



WORK INSTRUCTION

Effectivity Date:

June 28, 2023

Process Name/Title:

TAPING ASSEMBLY PROCESS

Validity Date:

-

Model code/Part number:

D94L / 7N0028-7020A

Customer:

TRJ

Car Model:

DAIHATSU-CAST

Document No.:

WI-ENG-PDE-055A

Purpose:

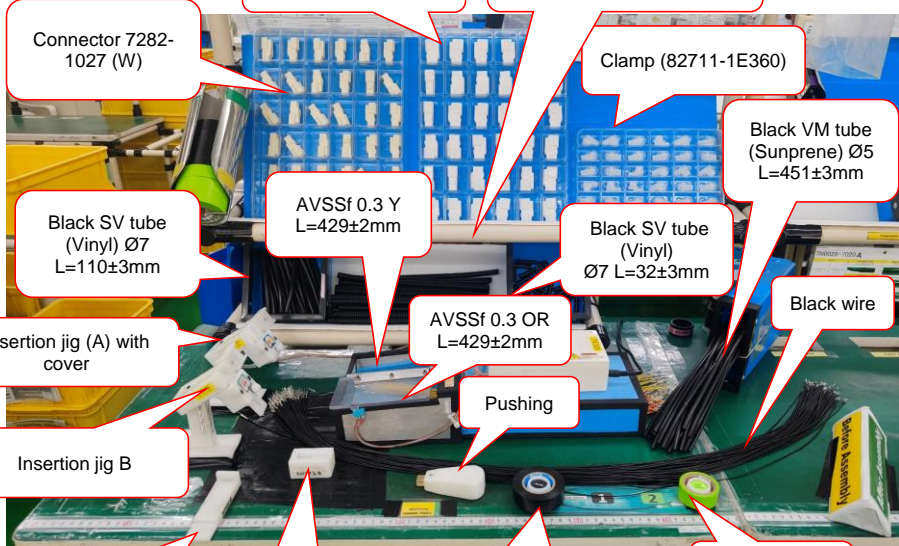
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PARTS:		1. Connector 7282-1027 (W); 4G5400-0000 (W) 2. AVSSf 0.3 OR L=429±2mm; Y L=429±2mm 3. Black SV tube (Vinyl) Ø7 L=32±3mm; Ø7 L=110±3mm				4. Black VM tube (Sunprene) Ø5 L=451±3mm 5. Black Corrugated tube (no slit) Ø7 L=245±3mm 6. Clamp 82711-1E360 (W)				JIG:		1. Insertion jig with and w/o switch cover 2. Locking jig 3. Pushing jig 4. Measuring jig					
NO.		PROCESS NAME		4 WORK PROCEDURE/ ILLUSTRATION						TOOLS/PPE		QUALITY POINTERS					
1		P1		Table Lay-out		<div><div>TABLE LAY-OUT</div></div>						<div><div>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</div><div>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</div><div>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</div></div>		<div><div>4 Document reference/s: 1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</div><div>1. No missing parts/tools 2. No excess parts/tools</div></div>			
Revision History																	
06/28/23		4		Inclusion of table lay-out and quality checkpoints; improve by two's inspection, work procedure/illustration and important reminder/s and document references. Update template, inclusion of car model; Standardize term of SV tube (Vinyl) and VM tube (Sunprene); Update template, inclusion of Car model.						J. Loterte		C. Villanueva		A.Arañes		n/a	
02/03/21		3		Change connector color in accordance with color standardization for plastic parts. Change from 2x pulling to Pull-Push-Pull-Push insertion quality pointers. Change locking method from using locking jig to pushing jig. Conduct semi-annual review. Remove cycle time.						D. Castillo		R. Peñaloza		A. Shimamura		A.Arañes	
06/17/20		2		Extend Validity date.						D. Castillo		J. Loterte		A. Shimamura		A.Arañes	
02/22/20		1		Change part number due to change vinyl tube to sunprene tube.						D. Castillo		J. Loterte		A. Shimamura		A.Arañes	
Eff. Date		Rev. No		Details of Change						Revised		Reviewed		Approved		Noted	
										J. Loterte		C. Villanueva		A.Arañes		n/a	

