



WORK INSTRUCTION

Process Name/Title:

ASSEMBLY PROCESS

Effectivity Date:

April 29, 2025

Model code/Part number:

412D / 628128-0000B

Customer: TRJ

Car Model:

LEXUS ES

Validity Date:

n/a

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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PARTS:

1. Connector PARP-03V-E (L); Connector PARP-03V (W); AVSS 0.3 W wire L=314±2mm; AVSS 0.3 P-B wires L=268±2mm; N6GR VM tube (Sunprene) Ø4.5, L=184±3mm; Black VM tube (Sunprene) Ø4, L=78±3mm; Retainer (PMS-03V-S (W); AVSS 0.3 OR wire L=162±2mm; Connector 4A1330-0000 (W); Black VM tube (Sunprene) Ø6, L=47±3mm

JIG:

1. Insertion jig
2. Navigation

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

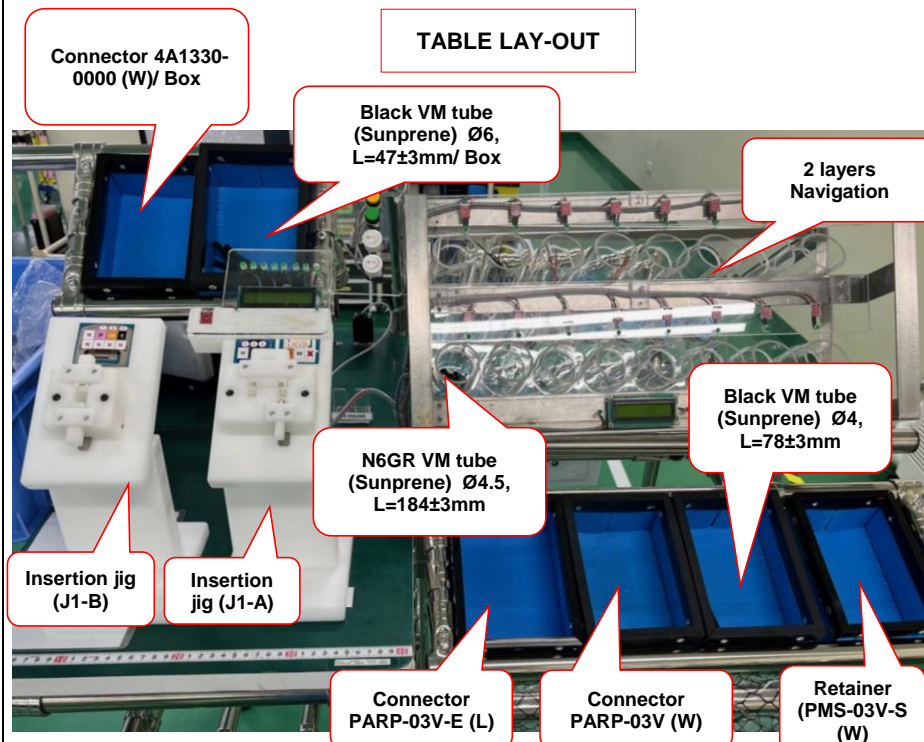
TOOLS/PPE

QUALITY POINTERS

1

P1

Table lay-out

**Safety Instruction**

Be sure to wear prescribed 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.

1. No missing parts/tools
2. No excess parts/tools

Important reminders/Note/s:

1. Please hold the wire near terminal.
 2. Make sure wires are properly inserted.
- Conduct Pull-Push-Pull-Push after insertion.
Do not exert extra force.

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

Revision History

Prepared by

Reviewed by

Approved by

Noted by

04/29/25 2 Inclusion of terminal "Good and No Good" illustration on page 4,6 and 9.

A.Hernandez

J.Loterte

C. Villanueva

A.Arañes

04/21/25 1 Change document purpose from pre-launch to mass pro.

A.Hernandez

J.Loterte

C. Villanueva

A.Arañes

04/11/25 0 Initial issue.

