



WORK INSTRUCTION

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 14, 2024

Process Name/Title:

Validity Date:

n/a

Model code/Part number:

VK00 / 75S059-0211

Customer:

TRJ

Car Model:

ISUZU

Document No.:

WI-ENG-PDE-589

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

4

Page No.:


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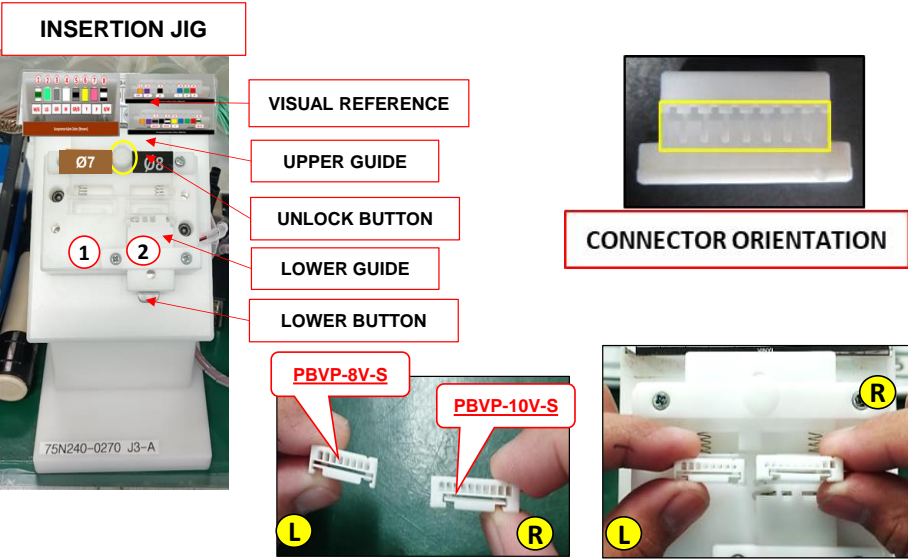
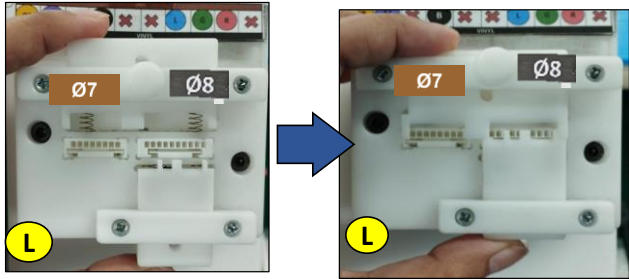
PARTS:		1. Connector PBVP-8V-S (W); Connector PBVP-10V-S (W); AVSS 0.3 Wires W/G L=480±2mm; LG L=251±2mm; GR L=249±2mm; W L=249±2mm; GR/B L=473±2mm; Y L=473±2mm; P L=251±2mm; B/W L=473±2mm; Dark Brown VM tube (Sunprene) Ø7 L=208±3mm; Black VM tube (sunprene) Ø8 L= 208±3 mm; AVSS 0.3 OR L=255±2mm; V L=253±2mm; B L=249±2mm; L L=249±2mm; G L=251±2mm; R L=253±2mm		JIG:	1. Insertion jig 2. Steering Navigation	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS		
1	P1 4 Table lay-out	<p>Table Lay-out</p> <p>Connector 1746872-1 (B)</p> <p>Dark Brown VM tube (Sunprene) Ø7 L= 208±3 mm</p> <p>2 layers navigator</p> <p>Black VM tube (sunprene) Ø8 L= 208±3 mm</p> <p>Master sample</p> <p>Insertion Jig B</p> <p>Insertion Jig A</p> <p>Connector PBVP-8V-S (W)</p> <p>Connector PBVP-10V-S (W)</p>	<p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p>	<p>Important reminders/Note/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No deformed terminal 2. No wrong use of parts 3. No wrong use of jigs</p>		
Revision History			Prepared by	Reviewed by	Approved by	Noted by
10/14/24	4	Aligned wire length based on Cutting ledger (Customer request). Inclusion of Table lay-out and Wire folding. Improved work procedure of Wire arrangement, Measurement and Visual inspection. Changed navigator from 1 layer to 2 layers.	D.Castillo	C.Villanueva	A. Arañes	n/a
05/06/24	3	Change VM tube color name from Brown to Dark Brown. Change Electrical test document number due to transfer process from Production to QC.	D.Castillo	C.Villanueva	A. Arañes	n/a
12/13/23	2	Change term from sunprene tue to VM tube (Sunprene).	D.Castillo	C.Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
			Est. Date:	September 02, 2022		

