

	<b>WORK INSTRUCTION</b>				Effectivity Date:		February 24, 2023	
	<b>TAPING ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Process Name/Title:		Model Code/Part Number: <b>400B / 75N241-0040</b>		Customer: <b>TRJ</b>		Document No.: <b>WI-ENG-PDE-093</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		6	Page No.: 1 of 14

<b>PARTS:</b>		1. Connector PBVP-10V-S (W) [2pcs]		JIG:	1. Insertion jig
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1  Connector setting to insertion jig PBVP-10V-S (W)	<p style="text-align: center;"><b>Insertion Jig</b></p> <p>1. Get the 2 pcs of <b>PBVP-10V-S</b> connector using right hand transfer the 1 connector to left hand then insert to insertion jig. <i>Note: Follow the connector orientation.</i></p> <p>2. Press the upper and lower guide using left hand in same timing. Holes that need to be insert are only open.</p>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <p style="color: red; text-align: center;"><b>Safety Instruction</b></p> <p>Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <p style="color: red; text-align: center;"><b>Housekeeping</b></p> <p>1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> </div> <div style="border: 1px dashed red; padding: 5px;"> <p style="color: red; text-align: center;"><b>Alert level</b></p> <p>For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>	<p>1. Use the provided jig per model</p> <p>2. No wrong usage of parts</p> <p>3. No wrong orientation of connector</p> <p>4. No damaged connector</p>

Revision History				Prepared by:	Reviewed by:	Approved by:	Noted by:
02/24/23	6	Change VM tube (sunprene) from Brown VM Tube (Sunprene) TO Dark Brown VM tube (sunprene); Improve work procedure/illustration.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	
02/16/23	5	Improved the insertion jig and procedure. Changed term of Sunprene tube to VM tube (Sunprene). Improved work procedure/illustration. Include quality checkpoints (Page 14).	D.Castillo	J. Loterte	C. Villanueva	A. Arañes	
09/22/22	4	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. Update By two's inspection.	D.Castillo	J. Loterte	C. Villanueva	A. Arañes	
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Established Date: October 04, 2019

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TRJ

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Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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**PARTS:**

1. AVSS 0.3 P L=130±1mm; G L=130±1mm; B/W L=208±2mm; BR L=130±1mm; R/W L=208±2m; GR L=130±1mm; LG L=208±2mm; OR L=208±2mm; R/L L=208±2mm  
2. Dark Brown VM tube (Sunprene) Ø7.5 L=85+2/-3mm

**JIG**

1. Insertion jig

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	Wire insertion to Connector PBVP-10V-S (W)	<p><b>INSERTION SEQUENCE FROM LEFT TO RIGHT</b></p> <p>1. Get the <b>P</b> wire using left hand and transfer to right hand then insert to connector. Repeat the process for G-B/W-BR-R/W-GR-LG-OR-R/L. Check the wire after insertion. <i>Note: Follow the insertion sequence based on the illustration.</i></p>	<p><b>STEERING NAVIGATION</b></p> <p><b>CONTROLLER</b></p>	<p>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</p> <p><b>Important reminders/Note/s:</b></p> <p>1. Please hold the wire near terminal during insertion.</p> <p>2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</p> <p><b>Document References:</b></p> <p>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.</p>
3	Wire insertion to Dark Brown VM tube (Sunprene) Ø7.5 L=85+2/-3mm	<p>1. Get the <b>Dark Brown VM tube (Sunprene) Ø7.5 L=85+2/-3mm</b> using left hand and transfer to right hand. Hold the wires using left hand and insert the wires using right hand.</p>	N/A	<p>1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires</p>

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# WORK INSTRUCTION

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Model Code/Part Number: **400B / 75N241-0040**

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

Customer: **TRJ**

☒ MASSPRO

Effectivity Date:

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### PARTS:

1. AVSS 0.3 V L=130±1mm; B L=130±1mm; Y L=130±1mm; GR/B L=130±1mm; R L=130±1mm

### JIG

1. Insertion jig

### NO.

### PROCESS NAME



### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE

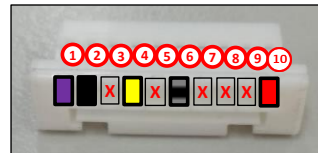
### QUALITY POINTERS

4

P1

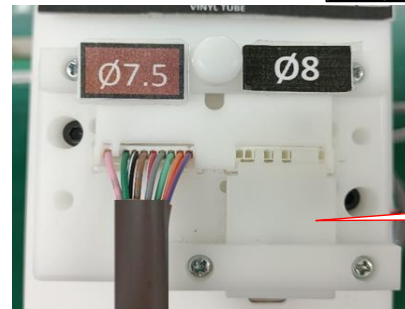
Wire insertion to  
Connector  
PBVP-10V-S (W)

