Process Name/Title:  TAPING ASSEMBLY PROCESS  Model code/Part number:  D01L / 7M0654-7020A  Customer: TRJ  Car Model:  DAIHATSU-TANTO  Document No:  WENG  Purpose:  PROTOTYPE  PROTOTYPE  PROTOTYPE  PROTOTYPE  PROTOTYPE  PROCESS NAME  PROCESS NAME  NO.  PROCESS NAME  PROCESS NAME  PROCESS NAME  PROCESS NAME  PROCESS NAME  Process Name/India  No.  Process Name/India  Process Name/India  No.  Process Name/India  Process Name/India  No.  Process Name/India  India  No.  Process Name/India  India  No.  Process Name/India  India  No.  Process Name/India  India  India  No.  Process Name/India  India	098-2220 OINTERS  PRO-CNC-017 for h tolerance ENG-PDE-155 for
PARTS: 1. Assy parts; AVSSI 0.3 wire Y L=373±2mm; AVSSI 0.3 wire B L=831±3mm; Black SV tube (Vinyl) e5 L=203±3mm; JG: 1. Insertion jig 2. Locking jig Connector 6098-2220 (W); Black SV tube (Vinyl) e5 L=497±3mm; Black tape  NO. PROCESS NAME    Part   Table lay-out   Process	1 of 11  1098-2220  OINTERS  PRO-CNC-017 for th tolerance  ENG-PDE-155 for
PARTS:  1. Assy parts: AVSSI 0.3 wire Y L=37342mm; AVSSI 0.3 wire B L=831±3mm; Black SV tube (Vinyl) ø5 L=203±3mm;  Connector 6098-2220 (W); Black SV tube (Vinyl) ø5 L=487±3mm; Black tape  1. Insertion jig 2. Locking jig-Connector 6098-2220 (W) 2. Locking jig-Connector 6098-2220 (W) 3. Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)  P1 Table lay-out  1. Insertion jig 2. Locking jig-Connector 6098-2220 (W) 3. Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)  P2 (Vinyl) ø5 (2. Personal things on the workplace is prohibited. Keep it in your locker.)  P3 (Vinyl) ø5 (2. Personal things on the workplace is prohibited. Keep it in your locker.)  1. No mising parts/toc 2. No excess parts/tol 3. No excess	operation of the control of the cont
NO. PROCESS NAME  WORK PROCEDURE/ ILLUSTRATION  TABLE LAY-OUT  TABLE LAY-OUT  Black SV tube (Vinyl) e5 (Vinyl)	erence/s: PRO-CNC-017 for th tolerance ENG-PDE-155 for
NO. PROCESS NAME  WORK PROCEDURE/ ILLUSTRATION  TABLE LAY-OUT  TABLE LAY-OUT  Black SV tube (Vinyl) e5 (Vinyl)	erence/s: PRO-CNC-017 for th tolerance ENG-PDE-155 for
TABLE LAY-OUT  Black SV tube (Vinyl) ø5 L=203±3mm  Connector 6098- 2220 (W) Connector box  Connector 6098- 2220 (W) Connector 6098- 2220 (W)  Locking jig- Connector 6098- 2220 (W)  Assy parts  Locking jig- Connector 6098- 2220 (W)  Assy parts  AVSSf 0.3 wire B L=777±3mm  Insertion jig  AVSSf 0.3 wire y L=373±2mm  AVSSf 0.3 wire y L=373±	erence/s: PRO-CNC-017 for h tolerance ENG-PDE-155 for
Black SV tube (Vinyl) ø5 (L=203±3mm)  Assy parts  Avssf 0.3 wire B L=777±3mm  Insertion jig A Vssf 0.3 wire B L=487±3mm  Avssf 0.3 wire B L=777±3mm  Insertion jig A Vssf 0.3 wire B L=773±2mm  Avssf 0.3 wire B L=777±3mm  Avssf	PRO-CNC-017 for h tolerance ENG-PDE-155 for
Assy parts  Avssf 0.3 wire B L=777±3mm  Insertion jig  Avssf 0.3 wire Y L=373±2mm  Locking jig-Connector 6098-2220 (W)  Avssf 0.3 wire B L=777±3mm  Avssf 0.3 wire Y L=373±2mm  Avssf 0.3 wire Y L=373±2mm  Avssf 0.3 wire Y L=373±2mm	
wire Y L=373±2mm	icess
Insertion jig  AVSSf 0.3 wire B L=831±3mm  AVSSf 0.3 wire B Locking jig  AVSSf 0.3 wire B L=831±3mm  AVSSf 0.3 wir	
Revision History Prepared by Reviewed by Approved	Noted by
Transfer Taping 1 to P2 (WI-ENG-PDE-156B) due to process improvement. Additional Work procedure/Illustration and notes on page 8-9 as countermeasure for the customer claim (Broken lock of connector 6098-2220 (W)). Inclusion of car model "DAIHATSU-TANTO". Update Table lay-out and Visual inspection/Quality checkpoints.  Transfer Taping 1 to P2 (WI-ENG-PDE-156B) due to process improvement. Additional Work procedure/Illustration and notes on page 8-9 as countermeasure for the customer claim (Broken lock of connector 6098-2220 (W)). Inclusion of car model "DAIHATSU-TANTO". Update Table lay-out and Visual inspection/Quality checkpoints.	
Changed Table lay-out. Improve Quality pointers on pages no.1,3,4,7,8,9 and 10 as documents improvements. Improved Work Procedure/Illustration on process no.5 (Connector lock); process no.10 Inclusion of Locking process Connector 6098-2220 (W); Inclusion of Quality Checkpoints on last process; Standardized tube description: SV tube (Vinyl).	
04/27/21 3 Change connector and clamp colors in accordance with color standardization for plastic parts refer to GL-COM-003. Put assy parts on pg. 4, 6, 9 and 10 parts section  C. A. Shimamura  A. Arañes  D. Castillo  C. Villanueva  D. Castillo	
Eff. Date Rev. No Details of Change Revised Revised Approved Noted Est. Date: September 14, 2019	n/a

