. No missing clamp 4. No wrong use of bando gun 5. No wrong setting of VM tube	



1. Get the assy parts and set into jig. (See above picture for correct setting of harness). First, set the connector **7283-7596 (W)** to **Connector receiver base 1**. Second, set the Blue wire (with white VM tube (Sunprene)) in vinyl guide and lock. Third, set the two (2) WM tube in **GREEN LINE**. Fourth, set the connector **PBVP-10V-S (W)** (with Blue VM tube (Sunprene)) to **Connector receiver base 2**. Last, set the connector **PBVP-08V-S (W)** to **Connector receiver base 3** (with N6GR VM tube (Sunprene)). Check if the sequence light of location **1** was **ON**.

White VM tube (Sunprene) Setting

Lock

VM tube (Sunprene) Setting

GOOD NG

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PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1 Clamp Assembly (Continuation)	<div></div> <div><p>2. Initially tighten the band clamp from location 1 and 2 using both hands.</p><p>3. Get the bando gun and cut the band clamp on location 1 using both hands. Press the SW button after cut. Continue if sequence light in location 2 is ON.</p><p>4. Cut the band clamp on location 2 using both hands. Press the SW button after cut. GO sound will be heard.</p><p>5. Conduct POINT CHECKING before removing from clamp assembly jig.</p></div> <div><div><p>GOOD</p></div><div><p>NG</p></div></div> <div><p>BANDO GUN ALIGNMENT</p></div> <div><p>Fixed setting of band clamp cutter: 1</p></div>		<div><p>BANDO GUN</p></div> <div><p>BANDO GUN ILLUSTRATION</p></div>	<div><p>1. No damaged clamp</p><p>2. No wrong use of clamp</p><p>3. No missing clamp</p><p>4. No wrong use of bando gun</p><p>5. No wrong setting of VM tube</p></div>

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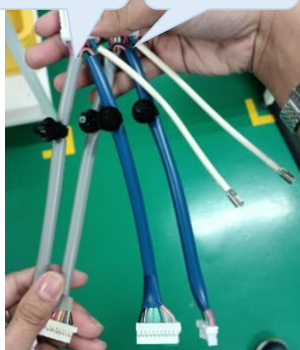


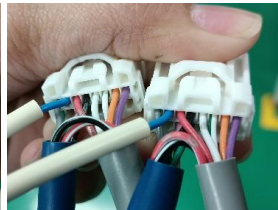


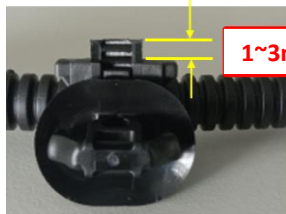
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PARTS:		1. Assy parts 2. Master sample		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1 Visual/By Two's Inspection	<div><p>ACTUAL PRODUCT</p></div> <div><div>Assembled parts</div><div>Master sample</div></div> <div><div><p>1. Check the connector lock condition (should be UNLOCK) and insertion.</p></div><div><p>3. Check the terminal if with backing out (not fully inserted) or deformed terminal.</p></div></div> <div><div><p>2. Check the presence of clamp attachment.</p></div><div><p>4. Check if deformed terminal and Peel-off wire</p></div></div>			<p>Document References:</p> <p>1. Refer to WI-ENG-PDE-431 for Steering Electrical Test after assembly.</p> <div>MASTER SAMPLE</div> <div></div> <p>1. No wrong facing of harness 2. No Tangled wires 3. No missing parts 4. No skip process</p> <div><p>1~3mm</p></div> <p>Important reminders/Note/s:</p> <p>1. Using a steel rule, check if the band cut measurement is within the required dimension (1~3mm) and should not exceed the maximum value.</p>

