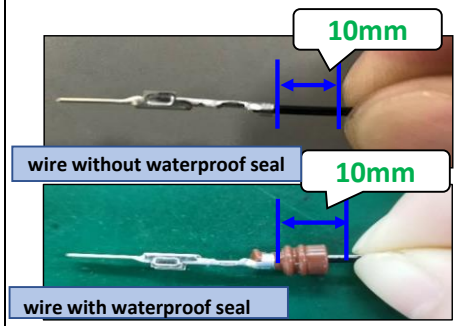
	Process Name/Title: **Proper Wire insertion to Connector**	Document No:	**WI-PRO-ASY-161**
	WORK INSTRUCTION	Effective Date:	**October 18, 2024**
	Product Code/Name: **All** / Customer Code: **All**	Rev.No.: **4**	Page No.: **1 of 4**

No.	Work Procedure / Illustration	Records/Remarks/ Quality Pointers
1	Wire Insertion to Connector	▪ **Make sure wires are properly inserted. Confirm insertion by 2x PULL-PUSH.** ***NOTE**:Refer to GL-PRO-ASY-029 for Pull-push procedure.* Be sure to follow the instructions when an abnormality occurs during work



• **Hold the wire at least 10mm away from the terminal**

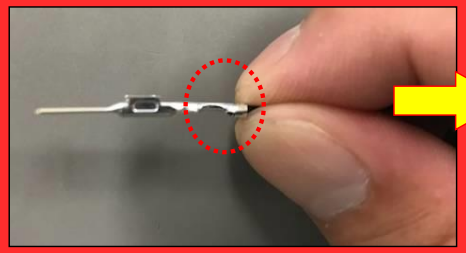
Insert the terminal into the connector

• **Fully insert the wire terminal into the connector**

Conduct checking of insertion condition

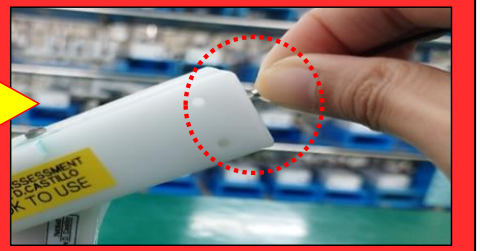
NG CONDITION OF WIRE INSERTION

IMPROPER HANDLING OF WIRE



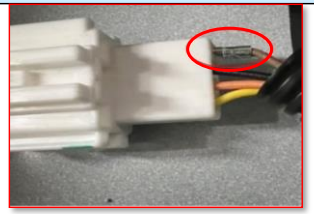
Holding the wire close to terminal

NOT FULLY INSERTED WIRES/ TERMINAL BACKING OUT



Cannot fully insert terminal on connector due to finger hits connector

NOTE: Terminal backing out may occur if wires are not fully inserted which can cause malfunction.



Sample photo of Terminal Backing Out (from Customer Claim)

Eff./Rev. Date	Rev. No	Details of change	Revise	Check	Approve	Prepare	Check	Approve
10/18/2024	4	Additional work procedure for Hazard models (page 4)	K.Hernandez	K.Aquino	W. Carbillon	K. Hernandez	K.Aquino	W. Carbillon
11/3/2023	3	Additional work procedure for steering models for wire insertion with pre-asy tube (page 3)	A. Morcozo	C. Calayan	W. Carbillon			
6/21/2023	2	Additional work procedure for steering models (page 2)	A. Morcozo	C. Calayan	O.Merin			
9/13/2022	1	Improve work procedure and illustration for proper holding of wire during insertion. Include sample photo of terminal backing out from customer claim	C. Recto	W.Carbillon	O.Merin			