			WORK INS	TRUCTION		Effectivity Date:	July 12, 2024
		Process Name/Title:	TAPIN	IG ASSEMBLY PROCE	ESS	Validity Date:	n/a
		Model code/Part number:	D01L / 7M0654-7020A	Customer: TRJ	Car Model: <b>DAIHATSU-TANTO</b>	Document No.:	WI-ENG-PDE-156A
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	5 Page No.: 2 of 11
PARTS: 1	1. Assy բ	parts ROCESS NAME	WORK F	PROCEDURE/ ILLUSTRA	ITION	JIG: TOOLS/PPE	Insertion jig     QUALITY POINTERS
NO	P1	Connector setting to insertion jig 4G5400-000 (W)	Insertion jig  Lock  Guide  Holes  Press  1. Press the lock of insertion jig using left thumb.	Insertion jig orientat  2. Insert the connector 4G5 hand and release the lock.	Connector Orientation	n/a	CONNECTOR ORIENTATION ILLUSTRATION  I-mark is align  I-mark is open  I-mark is not align  I-mark is not align  I-mark is open  I-mark is open



			WORK INS	TRUCTION				Effectivity Date:		July 12, 2024	ŀ
		Process Name/Title:	TAPIN	G ASSEMB	LY PROC	ESS		Validity Date:		n/a	
		Model code/Part number:	D01L / 7M0654-7020A	Customer:	TRJ	Car Model:	DAIHATSU-TANTO	Document No.:		WI-ENG-PDE-1	56A
		Purpose:	PROTOTYPE	PRE-LAUNCH	1	MASSPE	RO	Revision No.:	5	Page No.:	3 of 11
PARTS:	1. AVSS 2. Assy	Sf 0.3 wire Y L=373±2mm; B L parts	=777±3mm					JIG:	1. Insertion	ı jig	
NO.	F	PROCESS NAME	WORK I	PROCEDURE/	ILLUSTR	ATION		TOOLS/PPE	(	QUALITY POIN	TERS
3	Wire Insertion to assy parts and wire insertion to connector 4G5400-0000 (W) [1] (Yellow wire)  1. Get the Yellow wire L=373±2mm using right hand then insert to SV tube (Vinyl) Ø7, L=130±3mm.  SV tube (Vinyl) Ø7, L=72±3mm  2. Hold the insertion jig using left hand. Insert the yellow wire using right hand. Press the button after insertion, slot for black wire will open.						using left hand. Insert ght hand.	3. One by one insertion 4. No deform terminal 5. No wrong wire facing  but hand.  Document reference			ar terminal  pperly sh-Pull-Push  :: 117 for Wire
4	P1	Wire Insertion to assy parts and wire insertion to 4G5400-0000 (W) [2] (Black wire)	SV tube (Vinyl) ø7, L=72±3mm  1. Get the Black wire L=777±3mm us right hand then insert to SV tube (Vin L=72±3mm up to ø7, L=130±3mm.	3. After inse hold the wir using right I	Insert the ertion, Presses and gent	e Black wire	Wire facing  Black  R  g using left hand. using right hand.  g left thumb and then connector from jig	n/a	1. Pleas during it 3. Make inserted after ins Do not 6.  1. No loos 2. No wror 3. One by 4. No defo 5. No wror Docume 1. Refer and Strip	exert extra force.  the insertion one insertion orm terminal ong wire facing  ent reference/s to WI-PRO-CNC-Co to Length Tolerance of GL-PRO-ASY-O	ear terminal roperly ush-Pull-Push ::

