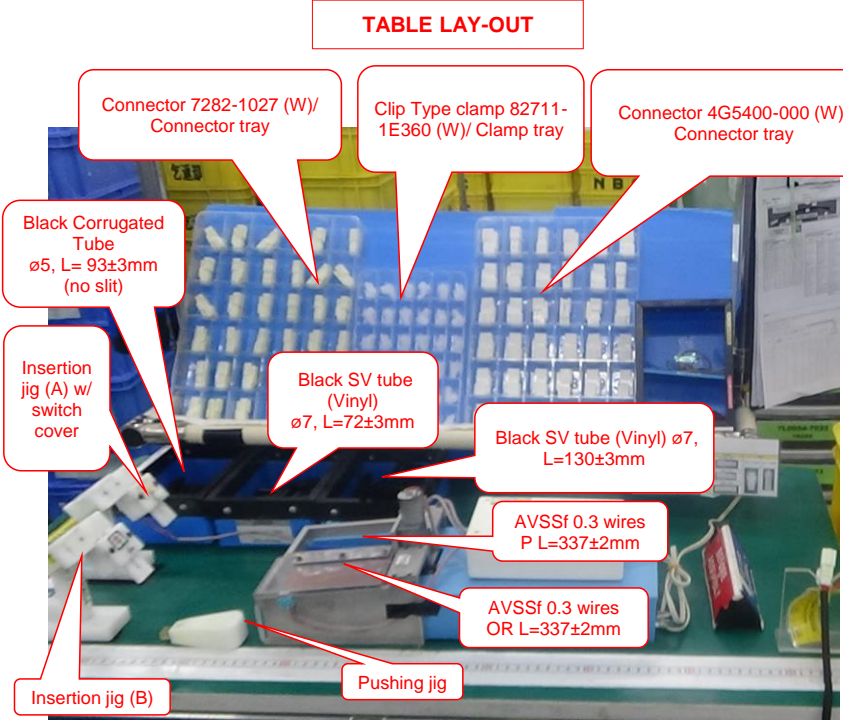
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	Process Name/Title:				Validity Date: <b>n/a</b>	
	Model code/Part number: <b>D01L / 7M0654-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>DAIHATSU-TANTO</b>	Document No.: <b>WI-ENG-PDE-155</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: <b>6</b>		Page No.:	1 of 9

<b>PARTS:</b> 1. Connector 7282-1027 (W); AVSSf 0.3 wires P L=337±2mm, AVSSf 0.3 wire OR L=337±2mm; Clip Type clamp 82711-1E360 (W); Black Corrugated Tube ø5, L= 93±3mm (no slit); Black SV tube (Vinyl) ø7, L=72±3mm; Black SV tube (Vinyl) ø7, L=130±3mm; Connector 4G5400-000 (W)		<b>JIG:</b> 1. Insertion jig With and W/O switch cover 2. Pushing jig	
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>
1	Offline	<div style="text-align: center;">  </div>	<div> <p><b>Safety Instruction</b> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p><b>Housekeeping</b> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p><b>Alert level</b> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>
		<b>QUALITY POINTERS</b>	
		<b>Document reference/s:</b>  1. Please refer to WI-PRO-CNC-017 for Wire and Strip Length tolerance	
		1. No missing parts/tools 2. No excess parts/tools	

Revision History				Prepared by	Reviewed by	Approved by	Noted by
07/12/24	6	Inclusion of car model "DAIHATSU-TANTO" and Measurement. Update Visual inspection/Quality checkpoints.	D.Castillo	C. Villanueva	A. Arañes	n/a	
06/05/23	5	Table lay-out. Standardized tube description: SV tube (Vinyl); Inclusion of Quality checkpoints on last page. Transferred process of Connector setting to insertion jig and Wire insertion to Connector 4G5400-000 (W) from P1 to OFFLINE ASSEMBLY PROCESS due to new process distribution; Improve Quality pointers: Reminders/notes and references on page no.1,3,4 and 7.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	
07/12/22	4	Change process name from Kitting Assembly Process to offline Assembly Process. Change Illustration of clamp attachment on pg.3 procedure 1. Additional notes for Wire and strip length tolerance (Please refer to WI-PRO-CNC-017), Additional notes for Pull-Push procedure (GL-PRO-ASY-029).	M. Ariola	J. Loterte	C. Villanueva	A. Arañes	n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date: September 14, 2019