#### INSERTION SEQUENCE FROM LEFT TO RIGHT



Wire facing

1	2	3	4	5	6	7	8	9	10
V	B	X	Y	X	GR/B	X	X	X	R
130	130	X	130	X	130	X	X	X	130



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

Lower guide



1. Get the **V** wire using right hand and insert to connector. Repeat the process for **B-Y-GR/B-R**. 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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Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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**6**

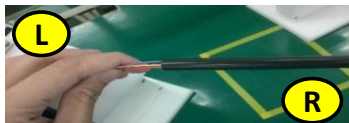


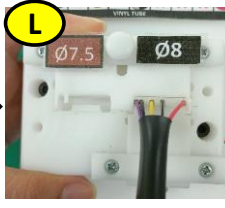
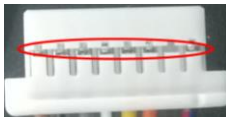
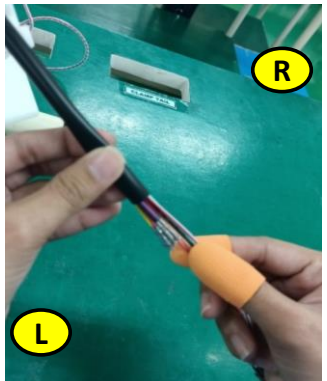

Page No.:

**4 of 14****PARTS:**

1. Black VM tube (Sunprene) Ø8 L=85+2/-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=85+2/-3mm	    <p>1. Get the <b>Black VM tube (Sunprene) Ø8 L=85+2/-3mm</b> using right hand. Hold the wire using left hand then insert the wires.</p> <p>2. Press the Upper button using left hand.</p> <p>3. Remove the 1st connector with inserted wires and <b>Dark Brown VM tube (Sunprene)</b> using right hand then press the upper guide using left hand. Check the wire insertion condition. <b>Note: Second connector with inserted wire and Black VM tube (Sunprene) will stay in the jig.</b></p>	N/A	<p>1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires</p>  <p><b>Terminal tip must be visible</b></p> <p><b>Document References:</b> 1. Refer to <b>GL-PRO-ASY-025</b> for <b>Inspection Standard for Coupler Insertion.</b></p>
6	Wire insertion to assy parts	  <p>1. Hold the <b>Black VM tube (Sunprene)</b> using left hand and insert the wires from <b>Dark Brown VM tube (Sunprene)</b> using right hand.</p>	N/A	<p>1. No wrong use of parts 2. No deformed terminal 3. No tangled wires</p>

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## WORK INSTRUCTION

### TAPING ASSEMBLY PROCESS

Process Name/Title:

Model Code/Part Number: **400B / 75N241-0040**Customer: **TRJ**Purpose: ☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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**February 24, 2023**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-093**

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1. Assy parts

**JIG**

1. Insertion jig

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

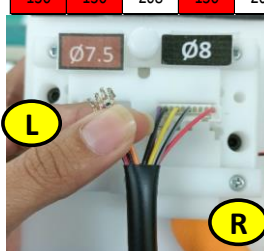
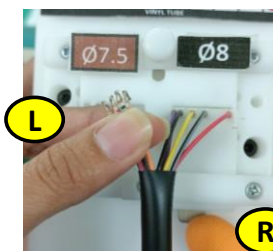
7

P1

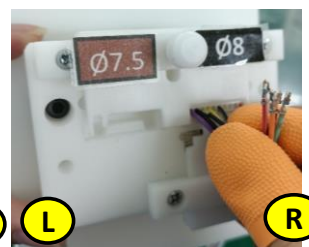
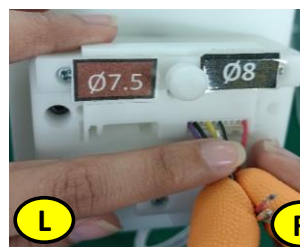
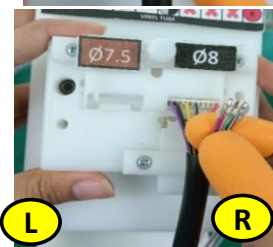
Wire insertion to  
Connector  
PBVP-10V-S (W)INSERTION SEQUENCE FROM LEFT TO  
RIGHT