A.Hernandez

n/a

C. Villanueva

A.Arañes

Eff. Date

Rev. No

Details of Change

Revised

Checked

Reviewed

Approved

Est. Date:

April 11, 2025

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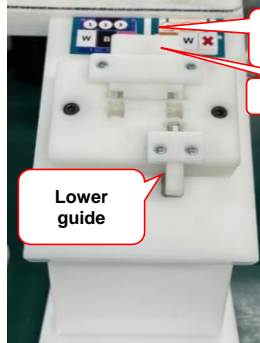
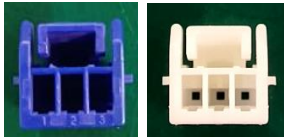
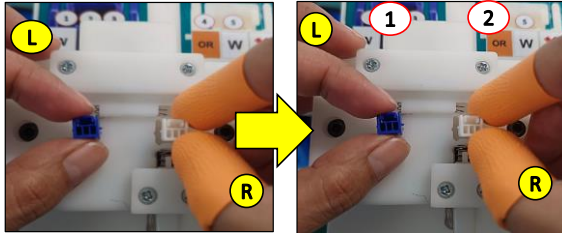
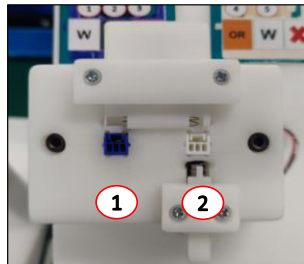
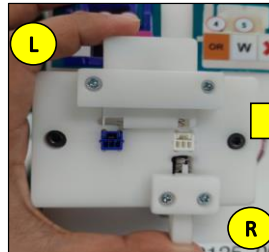
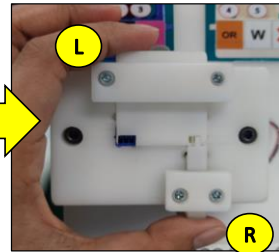

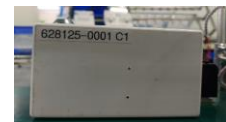
MASSPRO

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PARTS:		1. Connector PARP-03V-E (L) 2. Connector PARP-03V (W)		JIG:	1. Insertion jig 2. Navigation
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	P1	<div><div>INSERTION JIG</div><div></div><div></div><div>CONNECTOR ORIENTATION</div><div></div><div>1. Get 1pc. of connector PARP-03V-E (L) using left hand and 1pc. of Connector PARP-03V (W) then insert to insertion jig using both hands. <i>Note: Follow the connector orientation</i></div><div></div><div></div><div></div><div>3. Press the upper and lower guide using left hand in same timing. Holes that need to be insert are only open.</div></div> <div><div>STEERING NAVIGATION (2 layers)</div><div></div><div>CONTROLLER</div><div></div></div>		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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PARTS:

1. AVSS 0.3 W wire L=314±2mm
2. AVSS 0.3 P-B wires L=268±2mm

JIG:

1. Insertion jig
2. Navigation

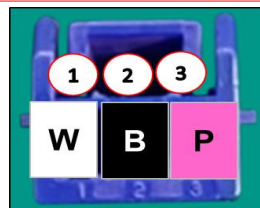
NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

INSERTION SEQUENCE FROM LEFT
TO RIGHTTERMINAL
FACING

WIRE INSERTION ILLUSTRATION

1	2	3
W	B	P
314	268	268

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
6. No stuck of terminal tip.

Important reminders/Note/s:

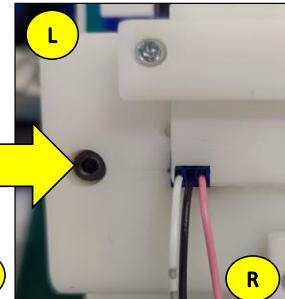
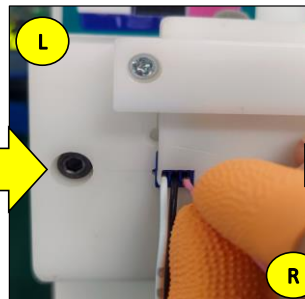
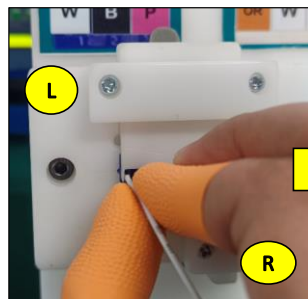
1. Please hold the wire near terminal.
2. Make sure wires are properly inserted.
- Conduct Pull-Push-Pull-Push after insertion.
- Do not exert extra force.
3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.
4. Insertion of wires must be from left to right.