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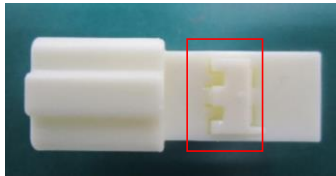
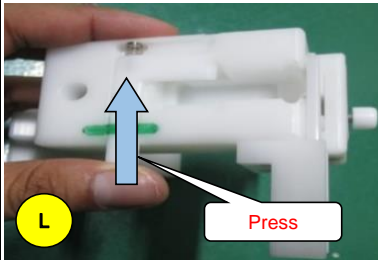
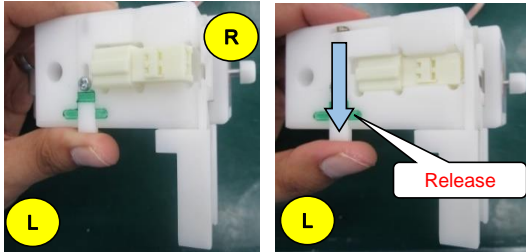
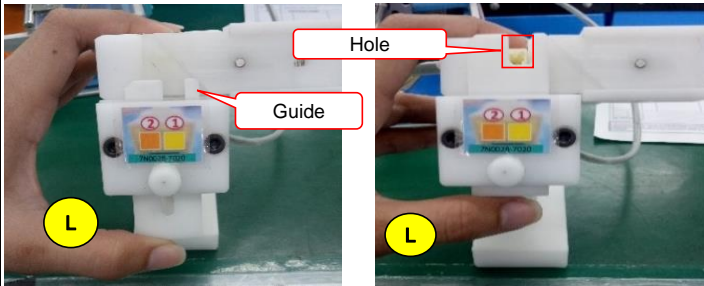

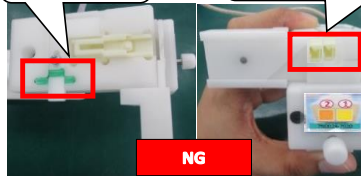
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PARTS:	1. Connector 7282-1027 (W)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P1 Connector setting to insertion jig 7282-1027(W)	<div><div><div><div>Switch Cover</div><div>Y wire</div><div>OR wire</div><div>Insertion jig</div><div>I-mark</div><div>Lock</div><div>Holes</div><div>Visual reference</div><div>Button</div></div><div><div>CONNECTOR ORIENTATION</div></div></div><div><div><p>1. Press the lock of insertion jig using left thumb.</p></div><div><div><p>2. Insert the connector (7282-1027) into jig using right hand and release the lock.</p></div><div><div><p>3. Push the guide using left hand. The slot for Yellow wire will be opened.</p></div></div></div></div></div>	n/a	<div><div><div><div>Connector Orientation Illustration</div><div>I-mark is align</div><div>1 hole is only open</div><div></div><div>GOOD</div></div><div><div>I-mark is not align</div><div>All holes are open</div><div></div><div>NG</div></div></div><div><p>1. Use the provided jig tool per model 2. No wrong orientation of connector</p></div></div>

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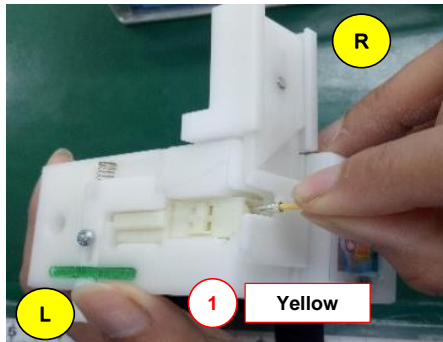
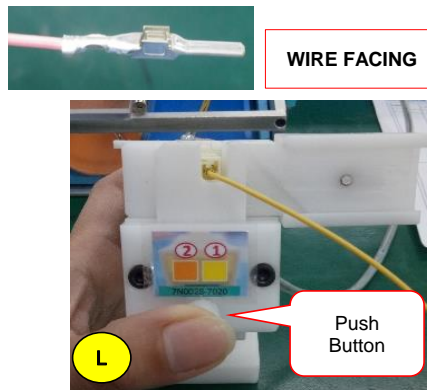
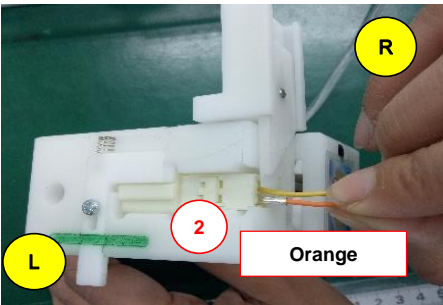
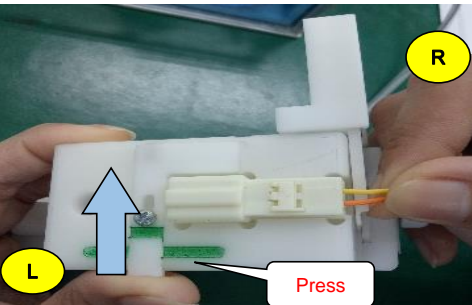
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PARTS:		1. AVSSf 0.3 OR L=429±2mm; Y L=429±2mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	4 WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to Connector 7282-1027 (W)	<div><p>1. Get Yellow wire then insert to terminal slot 1 using right hand.</p></div> <div><p>2. After insertion of Yellow wire press the button using left hand. The slot for Orange wire will be opened.</p></div> <div><p>3. Get Orange wire then insert to terminal slot 2 using right hand.</p></div> <div><p>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.</p></div>		n/a	<div>Important reminders and Note/s; 4 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div>