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	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:	4	Page No.:	2 of 14

PARTS:		1. Connector PBVP-8V-S (W) 2. Connector PBVP-10V-S (W)			JIG:	1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
2	P1 Connector setting to insertion jig PBVP-8V-S (W) PBVP-10V-S (W)	<div><div>INSERTION JIG</div><div></div><div><p>1. Get the 1 pc of PBVP-8V-S connector using left hand and get the 1 pc of PBVP-10V-S connector using right hand then insert to insertion jig (same timing) <i>Note: Follow the connector orientation.</i></p></div><div></div><div><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></div>			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	

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PROTOTYPE



PRE-LAUNCH





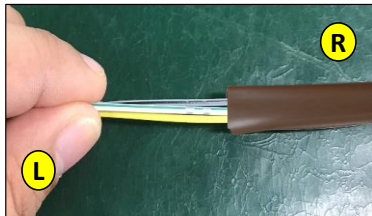


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PARTS: <div>4</div>		1. AVSS 0.3 Wires W/G L=480±2mm; LG L=251±2mm; GR L=249±2mm; W L=249±2mm; GR/B L=473±2mm; Y L=473±2mm; P L=251±2mm; B/W L=473±2mm; 2. Dark Brown VM tube (Sunprene) Ø7 L=208±3mm						JIG:	1. Insertion jig 2. Steering Navigation																								
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION						TOOLS/PPE	QUALITY POINTERS																								
3	P1 Wire insertion to Connector PBVP-8V-S (W)	<div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div> <div><div><div>1</div><div>2</div><div>3</div><div>4</div><div>5</div><div>6</div><div>7</div><div>8</div></div><div><div>W/G</div><div>LG</div><div>GR</div><div>W</div><div>GR/B</div><div>Y</div><div>P</div><div>B/W</div></div></div> <div><div>4</div><div>TERMINAL FACING</div><div>WIRE INSERTION ILLUSTRATION</div><table><tr><td>1</td><td>2</td><td>3</td><td>4</td><td>5</td><td>6</td><td>7</td><td>8</td></tr><tr><td>W/G</td><td>LG</td><td>GR</td><td>W</td><td>GR/B</td><td>Y</td><td>P</td><td>B/W</td></tr><tr><td>480</td><td>251</td><td>249</td><td>249</td><td>473</td><td>473</td><td>251</td><td>473</td></tr></table></div> <div><div><div><div>Ø7</div><div>R</div></div><div>→</div><div><div>R</div></div></div><div>1. Get the W/G wire using left hand and transfer to right hand then insert to connector. Repeat the process for LG-GR-W-GR/B-Y-P-B/W. Check the wire after insertion.</div></div>						1	2	3	4	5	6	7	8	W/G	LG	GR	W	GR/B	Y	P	B/W	480	251	249	249	473	473	251	473	<div>STEERING NAVIGATION (2 layers)</div> <div></div> <div>CONTROLLER</div> <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</div> <div>Important reminders/Note/s: 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. 2. Please hold the wire near terminal during insertion. 3. Follow the insertion sequence based on the illustration.</div> <div>Document references: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.</div>
1	2	3	4	5	6	7	8																										
W/G	LG	GR	W	GR/B	Y	P	B/W																										
480	251	249	249	473	473	251	473																										
4	Wire insertion to Dark Brown VM tube (Sunprene) Ø7 L=208±3mm	<div><div><div><div>L</div><div>R</div></div><div></div></div><div><div>1. Get the Dark Brown VM tube (Sunprene) Ø7 L=208±3mm using left hand and transfer to right hand. Hold the wires using left hand and insert the wires using right hand.</div><div><div></div></div></div></div>						n/a	<div>1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires</div> <div>Document references: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div>																								

