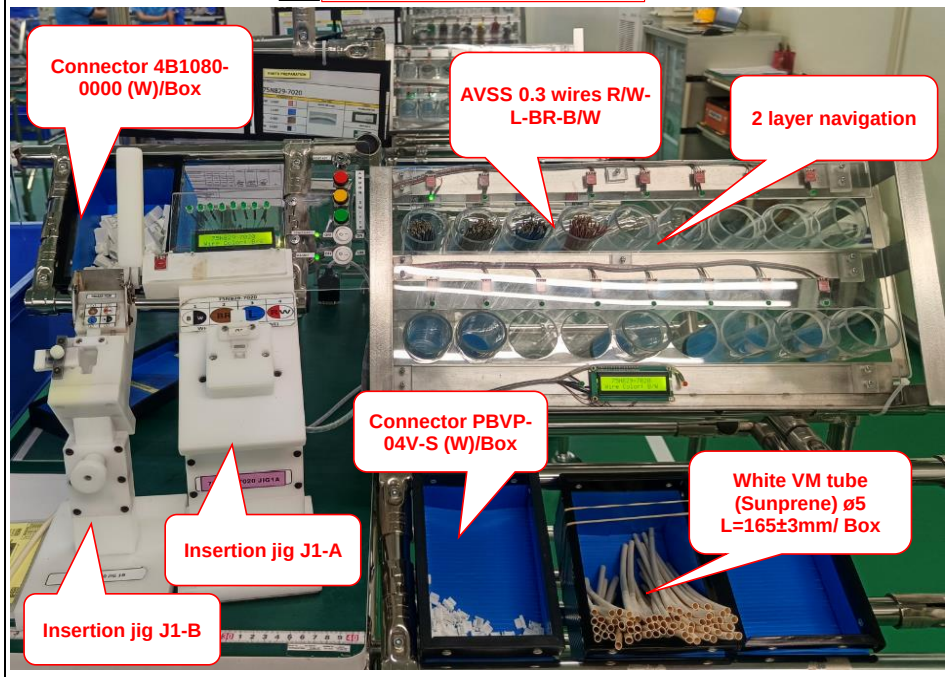
	WORK INSTRUCTION				Effectivity Date:	December 6, 2024		
	Process Name/Title:	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number:	Y2R/Y2K / 75N829-7020A	Customer: TRJ	Car Model: SUZUKI-HUSTLER	Document No.:	WI-ENG-PDE-1174		
	Purpose:	☐ PROTOTYPE	☐ PRE-LAUNCH	■ MASSPRO	Revision No.:	1	Page No.:	1 of 11

PARTS:	1. Assy parts; White VM tube (Sunprene) ø5 L=165±3mm ; Connector PBVP-04V-S (W); Connector 4B1080-0000 (W); AVSS 0.3 R/W L=197±2mm; L L=197±2mm; BR L=197±2mm; B/W L=197mm±2mm	JIG:	1. Insertion jig 2. Steering Navigation

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P1	Table lay-out	**TABLE LAY-OUT**  	**Safety Instruction** Be sure to wear 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

Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted
12/06/24	1	Change purpose from Pre-launch to Masspro. Additional table lay-out	M. Ariola	C. Villanueva	A. Arañes	n/a
11/18/24	0	Initial Issue.	M. Ariola	C. Villanueva	A. Arañes	n/a

Prepared by	Reviewed by	Approved by	Noted by
M. Ariola	C. Villanueva	A. Arañes	n/a
Est. Date:	November 18, 2024		