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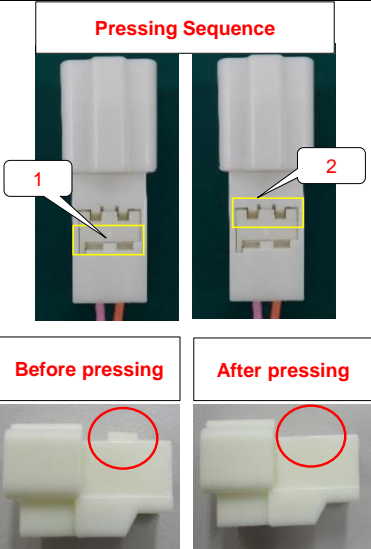
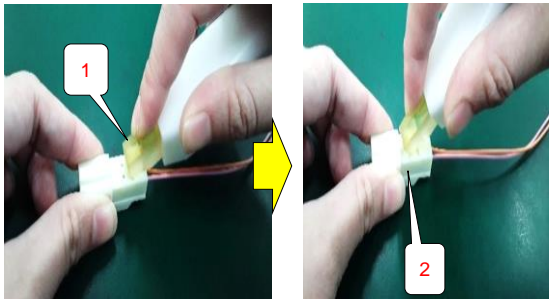


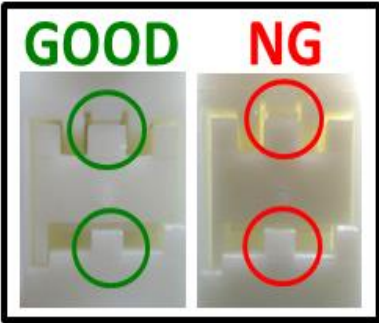


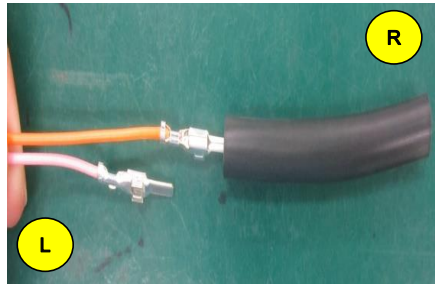
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PARTS:  1. Assy parts 2. Black SV tube (Vinyl) Ø7 L=110±3mm		JIG:		1. Pushing jig
NO.	PROCESS NAME	 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P1 Connector Lock	<div><p>1. Place the connector on the table while holding using left hand. 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 Position of pushing jig during locking must be slant.</p></div>	 	1. No unlocked/half-locked connector Important reminders and Note/s; 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR 
5	 Wire insertion to Black SV tube (Vinyl) Ø7 L=110±3mm	<div><p>1. Get the Black SV tube (Vinyl) Ø7 L=110±3mm using right hand then insert the Y and OR wire.</p></div>		1. No wrong use of parts

