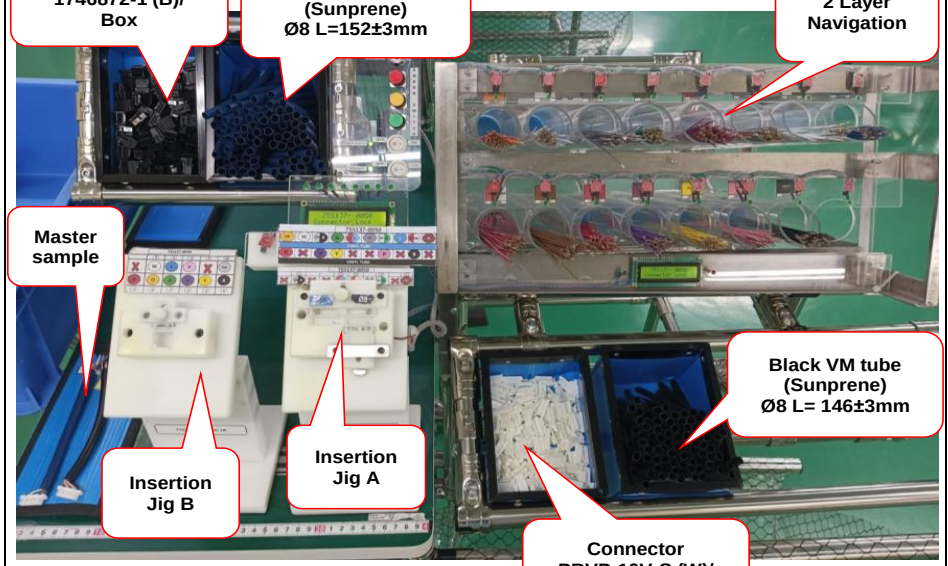
	WORK INSTRUCTION			Effectivity Date:	February 13, 2025	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 177D / 75S137-0050	Customer: TRJ	Car Model: TOYOTA-COROLLA	Document No.:	WI-ENG-PDE-369	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	3	Page No.: 1 of 18

PARTS:	1. Connector 1746872-1 (B); BlueVM tube (Sunprene) Ø8 L=152±3mm; Black VM tube (Sunprene) Ø8 L= 146±3mm; Connector PBVP-10V-S (W); AVSS 0.3 Wires OR L=206±2mm; W L=202±2mm; GR/B L=369±2mm; G L=200±2mm; R/L L=371±2mm; GR L=196±2mm; W/G L=373±2mm; L L=192±2mm; R/W L=365±2mm; BR L=371±2mm; AVSS 0.3 Wires R L=186±2mm; V L=190±2mm; Y L=192±2mm; P L=198±2mm; B L=204±2mm	JIG:	1. Insertion jig 2. Steering Navigation

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	Table lay-out	**Table Lay-out**  	**Safety Instruction** Be sure to wear required 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.	***Document reference/s:*** *1. Refer to **WI-PRO-CNC-017** for Wire and Strip Length Tolerance* 1. No deformed terminal 2. No wrong usage of parts

Revision History

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
02/13/25	3	Improved insertion jig; Change connector (PBVP-10V-S) orientation, terminal orientation and color sequence as customer claim countermeasure. Inclusion of Table lay-out. Additional method to Wire folding 1 process as countermeasure to damage lance. Improved Measurement and Visual inspection/Quality checkpoints. Change document number of Steering Electrical test (WI-QAD-QAC-252).	D. Castillo	C. Villanueva	A. Arañes	n/a
02/08/23	2	Standarized the tube descriptions: VM tube (Sunprene). Improve work procedure/illustration. Inclusion of Quality checkpoints	M. Ariola	J. Loterte	C. Villanueva	A. Arañes
03/15/22	1	Change from Pre-launch to Masspro. Merge P1 and P2 due to the process Improvement. Improve work Procedure/Illustration.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes

Prepared by	Reviewed by	Approved by	Noted by
D. Castillo	C. Villanueva	A. Arañes	n/a
Est. Date:	November 11, 2021		

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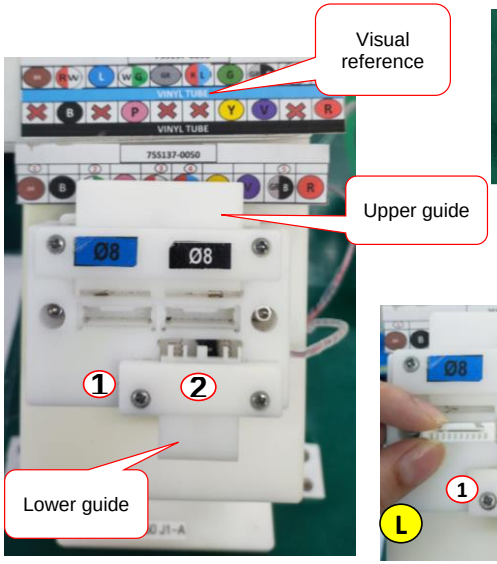
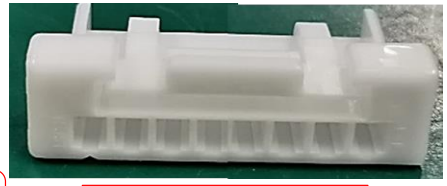
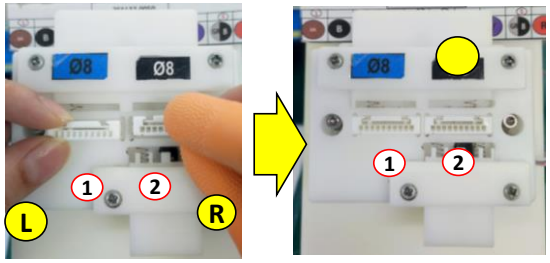
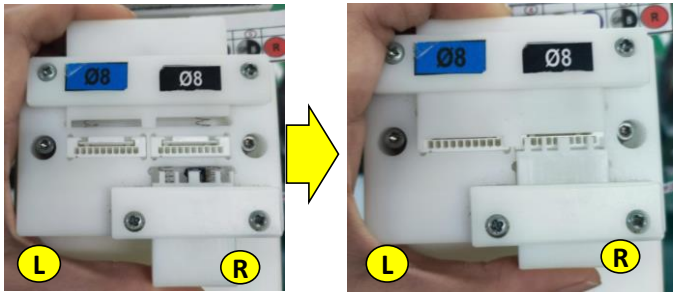
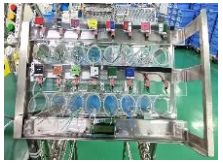
	WORK INSTRUCTION			Effectivity Date:	February 13, 2025	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 177D / 75S137-0050	Customer: TRJ	Car Model: TOYOTA-COROLLA	Document No.:	WI-ENG-PDE-369	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	3	Page No.: 2 of 18

