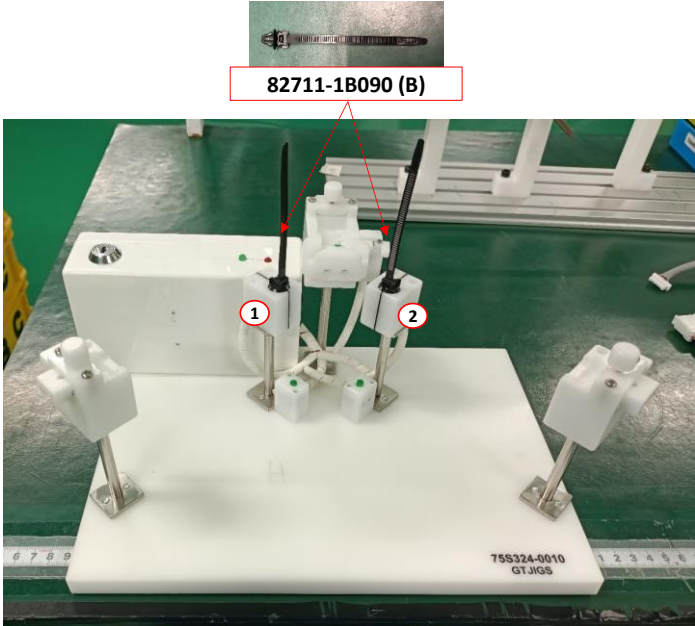


	WORK INSTRUCTION				Effectivity Date:		June 6, 2023	
	TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Process Name/Title:		Model Code/Part Number YDB / 75S324-0010		Customer: TRJ		Document No.: WI-ENG-PDE-609B	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		2	Page No.: 1 of 11

PARTS:	1. 82711-1B090 (B) [2pcs]	JIG:	1. Assembly jig
---------------	---------------------------	-------------	-----------------

NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P2	<div style="text-align: center;">  <p style="margin-top: 10px;">1. Get 2pcs. of clamp 82711-1B090 (B) using right hand then set to clamp location 1 and 2 using both hands.</p> </div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px dashed red; padding: 5px;"> 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 style="margin-top: 20px;"> 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:		Checked by:		Approved by:		Noted by:	
06/06/23	2	Change term Sunprene tube to VM tube (Sunprene). Improved work procedure of Page 2. Improved quality checkpoints (Page 11).	D.Castillo	J.Loterte	C. Vilanueva	A. Arañes									
01/13/23	1	Change Pre-launch to Masspro. Provide Insertion jig. Update By two's inspection, Bando gun and Quality pointers.	D.Castillo	J.Loterte	C. Vilanueva	A. Arañes									
01/04/23	0	Initial issue.	D.Castillo	J.Loterte	C. Vilanueva	A. Arañes									
Eff. Date	Rev. No	Details of Change	Revised	Checked	Approved	Noted	Established Date:		January 4, 2023						