Document references:

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

3

P1

Wire insertion to
Connector PARP-03V (L)

1. Get the **W** wire using **left hand** and transfer to the right hand then insert to connector Conduct **2x** pull push after wire insertion. Repeat the process to **B** and **Pink** wire.
Note: Follow the insertion sequence based on the illustration.

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PARTS:

1. AVSS 0.3 W wire L=314±2mm
2. AVSS 0.3 P-B wires L=268±2mm

JIG:

1. Insertion jig

NO.

PROCESS NAME

2

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

3

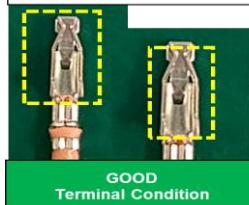
P1

Wire insertion to
Connector PARP-03V-E
(L)(Continuation)

Improper alignment of terminal to connector



BACK VIEW ON TERMINAL



FRONT VIEW ON TERMINAL



BACK VIEW ON TERMINAL



FRONT VIEW ON TERMINAL



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.*

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

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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PARTS:		1. Assy parts 2. Dark Brown VM tube (Sunprene) Ø4.5, L=184±3mm 3. Connector PARP-03V (W)		JIG:	1. Insertion jig 2. Navigation									
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS									
4	Wire insertion to N6GR VM tube (Sunprene) Ø4.5, L=184±3mm	<div><div></div><div></div><div>1. Hold the wires using left hand, get the N6GR VM tube (Sunprene) Ø4.5, L=184±3mm using right hand then insert the wires using left hands</div></div>		n/a	1. No wrong usage of parts. 2. No deformed terminal. 3. No tangled wires.									
5	P1 Wire insertion to Connector PARP-03V (W)	<div><div><div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div><div></div></div><div><div>WIRE INSERTION ILLUSTRATION</div><table><tr><td>1</td><td></td><td></td></tr><tr><td>OR</td><td>X</td><td>X</td></tr><tr><td>162</td><td></td><td></td></tr></table><div>1. Get the OR wire using right hand then insert to connector. Conduct 2x pull push after wire insertion. Note: Follow the insertion sequence based on the illustration.</div></div><div><div>TERMINAL FACING</div></div></div>		1			OR	X	X	162			<div>STEERING NAVIGATION (2 layers) </div> <div>CONTROLLER </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. Important reminders/Note/s: 1. Please hold the wire near terminal. 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. 4. Insertion of wires must be from left to right. Document references: 1. Refer to WI-PRO-CNC-017 2. Refer to WI-ENG-PDE-044 for the Steering Navigation Controller procedure. 3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div>
1														
OR	X	X												
162														

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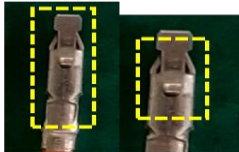
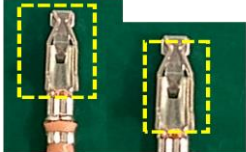
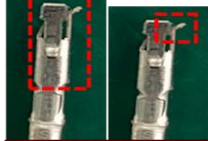
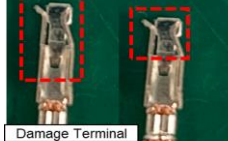
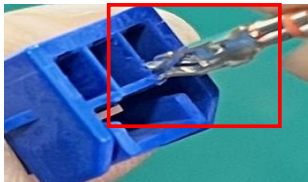
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PARTS:		1. AVSS 0.3 OR wire L=162±2mm		JIG:	1. Insertion jig
NO.	PROCESS NAME	2 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
5	P1 Wire insertion to Connector PARP-03V (W) (Continuation)	<div><div></div><div><div>BACK VIEW ON TERMINAL</div><div>FRONT VIEW ON TERMINAL</div><div></div><div>GOOD Terminal Condition</div><div>GOOD Terminal Condition</div></div><div><div>BACK VIEW ON TERMINAL</div><div>FRONT VIEW ON TERMINAL</div><div></div><div>Damage Terminal</div><div>NO GOOD Terminal Condition</div><div>NO GOOD Terminal Condition</div></div><div>Note: <i>*Make sure the terminal was in proper alignment before insert.</i> <i>*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.</i></div></div> <div><div>Improper alignment of terminal to connector</div><div></div></div>		<div>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong insertion 4. No deformed terminal 5. No stuck of terminal tip 6. One by one insertion</div> <div>Important reminders/Note/s: <i>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</i> <i>2. Please hold the wires near terminal during insertion.</i> <i>3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</i> <i>4. Insertion of wires must be from left to right.</i></div> <div>Document reference/s: <i>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</i> <i>2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..</i> <i>3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</i> <i>4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</i></div>	