			WORK INC.	FRUCTION		Effectivity Date:		ll. 40, 0004	
		Process Name/Title:	WORK INST	S ASSEMBLY PRO	CESS	Validity Date:		July 12, 2024 n/a	,
	7	Model code/Part number:	D01L / 7M0654-7020A	Customer: TRJ	Car Model: <b>DAIHATSU-TANTO</b>	Document No.:		WI-ENG-PDE-1	56A
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	5	Page No.:	4 of 11
	1					1			
PARTS:	1. Assy	Parts				JIG:			
NO.	F	PROCESS NAME	WORK P	ROCEDURE/ ILLUSTR	RATION	TOOLS/PPE	(	QUALITY POIN	TERS
5	P1	Connector Lock	1. Put the connector into locking jgig using both hands then press 2x using both hands.  2. Ensure that the connect connector lock based on the lock in the lock i	BEFORE PRESS  or is in locked condition by the sequence illustrated.	2 R	LOCKING JIG	1. Manudamage	tant reminders, ual locking may c ed connector lock vided jig per mode ock/Half-locked	rause k



			WORK INS				Effectivity Date:		July 12, 2024	
		Process Name/Title:		G ASSEMBLY PROC			Validity Date:		n/a	
		Model code/Part number:	D01L / 7M0654-7020A	Customer: TRJ	Car Model: <b>DAIHAT</b>	TSU-TANTO	Document No.:		WI-ENG-PDE-15	66A
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO		Revision No.:	5	Page No.:	5 of 11
PARTS:		Sf 0.3 wire B L=831±3mm SV tube (Vinyl) ø5 L=203±3r	nm	3. Assy parts			JIG:	n/a		
NO.	F	PROCESS NAME	WORK P	ROCEDURE/ ILLUSTR	ATION		TOOLS/PPE	(	QUALITY POIN	TERS
6	Wire Insertion to Assy Black SV tube (Vinyl) ø7, L=72±3mm  Wire L=831±2mm  SV tube (Vinyl) ø7, L=72±3mm  B wire L=831±2mm  B wire L=831±2mm  P1				using right ø7,	1. No wrong insertion to assy parts n/a 2. No wrong use of parts 3. No deformed terminal			arts	
7		Wire Insertion to Black SV tube (Vinyl) ø5 L=203±3mm	L	left hand. Get th	es <mark>(Yellow and Black wire</mark> e SV tube (Vinyl) ø5 ng right hand and insert nd Black wires)		n/a		g use of parts med terminal	



			WORK INS	TRUCTION		Effectivity Date:	<u> </u>	July 12, 2024	
		Process Name/Title:		G ASSEMBLY F	PROCESS	Validity Date:		n/a	
		Model code/Part number:	D01L / 7M0654-7020A	Customer: TR		Document No.:		WI-ENG-PDE-15	6A
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	5	Page No.:	6 of 11
PARTS:	1. Conn	ector 6098-2220 (W)				JIG:	1. Insertion	jig	
NO.	F	PROCESS NAME	WORK F	ROCEDURE/ ILLI	USTRATION	TOOLS/PPE	(	QUALITY POINT	TERS
8	P1	Connector Setting to Insertion jig 6098-2220 (W)	Lock  Guide  Button  Press  1. Press the lock of insertion jig usin thumb.	in the state of th	Connector Lock  Release  2. Insert the connector 6098-2220 (W) nto jig using right hand and release the lock.  guide using left hand. Slot for Yellow		I-mark aligr I-mark not align 1. Use prov 2. No wron 3. No wron	GOOD	1 hole is open  2 holes is open