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# WORK INSTRUCTION

Process Name/Title:

## OFFLINE ASSEMBLY PROCESS

Effectivity Date:

July 12, 2024

Validity Date:

n/a

Model code/Part number:

D01L / 7M0654-7020A

Customer:

TRJ

Car Model:

DAIHATSU-TANTO

Document No.:

WI-ENG-PDE-155

Purpose:

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☐ PRE-LAUNCH

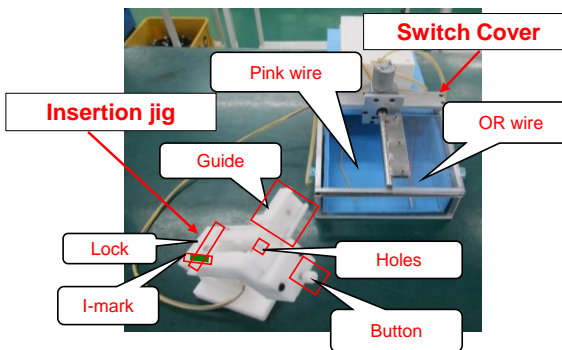
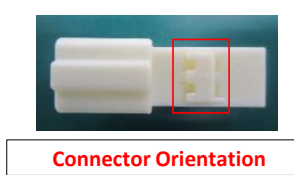
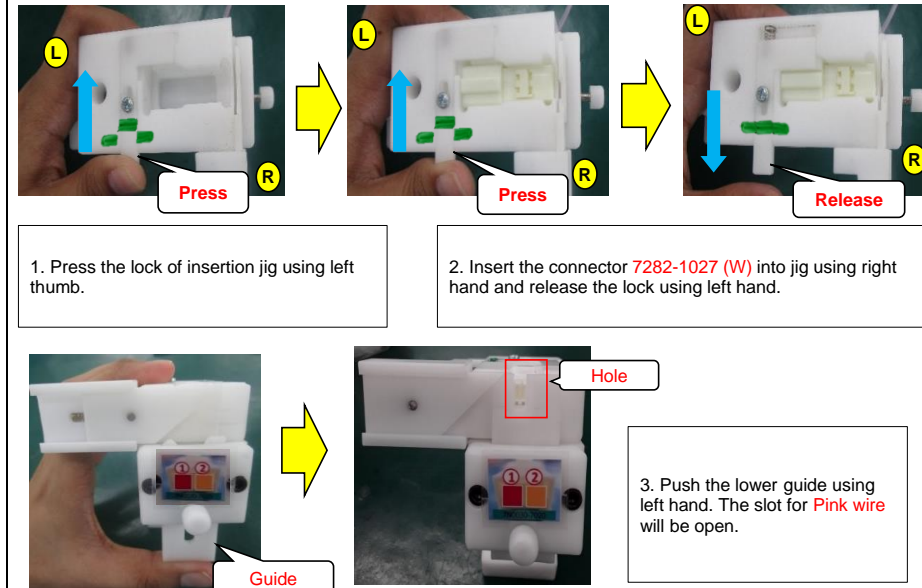

☒ MASSPRO

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PARTS:		1. Connector 7282-1027 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	Offline Connector Setting to Insertion jig Connector 7282-1027 (W)	   <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Insert the connector 7282-1027 (W) into jig using right hand and release the lock using left hand.</p> <p>3. Push the lower guide using left hand. The slot for Pink wire will be open.</p>		n/a	 <p><b>CONNECTOR ORIENTATION ILLUSTRATION</b></p> <p>I-mark is align, 1 hole is open (GOOD)</p> <p>I-mark is not align, 1 hole is open (NG)</p> <p>1. Use provided jig for model 2. No wrong use of parts 3. No wrong orientation of connector 4. No damaged connector</p>

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**WORK INSTRUCTION**

Process Name/Title:

**OFFLINE ASSEMBLY PROCESS**

Effectivity Date:

July 12, 2024

Validity Date:

n/a

Model code/Part number:

**D01L / 7M0654-7020A**

Customer:

**TRJ**

Car Model:

**DAIHATSU-TANTO**

Document No.:

**WI-ENG-PDE-155**

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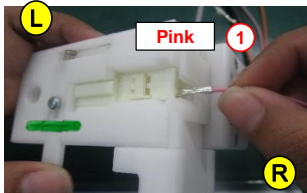
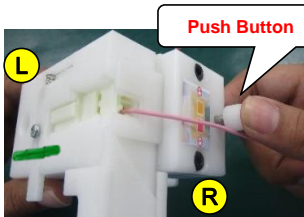
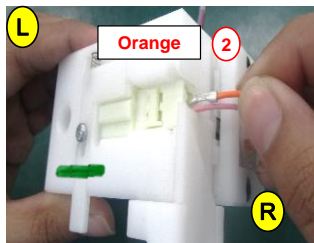
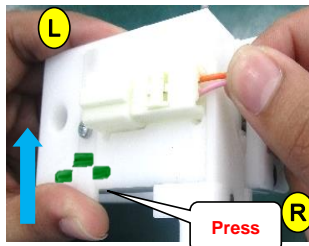
☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

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PARTS:	1. AVSSf 0.3 wires P L=337±2mm, OR L=337±2mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	Offline	<div><div></div><div></div><div></div><div></div><div></div></div> <p>1. Hold the insertion jig using left hand, get the <b>Pink</b> wire to switch cover then insert to connector using right hand.</p> <p>2. Push the button using right thumb, slot for <b>Orange</b> wire will be open.</p> <p>3. Get the <b>Orange</b> wire then insert to the open slot using right hand.</p> <p>4. After insertion, Press the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</p>	n/a	<p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</p> <p><b>Important reminderd/Note/s:</b></p> <p><b>1. Please hold the wire near terminal dueing insertion</b> <b>2. Insertion of wire must be from left to right</b> <b>3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion</b> <b>Do not exert extra force.</b></p> <p><b>Document reference/s:</b></p> <p><b>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b> <b>2.Refer to GL-PRO-ASY-029 for Pull-Push procedure</b></p>

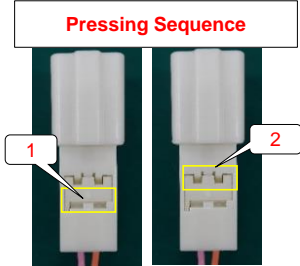
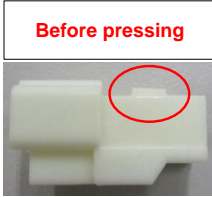
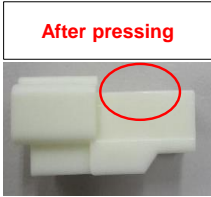
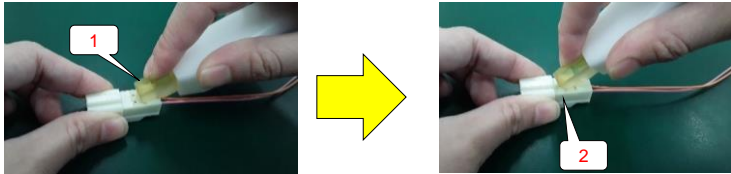

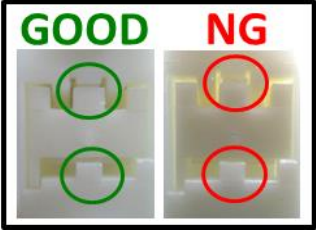
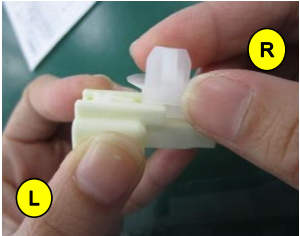