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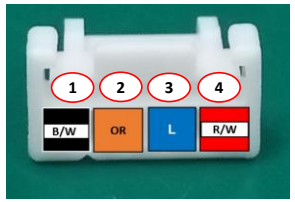
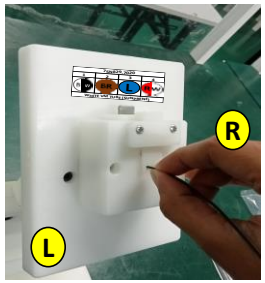
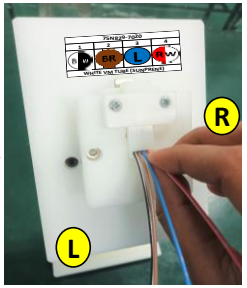
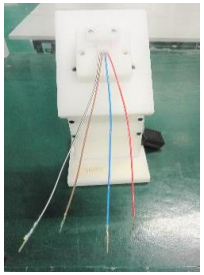
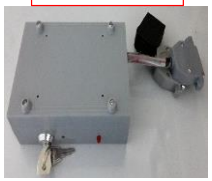
NBC	WORK INSTRUCTION			Effectivity Date:	December 6, 2024
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number: Y2R/Y2K / 75N829-7020A	Customer: TRJ	Car Model: SUZUKI-HUSTLER	Document No.:	WI-ENG-PDE-1174
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 1	Page No.: 2 of 11

PARTS:	1. AVSS 0.3 R/W L=197±2mm; L L=197±2mm; BR L=197±2mm; B/W L=197mm±2mm	JIG:	1. Insertion jig 2. Steering Navigation

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1	Wire insertion to connector PBVP-04V-S (W)	**INSERTION SEQUENE FROM LEFT TO RIGHT**  **TERMINAL ORIENTATION** **WIRE INSERTION ILLUSTRATION** 1 / 2 / 3 / 4 B/W / BR / L / R/W 197 / 197 / 197 / 197    1. Get the **B/W wire** and insert to terminal slot **1** using right hand. Repeat the process for BR-L-R/W **wires.** ***Note: Follow the insertion sequence based on the illustration.***	**STEERING NAVIGATION** **CONTROLLER** 	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing ***Important reminders/Note/s:*** *1. Please hold the wire near terminal during insertion.* *2. Insertion must be from left to right.* *3. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion.* *Do not exert extra force.* ***Document reference/s:*** *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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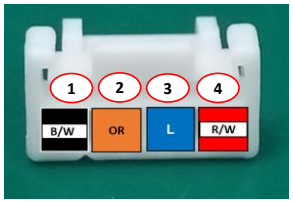
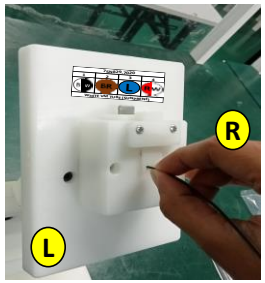
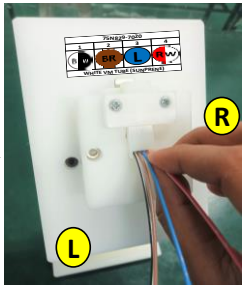
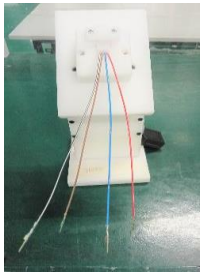
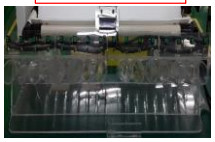
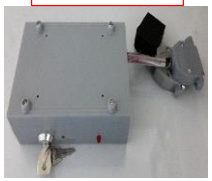
NBC	WORK INSTRUCTION			Effectivity Date:	December 6, 2024
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number: Y2R/Y2K / 75N829-7020A	Customer: TRJ	Car Model: SUZUKI-HUSTLER	Document No.:	WI-ENG-PDE-1174
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 1	Page No.: 3 of 11

PARTS:	1. AVSS 0.3 R/W L=197±2mm; L L=197±2mm; BR L=197±2mm; B/W L=197mm±2mm	JIG:	1. Insertion jig 2. Steering Navigation