Wire facing

1	2	3	4	5	6	7	8	9	10
V	B	B/W	Y	R/W	GR/B	LG	OR	R/L	R
130	130	208	130	208	130	208	208	208	130



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



2. Hold the **B/W wire** using right hand and support the wire by left index finger then insert to connector using right hand. Repeat the process on **R/W-LG-OR-R/L 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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Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

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#### PARTS:

1. Assy parts

#### JIG

1. Insertion jig

#### NO.

#### PROCESS NAME

#### WORK PROCEDURE/ ILLUSTRATION

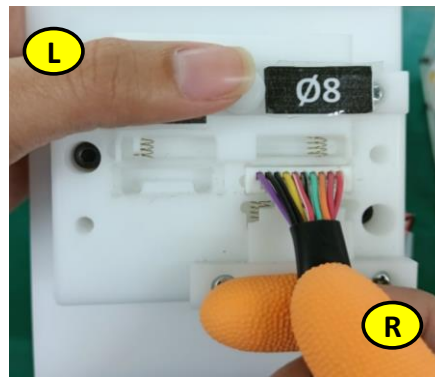
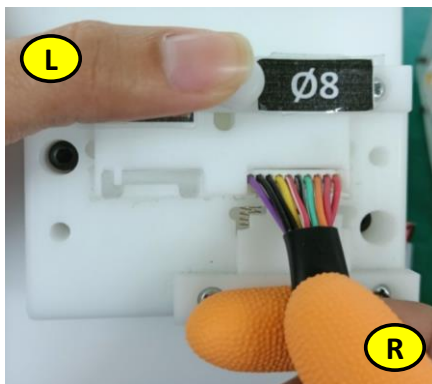
#### TOOLS/PPE

#### QUALITY POINTERS

7

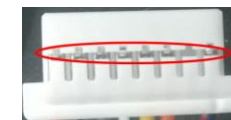
P1

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



3. Press the Upper button using left hand then remove the assy part using right hand. Check the insertion condition.

N/A



Terminal tip must be visible

#### Document References:

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

1. No deformed terminals
2. No tangled wires
3. No wrong facing

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☐ PRE-LAUNCH

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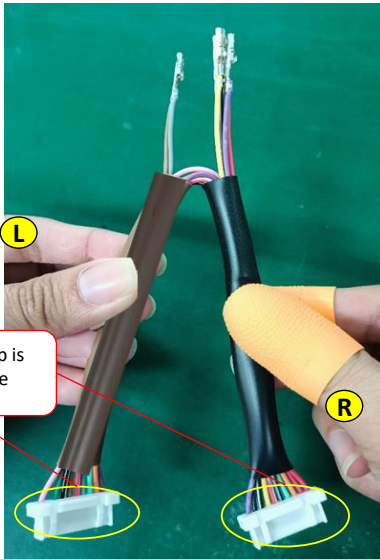
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PARTS:		1. Assy parts			JIG	n/a
NO.	PROCESS NAME		<div>6</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
8	P1	Wire arrangement	<div><p>BEFORE FOLDING</p><p>AFTER FOLDING</p><p>1. Hold the assy parts using both hands then conduct wire arrangement.</p></div>	n/a	1. No deformed terminals 2. No tangled wires 3. No wrong facing	

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☐ PROTOTYPE

☐ PRE-LAUNCH

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#### PARTS:

1. Connector 1746872-1 (B)

#### JIG

1. Insertion jig

#### NO.

#### PROCESS NAME

#### WORK PROCEDURE/ ILLUSTRATION

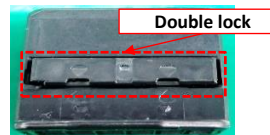
#### TOOLS/PPE

#### QUALITY POINTERS

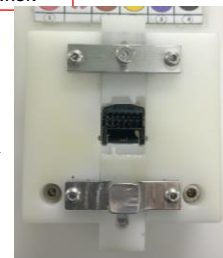
9

P1

Connector setting to  
insertion jig  
1746872-1 (B)