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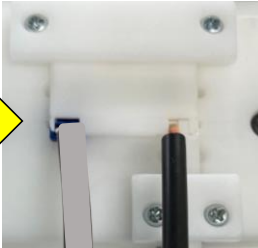
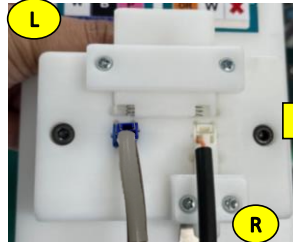
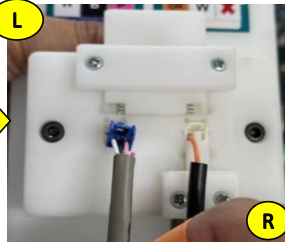
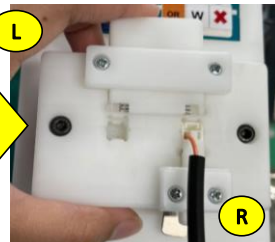
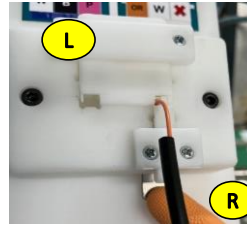
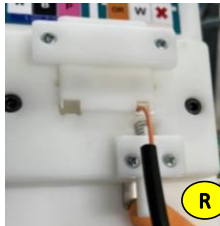
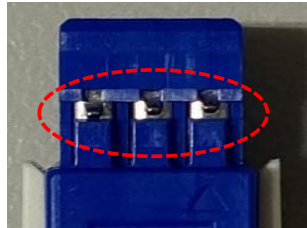
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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) Ø4, L=78±3mm		JIG:	1. Insertion jig 2. Navigation
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6	P1 Wire insertion to Black VM tube (Sunprene) Ø4, L=78±3mm	<div><div></div><div></div><div><div><p>1. Hold the wires using left hand, get the Black VM tube (Sunprene) Ø4, L=78±3mm using right hand then insert the wires using left hands</p></div></div></div> <div><div></div><div></div><div></div><div><p>2. Press the upper button using both hands. Remove the 1st Connector with inserted wires using right hand. After removal of harness, Press the Upper guide using left hand. Note: Second connector with inserted wire and Black VM tube (Sunprene) should stay on the jig.</p></div></div> <div><div></div><div></div><div><p>3. Press the lower button using right hand. Check the terminal tip condition, must be visible.</p></div></div>		n/a	<div>1. No wrong orientation of connector 2. No wrong use of parts 3. No deformed terminal 4. No wrong wire facing</div> <div></div> <div>Terminal tip must be visible.</div>

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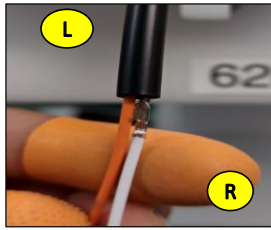
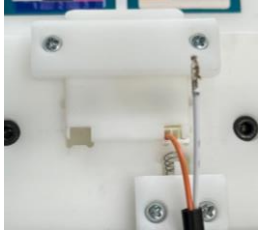
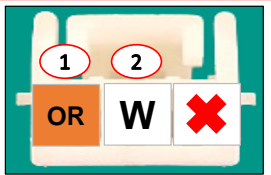

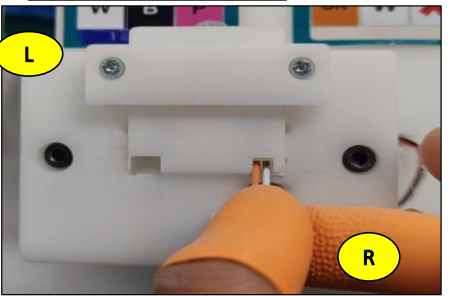
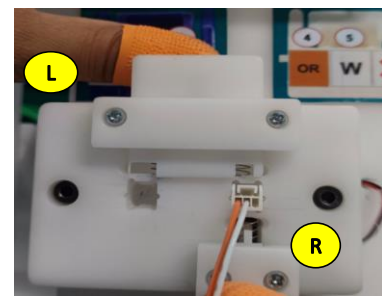