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1	Wire insertion to connector PBVP-04V-S (W)	**INSERTION SEQUENE FROM LEFT TO RIGHT**  **TERMINAL ORIENTATION** **WIRE INSERTION ILLUSTRATION** 1 / 2 / 3 / 4 B/W / BR / L / R/W 197 / 197 / 197 / 197    1. Get the **B/W wire** and insert to terminal slot **1** using right hand. Repeat the process for BR-L-R/W **wires.** ***Note: Follow the insertion sequence based on the illustration.***	**STEERING NAVIGATION**  **CONTROLLER** 	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing ***Important reminders/Note/s:*** *1. Please hold the wire near terminal during insertion.* *2. Insertion must be from left to right.* *3. Make sure wires are properly inserted. Conduct **Pull-Push-Pull-Push** after insertion.* *Do not exert extra force.* ***Document reference/s:*** *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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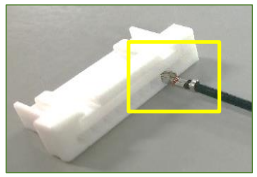
	WORK INSTRUCTION			Effectivity Date:	December 6, 2024	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: Y2R/Y2K / 75N829-7020A	Customer: TRJ	Car Model: SUZUKI-HUSTLER	Document No.:	WI-ENG-PDE-1174	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 4 of 11

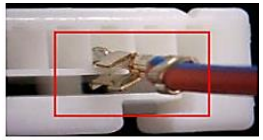
PARTS:	1. AVSS 0.3 R/W L=197±2mm; L L=197±2mm; BR L=197±2mm; B/W L=197mm±2mm	JIG:	1. Insertion jig

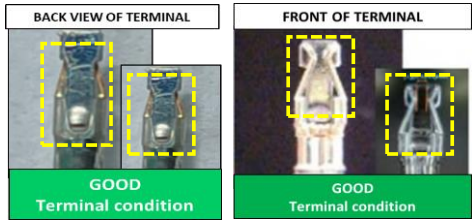
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1	Wire insertion to connector PBVP-04V-S (W) (Continuation)			1. Use provided jig per model 2. No wrong usage of parts 3. No wrong insertion 4. No deformed terminal 5. No stuck of terminal tip 6. One by one insertion ***Important 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.***

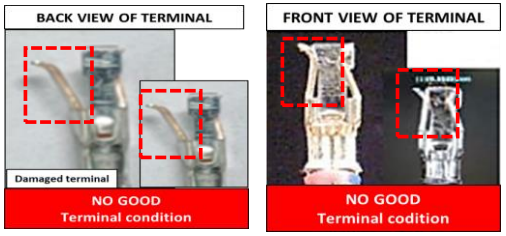
Proper alignment of terminal to connector



Improper alignment of terminal to connector







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

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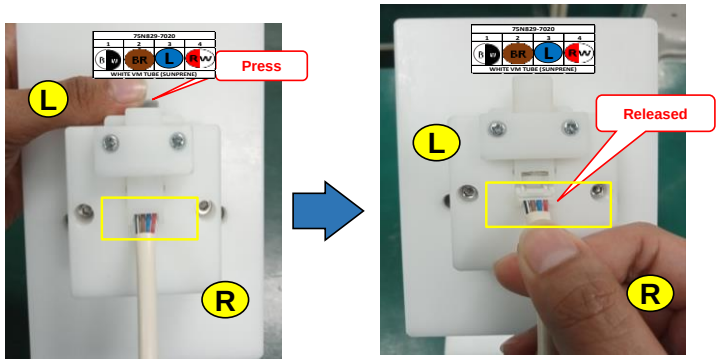
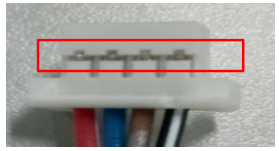
	Model code/Part number: Y2R/Y2K / 75N829-7020A	Customer: TRJ	Car Model: SUZUKI-HUSTLER	Document No.:	WI-ENG-PDE-1174	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 5 of 11

PARTS:	1. White VM tube (Sunprene) ø5 L=165±3mm 2. Assy parts	JIG:	1. Insertion jig 2. Steering Navigation