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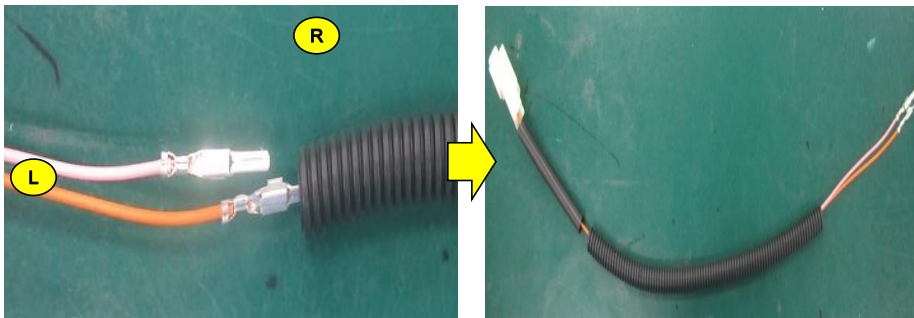
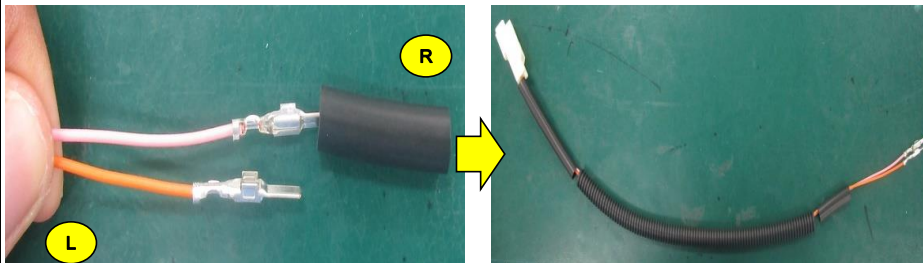
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PARTS:		1. Assy parts	3. Black Corrugated tube (no slit) Ø7 L=245±3mm	JIG:	n/a
		2. Black SV tube (Vinyl) Ø7 L=32±3mm			
NO.		PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
6	P1	Wire insertion to Black Corrugated tube (no slit) Ø7 L=245±3mm	 <div>1. Get the Black Corrugated tube ø7 L=245±3mm using right hand then insert the Y and OR wire.</div>	n/a	1. No wrong usage of parts
7		Wire insertion to Black SV tube (Vinyl) Ø7 L=32±3mm	 <div>1. Get the Black SV tube (Vinyl) Ø7 L=32±3mm using right hand then insert the Y and OR wire.</div>	n/a	1. No wrong usage of parts

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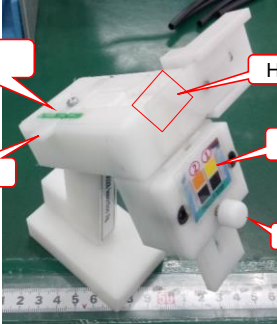
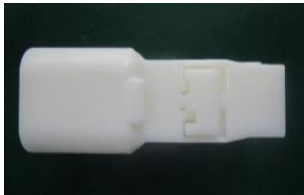
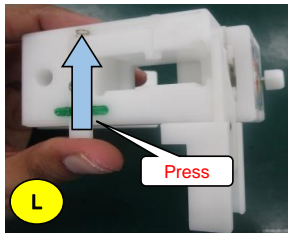
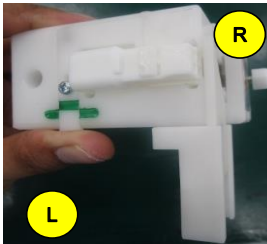
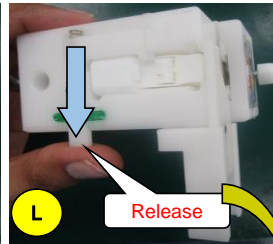
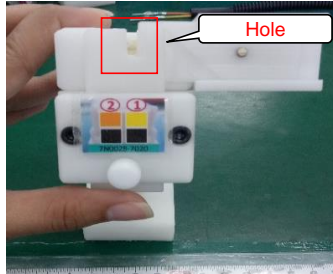
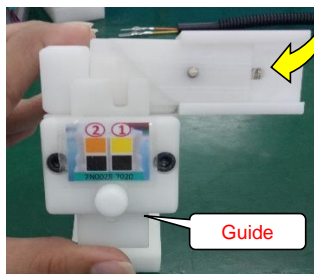