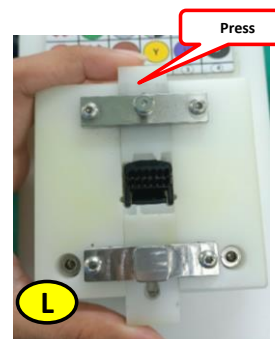


#### CONNECTOR ORIENTATION

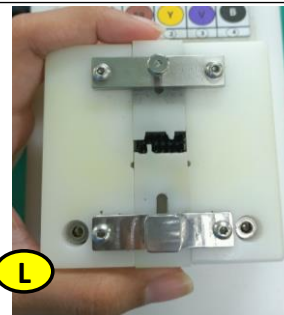


1. Get the connector **1746872-1 (B)** and insert to insertion jig using right hand.

*Note: Follow the connector orientation*



Press

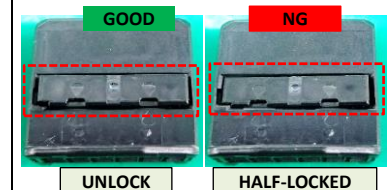


2. Press the upper and lower guide (same timing) using left hand. Holes that need to be insert are only open.

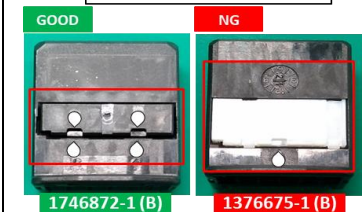
N/A

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

#### CONNECTOR LOCK APPEARANCE CHECK



#### CONNECTOR ILLUSTRATION



#### Important reminders/Note/s:

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

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☐ PROTOTYPE

☐ PRE-LAUNCH

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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

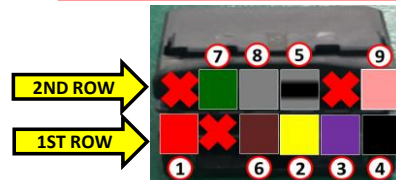
QUALITY POINTERS

10

P1

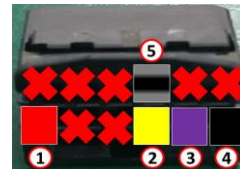
Wire insertion to Connector  
1746872-1 (B)

INSERTION SEQUENCE FROM LEFT TO RIGHT



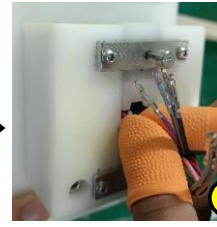
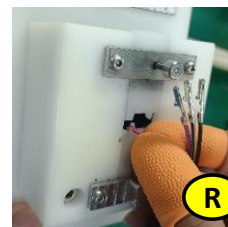
X	7	8	5	X	9
	G	GR	GR/B		P
1	130	130	130		131
R	X	6	2	3	4
		BR	Y	V	B
131		130	130	130	130

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 **Y-V-B wires**.  
*Note: Follow the insertion sequence based on the illustration stated above.*

2. Hold the **GR/B 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. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.
2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
3. Please hold the wire near terminal during insertion.

### Document reference/s:

1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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**PARTS:**

1. Assy parts

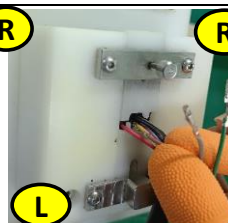
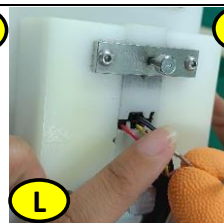
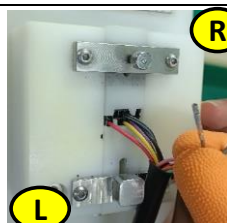
**JIG**

1. Insertion jig

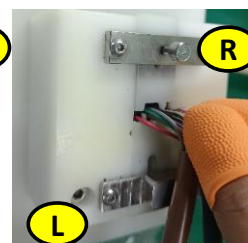
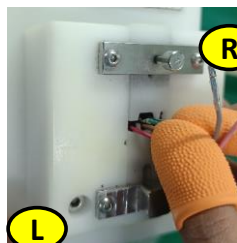
**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

10

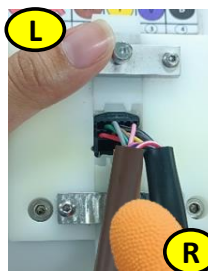
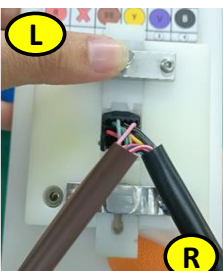
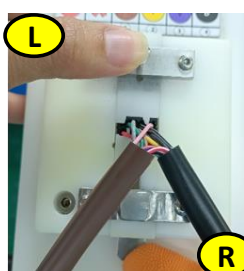
P1

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

3. Hold the **BR wire** using right hand and support the wire by left index finger then insert to terminal **slot 6** using right hand. *Note: Follow the insertion sequence based on the above illustration.*



4. Hold the **G wire** and insert to terminal **slot 7** using right hand. Repeat the process for **GR-P wires**.  
*Note: Follow the insertion sequence based on the illustration.*



5. Press the Upper and lower button 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. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.
2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.
3. Please hold the wire near terminal during insertion.