Est. date: 09/07/2019

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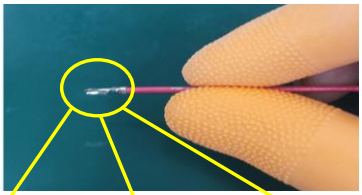
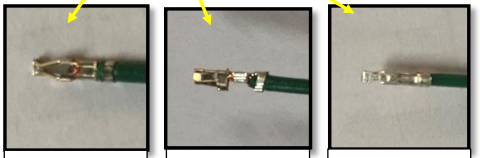
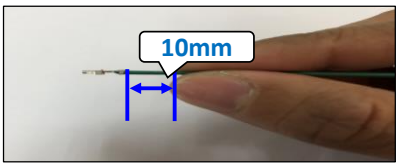
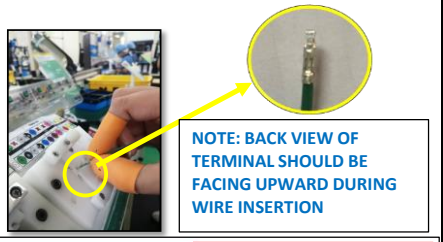
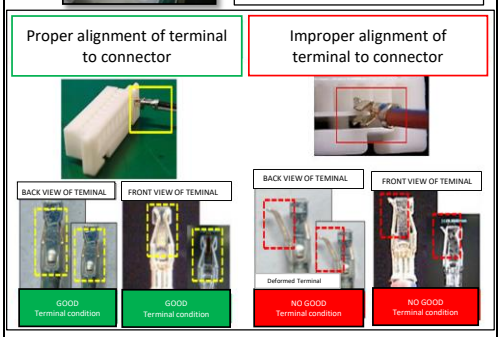
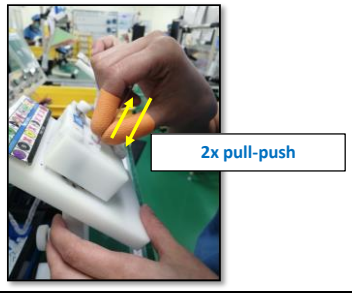
No.	Work Procedure/ Illustration		Records/Remarks/ Quality Pointers
1	Get one wire from the tube using right hand		***NOTE**: Refer to specific work instructions per model*
	Check terminal appearance NOTE: Should have **no visible deformation** on terminal	 	***NOTE**: No deformed terminal*
	Hold the wire **10 mm** away from terminal		***NOTE**: Conduct **STOP-CALL-WAIT** when encountered any abnormality*
	Align the facing of terminal then insert it to proper terminal slot	 	***NOTE**:* *> No bend wire* *> Make sure the terminal is in proper alignment before insertion* *> Avoid hitting the terminal into connector during wire insertion. If encountered abnormality, conduct STOP-CALL-WAIT*
	Conduct **2x pull-push** checking		***Remiders / Note :*** > Do not attempt to repair > Automatically disposed and replace the wire once encountered bumped terminal during insertion, difficulty of insertion and bend terminal . If encountered abnormality (ex. wrong insert) conduct **STOP-CALL-WAIT** *> Refer to GL-PRO-ASY-029 for Pull-push procedure*

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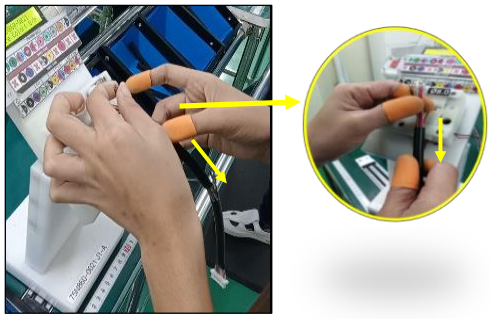
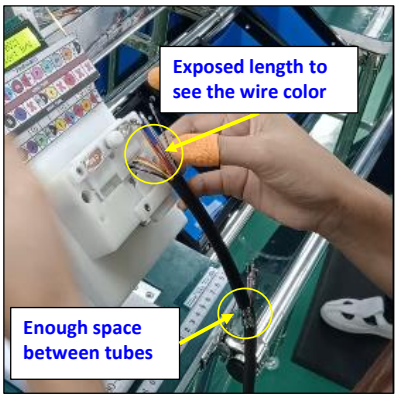
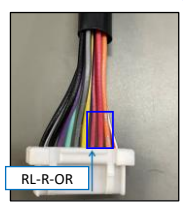
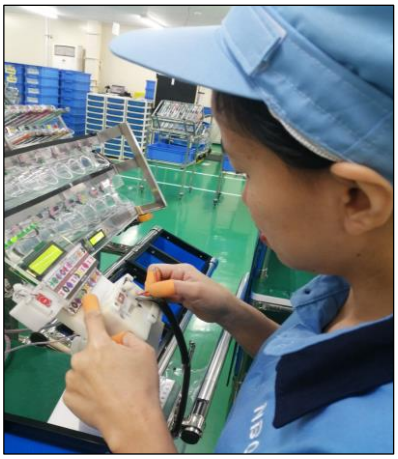
No.	Work Procedure/ Illustration		Records/Remarks/ Quality Pointers
1	**Wire Insertion (Pre-assy- with tube)** Hold the tube (near wire terminal to be inserted)		***NOTE**: Refer to specific work instructions per model*
	Pull down the tube prior wire insertion		***NOTE**:* > Make sure the wire have enough exposed length to see the wire color *> No wrong insert* *> No bend wire* *> Make sure the terminal is in proper alignment before insertion* *> Avoid hitting the terminal into connector during wire insertion.* *If encountered abnormality, conduct* ***STOP-CALL-WAIT***
			***NOTE**:* > Make sure the wire have enough exposed length to see the wire color > Make sure there is enough space between tubes
	Check the Wire Color **BEFORE** and **AFTER** insertion SAMPLE MODEL: 75N860-0021 **GOOD PRODUCT** (CORRECT INSERTED WIRE COLOR)  **NG PRODUCT** (WRONG INSERTED WIRE COLOR) WIRE INSERTION SEQUENCE		***NOTE**: Refer to page 2 for proper wire insertion*
			***NOTE**:* *> No wrong insert* *> If encountered abnormality (ex. wrong insert) conduct* ***STOP-CALL-WAIT***

