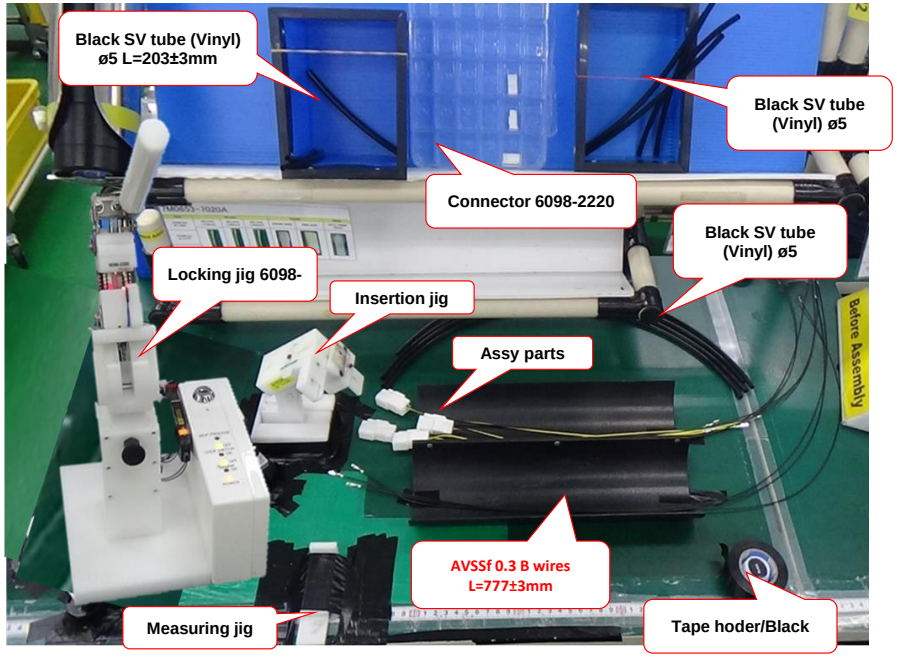
	WORK INSTRUCTION			Effectivity Date:	October 30, 2024		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model code/Part number: D01L / 7M0653-7020A	Customer: TRJ	Car Model: Daihatsu/Tanto	Document No.:	WI-ENG-PDE-133A		
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	6	Page No.:	1 of 8

PARTS:	1. Assy parts; Black SV tube (Vinyl) ø5 L=130±3mm ; Black SV tube (Vinyl) ø5 L=203±3mm; AVSSf 0.3 B wires L=777±3mm; Connector 6098-2220 (W); Black tape; Black SV tube (Vinyl) ø5 L=559±5mm	JIG:	1. Insertion jig 2. Locking jig 3. Measuring jig

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.	***Document reference/s:*** *1. Please refer to **WI-ENG-PDE-132** for **OFFLINE ASSEMBLY PROCESSS.*** *2. 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
10/30/24	6	Upadate new template and inclusion of Car mode 'DAIHATSU/TANTO". Additional Work procedure/Illustration and notes on page 5~6 as countermeasure for the customer claim(Broken lock of Connector 6098-2220 (W).	A.Hernandez	C. Villanueva	A. Arañes	n/a	A.Hernandez	C. Villanueva	A. Arañes	n/a
6/8/23	5	Table lay-out; Inclusion of Quality checkpoints; Standardized tube description: SV tube (Vinyl) (page 1,2 and 7) Inclusion of Locking process of Connector 6098-2220(page 5 and 6). Improve Quality pointers: Reminders/Notes and references(page 1,5,6 and 7)	M. Ariola	J. Loterte	C. Villanueva	A. Arañes				
04/09/21	4	Revise due to standardize the color of connector in accordance with color standardization of plastic parts (Please refer to GL-COM-003 for Color Standardization for Plastic Parts). Apply some improvements.	M. Catapang	C. Villanueva	A. Shimamura	A. Arañes				
10/08/20	3	Changed effectivity and validity date. Revised due to connector lock process from locking jig to sequential manual process.	M. Catapang	R. Peñaloza	A. Shimamura	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 14, 2019		

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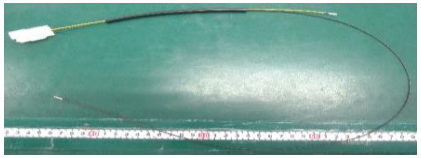
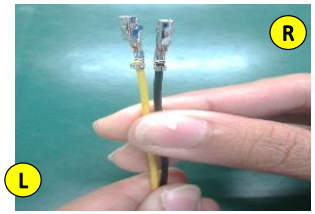
	Model code/Part number: D01L / 7M0653-7020A	Customer: TRJ	Car Model: Daihatsu/Tanto	Document No.:	WI-ENG-PDE-133A	
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	6	Page No.: 2 of 8