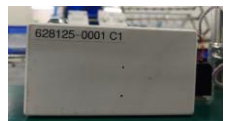

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PARTS:		1. Assy parts		JIG:	1. Insertion jig 2. Navigation
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	Wire insertion to Assy parts	  <p>1. Hold the Black VM tube (Sunprene) using left hand and insert the wire of assy parts using right hand.</p>		STEERING NAVIGATION (2 layers)	1. No wrong usage of parts. 2. No deformed terminal. 3. No tangled wires.
8	P1 Wire insertion to Connector PARP-03V (W)	<p>INSERTION SEQUENCE FROM LEFT TO RIGHT</p>  <p>TERMINAL FACING</p>  <p>WIRE INSERTION ILLUSTRATION</p>   <p>1. Get the W wire using right hand then insert to connector. Conduct 2x pull-pushl after wire insertion. Note: Follow the insertion sequence based on the illustration.</p> <p>2. Press the upper button using left hand. Remove the 2nd connector with inserted wires using right hand. Check the terminal tip condition, must be visible.</p>		 <p>CONTROLLER</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. Important reminders/Note/s: 1. Please hold the wire near terminal. 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. 4. Insertion of wires must be from left to right. Document references: 1. Refer to WI-PRO-CNC-017 2. Refer to WI-ENG-PDE-044 for the Steering Navigation Controller procedure. 3. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 

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Validity Date:

n/a

Model code/Part number:

412D / 628128-0000B

Customer: TRJ

Car Model:

LEXUS ES

Document No.:

WI-ENG-PDE-1242

Purpose:



PROTOTYPE



PRE-LAUNCH





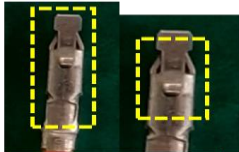



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PARTS:	1. AVSS 0.3 W wire L=314±2mm		JIG:	1. Insertion jig
NO.	PROCESS NAME	<div>2</div> WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P1 Wire insertion to Connector PARP-03V (W) (Continuation)	<div><div></div><div><div>BACK VIEW ON TERMINAL</div><div></div><div>GOOD Terminal Condition</div></div><div><div>FRONT VIEW ON TERMINAL</div><div></div><div>GOOD Terminal Condition</div></div><div><div>BACK VIEW ON TERMINAL</div><div></div><div>NO GOOD Terminal Condition</div></div><div><div>FRONT VIEW ON TERMINAL</div><div></div><div>NO GOOD Terminal Condition</div></div><div><div>Note:</div><div><div>*Make sure the terminal was in proper alignment before insert.</div><div>*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.</div></div></div></div>	<div>Improper alignment of terminal to connector</div> <div></div> <div>Important reminders/Note/s:</div> <div><div>1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div><div>2. Please hold the wires near terminal during insertion.</div><div>3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</div><div>4. Insertion of wires must be from left to right.</div></div> <div>Document reference/s:</div> <div><div>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance.</div><div>2. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure..</div><div>3. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</div><div>4. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</div></div>	

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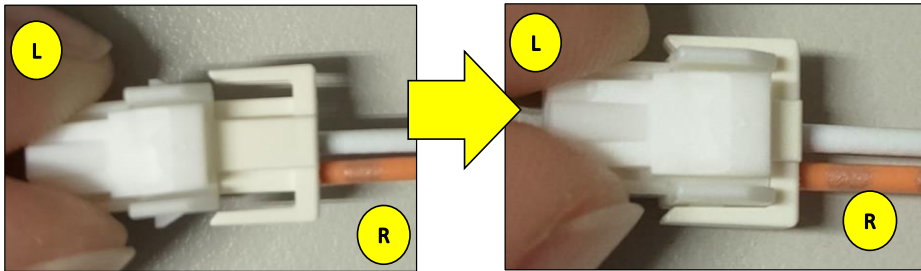
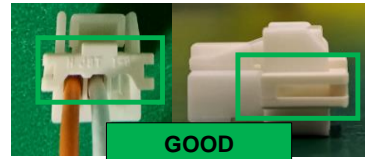