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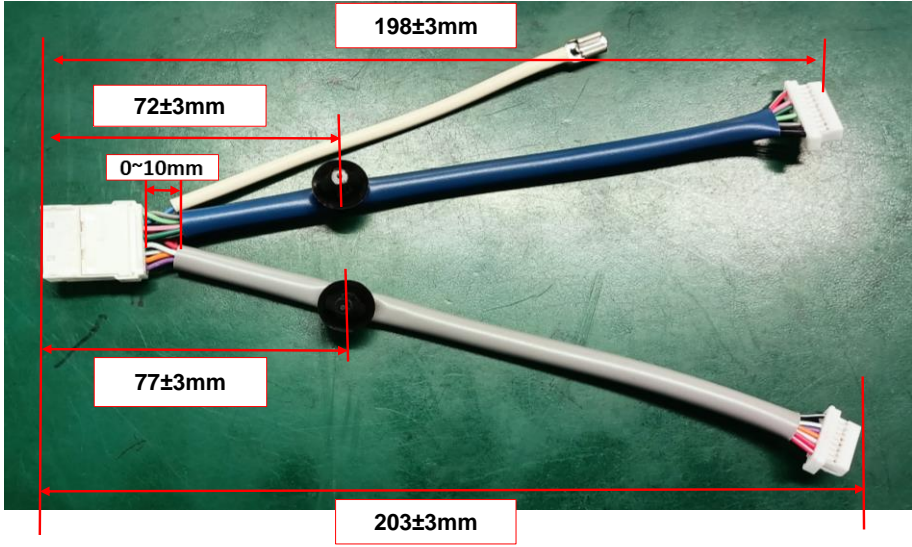
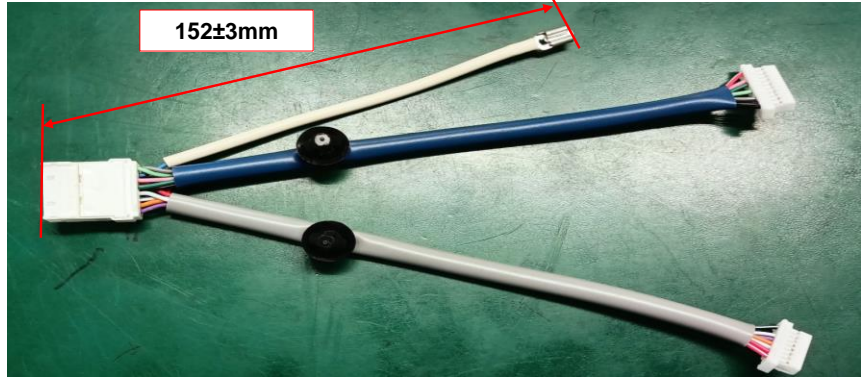
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	P1	Measurement	<div></div>	<div>Important reminders and note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. For Hatsumono, Nakamono and Owarimono. Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div>
			<div></div>	<div>1. No wrong dimension</div>

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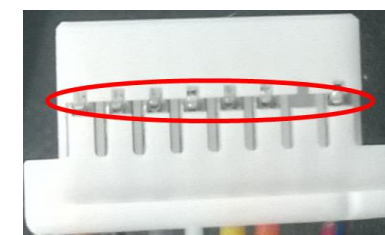
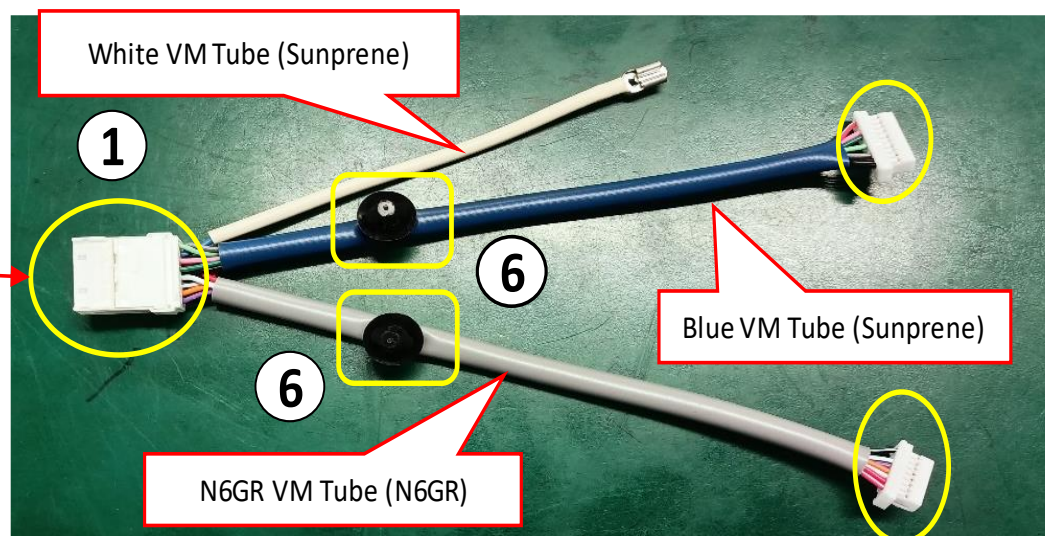
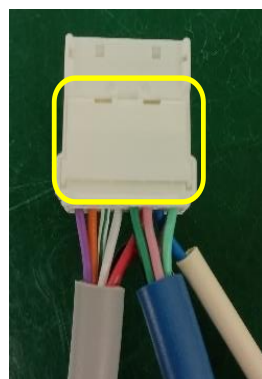
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PARTS:

n/a

JIG:

n/a

QUALITY CHECKPOINTS**P2****75S324-0011****Terminal tip must be visible**

- | | | |
|--|-------------------------------------|--|
| 1 No Locked connector | 3 No Tangled wires | 6 No Missing clamp |
| 2 No Wrong Insert | 4 No Backing out of terminal | 7 No Interchange of VM tube color |
| 5 No Missing Blue wire with Sunprene tube (W) | | |

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DCC Stamp