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P1	Wire insertion to White VM tube (Sunprene) ø5 L=165±3mm	 1. Get the **White VM tube (Sunprene) ø5 L=165±3mm** using right hand and insert the wires using left hand.  2. Press the unlock button using left thumb to release the lock. Gently pull out the connector from jig using right hand. Check the terminal tip condition.	n/a	1. No wrong usage of parts 2. No deformed terminal  **Terminal tip must be visible** ***Document reference/s:*** *1. Refer to GL-PRO-ASY-025 for Inspection Standard for connector insertion*

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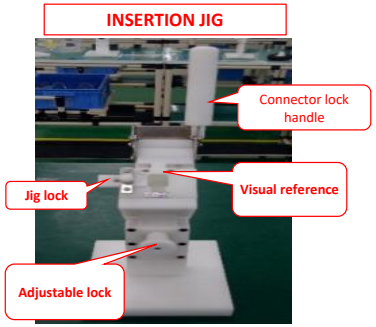
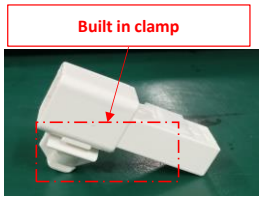
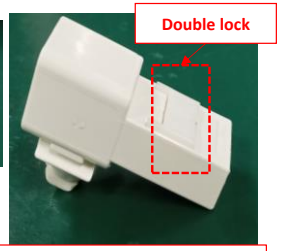
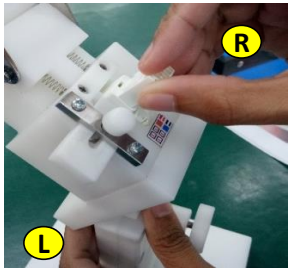
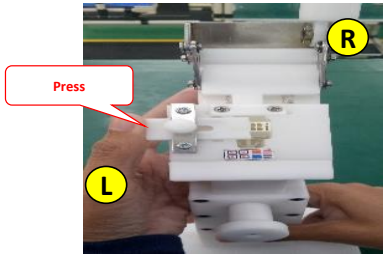
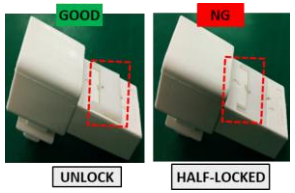
	Model code/Part number: Y2R/Y2K / 75N829-7020A	Customer: TRJ	Car Model: SUZUKI-HUSTLER	Document No.:	WI-ENG-PDE-1174
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 1	Page No.: 6 of 11

PARTS:	1. Connector 4B1080-0000 (W)	JIG:	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1	Connector setting to insertion jig 4B1080-0000 (W)	   CONNECTOR ORIENTATION  1. Get the connector **4B1080-0000 (W)** and insert to jig using right hand. ***Note: Follow the connector orientation.***  2. Press the lock using left thumb after insertion.	n/a	1. Use the provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector ***Important reminders/Note/s:*** *1. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector.* *2. Check the connector before insertion.* CONNECTOR LOCK APPEARANCE CHECK 

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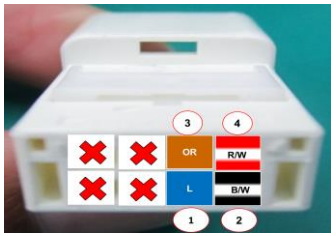
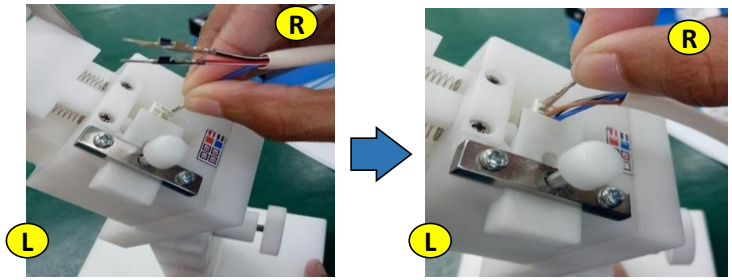
	WORK INSTRUCTION			Effectivity Date:	December 6, 2024	
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: Y2R/Y2K / 75N829-7020A	Customer: TRJ	Car Model: SUZUKI-HUSTLER	Document No.:	WI-ENG-PDE-1174	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 7 of 11