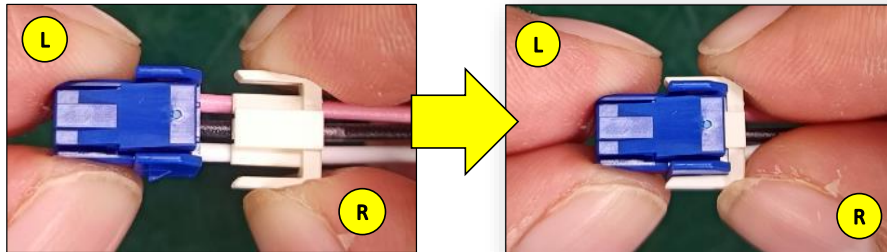
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PARTS:		1. Retainer (PMS-03V-S (W)) [2pcs] 2. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1	<div></div> <div>1. Hold the Connector using left hand, get the Retainer PMS-03V-S (W) then insert the clamp using right hand. <i>Note: Sound will be heard if properly inserted.</i></div>		n/a	<div>1. Retainer must be fully inserted 2. No missing retainers 3. No Unlock/halflocked</div> <div>RETAINER ORIENTATION</div> <div><div>GOOD</div><div><div>NO GOOD</div></div></div>
		<div></div> <div>2. Hold the Connector using left hand, get the Retainer PMS-03V-S (W) then insert the clamp using right hand. <i>Note: Sound will be heard if properly inserted.</i> <i>(After insertion, set aside the assy parts)</i></div>			

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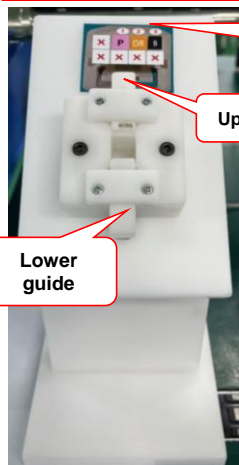
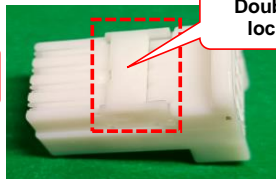
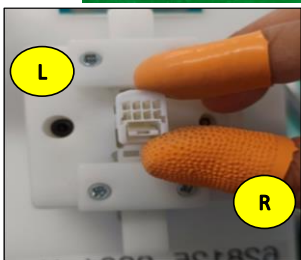
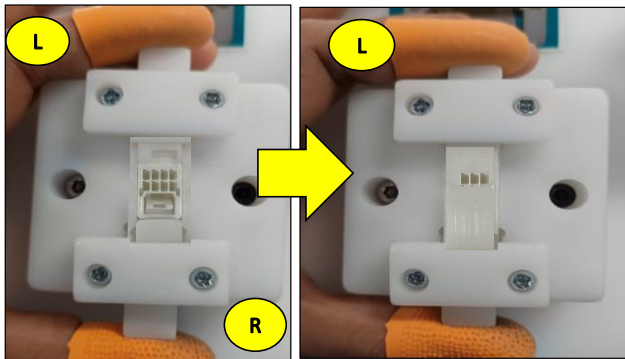
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PARTS:	1. Connector 4A1330-0000 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	P1 Connector setting to insertion jig 4A1330-0000 (W)	<div><div>INSERTION JIG</div><div></div><div></div><div>CONNECTOR ORIENTATION</div><div><div>1. Get the Connector 4A1330-0000 (W) and insert to insertion jig using right hand. Note: Follow the connector orientation.</div><div></div><div><div></div><div>2. Press the upper and lower guide (same timing) using left hand. Holes to be insert are only open.</div></div></div></div> <div>n/a</div> <div><p>1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector.</p><p>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.</p></div>		

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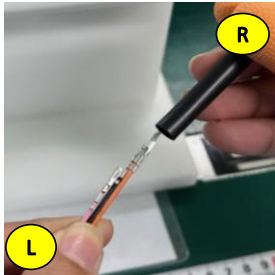