1	2	3	4	5	6	7	8	9	10
B/W	B	V	LG	GR/B	Y	R/L	R	OR	R/W
288	152	152	288	152	152	288	153	288	288

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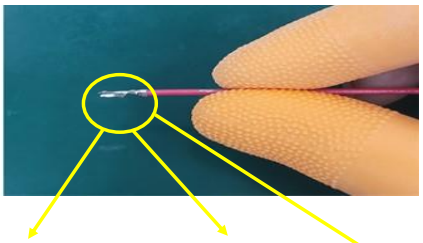
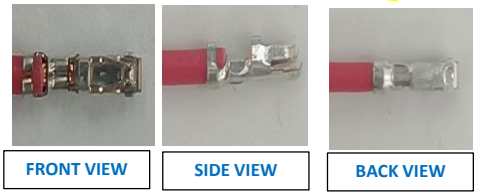
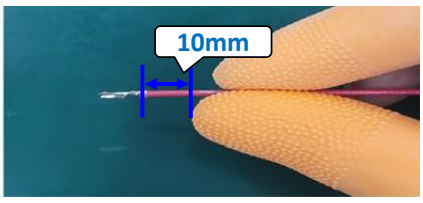
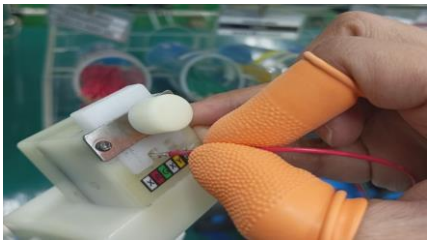
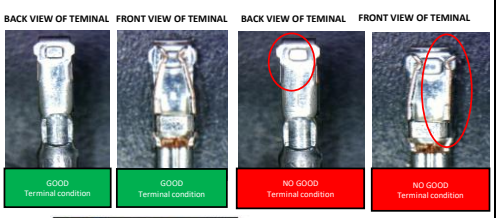
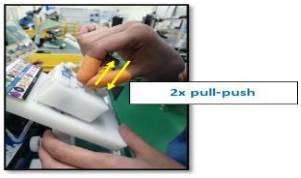
No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
1	4 Get one wire from the tube using right hand 4	***NOTE:*** **Refer to specific work instructions per model**
	Check terminal appearance NOTE: Should have **no visible deformation** on terminal   FRONT VIEW SIDE VIEW BACK VIEW	***Quality pointers :*** No deformed terminal
	Hold the wire **10 mm** away from terminal 	Conduct **STOP-CALL-WAIT** when encountered any abnormality
	Align the facing of terminal then insert it to proper terminal slot  Proper alignment of terminal to connector Improper alignment of terminal to connector 	***Quality pointers :*** 1. No wrong insert 2. No bend terminal 3. Make sure the terminal is in proper alignment before insertion 4. Avoid hitting the terminal into connector during wire insertion. ***Remiders / Note :*** > Do not attempt to repair > Automatically disposed and replace the wire once encountered bumped terminal during insertion, difficulty of insertion and bend terminal .
	Conduct **2x pull-push** checking 	If encountered abnormality (ex. wrong insert) conduct **STOP-CALL-WAIT** *> Refer to GL-PRO-ASY-029 for Pull-push procedure*

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