PARTS:	1. Connector PBVP-10V-S (W) [2pcs]	JIG:	1. Insertion jig 2. Steering Navigation

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1	3 Connector setting to insertion jig PBVP-10V-S (W)	 INSERTION JIG  CONNECTOR ORIENTATION  1. Get the 2pcs of **PBVP-10V-S** connector using right hands then transfer the 1 connector to left hand and insert to insertion jig. *Note: Follow the connector orientation.*  2. Press the upper and lower guide lock (same timing) using left hands. You will notice the holes that needs to be inserted are only open.	STEERING NAVIGATION (2 layer)  CONTROLLER 	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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	Model code/Part number: 177D / 75S137-0050	Customer: TRJ	Car Model: TOYOTA-COROLLA	Document No.:	WI-ENG-PDE-369	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	3	Page No.: 3 of 18

PARTS:	1. AVSS 0.3 Wires OR L=206±2mm; W L=202±2mm; GR/B L=369±2mm; G L=200±2mm; R/L L=371±2mm; GR L=196±2mm; W/G L=373±2mm; L L=192±2mm; R/W L=365±2mm; BR L=371±2mm	JIG:	1. Insertion jig 2. Steering Navigation

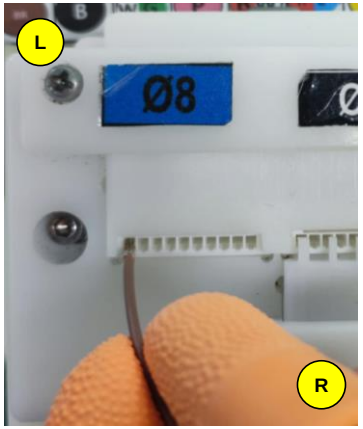
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1	Wire insertion to Connector PBVP-10V-S (W)			

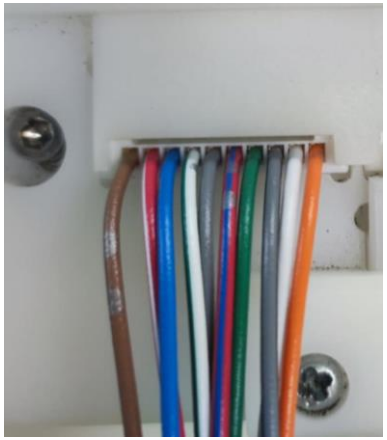
INSERTION SEQUENCE FROM LEFT TO RIGHT

TERMINAL FACING

WIRE INSERTION ILLUSTRATION

1	2	3	4	5	6	7	8	9	10
BR	R/W	L	W/G	GR	R/L	G	GR/B	W	OR
371	365	192	373	196	371	200	369	202	206

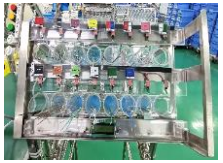




1. Get the BR wire using right hand then insert to connector. Repeat the process for R/W, L, W/G, GR, R/L, G, GR/B, W and OR wires. Check the wire after insertion.
Note: Follow the insertion sequence based on the illustration.

TOOLS/PPE

STEERING NAVIGATION (2 layer)



CONTROLLER

QUALITY POINTERS

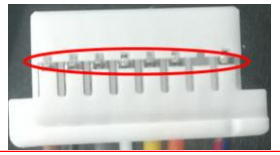
1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

Important reminders/Note/s:

1. 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.

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.



Terminal tip must be visible

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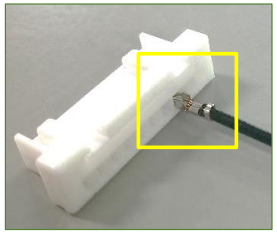
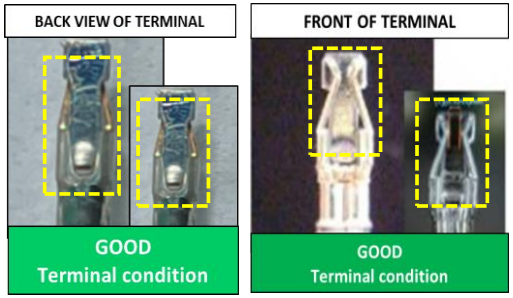
PARTS:	1. AVSS 0.3 Wires OR L=206±2mm; W L=202±2mm; GR/B L=369±2mm; G L=200±2mm; R/L L=371±2mm; GR L=196±2mm; W/G L=373±2mm; L L=192±2mm; R/W L=365±2mm; BR L=371±2mm	JIG:	1. Insertion jig 2. Steering Navigation

