

	<b>WORK INSTRUCTION</b> <b>TAPING ASSEMBLY PROCESS</b>				Effectivity Date:		September 22, 2022		
	Process Name/Title:				Validity Date:		n/a		
	Model Code/Part Number: <b>220B / 75L847-0022</b>			Customer: <b>TRJ</b>		Document No.:		WI-ENG-PDE-119	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:		5	Page No.:	1 of 14

<b>PARTS:</b>	1. Connector PBVP-10V-S (W)			JIG:	1. Insertion jig		
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NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1  Connector setting to insertion jig PBVP-10V-S (W)	<div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">   <small>Visual reference</small> </div> <div style="text-align: center;">   <b>CONNECTOR ORIENTATION</b> </div> </div> <div style="text-align: center; margin-top: 10px;">   <b>INSERTION JIG</b> </div> <div style="margin-top: 10px;"> <p>1. Get the connector <b>PBVP-10V-S (W)</b> using right hand and set to insertion jig.  <i>Note: Follow the connector orientation.</i></p> </div> <div style="display: flex; justify-content: space-around; margin-top: 10px;"> <div style="text-align: center;">   <b>BEFORE PRESSING</b> </div> <div style="text-align: center;">   <b>AFTER PRESSING</b> </div> </div> <div style="margin-top: 10px;"> <p>2. Press the guide lock button using left index finger.</p> </div>	<div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 10px;"> <b>Housekeeping</b>            1. Maintain and always practice 5's.            2. Personal things on the workplace is prohibited. Keep it in your locker.         </div> <div style="border: 1px dashed red; padding: 5px;"> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>	1. Use the provided jig per model 2. No wrong orientation of connector 3. No wrong use of connector 4. No damaged connector

Revision History						Prepared by		Reviewed by		Approved by		Noted by	
09/22/22	5	Improve process illustration. Merged P1 and P2 due to the process improvement. Additional quality pointers in wire insertion refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance. Include WI-ENG-PDE-431 for Steering Electrical Test after assembly. Improve the wire folding process.	D.Castillo	J. Loterte	C. Villanueva	A. Arañes	 D. Castillo	 J. Loterte	 C. Villanueva	 A. Arañes			
06/05/21	4	Removal of validity date. Apply some improvements in quality pointers.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes							
12/04/20	3	Change process sequence from insertion of Black sunprene tube Ø8 L=135±3mm into wires without OR wire to insertion of Black sunprene tube Ø8 L=135±3mm into wires with OR wire (inserted with Black Sunprene tube Ø3 L=64±3mm)	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes							
Eff. Date	Rev. No	Details of Change				Revised	Checked	Approved	Noted	Est. Date:	March 02, 2018		

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## WORK INSTRUCTION

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Model Code/Part Number: **220B / 75L847-0022**

Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

Effectivity Date:

**September 22, 2022**

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### PARTS:

1. AVSS 0.3 LG L=207±2mm; W L=205±2mm; GR L=203±2mm; GR/B L=363±2mm; G L=199±2mm; R/L L=365±2mm; W/G L=369±2mm; L L=193±2mm; R/W L=361±2mm; BR L=367±2mm

**JIG**

1. Insertion jig

**NO.**

**PROCESS NAME**

**WORK PROCEDURE/ ILLUSTRATION**

**TOOLS/PPE**

**QUALITY POINTERS**

2

P1

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

**INSERTION SEQUENCE FROM LEFT TO RIGHT**

1	2	3	4	5	6	7	8	9	10
LG	W	GR	GR/B	G	R/L	W/G	L	R/W	BR
207	205	203	363	199	365	369	193	361	367

**WIRE FACING**

**STEERING NAVIGATION**

**CONTROLLER**

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

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

#### Important reminders/Note/s:

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

#### Document References:

1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
2. Refer to GL-PRO-ASY-028 for Pull-Push procedure.
3. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

