



# WORK INSTRUCTION TAPING ASSEMBLY PROCESS

Effectivity Date:

April 6, 2023

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

n/a

Model code/Part number: 435B / 75N731-0101

Customer:

TRJ

Document No.:

WI-ENG-PDE-041A

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Revision No.:

7

Page No.:

1 of 10

## PARTS:

1. Connector XAP-07V-1-E (L)
2. Connector PBVP-08V-S (W)

JIG:

1. Insertion jig

NO.

PROCESS NAME



WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

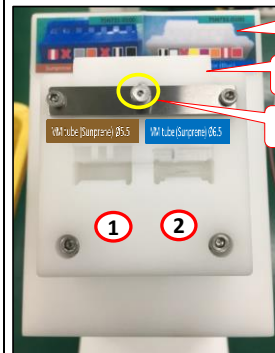
QUALITY POINTERS

1

P1

Connector setting to  
insertion jig  
XAP-07V-1-E (L)  
PBVP-08V-S (W)

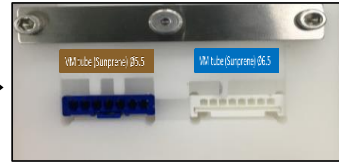
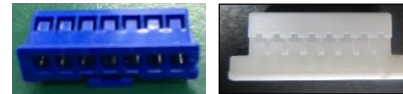
## INSERTION JIG

Visual  
reference

Guide lock

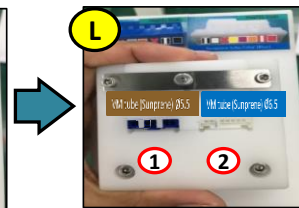
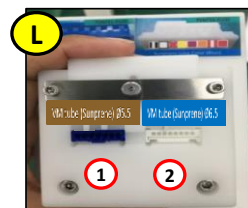
Unlock Button

## CONNECTOR ORIENTATION



1. Get the connector **XAP-07V-1-E** and **PBVP-08V-S** using right hand then insert to insertion jig.

*Note: Follow the connector orientation.*



2. Press the guide lock using left index finger. You will notice the holes that needs to be inserted are only open.

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

## Revision History

							Prepared by	Reviewed by	Approved by	Noted by
04/06/23	7	Standardized tube description; VM tube (Sunprene)	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
09/23/22	6	Remove Connector lock process and additional quality pointers in wire insertion refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance and conenctor illustration for 1746872-1 (B).	D. Castillo	J. Loterte	C. Villanueva	A. Arañes				
06/25/21	5	Include connector apperance check in quality pointers.	J. Loterte	C. Villanueva	A. Shimamura	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 28, 2019		

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PARTS:		1. AVSSf 0.3 R/W L=359±2mm , GR L=191±2mm, BR L=189±2mm, W/B L=361±2mm, B L=183±2mm 2. Brown VM tube (Sunprene) Ø5.5 L=125±3mm			JIG	1. Insertion jig																					
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS																					
2	P1 Wire insertion to Connector XAP-07V-1-E (L)	<div><div>INSERTION SEQUENCE</div></div> <div><div>WIRE INSERTION ILLUSTRATION</div><table><tr><td>1</td><td>2</td><td>3</td><td>4</td><td>5</td><td>6</td><td>7</td></tr><tr><td>R/W</td><td>X</td><td>GR</td><td>BR</td><td>X</td><td>W/B</td><td>B</td></tr><tr><td>359</td><td>X</td><td>191</td><td>189</td><td>X</td><td>361</td><td>183</td></tr></table></div> <div></div> <div></div> <div>1. Get the <b>R/W</b> wire using right hand and insert to connector. Repeat the process for <b>GR-BR-W/B-B</b> <b>Note: Follow the insertion sequence based on the illustration.</b></div>			1	2	3	4	5	6	7	R/W	X	GR	BR	X	W/B	B	359	X	191	189	X	361	183	<div><div>WIRE FACING</div></div> <div><div>STEERING NAVIGATION</div></div> <div><div>CONTROLLER</div></div>	<div>1. Use provided jig per model 2. No wrong usage of parts 3. One by one insertion 4. No wrong insertion 5. No deformed terminal 6. No stuck of terminal tip</div> <div><b>Important reminders/Note/s:</b> 1. Please hold the wire near terminal during insertion. 2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion. Do not exert extra force.</div> <div><b>Document References:</b> 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</div>
1	2	3	4	5	6	7																					
R/W	X	GR	BR	X	W/B	B																					
359	X	191	189	X	361	183																					
3	Wire insertion to Brown VM tube (Sunprene) Ø5.5 L=125±3mm	<div><div></div><div></div><div>1. Hold the wires using left hand, get the <b>Brown VM tube (Sunprene) Ø5.5 L=125±3mm</b> using right hand then insert the wires.</div></div>			n/a	<div>1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires</div>																					