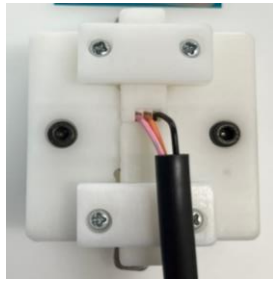
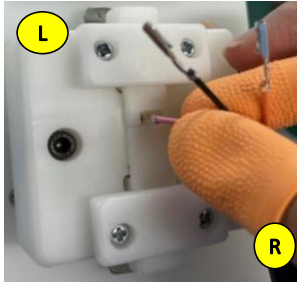
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PARTS:		1. Assy parts 2. Black VM tube (Sunprene) Ø6, L=47±3mm		JIG:	1. Insertion jig																
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS																
11	Wire insertion Black VM tube (Sunprene) Ø6, L=47±3mm	<div></div> <div>1. Hold the wires of assy parts using right hand, get the Black VM tube (Sunprene) Ø6, L=47±3mm using left hand then insert the wires (Assy parts) using both hands.</div>		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.																
12	P1 Wire insertion to Connector 4A1330-0000 (W)	<div><div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div></div> <div><div>WIRE INSERTION ILLUSTRATION</div><table><tr><td></td><td>1</td><td>2</td><td>3</td></tr><tr><td>X</td><td>P</td><td>OR</td><td>B</td></tr><tr><td></td><td>268</td><td>162</td><td>268</td></tr><tr><td>X</td><td>X</td><td>X</td><td>X</td></tr></table></div> <div><div>TERMINAL FACING</div></div> <div></div> <div>1. Insert the wires from Black VM tube (Sunprene). Hold the R wire and insert to terminal slot no.1 using right hand. Repeat the process for OR and B wires.</div>			1	2	3	X	P	OR	B		268	162	268	X	X	X	X	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 <u>Pull-Push-Pull-Push</u> 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 GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.
	1	2	3																		
X	P	OR	B																		
	268	162	268																		
X	X	X	X																		

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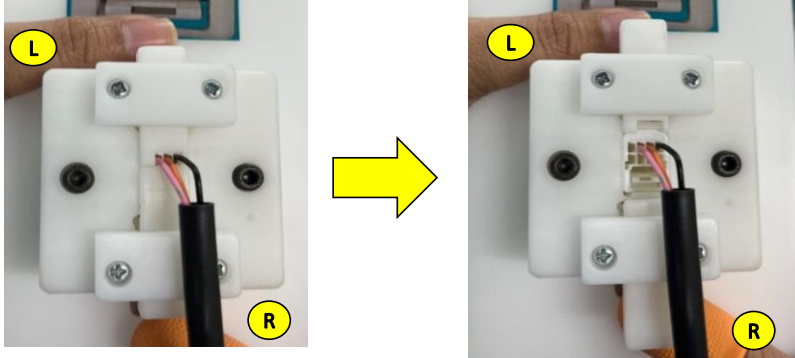
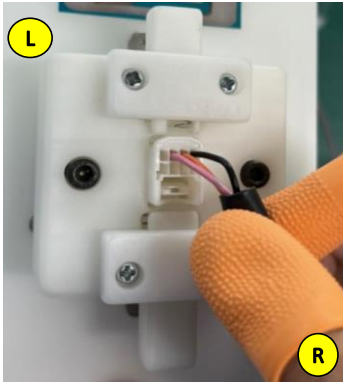
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PARTS:	1. Assy parts			JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
13	P1 Wire insertion to Connector 4A1330-0000 (W) (Continuation)	<div></div> <div>2. Press the upper and lower button (same timing) using both hands.</div> <div></div> <div>3. Remove the assy parts using right hand and check if the connector is totally locked.</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. Please hold the wire near terminal. 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. 4. Insertion of wires must be from left to right.</div> <div>Document reference/s: 1. Refer to GL-PRO-ASY-029 for Pull-Push procedure. 2. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.</div>

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PARTS:		1. Assembled parts 2. Master sample		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
14	P1	<div>1. Check the connector lock. Locking of connector is included in Steering Electrical test.</div> <div>2. Check the wire alignment. Must be no tangled wires.</div> <div>3. Check the Terminal if with Backing out (Not fully inserted) or no deformed terminal.</div>  <div>4. Check the orientation of harness.</div> <div>5. Compare to Master sample by tapping</div> 			<div>1. No skip process during inspection.</div> <div>Document reference/s: 1. Refer to WI-QAD-QAC-252 Steering Electrical Test</div> <div>MASTER SAMPLE</div> 