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☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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**3 of 14****PARTS:**

1. Assy parts
2. Brown Sunprene tube Ø8 L=153±3mm

**JIG**

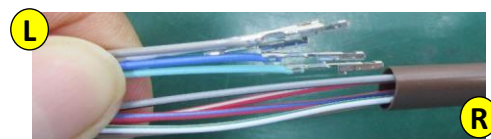
1. Insertion jig

**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****3****P1**

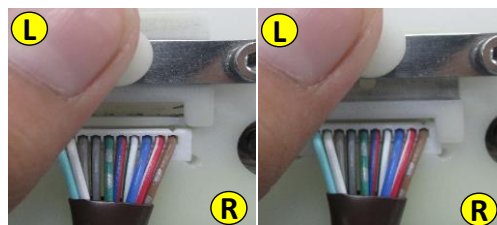
Wire insertion to  
Brown Sunprene tube  
Ø8 L=153±3mm



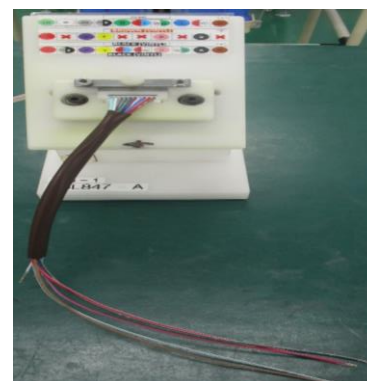
1. Hold the wires using left hand, get the **Brown Sunprene tube Ø8 L=153±3mm** using right hand then insert the long wires.



2. Continue to insert the short wires.

**BEFORE PRESSING****AFTER PRESSING**

3. Press the button using left thumb.



4. Gently pull out the harness from jig using right hand then check the terminal tip condition.

n/a

1. No wrong usage of parts
2. No deformed terminal
3. No tangled wires

**Terminal tip must be visible****Document References:**

1. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.

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☐ PRE-LAUNCH

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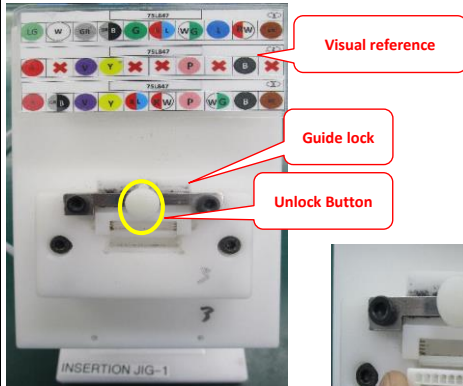
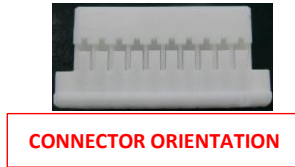


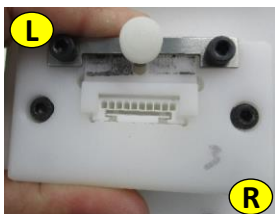
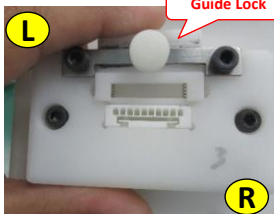
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PARTS:		1. Connector PBVP-10V-S (W)		JIG	1. Insertion jig	
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	P1	Connector setting to insertion jig PBVP-10V-S (W)	<div><div><div>Visual reference</div><div>Guide lock</div><div>Unlock Button</div></div><div><div>CONNECTOR ORIENTATION</div></div><div></div><div><div>1. Get the connector <b>PBVP-10V-S (W)</b> using right hand and set to insertion jig. <b>Note: Follow the connector orientation.</b></div></div><div><div></div><div><div>BEFORE PRESSING</div><div>AFTER PRESSING</div></div><div><div>2. Press the guide lock button using left index finger.</div></div></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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### PARTS:

1. AVSS 0.3 R L=184±2mm; V L=188±2mm; Y L=190±2mm; P L=196±2mm; B L=200±2mm

### JIG

1. Insertion jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE

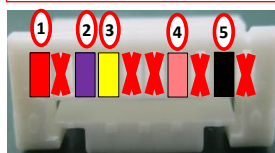
### QUALITY POINTERS

5

P1

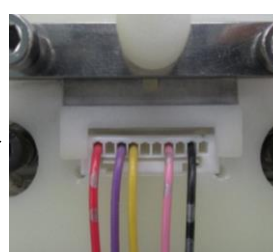
Wire insertion to  
connector  
PBVP-10V-S (W)

INSERTION SEQUENCE FROM  
LEFT TO RIGHT



WIRE FACING

1	2	3	4	5	6	7	8	9	10
R	X	V	Y	X	X	P	X	B	X
184		188	190			196		200	



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

STEERING  
NAVIGATION



CONTROLLER



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

#### Important reminders/Note/s:

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

#### Document References:

1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
2. Refer to GL-PRO-ASY-028 for Pull-Push procedure.
3. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

5

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Purpose:

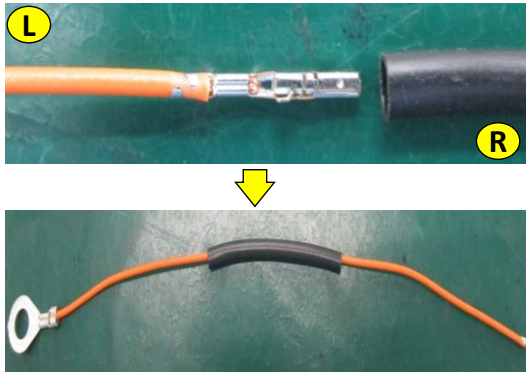
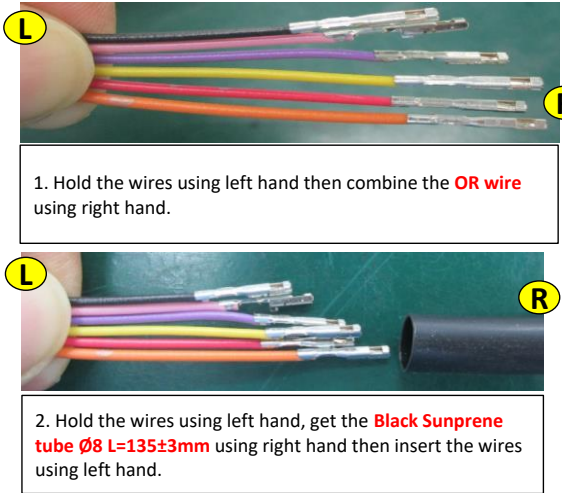

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts 2. Black Sunprene tube Ø3 L=64±3mm	4. AVSS0.5 OR L=247±2mm 3. Black Sunprene tube Ø8 L=135±3mm	JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
6		Wire insertion to Black Sunprene tube Ø3 L=64±3mm	 <p>1. Get the <b>OR wire</b> using left hand and the <b>Black sunprene tube Ø3 L=64±3mm</b> using right hand and insert <b>OR wire</b> using left hand.</p>	n/a	1. No wrong use of parts 2. No deformed terminal  <b>Document References:</b> 5 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance
7	P1	Wire insertion to Black Sunprene tube Ø8 L=135±3mm	 <p>1. Hold the wires using left hand then combine the <b>OR wire</b> using right hand.</p> <p>2. Hold the wires using left hand, get the <b>Black Sunprene tube Ø8 L=135±3mm</b> using right hand then insert the wires using left hand.</p> 	n/a	1. No wrong use of parts 2. No deformed terminal

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Purpose:


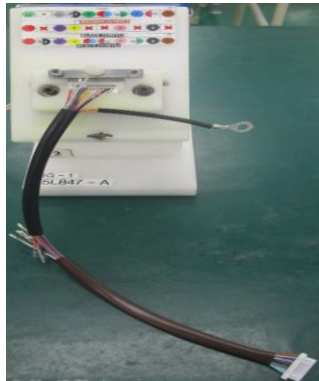
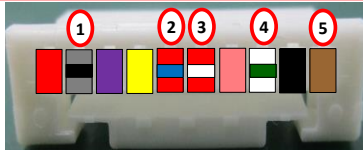


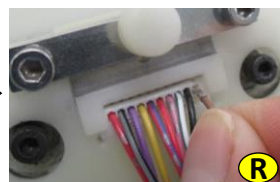



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PARTS:		1. Assy parts			JIG	1. Insertion jig																													
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS																													
8	P1	Wire insertion to assy parts	<div><div><div>L</div><div>R</div></div><div>1. Hold the Black sunprene tube using left hand and then insert the assy parts using right hand.</div></div> <div></div>		n/a	1. No wrong insertion 2. No deformed terminal																													
9		Wire insertion to connector PBVP-10V-S (W)	<div><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></div><div><div>WIRE FACING</div></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><td>9</td><td>10</td></tr><tr><td>R</td><td>GR/B</td><td>V</td><td>Y</td><td>R/L</td><td>R/W</td><td>P</td><td>W/G</td><td>B</td><td>BR</td></tr><tr><td>184</td><td>363</td><td>188</td><td>190</td><td>365</td><td>361</td><td>196</td><td>369</td><td>200</td><td>367</td></tr></table></div> <div><div></div><div>1. Hold the <b>GR/B</b> wire using right hand and insert to connector. Repeat the process for <b>R/L-R/W-W/G-BR</b> wires. <b>Note: Follow the insertion sequence based on the illustration.</b></div></div>		1	2	3	4	5	6	7	8	9	10	R	GR/B	V	Y	R/L	R/W	P	W/G	B	BR	184	363	188	190	365	361	196	369	200	367	<div><div>STEERING NAVIGATION</div></div> <div><div>CONTROLLER</div></div>
1	2	3	4	5	6	7	8	9	10																										
R	GR/B	V	Y	R/L	R/W	P	W/G	B	BR																										
184	363	188	190	365	361	196	369	200	367																										

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#### PARTS:

1. Assy parts

#### JIG

1. Insertion jig

#### NO.

#### PROCESS NAME

#### WORK PROCEDURE/ ILLUSTRATION

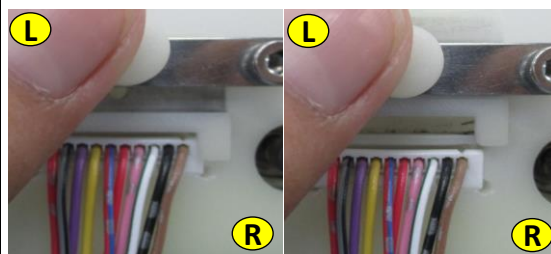
#### TOOLS/PPE

#### QUALITY POINTERS

9

P1

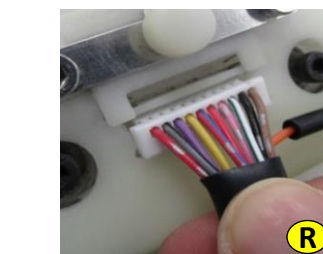
Wire insertion to connector PBVP-10V-S (W) (Continuation)



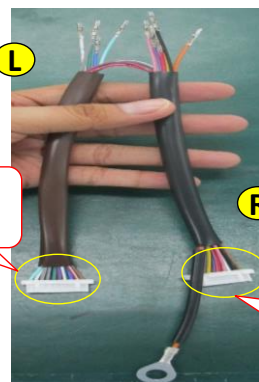
BEFORE PRESSING

AFTER PRESSING

2. Press the button using left thumb.



3. Gently pull out the harness from jig using right hand then check the terminal tip condition.



Terminal tip is not visible

4. Slowly fold the harness using both hands.

Terminal tip is not visible

n/a

#### Document References:

1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.
2. Refer to GL-PRO-ASY-028 for Pull-Push procedure.
3. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion.
4. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance