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Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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#### PARTS:

1. AVSSf 0.3 W L=195±2mm; Y L=191±2mm; V L=189±2mm; OR L=187±2mm; R L=183±2mm

#### JIG

1. Insertion jig

#### NO.

#### PROCESS NAME



#### WORK PROCEDURE/ ILLUSTRATION

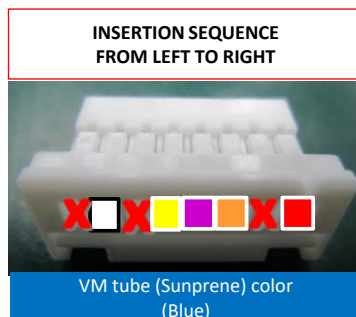
#### TOOLS/PPE

#### QUALITY POINTERS

4

P1

Wire insertion to  
Connector  
PBVP-08V-S (W)



#### WIRE INSERTION ILLUSTRATION

1	2	3	4	5	6	7	8
X	W	X	Y	V	OR	X	R
	195		191	189	187		183



#### WIRE FACING

#### STEERING NAVIGATION



#### CONTROLLER



1. Get the **W** wire using right hand and insert to connector. Repeat the process for **Y-V-OR-R**  
**Note: Skip the 1st, 3rd and 7th terminal slot. Follow the insertion sequence based on the above illustration.**

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

#### 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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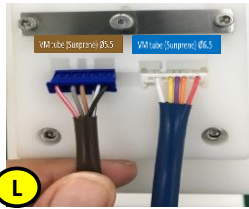
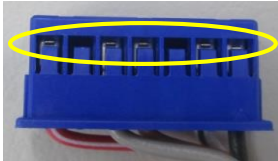
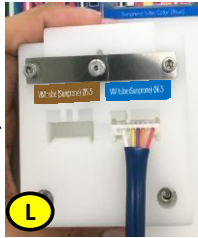
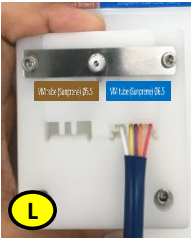
## TAPING ASSEMBLY PROCESS

Effectivity Date:	April 6, 2023		
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Document No.:	WI-ENG-PDE-041A		
Revision No.:	7	Page No.:	4 of 10

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Model code/Part number: **435B / 75N731-0101** Customer: **TRJ**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