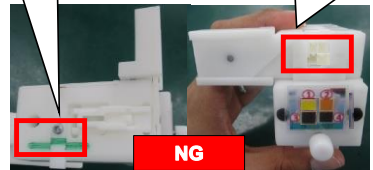

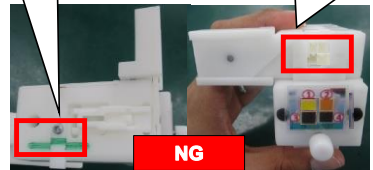
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PARTS:		1. Assy parts 2. Connector 4G5400-0000 (W)		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
8	P1 Connector setting to insertion jig 4G5400-0000 (W)	<div><div>INSERTION JIG</div><div></div><div>CONNECTOR ORIENTATION</div><div></div><div></div><div>1. Press the lock of insertion jig using left thumb.</div><div></div><div>2. Insert the connector (4G5400-0000) into jig using right hand and release the lock.</div><div></div><div></div><div>3. Push the guide using left hand. The slot for Yellow wire will be opened.</div><div></div></div> <div>n/a</div> <td><div>Connector Orientation Illustration</div><div><p>I-mark is align</p><p>1 hole is open</p><p>GOOD</p></div><div><p>I-mark is not align</p><p>All holes are open</p><p>NG</p></div><div>1. Use the provided jig tool per model 2. No wrong orientation of connector</div></td>		<div>Connector Orientation Illustration</div> <div><p>I-mark is align</p><p>1 hole is open</p><p>GOOD</p></div> <div><p>I-mark is not align</p><p>All holes are open</p><p>NG</p></div> <div>1. Use the provided jig tool per model 2. No wrong orientation of connector</div>	

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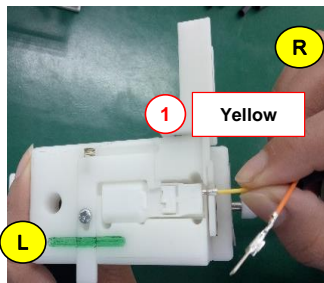
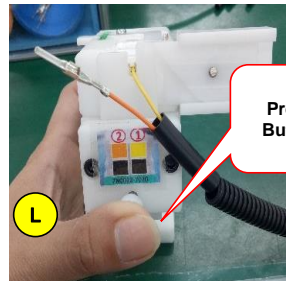
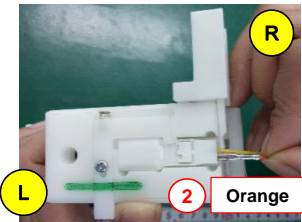
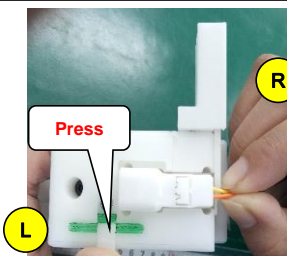
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


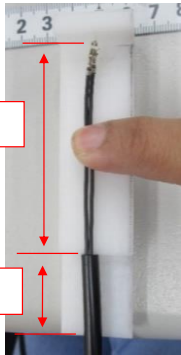
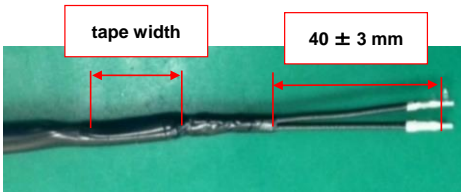
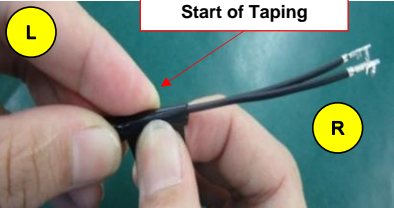
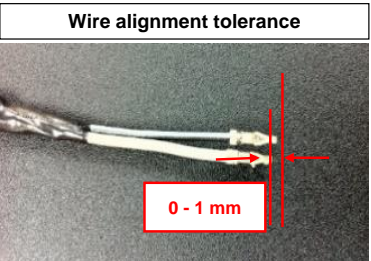



PARTS:		1. AVSSf 0.3 wires B L=931mm [2pcs] 2. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1 Wire insertion to connector 4G5400-0000(W)	<div><div>WIRE FACING</div></div> <div><div>1 Yellow</div><div>L</div><div>R</div></div> <div>1. Hold the insertion jig using left hand, get the Yellow wire then insert to connector slot 1 using right hand.</div> <div><div>Press Button</div><div>L</div></div> <div>2. Press the Button using Left thumb to open the next slot.</div> <div><div>2 Orange</div><div>L</div><div>R</div></div> <div>3. Get the Orange wire then insert to connector slot 2 using right hand.</div> <div><div>Press</div><div>L</div><div>R</div></div> <div>4. After insertion, Press the lock button using left thumb and then hold the wires and gently pull out the connector from jig using right hand.</div>		n/a	<div>⚠</div> <div>Important reminders and Note/s; 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</div> <div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div>