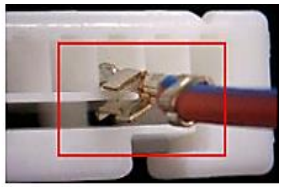
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1	3 Wire insertion to Connector PBVP-10V-S (W) (Continuation)			1. Use provided jig per model 2. No wrong usage of parts 3. One by one insertion 4. No wrong insertion 5. No deformed terminal 6. No stuck of terminal tip ***Important reminders/Note/s:*** ***1. 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.*** ***Document reference/s:*** ***1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.*** ***2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..*** ***3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.*** ***4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.***

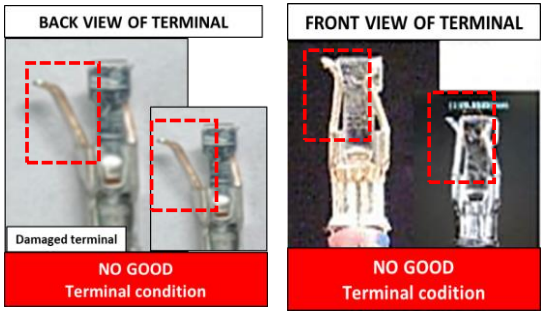
Proper alignment of terminal to connector





Improper alignment of terminal to connector





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.

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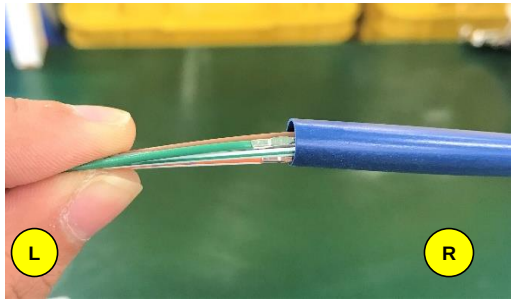
PARTS:	1. Blue VM tube (Sunprene) Ø8 L=152±3mm			JIG:	1. Insertion jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
4	P1	Wire insertion to Blue VM tube (Sunprene) Ø8 L=152±3mm	 1. Get the Blue VM tube (Sunprene) Ø8 L=152±3mm using left hand and transfer to right hand. Hold the wires using left hand and insert the wires using right hands.	n/a	1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires

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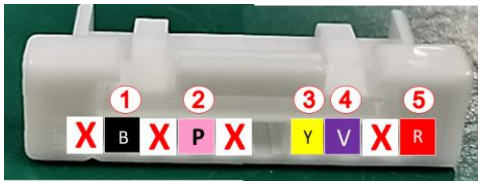
PARTS:	1. AVSS 0.3 Wires R L=186±2mm; V L=190±2mm; Y L=192±2mm; P L=198±2mm; B L=204±2mm	JIG:	1. Insertion jig 2. Steering Navigation

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1	3 Wire insertion to Connector PBVP-10V-S (W)			

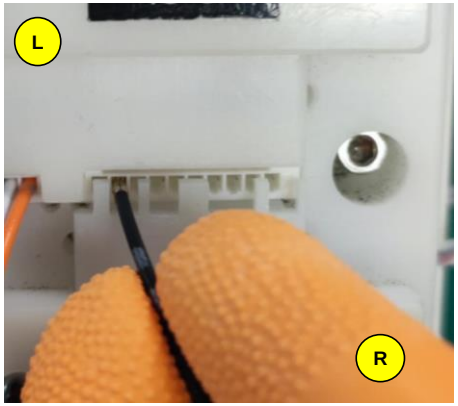
INSERTION SEQUENCE FROM LEFT TO RIGHT



TERMINAL FACING

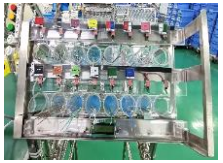
WIRE INSERTION ILLUSTRATION

	1		2			3	4		5
X	B	X	P	X	X	Y	V	X	R
	204		198			192	190		186



1. Get the B wire using right hand then insert to connector. Repeat the process for P, Y,V and R wires. Check the wire after insertion.
Note: Follow the insertion sequence based on the illustration.

STEERING NAVIGATION (2 layer)



CONTROLLER

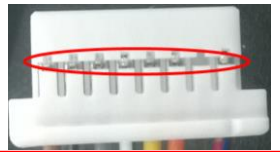
1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

Important reminders/Note/s:

1. 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.

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.



Terminal tip must be visible

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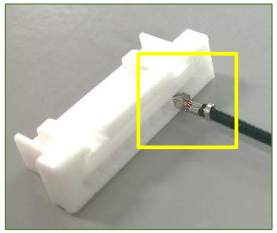
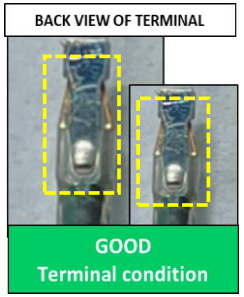
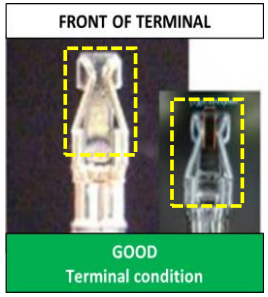
PARTS:	1. AVSS 0.3 Wires OR L=206±2mm; W L=202±2mm; GR/B L=369±2mm; G L=200±2mm; R/L L=371±2mm; GR L=196±2mm; W/G L=373±2mm; L L=192±2mm; R/W L=365±2mm; BR L=371±2mm	JIG:	1. Insertion jig 2. Steering Navigation