<b>PARTS:</b> 		1. Blue VM tube (Sunprene) Ø6.5 L=125±3mm 2. Assy parts		<b>JIG</b>	1. Insertion jig
NO.	PROCESS NAME	 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
5	 Wire insertion to Blue VM tube (Sunprene) Ø6.5 L=125±3mm	<div><p>1. Hold the wires using left hand, get the <b>Blue VM tube (Sunprene) Ø6.5 L=125±3mm</b> using right hand then insert the wires.</p></div> <div><p>2. Press the unlock button using left thumb.</p></div> <div><p>3. Remove the 1st connector with inserted wires with <b>Brown VM tube (Sunprene)</b> and check the wire insertion.</p><p><b>Note:</b> Second connector with inserted wire is still on the jig. Check the terminal.</p></div>	n/a	<div>1. No wrong usage of parts 2. No deformed terminal 3. No tangled wires</div> <div><p><b>Terminal tip must be visible</b></p><p><b>Document References:</b> 1. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.</p></div>	
6	Wire insertion to assy	<div><p>1. Press the guide lock using left thumb.</p></div> <div><p>2. Hold the <b>Blue VM tube (Sunprene)</b> using left hand, insert the <b>W/B and R/W</b> wires to <b>Blue Sunprene tube</b>.</p></div>	n/a	<div>1. No wrong use of parts 2. No deformed terminal 3. No tangled wires</div>	

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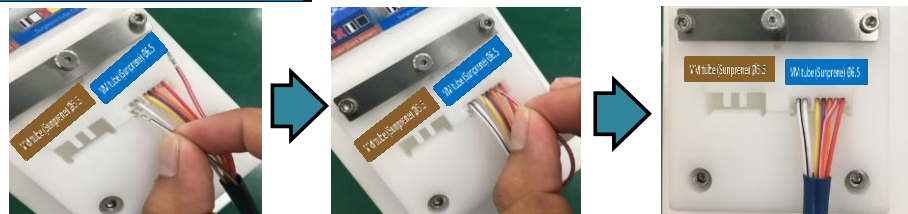
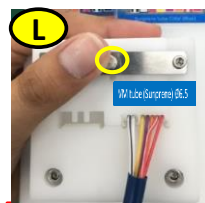
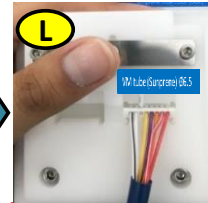
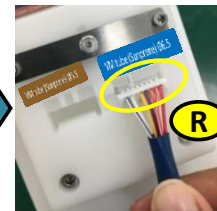
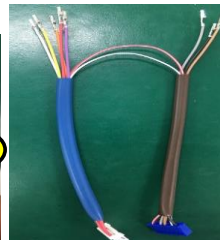



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PARTS:		1. Assy parts		JIG	1. Insertion jig																						
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS																						
7	P1	<div><div>INSERTION SEQUENCE FROM LEFT TO RIGHT</div><div></div><div>WIRE INSERTION ILLUSTRATION</div><table><tr><td>1</td><td>2</td><td>3</td><td>4</td><td>5</td><td>6</td><td>7</td><td>8</td></tr><tr><td>W/B</td><td>X</td><td>X</td><td>X</td><td>X</td><td>X</td><td>R/W</td><td>X</td></tr><tr><td>361</td><td></td><td></td><td></td><td></td><td></td><td>359</td><td></td></tr></table><div>WIRE FACING</div><div></div><div></div><div><div>1. Hold the <b>W/B</b> wire using right hand and insert to connector at the left side of <b>White</b> wire.</div><div>2. Hold the <b>R/W</b> wire using right hand and insert to connector at the right side of <b>Orange</b> wire.</div></div><div><div>BEFORE PRESSING</div><div>AFTER PRESSING</div><div></div><div></div><div>4. Check the appearance of the harness using both hands.</div></div><div>3. Press the unlock button using left hand and remove the harness from jig using right hand. Check the insertion of wire.</div></div> <div><div>STEERING NAVIGATION</div><div></div><div>CONTROLLER</div><div></div></div> <div><div>1. Use provided jig per model</div><div>2. No wrong usage of parts</div><div>3. One by one insertion</div><div>4. No wrong insertion</div><div>5. No deformed terminal</div><div>6. No stuck of terminal tip</div><div>Do not exert extra force.</div><div><b>Important reminders/Note/s:</b></div><div>1. Please hold the wire near terminal during insertion.</div><div>2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion.</div><div>Do not exert extra force.</div><div><b>Document References:</b></div><div>1. Refer to WI-ENG-PDE-044 for Steering Navigation Controller procedure.</div><div>2. Refer to GL-PRO-ASY-028 for Pull-Push procedure.</div><div>3. Refer to GL-PRO-ASY-025 for Inspection Standard for Coupler Insertion.</div><div>4. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div><div></div><div>Terminal tip must be visible</div></div>		1	2	3	4	5	6	7	8	W/B	X	X	X	X	X	R/W	X	361						359	
1	2	3	4	5	6	7	8																				
W/B	X	X	X	X	X	R/W	X																				
361						359																					