5

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



Terminal tip must be visible

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**PARTS:**

1. Connector 1746872-1 (B)

**JIG**

1. Insertion jig

**NO.**

**PROCESS NAME**

**WORK PROCEDURE/ ILLUSTRATION**

**TOOLS/PPE**

**QUALITY POINTERS**

5

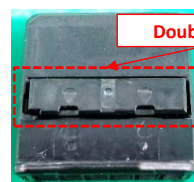
10

P1

Connector setting to  
insertion jig  
1746872-1 (B)

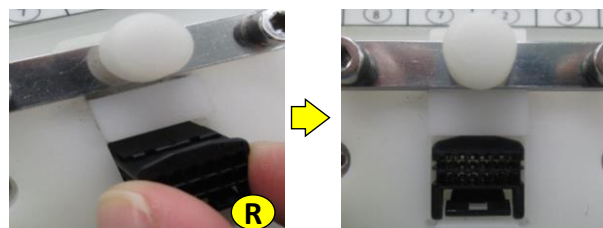


**INSERTION JIG**



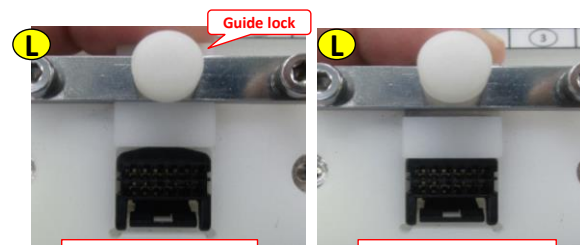
**CONNECTOR ORIENTATION**

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.**



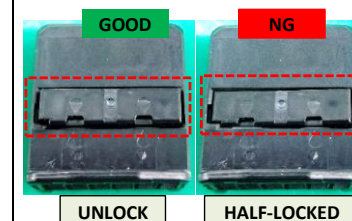
**BEFORE PRESSING**

**AFTER PRESSING**

2. Press the guide lock using left  
index finger.

n/a

**CONNECTOR LOCK APPEARANCE  
CHECK**



**CONNECTOR ILLUSTRATION**



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

**Important reminders/Note/s:**

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

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### PARTS:

1. Assy parts

### JIG

1. Insertion jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

11

P2

Wire insertion to  
connector  
1746872-1 (B)

**INSERTION SEQUENCE FROM LEFT TO RIGHT**

**Wire facing**

**BLACK SUNPRENE TUBE**

**FIRST ROW (LEFT TO RIGHT)**

**SECOND ROW (LEFT TO RIGHT)**

1. Hold the **R** wire using right hand and insert to terminal slot **1**. Repeat the process for **V-Y-B** wires.  
*Note: Follow the insertion sequence based on the illustration stated above.*

2. Hold the **P** wire using right hand and insert to terminal slot **10**. Repeat the process for **OR** wire.  
*Note: Follow the insertion sequence based on the illustration stated above.*

n/a

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

#### Important reminders/Note/s:

**1. Please hold the wire near terminal during insertion.**

**2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.**

**3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.**

#### Document References:

**1. Refer to GL-PRO-ASY-028 for Pull-Push procedure.**

**2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance**

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## WORK INSTRUCTION

### TAPING ASSEMBLY PROCESS

Process Name/Title:

Model Code/Part Number:

220B / 75L847-0022

Customer:

TRJ

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

September 22, 2022

Validity Date:

n/a

Document No.:

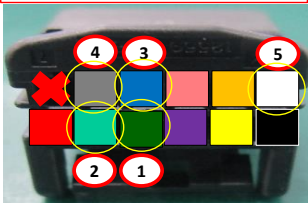
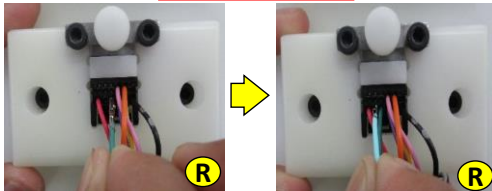
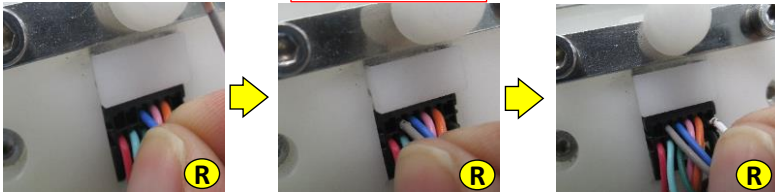
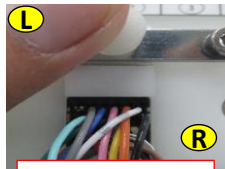
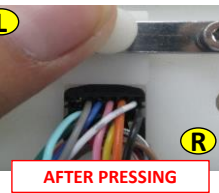
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Revision No.:

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Page No.:

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PARTS:		1. Assy parts	JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
11	P2 Wire insertion to connector 1746872-1 (B) (Continuation)	<p><b>DARK BROWN SUNPRENE TUBE</b></p>  <p><b>FIRST ROW</b></p>  <p>3. Hold the <b>G wire</b> using right hand then insert to terminal slot <b>3</b> and the <b>LG wire</b> to terminal slot <b>2</b>. <i>Note: Follow the insertion sequence based on the illustration.</i></p> <p><b>SECOND ROW</b></p>  <p>4. Hold the <b>L wire</b> using right hand then insert to terminal slot <b>9</b>; <b>GR wire</b> to terminal slot <b>12</b>. <i>Note: Follow the insertion sequence based on the illustration.</i></p> <p><b>BEFORE PRESSING</b></p>  <p><b>AFTER PRESSING</b></p>  <p>5. Press the button using left thumb.</p> <p><b>6. Hold the wires using right hand and gently pull out the connector from jig using right hand.</b></p>	n/a	<p>1. Use the provided jig per model 2. No wrong use of parts 3. No wrong insertion of wires 4. No deformed terminal 5. One by one insertion 6. No stuck-up of terminal tip</p> <p><b>Important reminders/Note/s:</b></p> <p>1. Please hold the wire near terminal during insertion.</p> <p>2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</p> <p>3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</p> <p><b>Document References:</b></p> <p>1. Refer to GL-PRO-ASY-028 for Pull-Push procedure.</p> <p>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p>

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# WORK INSTRUCTION

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Process Name/Title:

Model Code/Part Number: **220B / 75L847-0022**Customer: **TRJ**

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Effectivity Date:

**September 22, 2022**

Validity Date:

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Document No.:

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**12 of 14****PARTS:**

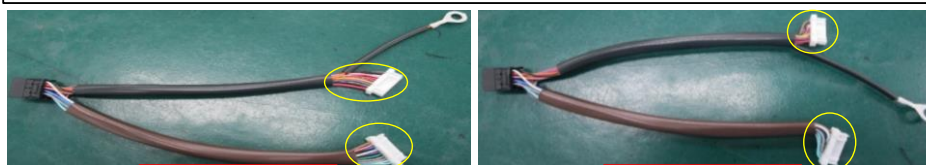
1. Assy parts

**JIG**

n/a

**NO.****PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS****5****5**

1. Hold the connector **PBVP-10V-S (W)** using left hand and slightly fold the wires from Black sunprene tube (as shown in illustration above) using right hand. Repeat the process for connector of Brown sunprene tube.