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	3 P1	Wire insertion to Connector PBVP-10V-S (W) (Continuation)			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. 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.*** ***Document reference/s:*** ***1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.*** ***2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..*** ***3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.*** ***4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.***

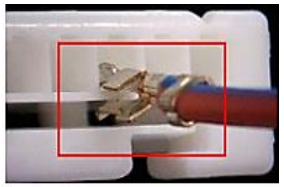
Proper alignment of terminal to connector

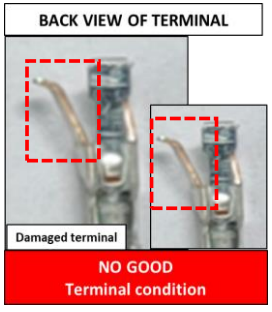


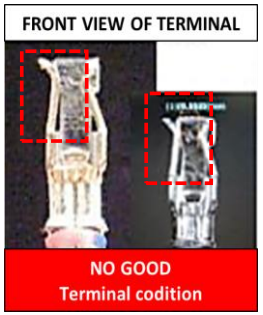




Improper alignment of terminal to connector







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.

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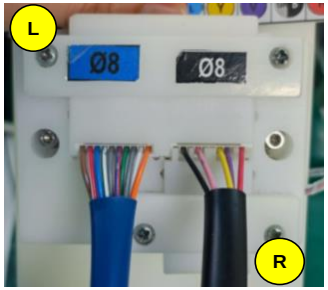
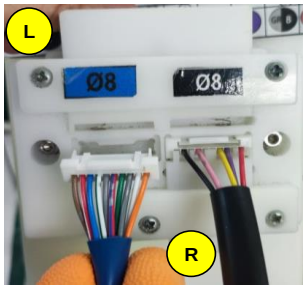
	Model code/Part number: 177D / 75S137-0050	Customer: TRJ	Car Model: TOYOTA-COROLLA	Document No.:	WI-ENG-PDE-369	
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	3	Page No.: 8 of 18

PARTS:	1. Assy parts 2. Black VM tube (Sunprene) Ø8 L= 146±3mm			JIG:	1. Insertion jig
NO.	**PROCESS NAME**		**WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
6	P1	Wire insertion to Black VM tube (Sunprene) Ø8 L=146±3mm	 1. Get the **Black VM tube (Sunprene) Ø8 L= 146±3mm** using right hand. Hold the wires using left hand then insert..   2. Press the upper lock using left thumb. Remove the 1st connector with inserted wires with Blue VM tube (Sunprene) using right hand. Press the lower lock. Check the wire insertion condition. Note: The 2nd connector with inserted wires (With Black VM tube (Sunprene) remains on the jig.	n/a	1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires
7		Wire insertion to assy parts	 2. Hold the Black VM tube (Sunprene) using left hand and insert the wires from Blue VM tube (Sunprene) using right hand.	n/a	1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires

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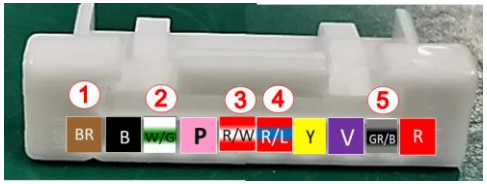
PARTS:	1. Assy parts	JIG:	1. Insertion jig 2. Steering Navigation

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	△3 P1	Wire insertion to Connector PBVP-10V-S (W)			

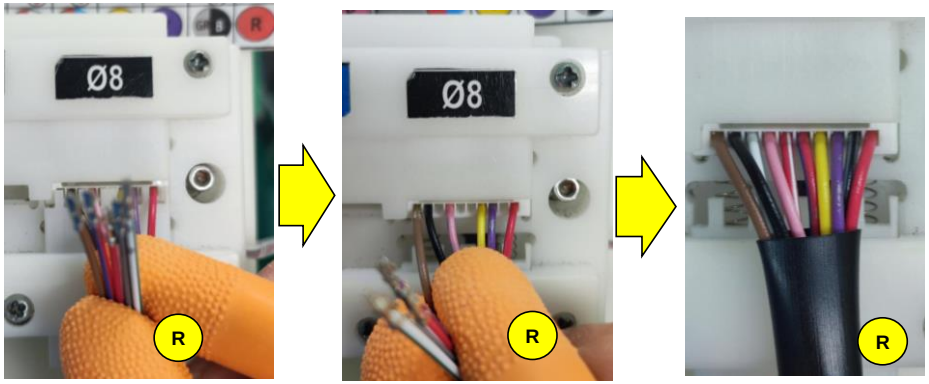
INSERTION SEQUENCE FROM LEFT TO RIGHT



TERMINAL FACING

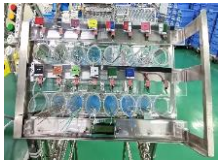
WIRE INSERTION ILLUSTRATION

1		2		3	4			5	
BR	B	W/G	P	R/W	R/L	Y	V	GR/B	R
371	204	373	198	365	371	192	190	369	186



1. Hold the **BR wire** using right hand and support the wire by left index finger then insert to connector slot 1 using right hand. Repeat the process on W/G, R/W, R/L and GR/B wires.
Note: Follow the insertion sequence based on the above illustration.

STEERING NAVIGATION (2 layer)



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. 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.

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.