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PROTOTYPE



PRE-LAUNCH



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PARTS:



1. AVSS 0.3 OR L=255±2mm; V L=253±2mm; B L=249±2mm; L L=249±2mm; G L=251±2mm; R L=253±2mm;

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

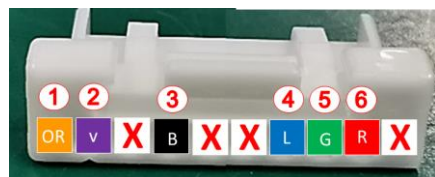
QUALITY POINTERS

5

P1

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

INSERTION SEQUENCE FROM LEFT TO RIGHT

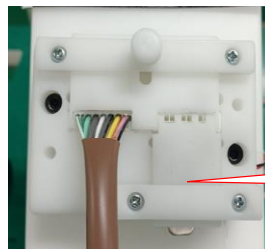


TERMINAL FACING

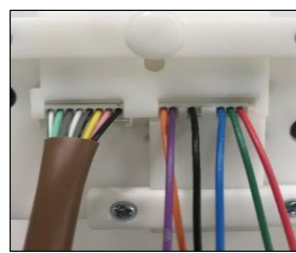


WIRE INSERTION ILLUSTRATION

1	2		3			4	5	6	
OR	V	X	B	X	X	L	G	R	X
255	253	X	249	X	X	249	251	253	X

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

Lower guide

1. Get the **ORANGE** wire using right hand and insert to connector. Repeat the process for **V-B-L-G-R**. Check the wire after insertion.**Note:** Follow the insertion sequence based on the above illustration.STEERING
NAVIGATION
(2 layers)


CONTROLLER

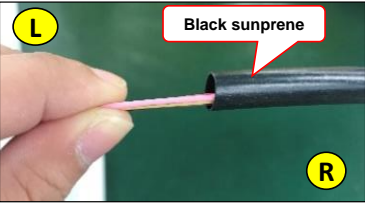



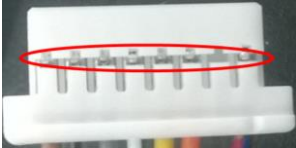
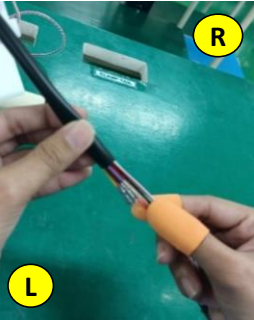
**Important reminders/Note/s:**1. Make sure wires are properly inserted.
Conduct **Pull-Push-Pull-Push** after
insertion.
Do not exert extra force.2. Please hold the wire near terminal
during insertion.3. Follow the insertion sequence based on
the illustration.

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

Document references:1. Refer to **GL-PRO-ASY-029** for Pull-Push
procedure.2. Refer to **WI-ENG-PDE-044** for Steering
Navigation Controller procedure.**CONFIDENTIAL:** Any misuse or misappropriation, including
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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	4	Page No.:	5 of 14

PARTS:	1. Assy parts; 2. Black VM tube (Sunprene) Ø8 L=208±3mm			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1 Wire insertion to Black VM tube Ø8 L=208±3mm	<div><p>1. Get the Black VM tube (sunprene) Ø8 L=208±3mm using right hand. Hold the wires using left hand then insert the wires.</p></div> <div><p>2. Press the Upper button using left hand.</p></div> <div><p>3. Remove the 1st connector with inserted wires and Dark Brown VM tube (sunprene) using right hand then press the upper guide using left hand. Check the wire insertion condition. <i>Note: Second connector with inserted wire and Black VM tube (Sunprene) will stay in the jig.</i></p></div> <div><p>4. Press the Lower button using right hand. Holes that need to be insert are only open.</p></div>		n/a	<div><p>Terminal tip must be visible</p></div> <p>Document References:</p> <p>1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.</p>
7	P1 Wire insertion to Assy parts	<div><p>1. Hold the Black VM tube (sunprene) using left hand and insert the wires from Dark Brown VM (sunprene) tube using right hand.</p></div>		n/a	<p>1. No wrong use of parts 2. No deformed terminal 3. No tangled wires</p>