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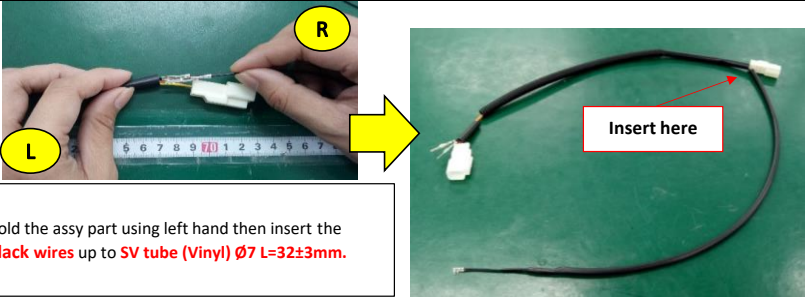
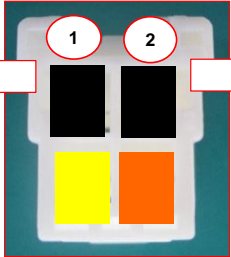

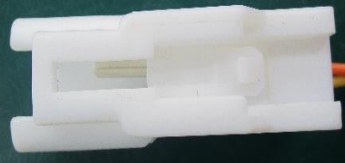
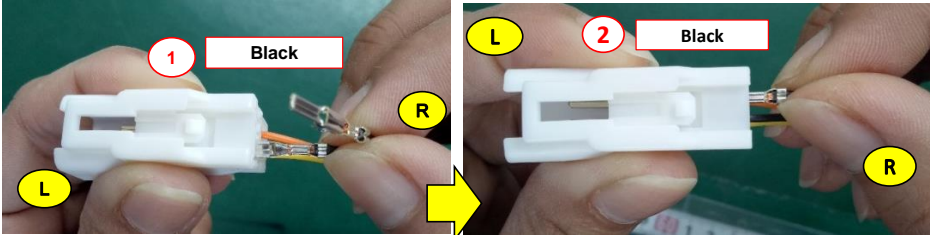

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PARTS:  1. Assy parts 2. Black VM tube (Sunprene) Ø5 L=451±3mm 3. Black tape		JIG:	1. Measuring jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
10	 Wire insertion to Black VM tube (Sunprene) Ø5 L=451±3mm	 <div>  1. Get the 2 Black wires using left hand and get the VM tube (Sunprene) ø5 L=451±3mm then insert to wire using right hand. </div>	n/a	1. No wrong usage of parts
11	P1 Taping 1 Sunprene tube to wire near terminal	<div>  <div> 1. Get the assy part and measure the end of the sunprene tube up to the terminal tip 65mm. Then, measure 25mm from the end of sunprene tube using measuring jig. </div> </div> <div>  <div> 3. After taping, check the condition of tape, measurement and wire alignment. </div> </div> <div>  <div> 2. Hold the sunprene tube using left hand and get the Black tape then start taping using right hand. </div> </div> <div>  </div>	<div> MEASURING TAPE  </div> <div> MEASURING JIG  </div>	 Important reminders and Note/s; 1. Please use calibrated/verified measuring tape when getting the measurement. Document references; 1. Refer to WI-PRO-ASY-001 for taping procedure. 1.No flip out tape 2.No tape peeling 3. No loose tape 4. No wrong use of tape

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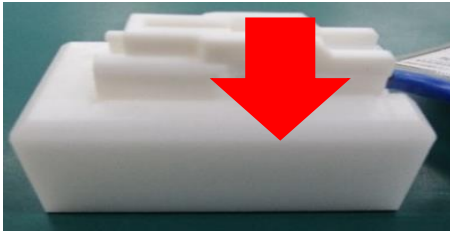