PARTS:	1. Assy parts 2. Black SV tube (Vinyl) ø5 L=130±3mm ; Black SV tube (Vinyl) ø5 L=203±3mm 3. AVSSf 0.3 B L=777±3mm	JIG:	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1	Wire insertion to Black SV tube (Vinyl) ø5 L=130±3mm	 1. Get the **SV tube (Vinyl) ø5 L=130±3mm** and insert the **B wire** using left hand. 2. Continue to insert the **Y wire** using left hand. 	n/a	1. No wrong use of parts 2. No deformed terminal
3		Wire insertion to Black SV tube (Vinyl) ø5 L=203±3mm	 1. Hold the assy part using left hand, get the **B wire L=777±3mm** using right hand and then combine to **Y wire** using right hand. 2. Get the **Black SV tube (Vinyl) ø5 L=203±3mm** using right hand then insert the 2 wires using left hand.		

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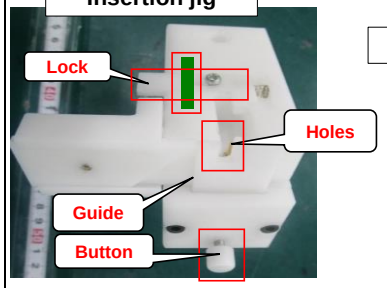
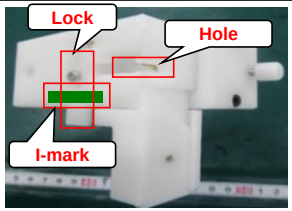
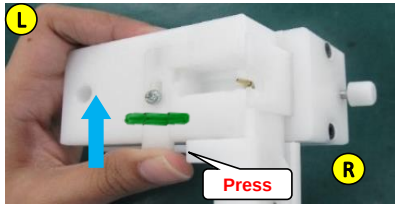
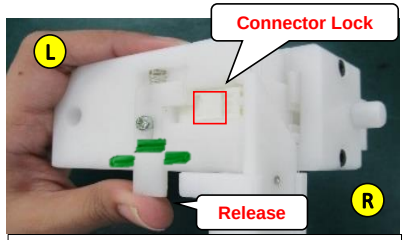
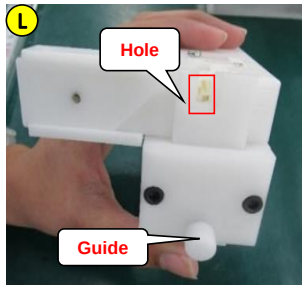
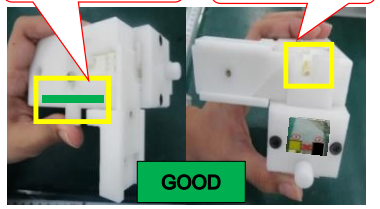
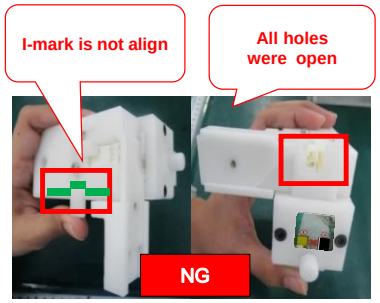
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	6	Page No.: 3 of 8

PARTS:	1. Assy parts 2. Connector 6098-2220 (W)	JIG:	1. Insertion jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1	Connector Setting to Insertion jig 6098-2220 (W)	Insertion jig  Insertion jig orientation  Coupler Orientation  1. Press the lock of insertion jig using left thumb.  2. Insert the connector **6098-2220 (W)** into jig using right hand and release the lock.  3. Push the guide using left hand. Slot for Yellow wire will be open.	n/a	1. Use provided jig for model 2. No wrong use of parts 3. No wrong orientation of connector 4. No damaged connector **Connector Orientation Illustration**  