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

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1	Wire insertion to connector 4B1080-0000 (W)	**INSERTION SEQUENE FROM LEFT TO RIGHT**  **WIRE INSERTION ILLUSTRATION** 3: BR 197 4: R/W 197 1: L 197 2: B/W 197 **TERMINAL ORIENTATION**  1. Get the **L wire** and insert to terminal slot **1** using right hand. Repeat the process for **B/W-BR-R/W wires.** ***Note: Follow the insertion sequence based on the illustration.***	**n/a**	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing ***Important reminders/Note/s:*** *1. Please hold the wire near terminal during insertion.* *2. Insertion of wire must be from left to right.* *3. Make sure wires are properly inserted.* *Conduct **Pull-Push-Pull-Push** after insetion.* *Do not exert extra force.* *4. Automatically dispose and replace the unit if once encountered bend terminal, difficulty of insertion and half-locked connector* ***Document reference/s:*** *1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance* *2. Refer to GL-PRO-ASY-029 for Pull-Push procedure.*

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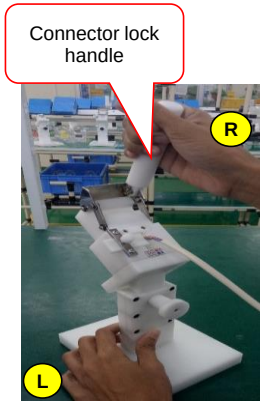
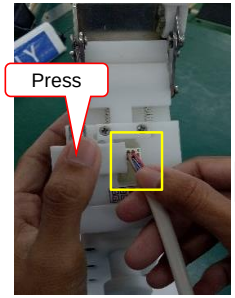
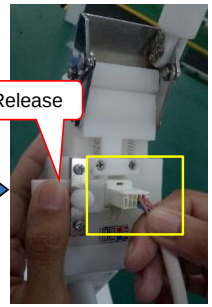
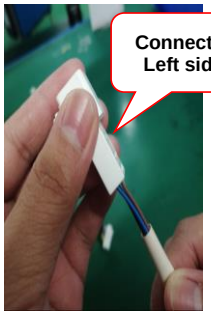
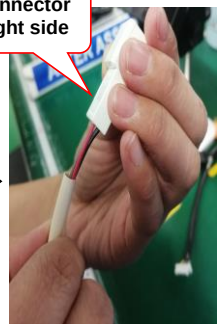
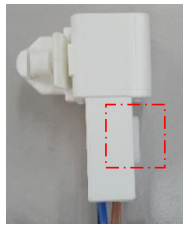
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: Y2R/Y2K / 75N829-7020A	Customer: TRJ	Car Model: SUZUKI-HUSTLER	Document No.:	WI-ENG-PDE-1174	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 8 of 11

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

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1	Connector lock	   1. Pull down the handle using right hand to lock the connector. 2. Press the unlock button to release the lock using left thumb. Then slowly remove the harness from jig. Check the lock if properly pressed.   3.Conduct visual checking of lock from side to side (Left to right).	n/a	1. Use the provided jig tool to lock the connector. 2. No unlock/half-locked connector ***Important reminders/Notes/:*** *1. Manual locking may cause damaged connector lock.*  **BEFORE** **AFTER**