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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

8

P1

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

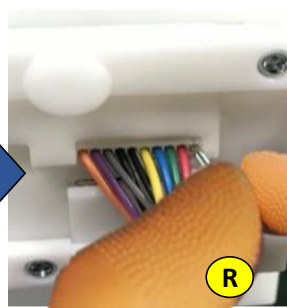
INSERTION SEQUENCE FROM LEFT TO RIGHT



TERMINAL FACING

WIRE INSERTION ILLUSTRATION

		1		2	3				4
OR	V	GR/B	B	B/W	Y	L	G	R	W/G
255	253	473	249	473	473	249	251	253	480

Press the unlock button
using left thumb.

1. Hold the **GR/B** wire using right hand and support the wire by left index finger then insert to connector using right hand. Repeat the process for **B/W-Y-W/G**.

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

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

Important reminders/Note/s:

1. Please hold the wire near terminal during insertion.
2. Refer to **GL-PRO-ASY-029** for Pull-Push procedure.
3. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion. Do not exert extra force.
4. Follow the insertion sequence based on the above illustration.

Document references:

1. Refer to **WI-PRO-CNC-O17** for Wire and Strip length tolerance.




Terminal tip must be visible

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	4	Page No.:	7 of 14

PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
9	P1	Wire folding	N/A	1. No deformed terminals 2. No tangled wires 3. No wrong facing	

4

BEFORE FOLDING

AFTER FOLDING

L

R

1. Hold the assy parts using both hands then conduct wire arrangement.

Terminal tip is not visible

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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

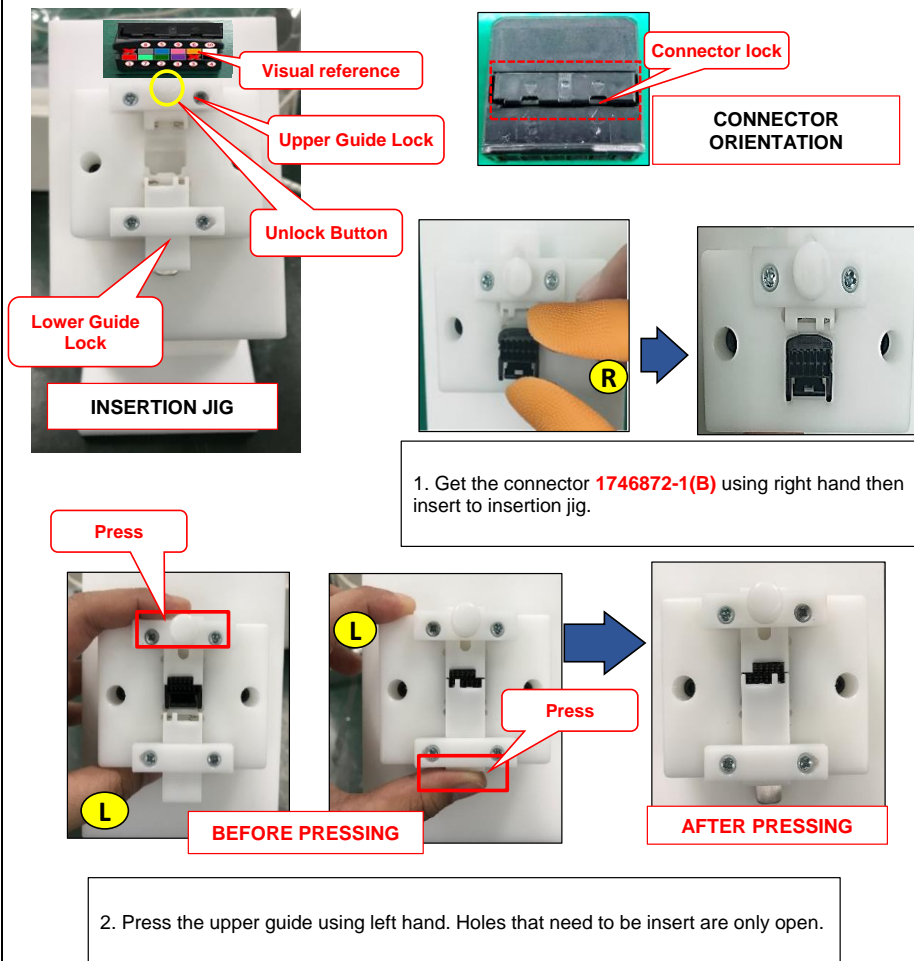
TOOLS/PPE

QUALITY POINTERS

10

P1

Connector setting to
insertion jig
1746872-1 (B)