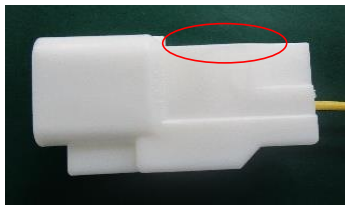


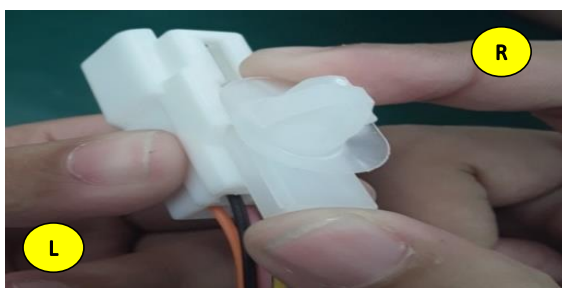
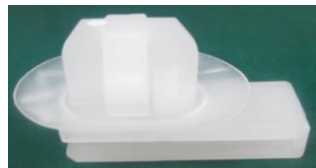
	WORK INSTRUCTION				Effectivity Date:	June 28, 2023		
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:	-		
	Model code/Part number: D94L / 7N0028-7020A		Customer: TRJ	Car Model: DAIHATSU-CAST	Document No.:	WI-ENG-PDE-055A		
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO				Revision No.:	4	Page No.:	9 of 12



PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
12	Wire insertion to assy part	 <p>Hold the assy part using left hand then insert the Black wires up to SV tube (Vinyl) Ø7 L=32±3mm.</p>	n/a	1. No wrong location 2. No deform terminal	
13	Wire insertion to connector 4G5400-0000 (W)	<div> <div> CONNECTOR SETTING  </div> <div> WIRE FACING  </div> <div> CONNECTOR ORIENTATION  </div> </div> <div>  <p>1. Get the first black wire and insert to connector slot 1 using right hand.</p> <p>2. Get the 2nd black wire and insert to connector slot 2 using right hand.</p> </div>	<div>  Important reminders and Note/s; 1. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force. </div> <div> 1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing </div>		

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	Purpose:		<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH		<input checked="" type="checkbox"/> MASSPRO		Revision No.:	4	Page No.:

PARTS:		1. Assy parts 2. Clamp 82711-1E260 (W)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
14	P1 Connector lock	<div>  <div> 1. Put the connector into locking jig using right hand then press 2x to lock. Check the connector lock to confirm if properly pressed. </div> </div> <div>  <div>BEFORE PRESSING</div> </div> <div>  <div>AFTER PRESSING</div> </div>		<div>  </div> <div>LOCKING JIG</div>	<div>  Important reminders and Note/s; 1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR </div> <div>1. No unlocked/half-locked connector</div>
15	Clamp attachment	<div>  <div>CLAMP ORIENTATION</div> </div> <div>  </div> <div> 1. Hold the connector (7282-1027) using left hand and insert the Clamp (82711-1E360) using right hand. <i>Note: Click sound will be heard if totally inserted.</i> </div>		n/a	1. No loose attachment 2. No wrong usage of parts 3. No missing clamp

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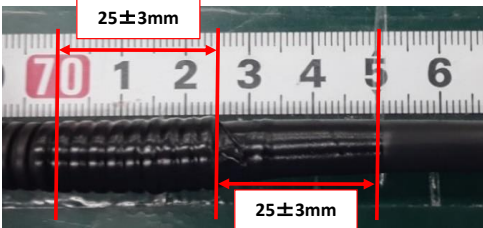


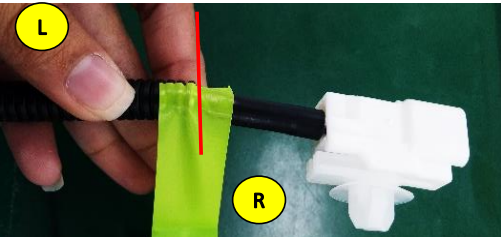
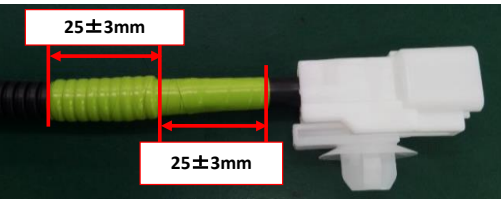