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2 of 11**PARTS:**

1. Connector 7283-7596 (W)

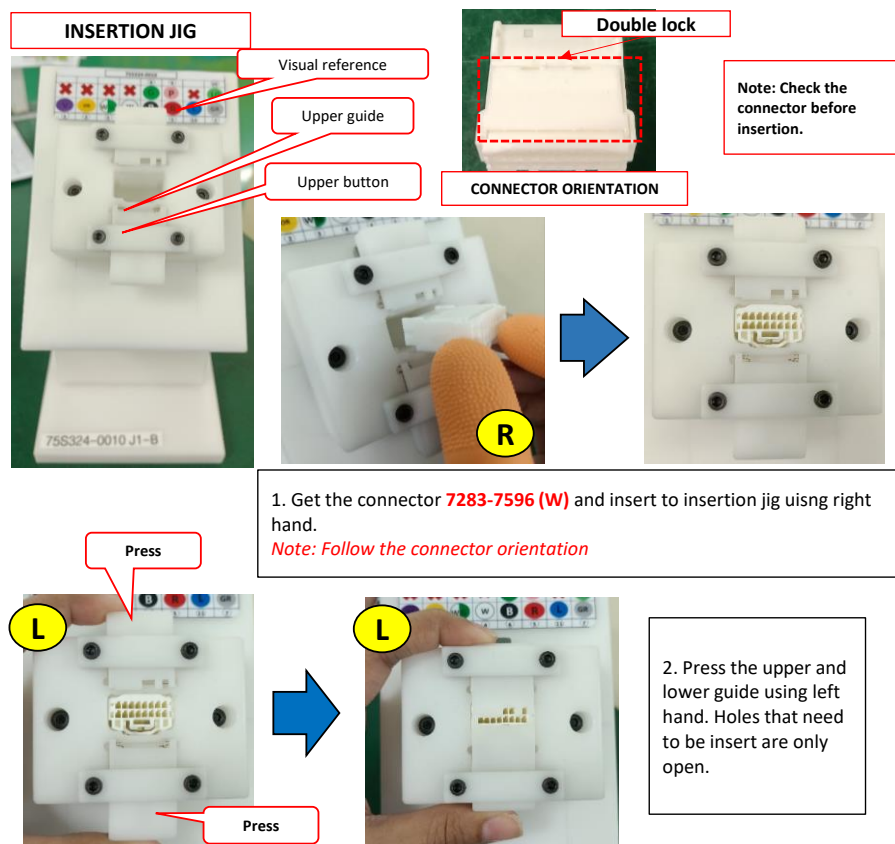
JIG

1. Insertion jig

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

9

P1

Connector setting to
insertion jig
7283-7596 (W)

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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3 of 11**PARTS:**

1. Assy parts

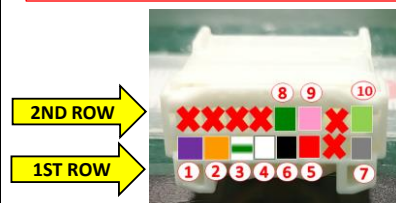
JIG

1. Insertion jig

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

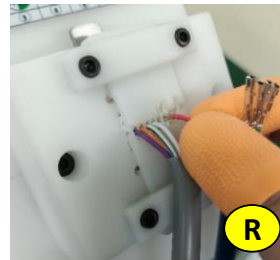
2

P2

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

X	X	X	X	8	9	X	10
1	2	3	4	G	P	X	LG
188	188	188	188	6	5	X	7
V	OR	W/G	W	B	R	X	GR
193	193	193	193	188	193	X	188

2

N6GR VM tube (Sunprene)**FIRST ROW (LEFT TO RIGHT)**

2

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.

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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PARTS:

1. Assy parts

JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

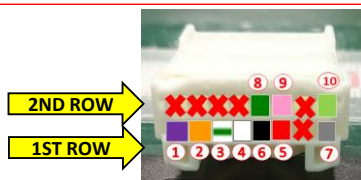
QUALITY POINTERS

2

P2

Wire insertion to
Connector
7283-7596 (W)
(Continuation)

INSERTION SEQUENCE FROM LEFT TO RIGHT

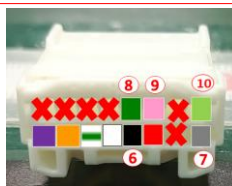


Wire facing

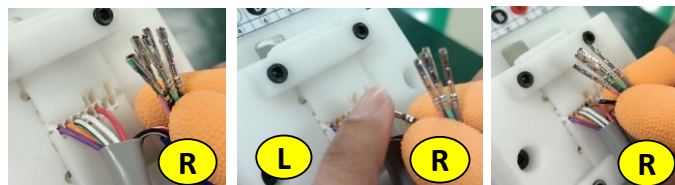
WIRE INSERTION ILLUSTRATION

X	X	X	X	8	9	X	10
1	2	3	4	6	5	X	7
V	OR	W/G	W	B	R	X	GR
193	193	193	193	188	193	188	188

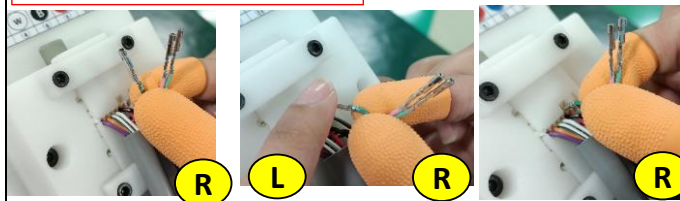
Blue VM Tube (Sunprene)



FIRST ROW (LEFT TO RIGHT)



SECOND ROW (LEFT TO RIGHT)