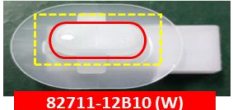
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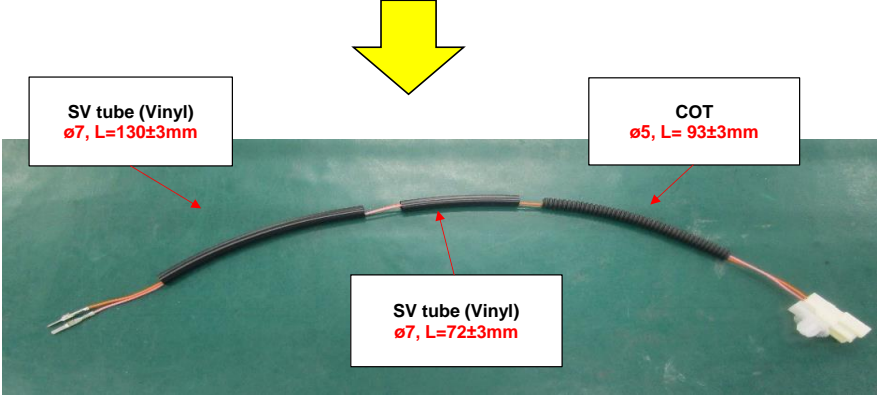
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	Process Name/Title: <b>OFFLINE ASSEMBLY PROCESS</b>			Validity Date:	n/a		
	Model code/Part number: <b>D01L / 7M0654-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>DAIHATSU-TANTO</b>	Document No.:	<b>WI-ENG-PDE-155</b>	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	6	Page No.:	4 of 9

<b>PARTS:</b> 1. Assy Parts 2.Clip Type clamp 82711-1E360 (W)	JIG: 1. Pushing jig			
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
4	Connector Lock  Offline	<div> <div> <b>Pressing Sequence</b>   </div> <div> <b>Before pressing</b>   </div> <div> <b>After pressing</b>   </div> <div>  </div> <div> <p>1. Place the connector on the table while holding using left hand. Get the pushing jig using right hand and start the sequential locking based on above illustration. Push the lower part of the connector lock first and then push the upper part  <i>Position of pushing jig during locking must be slant.</i></p> </div> </div>	<div> <b>PUSHING JIG</b>   </div>	<div> <b>GOOD NG</b>   </div> <p><b>Important reminders/Notes:</b></p> <p>1. Manual locking may cause damaged connector lock</p> <p>1. Use provided jig per models 2. No Unlock/Half-locked</p>
5	Clamp attachment (Clip type) 82711-1E360 (W)	<div>  </div> <div>  </div> <div> <p>1. Hold the connector using left hand and insert the Clamp 82711-1E360 (W) using right hand.</p> </div>	n/a	<p>1. No loose attachment of clamp</p> <div> <b>CLIP CLAMP ILLUSTRATION</b>  <div> <b>GOOD</b>   <p>82711-1E360 (W)</p> </div> <div> <b>NG</b>   <p>82711-12B10 (W)</p> </div> </div>