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Customer: **TRJ**

Purpose: ☐ PROTOTYPE

☐ PRE-LAUNCH

☒ MASSPRO

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### PARTS:

1. Connector 1746872-1 (B)

### JIG

1. Insertion jig

### NO.

### PROCESS NAME

### WORK PROCEDURE/ ILLUSTRATION

### TOOLS/PPE

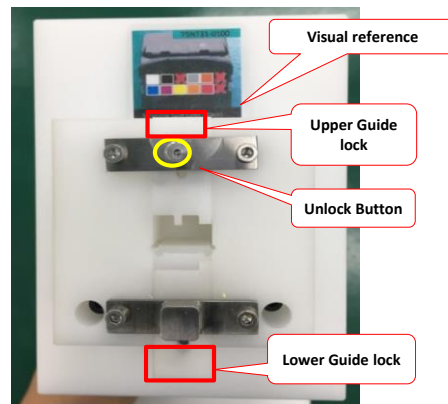
### QUALITY POINTERS

8

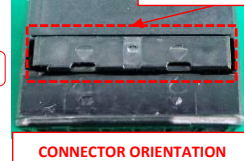
P1

Connector setting to  
insertion jig  
1746872-1 (B)

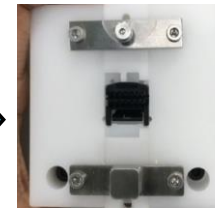
#### INSERTION JIG



#### Double lock



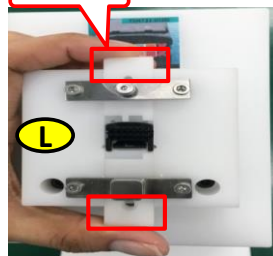
Note: Check the connector  
before insertion.



1. Get the connector **1746872-1 (B)** using left hand then  
insert to insertion jig.

Note: Follow the connector orientation

Press



BEFORE PRESSING



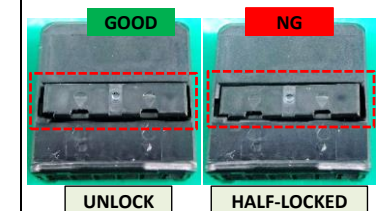
AFTER PRESSING

2. Press the upper and lower  
guide lock using left thumb  
and index finger. You will  
notice the holes that needs  
to be inserted are only open.

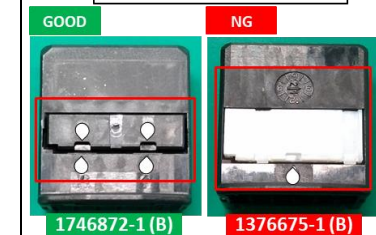
n/a

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

#### CONNECTOR LOCK APPEARANCE CHECK



#### CONNECTOR ILLUSTRATION



#### 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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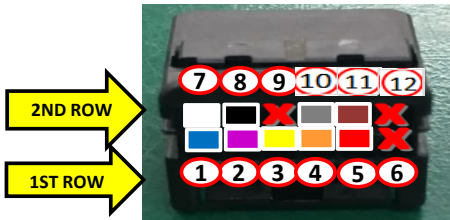