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

2

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

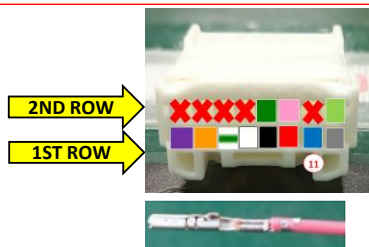
QUALITY POINTERS

2

P2

Wire insertion to
Connector
7283-7596 (W)
(Continuation)

INSERTION SEQUENCE FROM LEFT TO RIGHT

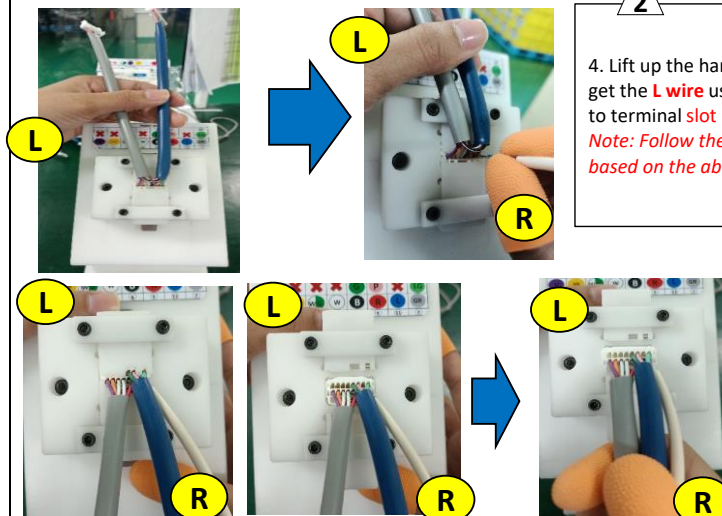


WIRE INSERTION ILLUSTRATION

				8	9		10
X	X	X	X	G	P	X	LG
				188	188		188
1	2	3	4	6	5	11	7
V	OR	W/G	W	B	R	L	GR
193	193	193	193	188	193	129	188

Wire facing

FIRST ROW (LEFT TO RIGHT)



2

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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PROTOTYPE



PRE-LAUNCH



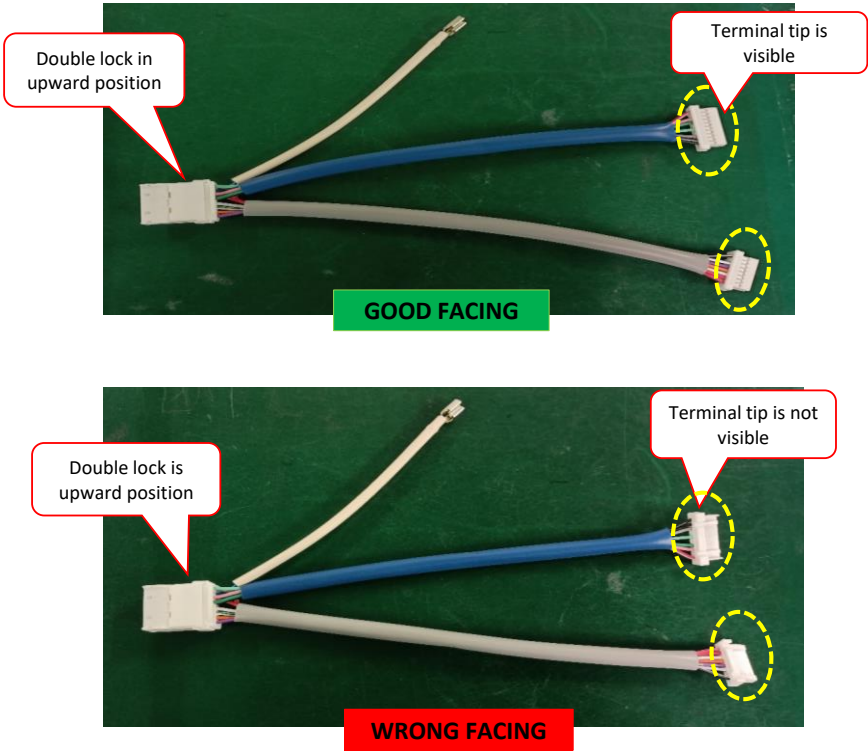
MASSPRO

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PARTS:		1. Assy parts			JIG	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P2	Wire arrangement			n/a	1. No wrong orientation of connector. 2. No tangled wires. 3. Terminal backing out.