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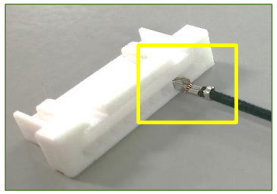
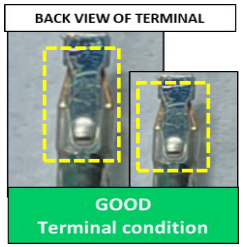
	WORK INSTRUCTION			Effectivity Date:	February 13, 2025	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: 177D / 75S137-0050	Customer: TRJ	Car Model: TOYOTA-COROLLA	Document No.:	WI-ENG-PDE-369	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	3	Page No.: 10 of 18

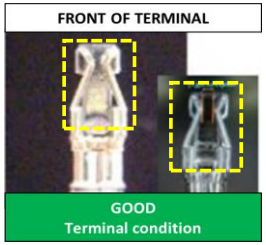
PARTS:	1. Assy parts	JIG:	1. Insertion jig 2. Steering Navigation

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	3 P1	Wire insertion to Connector PBVP-10V-S (W) (Continuation)			

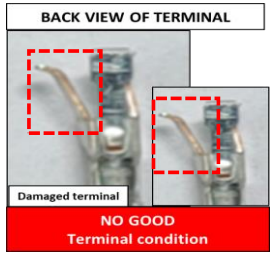
Proper alignment of terminal to connector

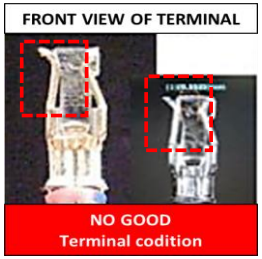




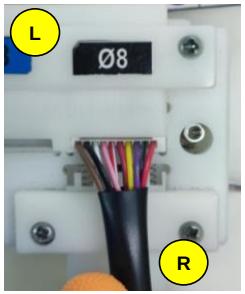


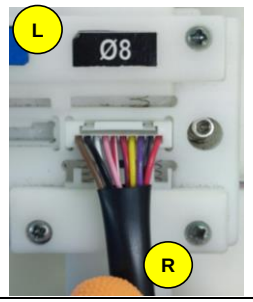
Improper alignment of terminal to connector

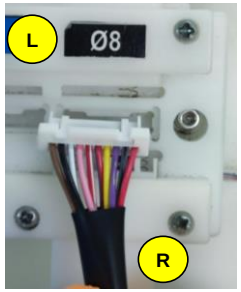




Note:
Make sure the terminal was in proper alignment before insert.
Avoid hitting the terminal into the connector during wire insertion, if encountered abnormality stop the process and call the attention of Immediate superior and Automatically disposed and replace the unit.







2. Press the upper lock by left hand and hold the assy part by right hand. Check the wire after insertion

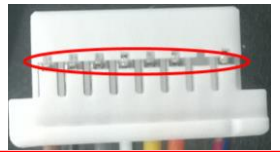
1. Use provided jig per model
2. No wrong usage of parts
3. One by one insertion
4. No wrong insertion
5. No deformed terminal
6. No stuck of terminal tip

Important reminders/Note/s:

1. 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.

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.
2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..
3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.



Terminal tip must be visible

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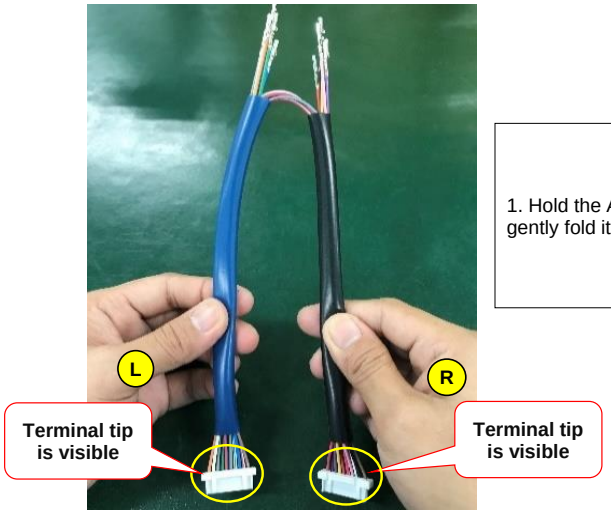
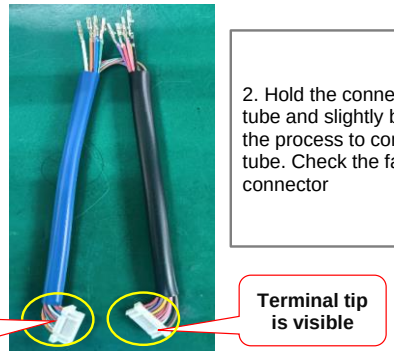
PARTS:	1. Assy parts			JIG:	n/a
NO.	**PROCESS NAME**		**3 WORK PROCEDURE/ ILLUSTRATION**	**TOOLS/PPE**	**QUALITY POINTERS**
9	P1	Wire folding 1	 1. Hold the Assy parts using both hands and gently fold it.  2. Hold the connector with Blue VM tube and slightly bend the wire. Reapet the process to connector with Black VM tube. Check the facing of both connector	n/a	1. No wrong orientation of connector 2. No deformed terminal 3. No wrong terminal facing 4. No damage lance 5. No wrong folding of position