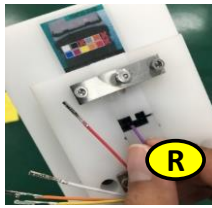
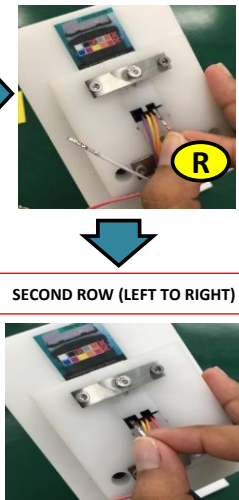
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PARTS:		1. Assy parts		JIG	1. Insertion jig																																				
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS																																				
9	P1  Wire insertion to Connector 1746872-1 (B)	<div><div>INSERTION SEQUENCE (FROM LEFT TO RIGHT)</div><div></div><div>2ND ROW</div><div>1ST ROW</div><div>WIRE FACING</div><div></div><div>WIRE INSERTION ILLUSTRATION</div><table><tr><td>7</td><td>8</td><td>9</td><td>10</td><td>11</td><td>12</td></tr><tr><td>W</td><td>B</td><td>X</td><td>GR</td><td>BR</td><td>X</td></tr><tr><td>195</td><td>183</td><td></td><td>191</td><td>189</td><td></td></tr><tr><td>1</td><td>2</td><td>3</td><td>4</td><td>5</td><td>6</td></tr><tr><td>L</td><td>V</td><td>Y</td><td>OR</td><td>R</td><td>X</td></tr><tr><td>154</td><td>189</td><td>191</td><td>187</td><td>183</td><td></td></tr></table><div>VM tube (Sunprene) (BLUE)</div><div></div><div>FIRST ROW (LEFT TO RIGHT)</div><div></div><div>SECOND ROW (LEFT TO RIGHT)</div><div></div><div>1. Insert first the wires from VM tube (Sunprene) (Blue). Get the Violet wire and insert to terminal slot no. 2 using right hand. Repeat the process for Y-OR-R wires. Get the White wire then insert to terminal slot no. 7</div><div>Note: Follow the insertion sequence based on the illustration stated above.</div></div>		7	8	9	10	11	12	W	B	X	GR	BR	X	195	183		191	189		1	2	3	4	5	6	L	V	Y	OR	R	X	154	189	191	187	183		n/a	<div>1. Use provided jig per model</div> <div>2. No wrong usage of parts</div> <div>3. One by one insertion</div> <div>4. No wrong insertion</div> <div>5. No deformed terminal</div> <div>6. No stuck of terminal tip</div> <div>Important reminders/Note/s:</div> <div>1. Please hold the wire near terminal during insertion.</div> <div>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>3. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.</div> <div>Document References:</div> <div>1. Refer to GL-PRO-ASY-028 for Pull-Push procedure.</div> <div>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div>
7	8	9	10	11	12																																				
W	B	X	GR	BR	X																																				
195	183		191	189																																					
1	2	3	4	5	6																																				
L	V	Y	OR	R	X																																				
154	189	191	187	183																																					

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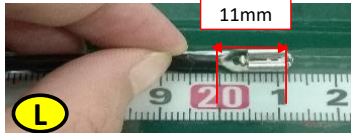


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Process Name/Title: **TAPING ASSEMBLY PROCESS**