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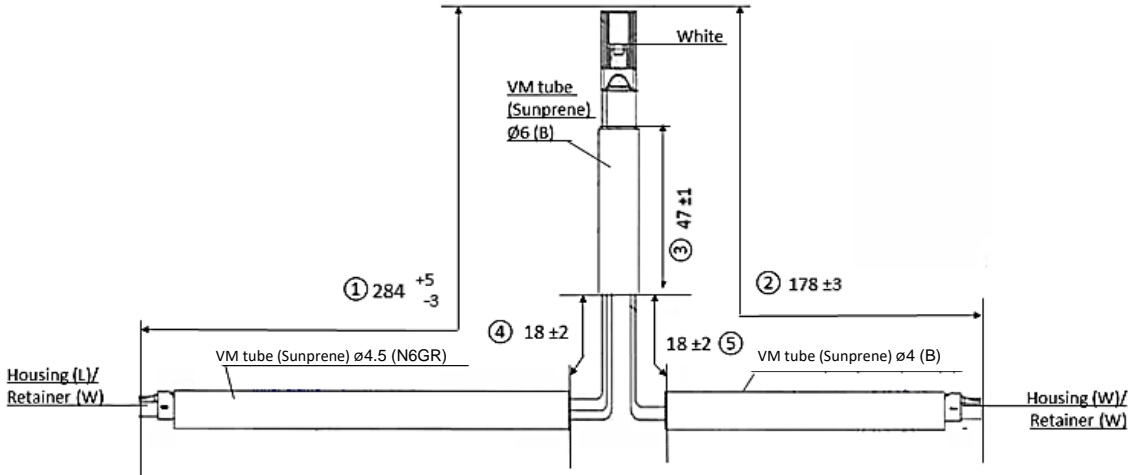
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PARTS:	1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
12	P1	Measurement	<div>MEASURING TAPE</div>  	<p>Important reminders and note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting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

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PARTS:

1. Assy parts

JIG:

n/a

VISUAL INSPECTION/ QUALITY CHECKPOINTS

PADDLE SWITCH

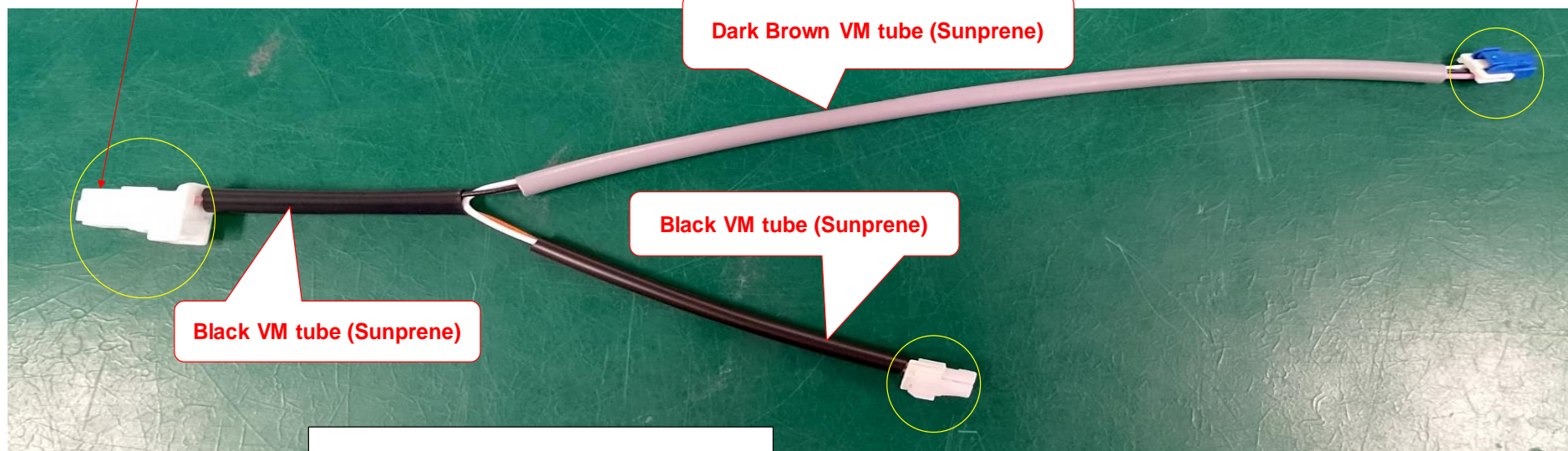
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1. Check the Connector lock, should be unlock.

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. Check if no missing parts. Check the presence and position of retainer (2 connectors).

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