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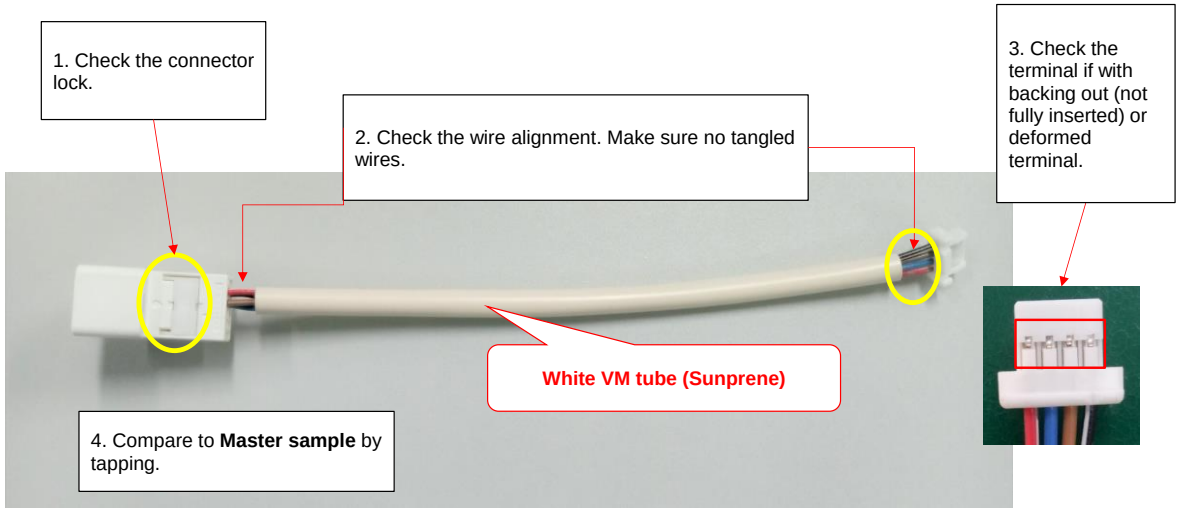
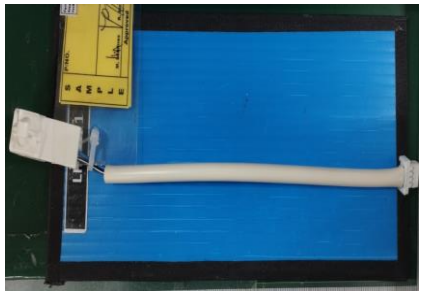
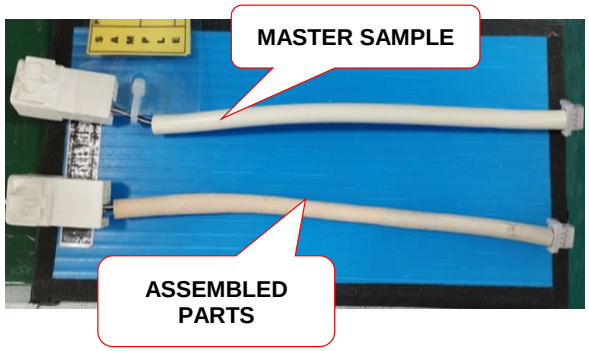
NBC	WORK INSTRUCTION			Effectivity Date:	December 6, 2024
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a
	Model code/Part number: Y2R/Y2K / 75N829-7020A	Customer: TRJ	Car Model: SUZUKI-HUSTLER	Document No.:	WI-ENG-PDE-1174
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 1	Page No.: 9 of 11

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

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1	Visual/By Two's Inspection	  		**MASTER SAMPLE** 1. No skip checking during inspection. ***Document reference/s:*** *1. Refer to WI-ENG-PDE-431 for Steering Electrical Test after assembly.*

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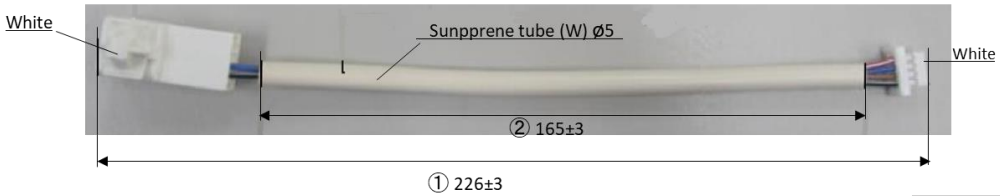
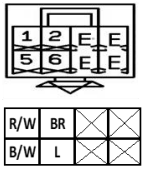
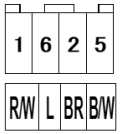
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a	
	Model code/Part number: Y2R/Y2K / 75N829-7020A	Customer: TRJ	Car Model: SUZUKI-HUSTLER	Document No.:	WI-ENG-PDE-1174	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 10 of 11