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.
2. Follow the connector orientation
3. 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

11

P1

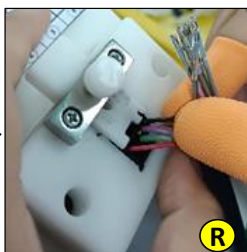
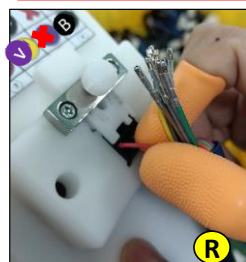
Wire insertion to
Connector
1746872-1 (B)

INSERTION SEQUENCE FROM LEFT TO RIGHT



TERMINAL FACING

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

WIRE INSERTION ILLUSTRATION

	8	5	9	6	10
X	GR	L	P	OR	W
	249	249	251	255	249
1	7	2	3		4
R	LG	G	V	X	B
253	251	251	253		249

BLACK VM TUBE (SUNPRENE)



SECOND ROW (LEFT TO RIGHT)



2. Hold the **L wire** and insert to terminal slot 5. Repeat the process for **OR wire**.
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.
4. Follow the insertion sequence based on the illustration stated above.


Document references:



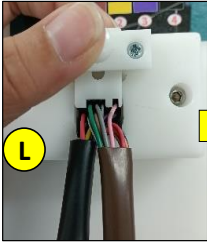

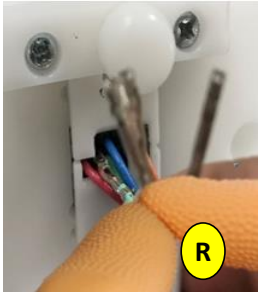
1. Refer to **GL-PRO-ASY-029** for Pull-Push procedure.
2. Refer to **WI-PRO-CNC-017** for Wire and Strip Length Tolerance

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PARTS:		1. Assy parts		JIG:	1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
11	P1 Wire insertion to Connector 1746872-1 (B) (Continuation)	<div><div><div>DARK BROWN VM TUBE (SUNPRENE)</div><div></div><div></div></div><div><div>3. Hold the LG wire using right hand and support the wire by left index finger then insert to terminal slot 7 using right hand.</div><div>4. Hold the GR wire and insert to terminal slot 8 using right hand. Repeat the process for P-W wires. Note: Follow the insertion sequence based on the illustration.</div><div>5. Press the Upper button using left hand then remove the assy part using right hand.</div></div></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. 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. 4. Follow the insertion sequence based on the illustration stated above.</div> <div>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</div>	


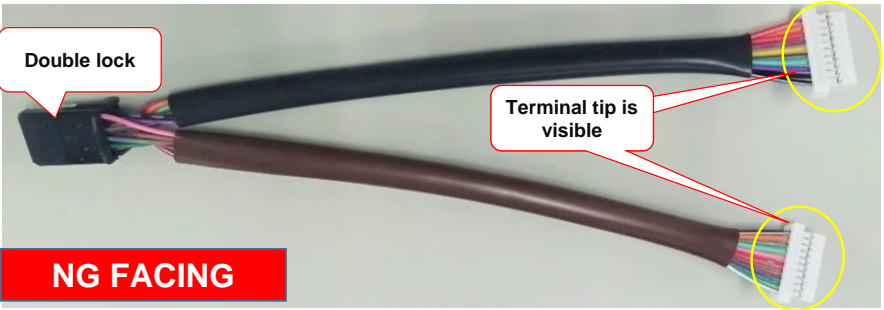
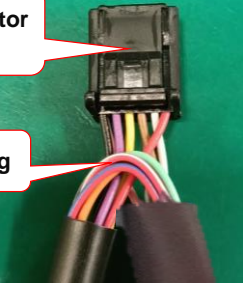
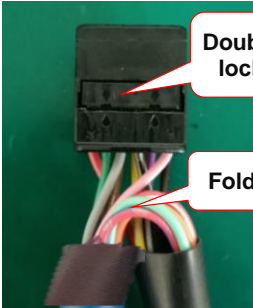
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	WORK INSTRUCTION				Effectivity Date:	October 14, 2024		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: VK00 / 75S059-0211		Customer: TRJ	Car Model: ISUZU	Document No.:	WI-ENG-PDE-589		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	4	Page No.:	11 of 14


PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	<div><div>4</div>WORK PROCEDURE/ ILLUSTRATION</div>	TOOLS/PPE	QUALITY POINTERS	
12	P1	<div><div><div><div>Double lock</div><div>Terminal tip is Not visible</div><div>GOOD FACING</div></div><div><div>Double lock</div><div>Terminal tip is visible</div><div>NG FACING</div></div><div><div>1. Hold the harness using both hands. Arrange the wire properly to avoid tangled wires. <i>Note: Photos shown reference only.</i></div><div><div>Connector Lock</div><div>Folding</div></div><div><div>Double lock</div><div>Folding</div></div></div></div><div><div>GOOD FACING</div><div>NG FACING</div></div></div>	N/A	<div>1. No wrong orientation of connector 2. No tangled wires 3. No wrong facing of wire folding</div>	

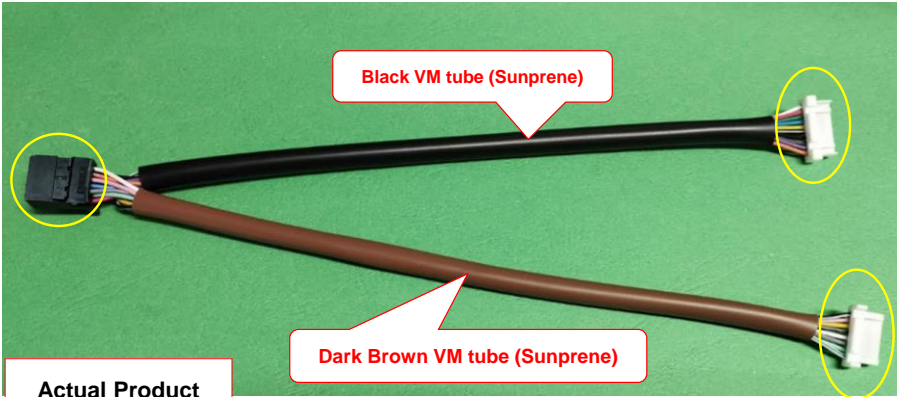
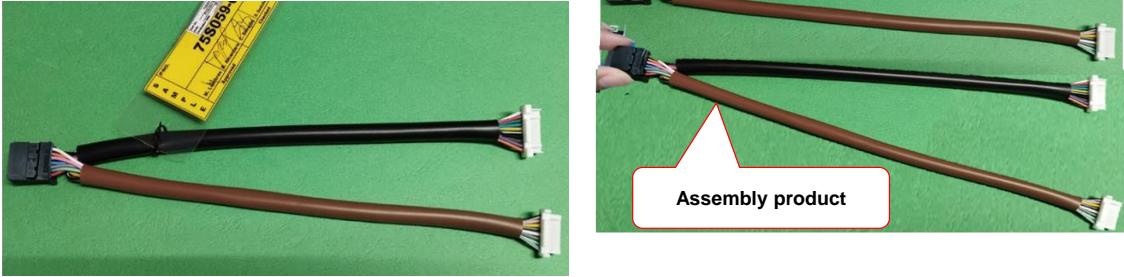

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	Model code/Part number: VK00 / 75S059-0211		Customer: TRJ	Car Model: ISUZU	Document No.:	WI-ENG-PDE-589		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	4	Page No.:	12 of 14