	<b>WORK INSTRUCTION</b>				Effectivity Date:		July 12, 2024	
	Process Name/Title: <b>OFFLINE ASSEMBLY PROCESS</b>				Validity Date:		n/a	
	Model code/Part number: <b>D01L / 7M0654-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>DAIHATSU-TANTO</b>	Document No.:		<b>WI-ENG-PDE-155</b>	
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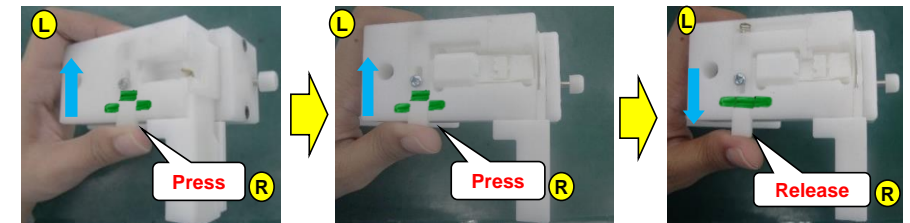
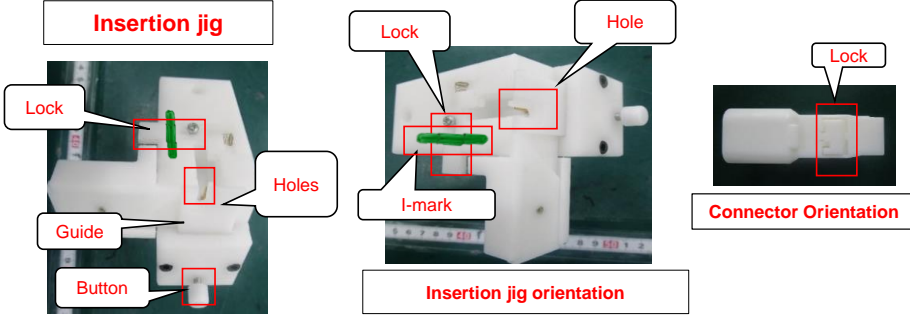
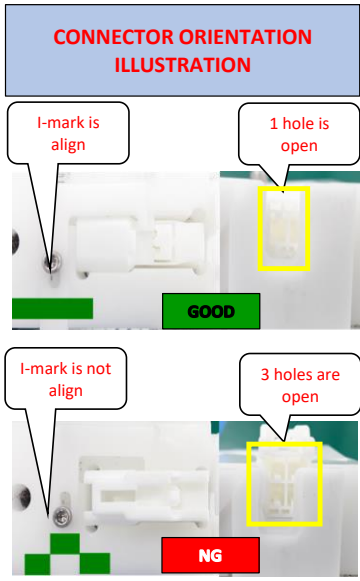
<b>PARTS:</b>	1. Black Corrugated tube $\phi 5$ , L= 93 $\pm$ 3mm (no slit) 2. Black SV tube (Vinyl) $\phi 7$ , L=72 $\pm$ 3mm 3. Black SV tube (Vinyl) $\phi 7$ , L=130 $\pm$ 3mm 4. Assy parts		JIG:	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>	<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
6	Wire Insertion to Black Corrugated Tube $\phi 5$ , L= 93 $\pm$ 3mm (no slit)	 <div> <p>1. Get the Corrugated tube (<math>\phi 5</math>, L= 93<math>\pm</math>3) using right hand then insert the Pink wire and Orange wire by using left hand.</p> </div>	n/a	1. No wrong use of parts
7	Offline Wire Insertion to SV tube (Vinyl) $\phi 7$ , L=72 $\pm$ 3mm $\phi 7$ , L=130 $\pm$ 3mm	 <div> <p>1. Get the SV tube (Vinyl) <math>\phi 7</math>, L=72<math>\pm</math>3 &amp; <math>\phi 7</math>, L=130<math>\pm</math>3 using right hand then insert the Pink wire and Orange wire by using left hand.</p> </div> 	n/a	1. No wrong use of parts 2. No deformed terminal

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	Process Name/Title:		Model code/Part number: <b>D01L / 7M0654-7020A</b>		Customer: <b>TRJ</b>	Car Model: <b>DAIHATSU-TANTO</b>		Document No.: <b>WI-ENG-PDE-155</b>
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		6	Page No.: 6 of 9

<b>PARTS:</b>		1. Connector 4G5400-000 (W)		JIG:	1. Insertion jig
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>		<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
8	Offline Connector Setting to Insertion jig 4G5400-000 (W)	<div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Insert the connector 4G5400-000 (W) into jig using right hand and release the lock. Press the lower wire guide, slot for pink wire will open.</p></div>		n/a	<div><p>1. Use provided jig for model 2. No wrong use of parts 3. No wrong orientation of connector 4. No damaged connector</p></div>

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**OFFLINE ASSEMBLY PROCESS**

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Model code/Part number:

**D01L / 7M0654-7020A**

Customer:

**TRJ**

Car Model:

**DAIHATSU-TANTO**

Document No.:

**WI-ENG-PDE-155**

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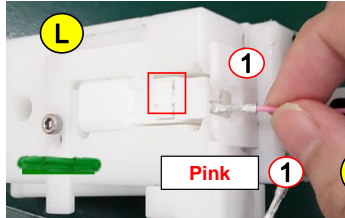
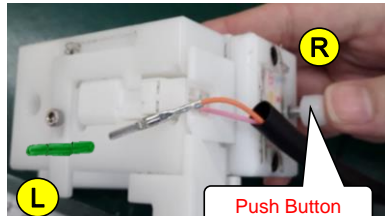
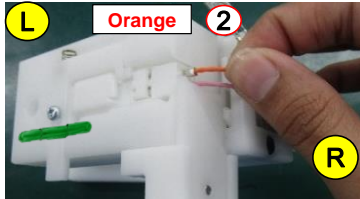
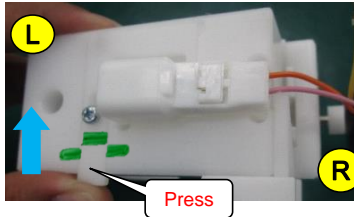
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PARTS:	1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
9	Offline	<div><div><div>Wire facing</div></div><div><div><div>L1Pink1R</div></div><div><div>RPush ButtonL</div></div><div><div>1. Hold the insertion jig using left hand, insert the <b>pink wire</b> from assy parts using right hand.</div></div><div><div><div>LOrange2R</div></div><div><div>LPressR</div></div><div><div>3. Get the <b>Orange</b> wire from assy parts then insert to the open slot using right hand.</div></div><div><div>4. After insertion, Press the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</div></div></div></div><div>n/a</div><div><div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deform terminal 5. No wrong wire facing</div><div><b>Important reminderd/Note/s:</b>  <b>1. Please hold the wire near terminal during insertion</b> <b>2. Insertion of wire must be from left to right.</b> <b>3. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion</b> <b>Do not exert extra force.</b></div><div><b>Document reference/s:</b>  <b>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</b> <b>2. Refer to GL-PRO-ASY-029 for Pull-Push procedure</b></div></div></div>		