PARTS:	n/a	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
8	P1	Measurement	  WIRE TYPE TABLE No / Color / Wire Type 1 / R/W / AVSS 0.3 2 / BR / AVSS 0.3 5 / B/W / AVSS 0.3 6 / L / AVSS 0.3 E / EMPTY *Unit of dimension is in millimeter (mm) MEASURING TAPE 		1. No wrong dimension. ***Important reminders and note/s:*** *1. Please use calibrated/verified measuring tape when getting the measurement.* *2. For Hatsumono and Owarimono.* ***Document reference/s:*** *1. Refer to **WI-QAD-QAC-252** for Sub-assembly Hatsumono Nakamono Owarimono Inspection*

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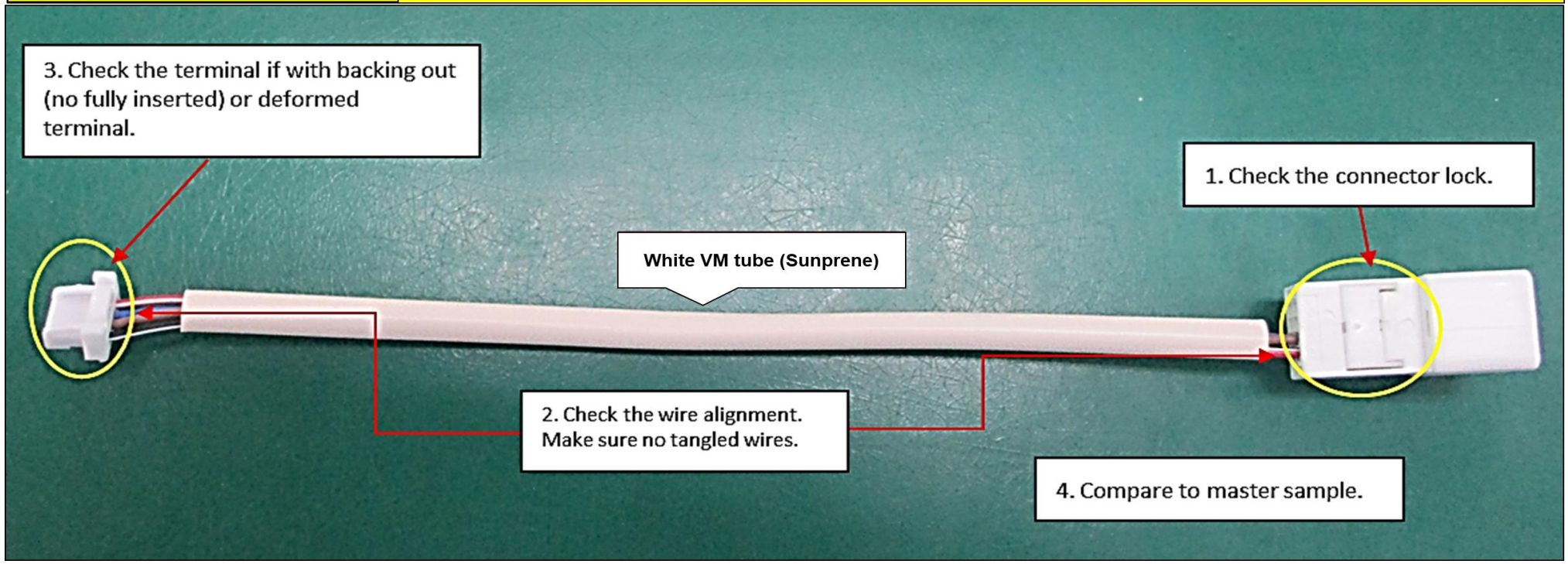
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.: 1	Page No.: 11 of 11

PARTS:	n/a	JIG:	n/a

QUALITY CHECKPOINTS

STEERING 75N829-7020A



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