**BEFORE FOLDING****AFTER FOLDING**

Double lock upward position

**CORRECT FACING**

Terminal tip is not visible

Double lock in upward position

**WRONG FACING**

Terminal tip is not visible

Terminal tip is visible

n/a

1. No wrong orientation of connector
2. No tangled wires
3. No terminal backing out
4. No wrong facing
5. No tangled wires

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### TAPING ASSEMBLY PROCESS

Effectivity Date:

September 22, 2022

Model Code/Part Number:

220B / 75L847-0022

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TRJ

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Purpose:

☐ PROTOTYPE

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PARTS:

n/a

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

QUALITY POINTERS

13

P1

Visual/By two's inspection

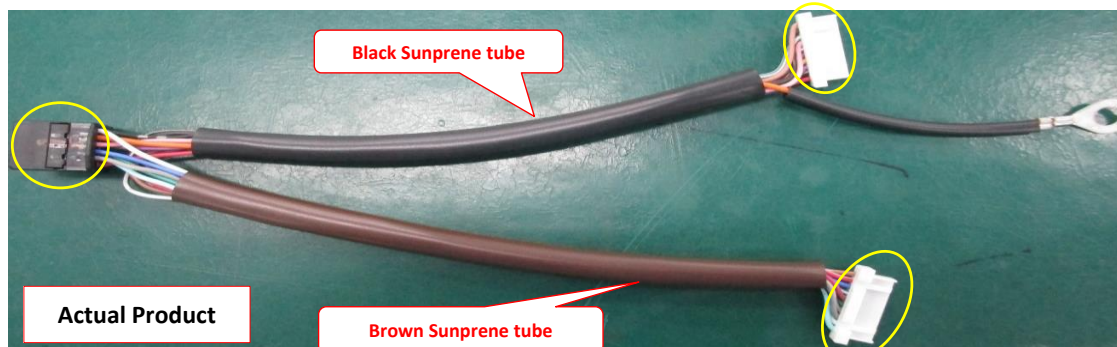
5

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

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

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

4. Check the orientation of harness.



5

5. Compare to Master Sample by tapping.



Master Sample

Assembly product

5

#### Document References:

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

MASTER SAMPLE



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# WORK INSTRUCTION

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## TAPING ASSEMBLY PROCESS

Validity Date:

n/a

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WI-ENG-PDE-119

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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Page No.:

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PARTS:

n/a

JIG:

n/a

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

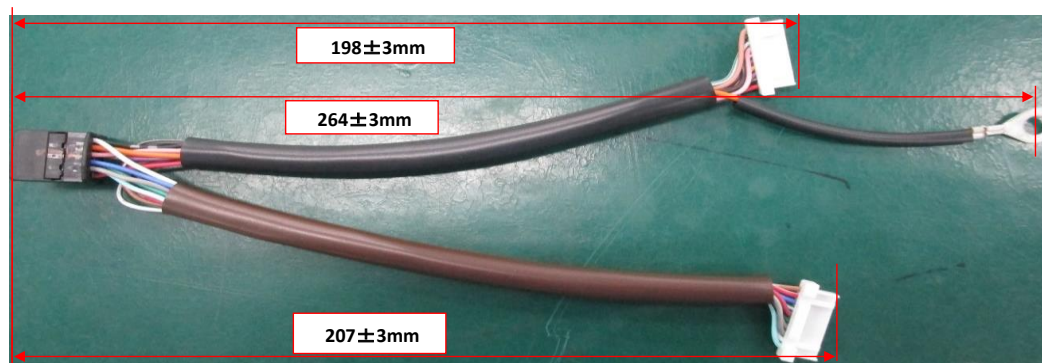
TOOLS/PPE

QUALITY POINTERS

14

Measurement

P1



Measuring tape



1. No wrong dimension

**Important Reminder/Note/s:**

1. Please use calibrated/verified measuring tape when getting the measurement.

2. For Hatsumono and Owarimono

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