PARTS:	1. Assy parts				JIG:	n/a			
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE	QUALITY POINTERS		
13	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. Make sure no tangled wires.</div> <div>3. Check the terminal if with backing out (not fully inserted) or deformed terminal.</div> <div>4. Check the orientation of harness.</div> <div><p>Black VM tube (Sunprene)</p><p>Dark Brown VM tube (Sunprene)</p><p>Actual Product</p></div> <div><div>5. Compare to Master Sample by taping.</div><div><p>Master Sample</p><p>Assembly product</p></div></div>					<div>Document References:</div> <div>1. Refer to WI-QAD-QAC-252 for Steering Electrical Test after assembly.</div> <div><div>MASTER SAMPLE</div><div><p>MASTER SAMPLE</p></div></div>		


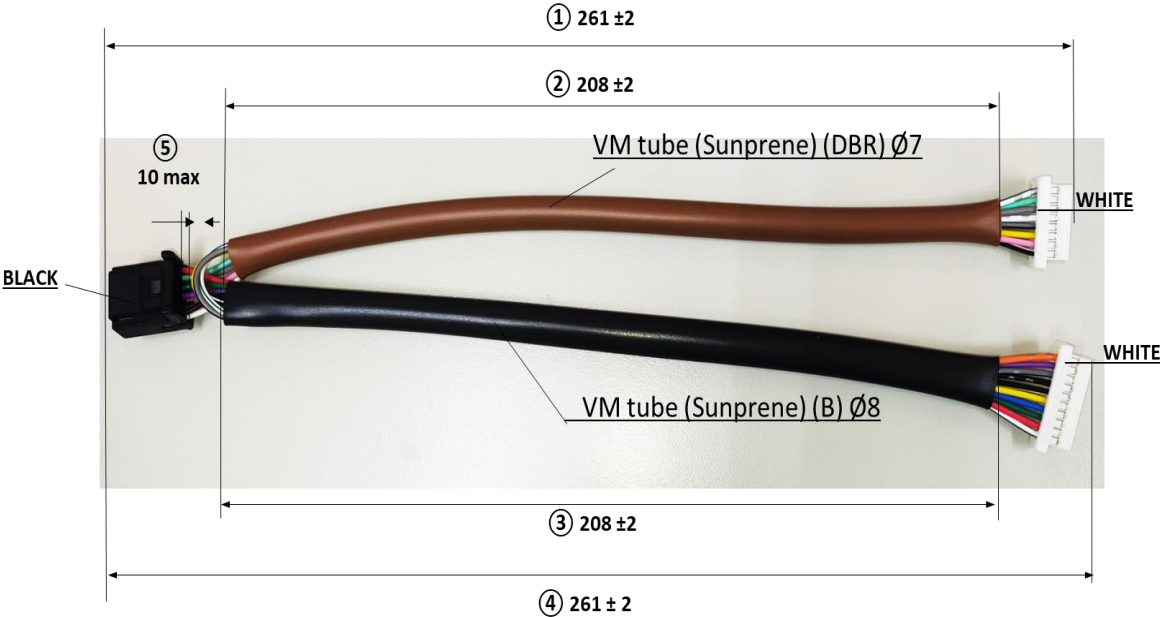
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	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	n/a		
	Model code/Part number: VK00 / 75S059-0211		Customer: TRJ	Car Model: ISUZU	Document No.:	WI-ENG-PDE-589		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	4	Page No.:	13 of 14

PARTS:		1. Assy parts		JIG:	n/a	
NO.	PROCESS NAME	<div><div></div>4</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS		
14	P1	Measurement <div><div><div>Measuring tape</div></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.</div> <div>Document reference/s: 1. Refer to WI-PRO-ASY-056 for Sub-assembly Hatsumono Nakamono Owarimono Inspection</div> <div>1. No wrong dimension</div>		

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WORK INSTRUCTION

Process Name/Title:

TAPING ASSEMBLY PROCESS

Effectivity Date:

October 14, 2024

Validity Date:

n/a

Model code/Part number:

VK00 / 75S059-0211

Customer:

TRJ

Car Model:

ISUZU

Document No.:

WI-ENG-PDE-589

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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4

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14 of 14

PARTS:

1. Assy parts

JIG:

n/a



VISUAL INSPECTION/ QUALITY CHECKPOINTS

STEERING

75S059-0211

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

4. Check the orientation of harness.

5. Check if no missing parts.

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