**Document reference/s:**

1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.

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# WORK INSTRUCTION

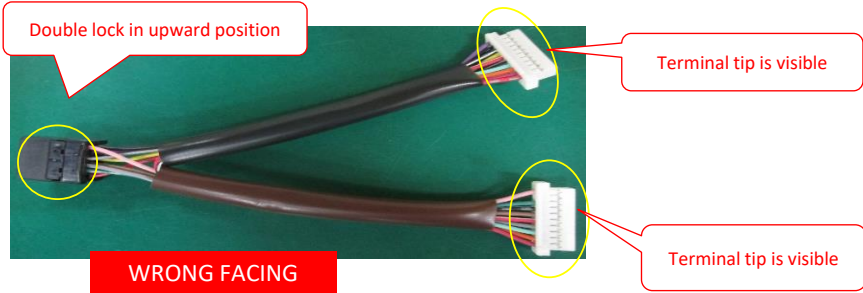
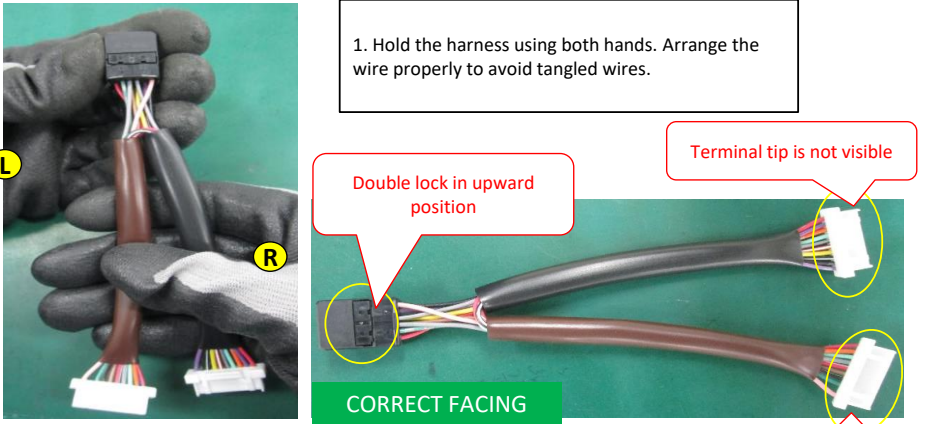
## TAPING ASSEMBLY PROCESS

Effectivity Date:	February 24, 2023		
Validity Date:	n/a		
Document No.:	WI-ENG-PDE-093		
Revision No.:	6	Page No.:	11 of 14

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

Model Code/Part Number: **400B / 75N241-0040** Customer: **TRJ**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

<b>PARTS:</b>		1. Assy parts			<b>JIG</b>	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>6</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>	
11	P1	Wire Arrangement	<div></div>	n/a	1. No wrong orientation of connector 2. No tangled wires 3. No wrong harness facing	

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## WORK INSTRUCTION

### TAPING ASSEMBLY PROCESS

Process Name/Title:

Model Code/Part Number: **400B / 75N241-0040**

Customer: **TRJ**

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

**February 24, 2023**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-093**

Revision No.:

**6**

Page No.:

**12 of 14**

**PARTS:**

n/a

JIG:

n/a

**NO.**

**PROCESS NAME**

**6**

**WORK PROCEDURE/ ILLUSTRATION**

**TOOLS/PPE**

**QUALITY POINTERS**

12

P1

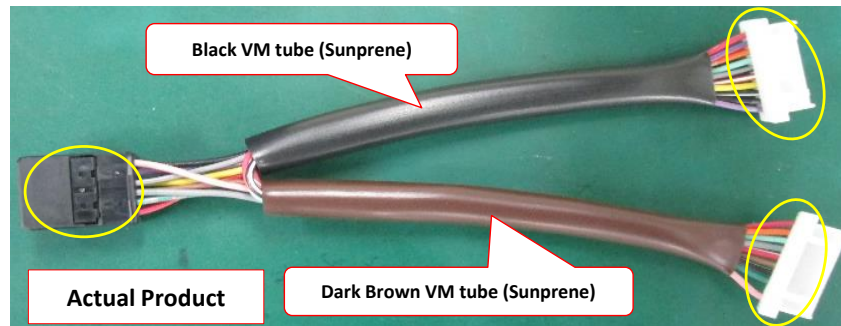
Visual/By two's inspection

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

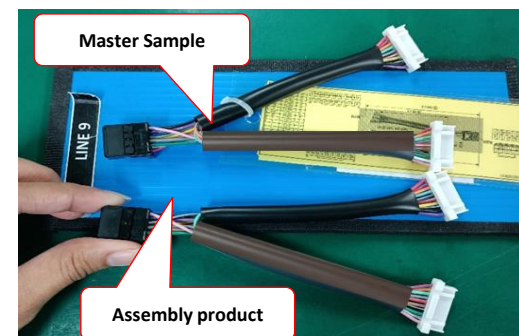
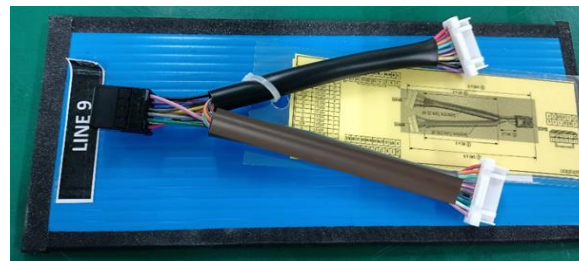
2. Check the wire alignment. Make sure no tangled wires.

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

4. Check the orientation of harness.



5. Compare to **Master Sample** by tapping.



#### Document References:

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

**MASTER SAMPLE**



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**WORK INSTRUCTION**

Effectivity Date:

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Process Name/Title:

**TAPING ASSEMBLY PROCESS**

Validity Date:

n/a

Model Code/Part Number:

**400B / 75N241-0040**

Customer:

**TRJ**

Document No.:

**WI-ENG-PDE-093**

Purpose:

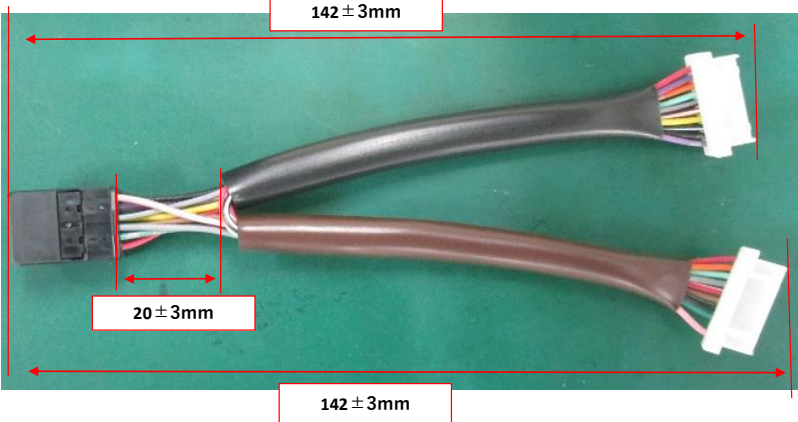

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

6

Page No.:

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PARTS:	N/A			JIG:	N/A
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
13	Measurement		<b>MEASURING TAPE</b> 	1. No wrog dimension  <b>Important Reminder/Note/s:</b> <b>1. Please use calibrated/verified measuring tape when getting the measurement.</b> <b>2. For Hatsumuno and Owarimono</b>	
	P1				

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## WORK INSTRUCTION

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

Model Code/Part Number: **400B / 75N241-0040**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

**February 24, 2023**

Validity Date:

**n/a**

Document No.:

**WI-ENG-PDE-093**

Revision No.:

**6**

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**14 of 14**

**PARTS:**

n/a

**JIG**

n/a

### QUALITY CHECKPOINTS

## 75N241-0040

1. Check the connector lock, should be unlock.

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

Black VM Tube (Sunprene)

Dark Brown VM tube (Sunprene)

3. Check the orientation of harness.

4. Check if no missing parts.

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

6. Compare to master sample.

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