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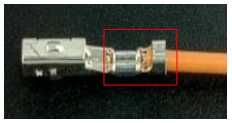
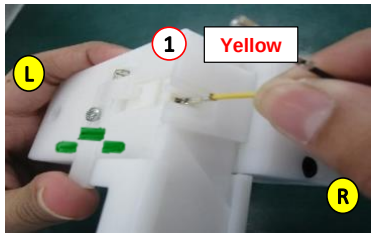
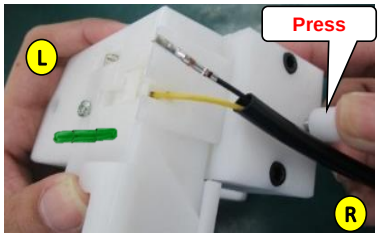
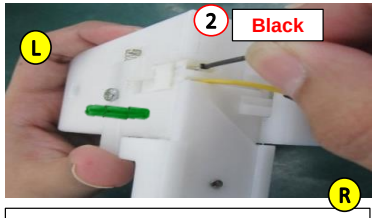
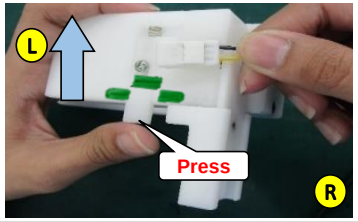
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	6	Page No.: 4 of 8

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

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
5	P1	Wire insertion to connector 6098-2220 (W)	 Wire facing  1. Hold the insertion jig using left hand. Get the assy part, hold the Yellow wire then insert to terminal slot ① using right hand.  2. Push the button after insertion using right hand. Slot for Black wire will be open.  3. Hold the Black wire then insert to terminal slot ② using right hand.  4. After insertion, push the lock using left thumb and then hold the wires and gently pull out the connector from jig using right hand.	n/a	1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing

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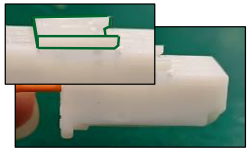
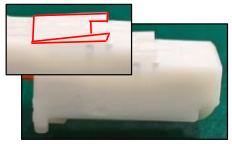
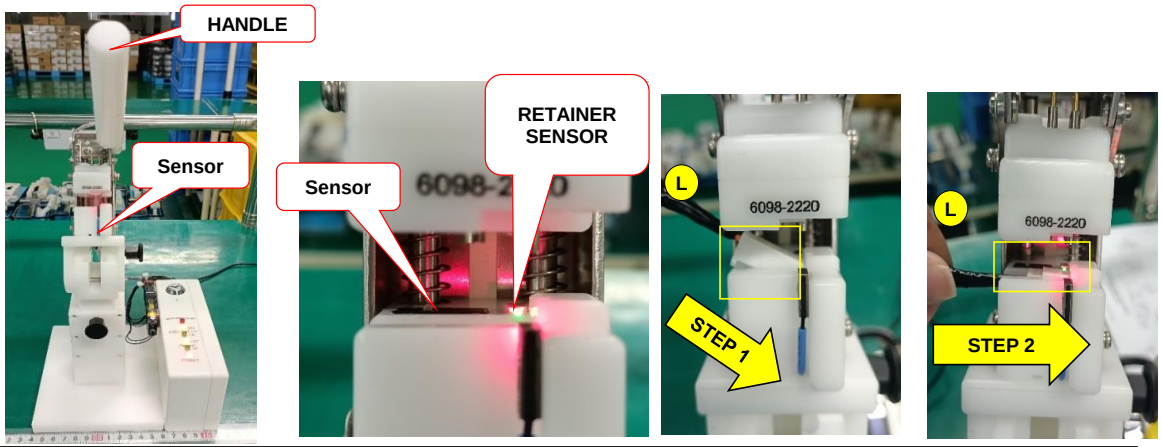
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	6 / Page No.: 5 of 8

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

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION 6	TOOLS/PPE	QUALITY POINTERS 6
6	P1	Connector lock	6 **CONNECTOR RETAINER ILLUSTRATION** **SIDE VIEW**  **GOOD**  **NG** 1.Check the Retainer lock of connector before insertion to locking jig. *Note: Must be **NO** half-locked condition prior connector locking.*  2. Hold the assy parts using left hand and insert into connector locking jig based on the direction of arrow. Make sure the connector touch the sensor. Sound will be heard if properly lock. ***NOTE: CONNECTOR LOCKING JIG WILL NOT FUNCTION IF CONNECTOR NOT REACH THE SENSOR.***		1. Please ensure that Connector lock/retainer will not touch or hit by any object prior insertion into locking jig to avoid half-lock connector. 2. Maintain 10mm proper holding of wire to connector 3.Connector must be fully inserted to connector slot. 4. Make sure no offset setting before locking process. 5.No wrong setting of connector. 6. No damaged connector lock 7. No unlocked/ half-locked connector. 6 ***Important reminders/Note/s:*** *1. Incomplete locking process will alarm the jig.* *2. No retainer in connector cannot proceed.* *3. If encountered abnomality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction and continue the process.*