Model code/Part number: **435B / 75N731-0101** Customer: **TRJ**

Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ☒ MASSPRO

PARTS:		1. Black VM tube (Sunprene) Ø3 L=140±3mm 2. AVSS 0.5 L L=154±2mm 3. Assy parts			JIG	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
9	Wire insertion to Connector 1746872-1 (B) (Continuation)	<div><div>VM tube (Sunprene) (DARK BROWN)</div><div></div><div></div><div></div></div> <div>2. Hold the wires from <b>Sunprene tube (Dark Brown)</b>. Get the <b>Black wire</b> and insert to the terminal slot <b>no. 8</b> using right hand. Repeat the process for <b>GR-BR wires</b>. <i>Note: Follow the insertion sequence based on the illustration stated above.</i></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
10	Wire insertion to VM tube (Sunprene) (Black) Ø3 L=140±3mm	<div><div></div><div>1. Get the <b>Blue wire</b> using right hand and insert to <b>VM tube (Sunprene) (Black) Ø3 L=140±3mm</b></div><div></div><div>2. Measure the Sunprene tube up to the tip of the terminal it should be <b>11mm</b>.</div></div>			<div>MEASURING TAPE</div> <div></div>	1. No wrong usage of parts 2. No wrong dimension <div></div> <div>Peel-off wire should be covered by <b>VM tube (Sunprene) (Black)</b></div> <div><b>Important Reminder/Note/s:</b> 1. Please use calibrated/verified measuring tape when getting the measurement.</div> <div><b>Document References:</b> 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div>

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## WORK INSTRUCTION

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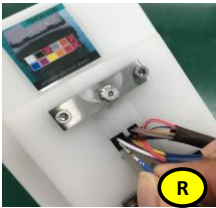

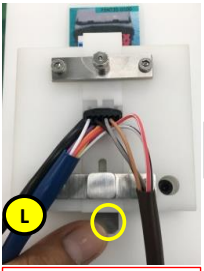
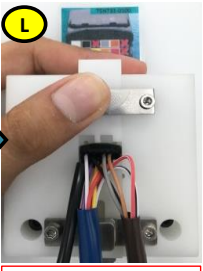
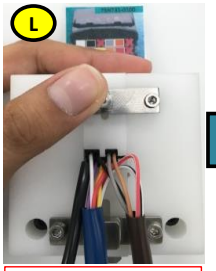
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:		1. Assy parts		JIG	1. Insertion jig																														
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS																														
11	P1	<div><div>INSERTION SEQUENCE (FROM LEFT TO RIGHT)</div><div>WIRE INSERTION ILLUSTRATION</div><table><tr><td>7</td><td>8</td><td>9</td><td>10</td><td>11</td><td>12</td></tr><tr><td>X</td><td>X</td><td>X</td><td>X</td><td>X</td><td>X</td></tr><tr><td>1</td><td>2</td><td>3</td><td>4</td><td>5</td><td>6</td></tr><tr><td>L</td><td></td><td></td><td></td><td></td><td></td></tr><tr><td>154</td><td>X</td><td>X</td><td>X</td><td>X</td><td>X</td></tr></table><div>WIRE FACING</div><div><div>1. Get the <b>Blue wire</b> with inserted tube and insert to connector at <b>slot no. 1</b> using right hand.</div><div><div>BEFORE PRESSING</div><div>AFTER PRESSING</div><div>BEFORE PRESSING</div><div>AFTER PRESSING</div><div>2. Push the upper and lower release button using left thumb and pull out the inserted wires from insertion jig.</div></div></div></div>		7	8	9	10	11	12	X	X	X	X	X	X	1	2	3	4	5	6	L						154	X	X	X	X	X	n/a	<div>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</div> <div><b>Important reminders/Note/s:</b> <i>1. Please hold the wire near terminal during insertion.</i> <i>2. Make sure wires are properly inserted. Conduct <u>Pull-Push-Pull-Push</u> after insertion.</i> <i>Do not exert extra force.</i></div> <div><b>Document References:</b> <i>1. Refer to GL-PRO-ASY-028 for Pull-Push procedure.</i> <i>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</i></div>
7	8	9	10	11	12																														
X	X	X	X	X	X																														
1	2	3	4	5	6																														
L																																			
154	X	X	X	X	X																														

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PARTS:

n/a

JIG

n/a



### QUALITY CHECKPOINTS

## 75N731-0101

1. Check the connector lock.

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

Brown VM tube (Sunprene)

CORRECT FACING

Blue VM tube (Sunprene)

Black VM tube (Sunprene)

3. Check the orientation of harness.

4. Check if no missing parts.

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

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