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☐ PRE-LAUNCH

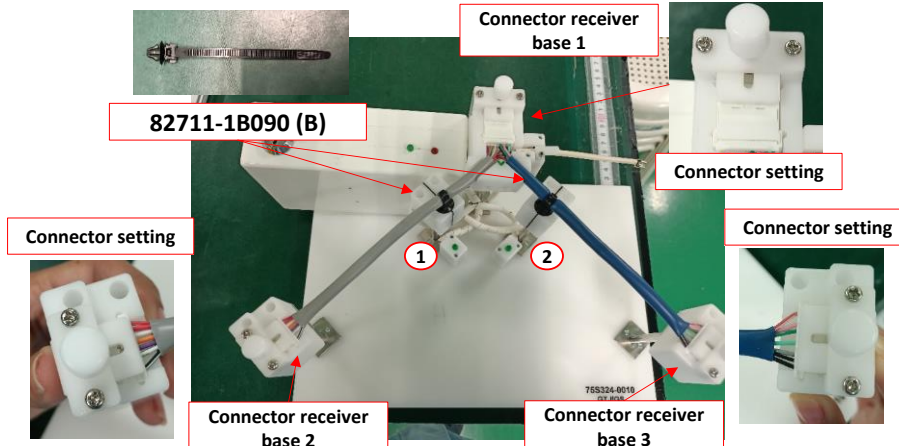
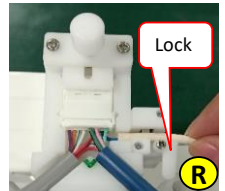
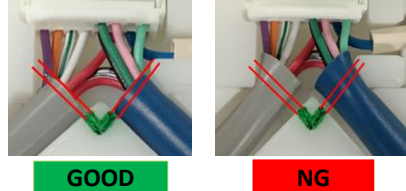
☒ MASSPRO

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PARTS:		1. Assy parts		JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P2	Clamp Assembly	<div><p>1. Get the assy parts and set into jig. (<i>See above picture for correct setting of harness</i>). First, set the connector 7283-7596 (W) to Connector receiver base 1. Second, set the Blue wire (<i>with white VM tube (Sunprene)</i>) in vinyl guide and lock. Third, set the two (2) WM tube in GREEN LINE. Fourth, set the connector PBVP-08V-S (W) (<i>with N6GR VM tube (Sunprene)</i>) to Connector receiver base 2. Last, set the connector PBVP-10V-S (W) to Connector receiver base 3 (<i>with Blue VM tube (Sunprene)</i>). Check if the sequence light of location 1 was ON.</p><div><div><p>White VM tube (Sunprene) Setting</p></div><div><p>VM tube (Sunprene) Setting</p></div></div></div>	n/a	<ol style="list-style-type: none">1. No damaged clamp2. No wrong use of clamp3. No missing clamp4. No wrong use of bando gun5. No wrong setting of VM tube

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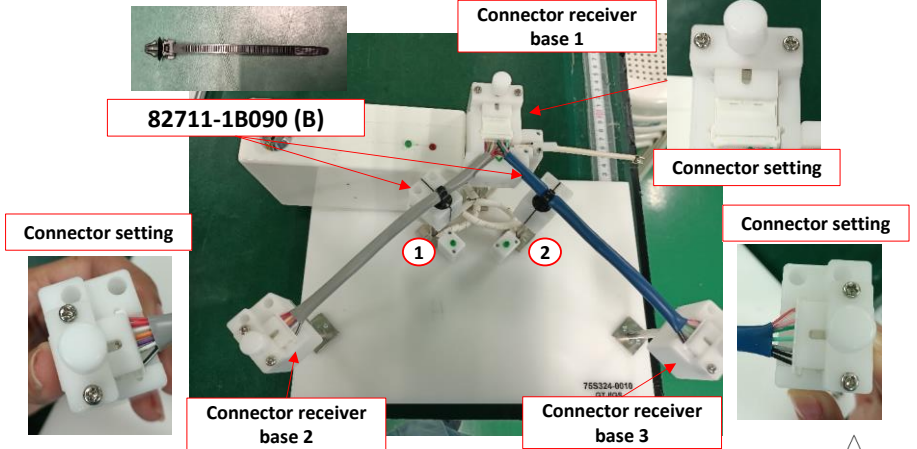
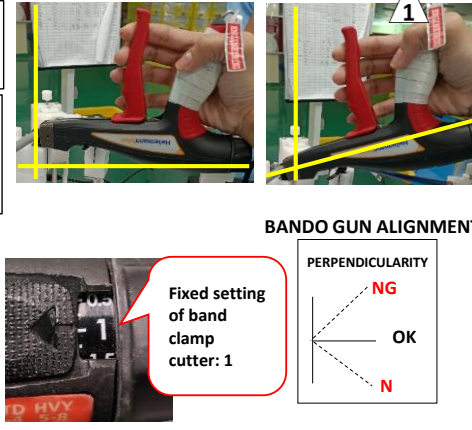