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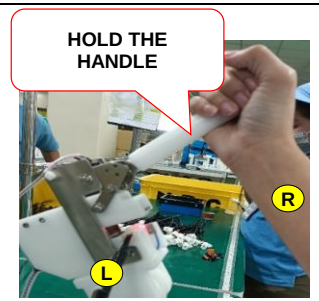
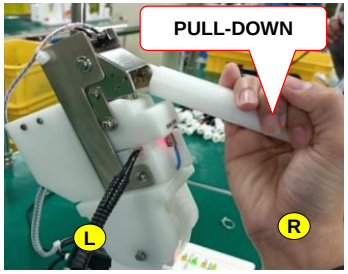
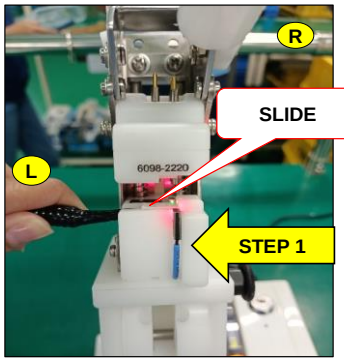
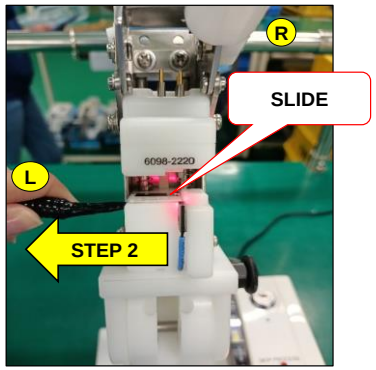
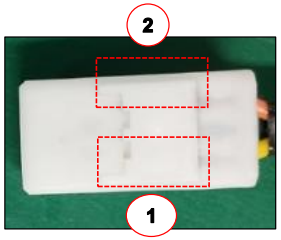
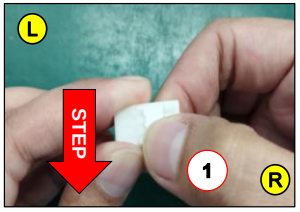
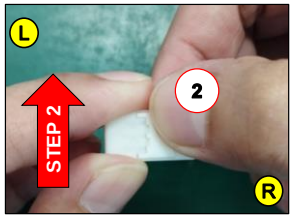
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	6	Page No.:	6 of 8

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

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION 6	TOOLS/PPE	QUALITY POINTERS 6
6	P1	Connnector lock (Continuation)	  3. Hold the handle of the connector locking jig using right hand then gently pull down and bring back to original position after locking. Note: Pull down one time only.		1. Please ensure that Connector lock/retainer will not touch or hit by any object prior insertion into locking jig to avoid half-lock connector. 2. Maintain 10mm proper holding of wire to connector 3.Connector must be fully inserted to connector slot. 4. Make sure no offset setting before locking process. 5.No wrong setting of connector. 6. No damaged connector lock 7. No unlocked/ half-locked connector
		6	  4. Remove the locked connector using left hand based on the illustration, follow the direction of arrow.		6 ***Important reminders/Note/s:*** *1. Incomplete locking process will alarm the jig.* *2. No retainer in connector cannot proceed.* *3. If encountered abnomality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction and continue the process.*
			   5. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.		

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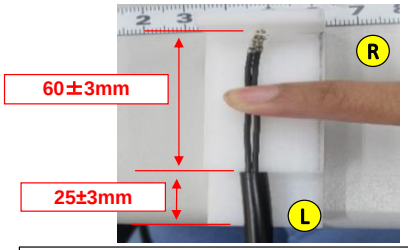
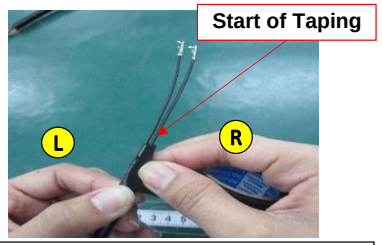
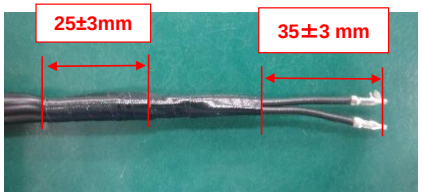
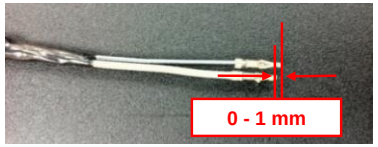
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	6	Page No.: 7 of 8