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Effectivity Date:

July 12, 2024

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**D01L / 7M0654-7020A**

Customer:

**TRJ**

Car Model:

**DAIHATSU-TANTO**

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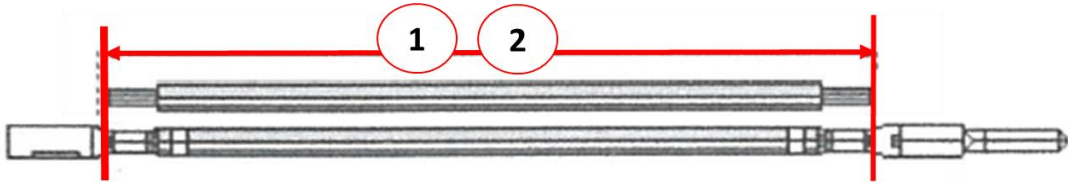

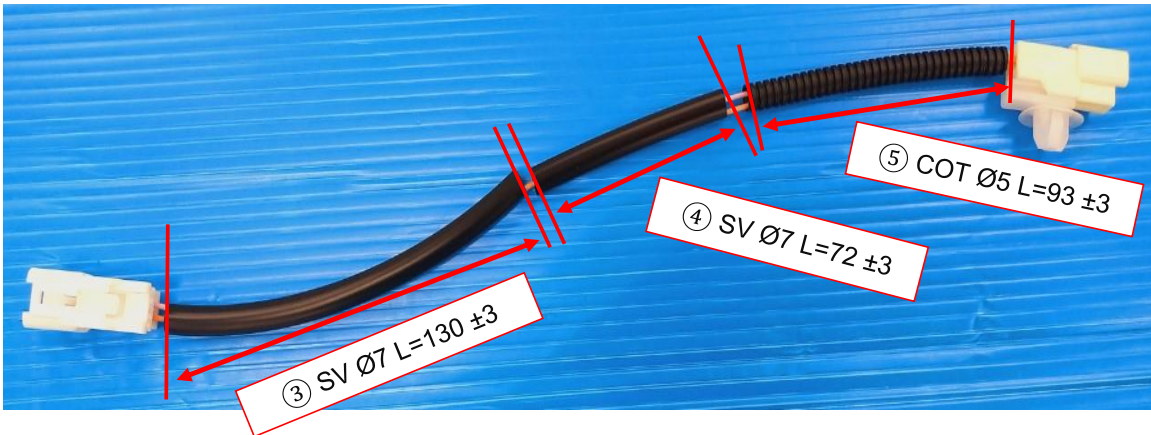
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PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
10	Offline	Measurement		<div><p>Note:</p><p>1. Measurement point: End of core wire to the end of core wire</p><p>2. Terminal is reference only.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

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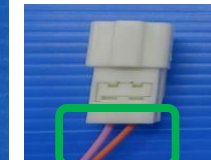
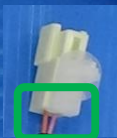
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**PARTS:**

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****OFFLINE INSERTION****7M0654-7020A****1****GOOD****5****GOOD****4****GOOD****2****NO GOOD****NO GOOD****3****NO GOOD****1****No Unlock connector****4****No Terminal Backing Out****2****3****No Wrong insert****5****Check Presence of Clip Clamp**

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