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PARTS:		1. Black tape 2. Light green tape		3. Assy parts		JIG:	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS
16	P1	Taping 2 COT to vinyl tube	<div></div> <div></div> <div>1. Fix the corrugated tube to vinyl tube using left hand then get Black tape and start taping using right hand.</div> <div>2. After taping, check the tape condition & measurement.</div>			<div></div> <div>MEASURING TAPE</div>	<div></div> <div>MEASURING TAPE</div> <div>Important reminders and Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement. 2. Must be no gap between COT and vinyl Document references: 1. Refer to WI-PRO-ASY-001 for taping procedure</div> <div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</div>
17	P1	Taping 3 COT to vinyl near connector	<div></div> <div></div> <div>1. Fix the corrugated tube to vinyl tube using left hand then get Light Green tape and start taping using right hand.</div> <div>2. After taping, check the tape condition & measurement.</div>			<div></div> <div>MEASURING TAPE</div>	<div></div> <div>MEASURING TAPE</div> <div>Important reminders and Note/s: 1. Must be no gap between COT and vinyl. 2. Please use calibrated/verified measuring tape when getting the measurement. Document references: 1. Refer to WI-PRO-ASY-001 for taping procedure</div> <div>1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong dimension 6. No wrong use of tape</div>

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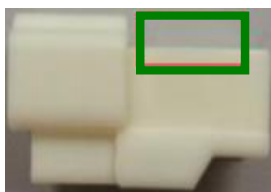
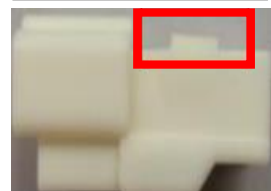
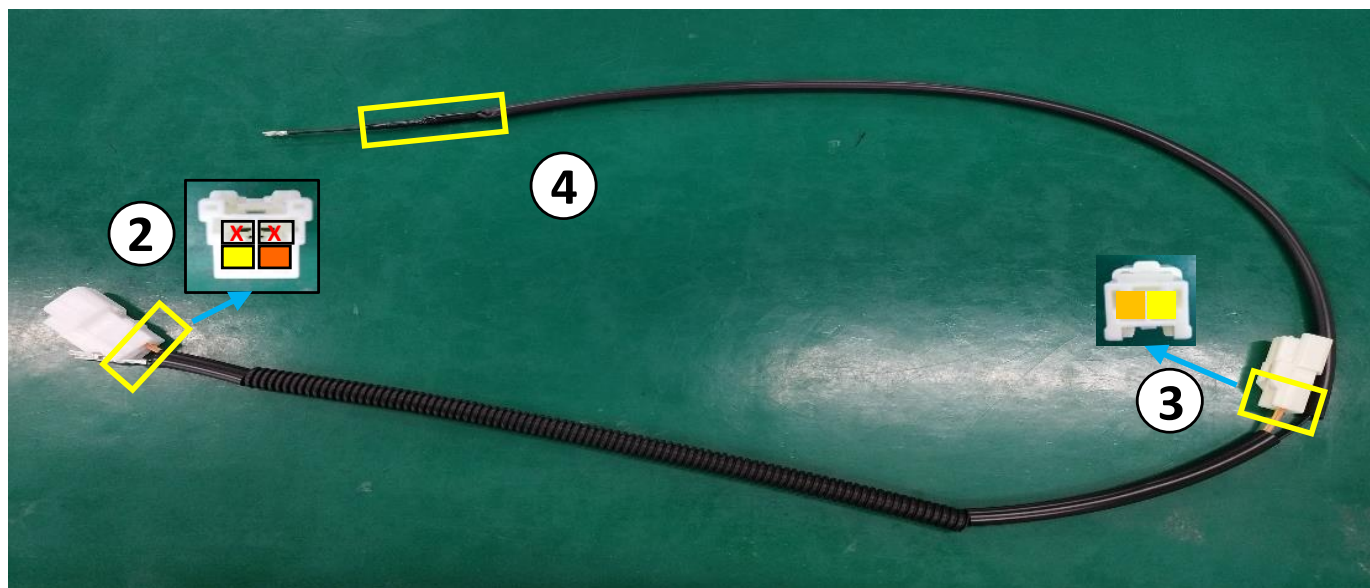
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PARTS:

n/a

JIG:

n/a

**QUALITY CHECKPOINTS****P1****7N0028-7020A****GOOD****NO GOOD****5****GOOD****NO GOOD****1** No **Unlock/ Half Lock Connector****4** No **Missing Tape****2** **3** No **Wrong Insert****5** No **Terminal Backing Out**

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