PARTS:	1. Black SV tube (Vinyl) ø5 L=559±5mm 2. Black tape	JIG:	1. Measuring jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
7	P1	Wire insertion to Black SV tube (Vinyl) ø5 L=559±5mm	 1. Get the **Black SV tube (Vinyl) ø5 L=559±5mm** using right hand then insert the **B/B wires** using left hand. 	n/a	1. No wrong use of parts 2. No deformed terminal
8		Taping 1 Black SV tube (Vinyl) to wire near terminal	 1. Get the assy part and measure the end of the SV tube (Vinyl) up to the terminal tip **60mm.** Then, measure **25mm** from the end of vinyl tube using measuring jig.  2. Hold the SV tube (Vinyl) using left hand and get the **Black tape** then start taping using right hand.  3. After taping, check the condition of tape, measurement and wire alignment.	**MEASURING JIG** **MEASURING TAPE** 	1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No wrong use of tape 5. No wrong dimension **Wire alignment tolerance**  ***Important reminders/note/s:*** *1.Please use calibrated/verified measuring tape when getting the measurement.* ***Document reference/s:*** *1. Refer to **WI-PRO-ASY-001** for taping procedure.*

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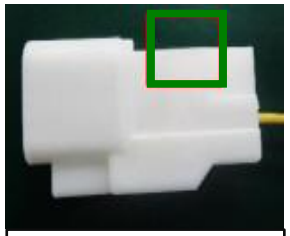
PARTS:	1. Assy parts	JIG:	n/a

QUALITY CHECKPOINTS

P1 7M0653-7020A



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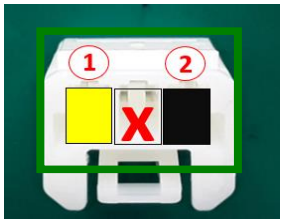

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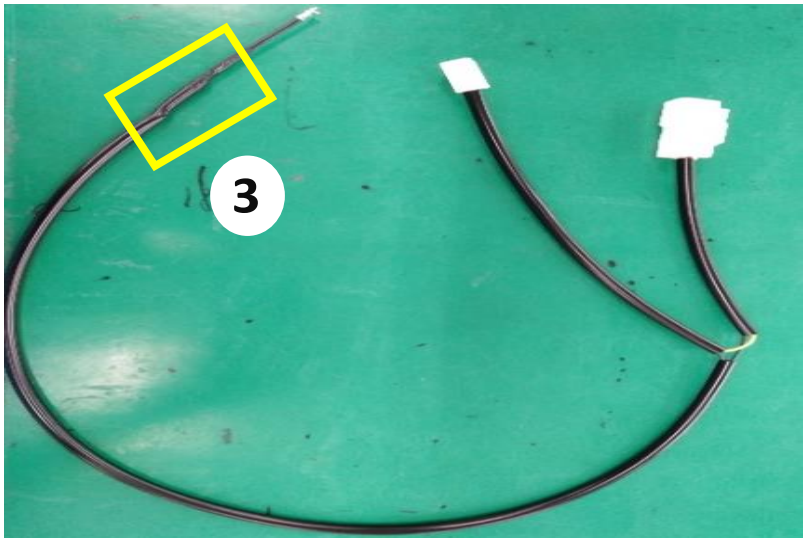
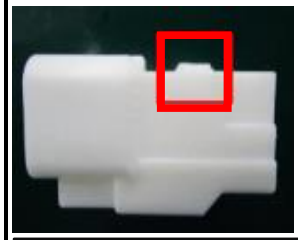


GOOD

GOOD



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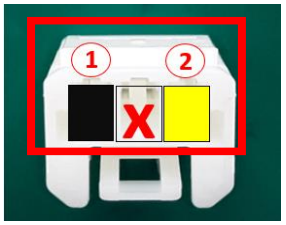

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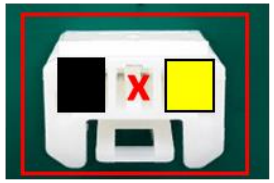

NO GOOD

NO GOOD

1 No Unlock/ Halflocked Connector (2 connector)

2 No Wrong Insert

3 No Missing Tape

4 No Terminal Backing Out

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