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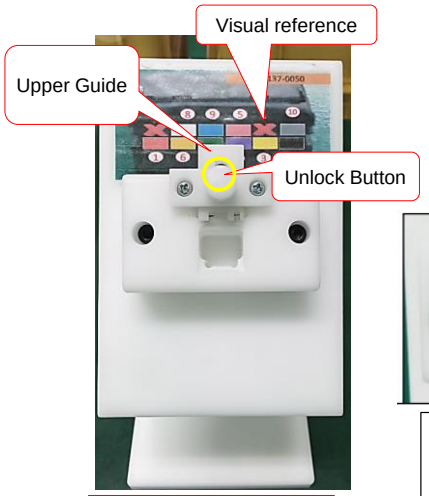
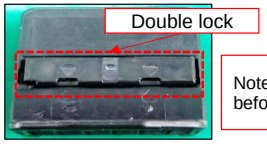
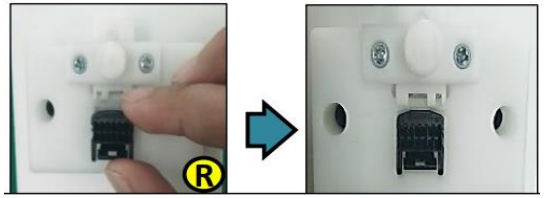
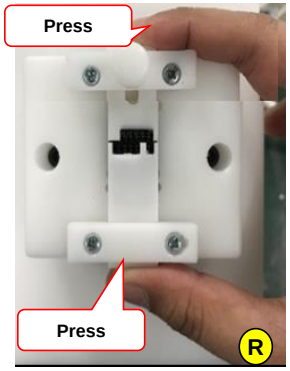
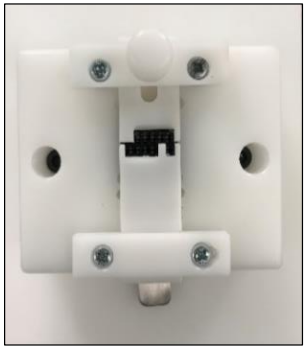
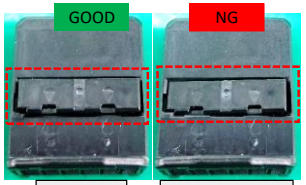
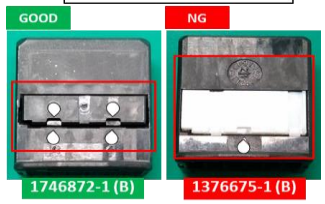
	WORK INSTRUCTION			Effectivity Date:	February 13, 2025		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: 177D / 75S137-0050	Customer: TRJ	Car Model: TOYOTA-COROLLA	Document No.:	WI-ENG-PDE-369		
	Purpose: ☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	3	Page No.:	12 of 18

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)	 INSERTION JIG  CONNECTOR Note: Check the connector before insertion.  1. Get the connector 1746872-1 (B) using right hand then insert to insertion jig. *Note: Follow the connector orientation*   2. Press the upper and lower guide lock using right thumb and index finger. (Same timing) You will notice the holes that needs to be inserted 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 ***Important reminders/Note/s:*** *1. Check the connector before insertion.* *2. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked.* **CONNECTOR LOCK APPEARANCE CHECK**  UNLOCK HALF-LOCKED CONNECTOR ILLUSTRATION 

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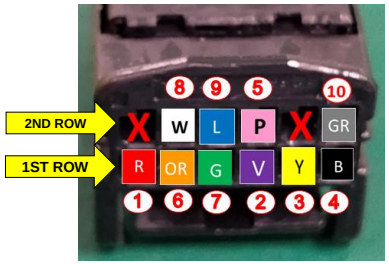
PARTS:	1. Assy parts	JIG:	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
11	P1	Wire insertion to Connector 1746872-1 (B)		n/a	

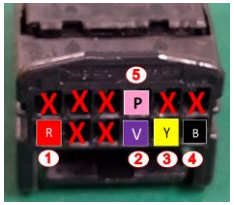
INSERTION SEQUENCE FROM LEFT TO RIGHT



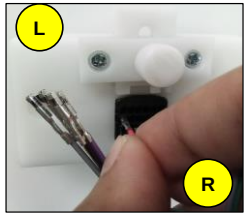
WIRE INSERTION ILLUSTRATION

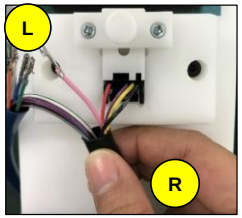
	8	9	5		10
X	W	L	P	X	GR
	202	192	198		196
1	6	7	2	3	4
R	OR	G	V	Y	B
186	206	200	190	192	204

BLACK VM TUBE (SUNPRENE)



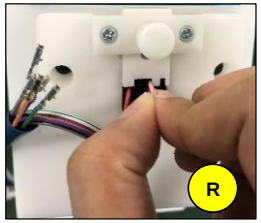
FIRST ROW (LEFT TO RIGHT)





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

SECOND ROW



2. Hold the pink wire and insert to terminal slot 10.
Note: Follow the insertion sequence based on the illustration stated above.

QUALITY POINTERS

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. 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.

Document reference/s:

1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.
2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.
3. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.

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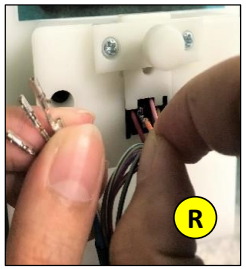
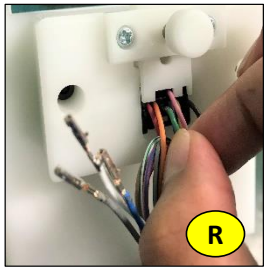
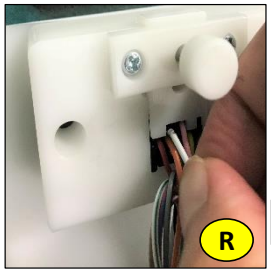
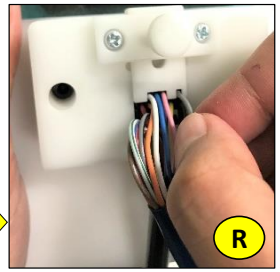
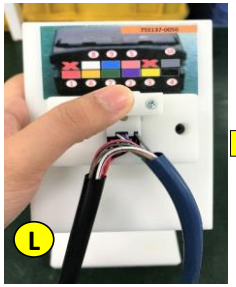
PARTS:	1. Assy parts	JIG:	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
11	P1	Wire insertion to Connector 1746872-1 (B) (Continutaion)	**BLUE VM TUBE (SUNPRENE)**  3. Insert the wires from Blue VM tube (Sunprene). Hold the OR wire and using right hand and support the wire by index findex then insert to terminal slot 6 using right hand. Repeat the process for G wire. *Note: Follow the insertion sequence based on the above illustration.*    4. Hold the W wire and insert to terminal slot 8, repeat the process for L-GR wires. *Note: Follow the insertion sequence based on the above illustration.*  5. Press the upper button using left hand and remove the assy parts using right hands.	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. 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.*** ***Document reference/s:*** ***1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.*** ***2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.*** ***3. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.***