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PARTS:		1. Assy parts		JIG	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
4	P2	Clamp Assembly (Continuation)	<div><div></div><div><p>2. Initially tighten the band clamp from location 1 and 2 using both hands.</p><p>3. 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></div> <div><div></div><div></div></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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PARTS:

1. Assy parts

JIG

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

16

P1

Visual/By two's inspection

Assembled parts

Master sample

1. Check the **connector lock** condition (should be UNLOCK) and **insertion**.

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

2. Check the **presence of clamp attachment**.

4. Check if **deformed terminal** and **Peel-off wire**

Document References:

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

MASTER SAMPLE

1. No skip process

1~3mm

Important reminders/Note/s:

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.

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PARTS:		1. Assy parts			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
6	P2	Measurement				<div>Measuring tape</div>
						Important reminders/Note/s: 1. Please use calibrated /verified measuring tape when getting the measurement. 2. For Hatsumono and Owarimono. 1. No wrong dimension.

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PARTS:

n/a

JIG

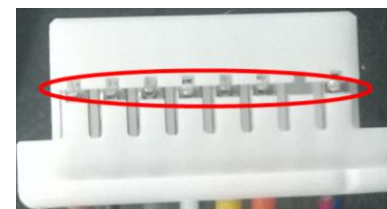
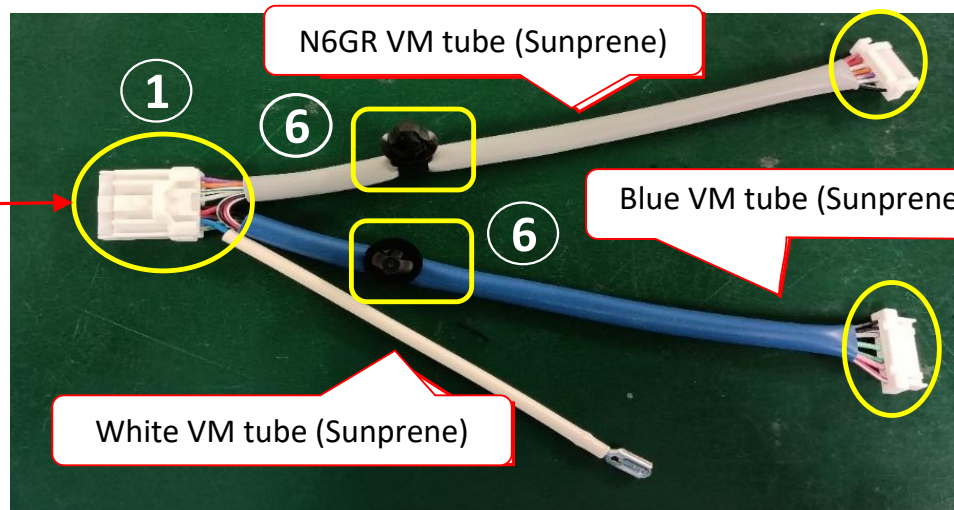
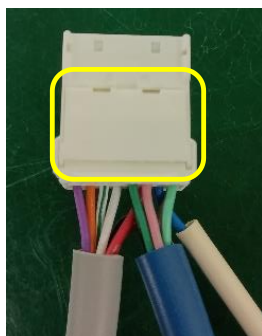
n/a

2

QUALITY CHECKPOINTS

P2

75S324-0010



Terminal tip must be visible

1 No Locked connector

2 No Wrong Insert

3 No Tangled wires

4 No Backing out of terminal

5 No Missing Blue wire with White VM tube (Sunprene)

6 No Missing clamp

7 No Interchange of VM tube color

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