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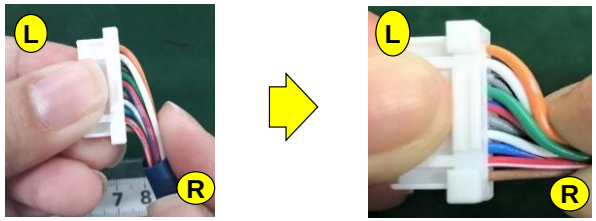
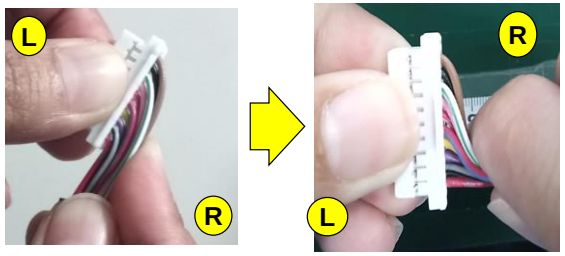
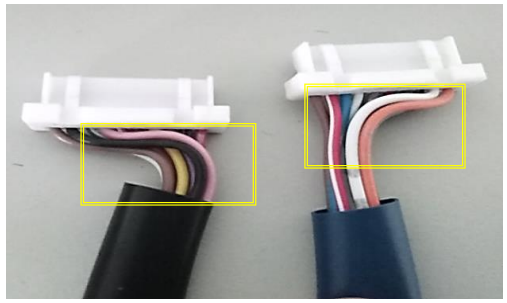
PARTS:	1. Assy parts	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
12	P1	Wire folding 2	**BLUE VM TUBE (SUNPRENE)**  1. Hold the connector PBVP-10V-S (W) using left hand and slightly fold the wires from Blue VM tube (Sunprene) *(as shown in illustration above)* using right hand. **BLACK VM TUBE (SUNPRENE)**  2.Repeat the process for connector of Black sunprene tube.  3. After wire folding check the wire arrangement and facing.	n/a	1. No wrong orientation of connector 2. No wrong use of connector 3. No wrong terminal facing

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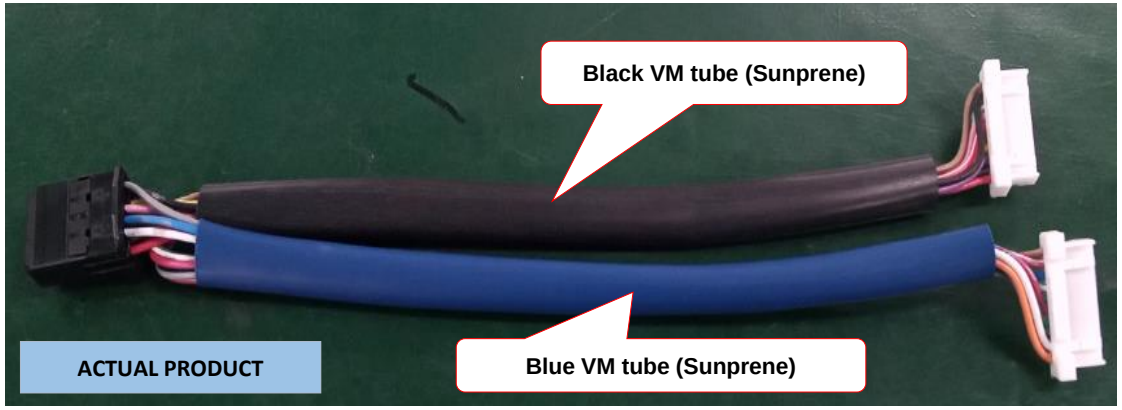
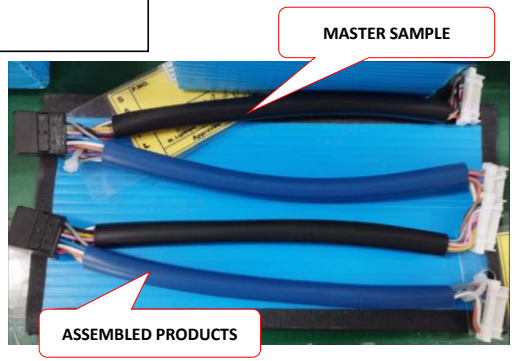
PARTS:	1. Assy parts 2. Master sample	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
13	P1	Visual/By Two's Inspection	1. Check the connector lock. Locking of connector is included to 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 no deformed terminal.  4. Check the orientation of harness. 5. Compare to **Master sample** by tapping.  		***Document reference/s:*** *1. Refer to **WI-QAD-QAC-252** Steering Electrical Test* **MASTER SAMPLE** 1. No skip checking during inspection

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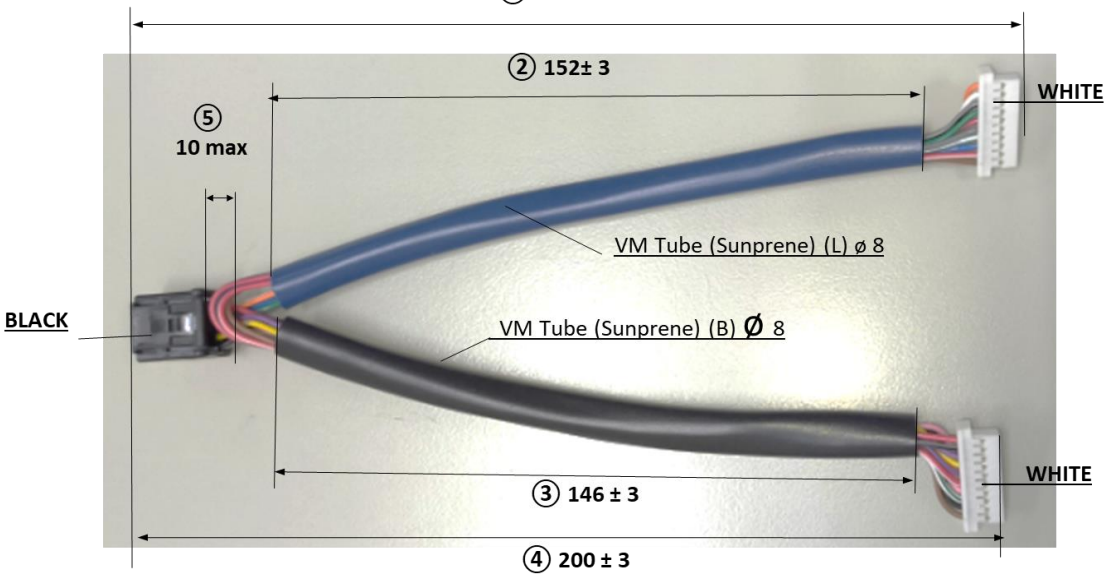
PARTS:	1. Assy parts	JIG:	n/a

NO.	PROCESS NAME		3 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
14	P1	Measurement	 NOTE: *Unit of dimension is in millimeter (mm)	MEASURING TAPE 	1. No wrong dimension. ***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*

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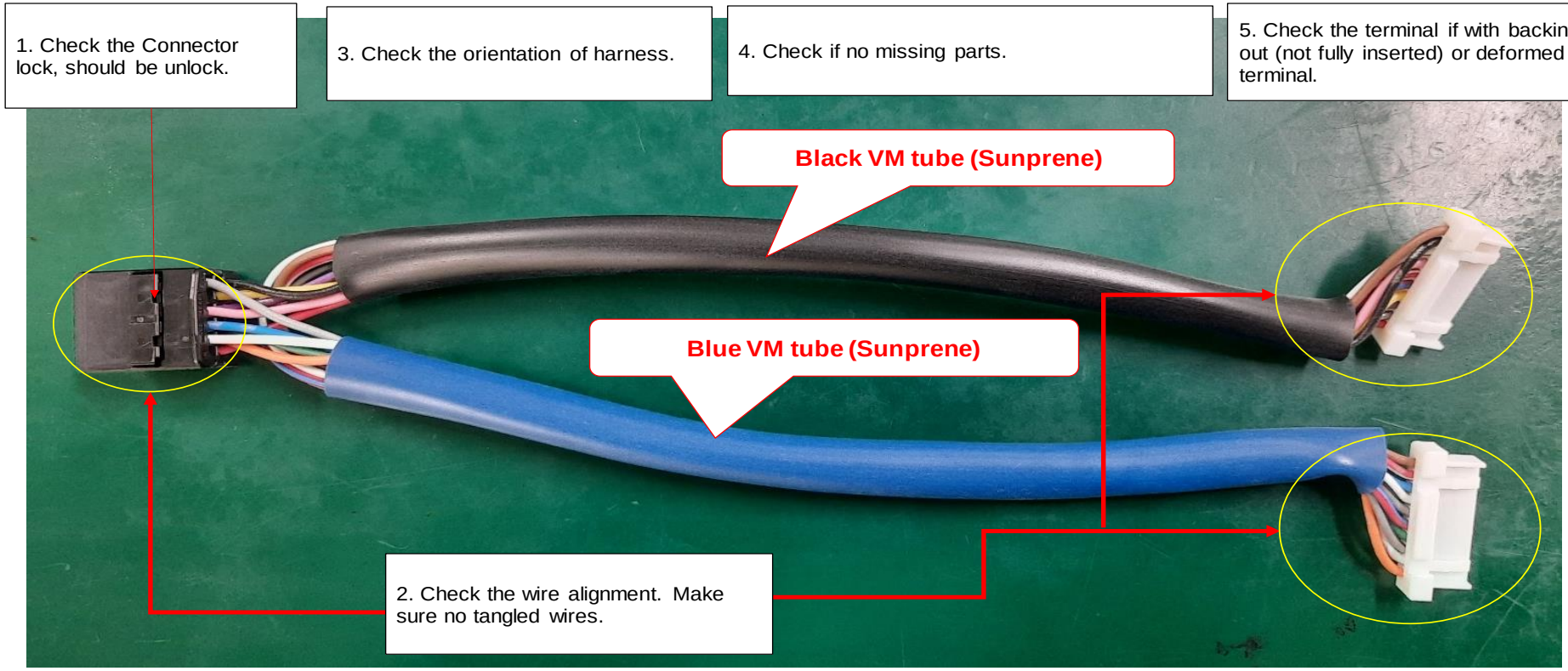
PARTS:	1. Assy parts	JIG:	n/a

3 VISUAL INSPECTION/ QUALITY CHECKPOINTS

STEERING 75S137-0050



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