	_		WORK INS	TRUCTION		Effectivity Date:		July 12, 2024	
	lacksquare	Process Name/Title:		IG ASSEMBLY PRO	OCESS	Validity Date:		n/a	
		Model code/Part number:	D01L / 7M0654-7020A	Customer: TRJ	Car Model: DAIHATSU-TANTO	Document No.:		WI-ENG-PDE-15	66A
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	5	Page No.:	7 of 11
PARTS:	1. Assy	· 				JIG:	1. Insertion		
NO.	F	PROCESS NAME	WORK F	PROCEDURE/ ILLUST	RATION	TOOLS/PPE	(	QUALITY POIN	TERS
9	P1	Wire insertion to connector 6098-2220 (W)	1. Hold the insertion jig using left ha assy part, hold the Yellow wire then terminal slot ① using right hand.  2 Black  3. Hold the Black wire then insert to terminal slot ② using right hand.	and. Get the rinsert to  2. rig op  4. After insertion	Push the button after insertion using the hand. Slot for Black wire will be seen.  Push the lock using left thumb and tres and gently pull out the connector ght hand.	n/a	1. Please during in 3. Make s inserted. Push after Do not established.  1. No loose 2. No wron 3. One by 0 4. No defor 5. No wron Docume	cure wires are proceed to conduct Pull-Puller insertion wert extra force.  It insertion g insertion one insertion one insertion one insertion one insertion one the following wire facing wire facing the control of the	ar terminal operly sh-Pull-

			WORK INS	STRUCTION		Effec	ectivity Date:		July 12, 2024	
		Process Name/Title:	TAPIN	IG ASSEMBLY PRO	CESS	Valid	dity Date:		n/a	
		Model code/Part number:	D01L / 7M0654-7020A	Customer: TRJ	Car Model: DAIHATSU-T	ANTO Docu	cument No.:		WI-ENG-PDE-15	66A
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revi	rision No.:	5	Page No.:	8 of 11
PARTS:	1. Assy	parts					JIG:	1. Locking	jig	
NO.	F	PROCESS NAME	WORK I	PROCEDURE/ ILLUSTR	RATION		TOOLS/PPE	(	QUALITY POIN	TERS
		5	CONNECTOR RETAINED SIDE	king jig.	half-locked condition prior		1. Please ensure that Connector lock/retainer will not touch or hit by any object prior insertion into locking jig to half-lock connector.  2. Maintain 10mm proper holding of wi connector 3. Connector must be fully inserted to connector slot.  4. Make sure no offset setting before leprocess.  5. No wrong setting of connector.  6. No damaged connector lock  7. No unlocked/ half-locked connector.  Important reminders/Note/s:  1. Incomplete locking process will a the jig.			
10	P1	Connector lock	2. Hold the assy parts using left hand a connector touch the sensor. Sound will NOTE: CONNECTOR LOCKING JIG V	and insert into connector lock be heard if properly lock.	ing jig based on the direction o	f arrow. Make	6098-2220 Estrep 2	proceed.  3. If enco immediate leader. W	ainer in connector untered abnomal ely CALL the atte 'AIT for further in the process.	ity, <b>STOP</b> and ention of the



			WORK INS	TRUCTION			Effectivity Date:	T	July 12, 2024	!
		Process Name/Title:	TAPIN	G ASSEMBLY PRO	CESS		Validity Date:		n/a	
		Model code/Part number:	D01L / 7M0654-7020A	Customer: TRJ	Car Model: DAIHATSU	J-TANTO	Document No.:		WI-ENG-PDE-1	56A
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO		Revision No.:	5	Page No.:	9 of 11
	1	1					1			
PARTS:	1. Ass	y parts					JIG:	1. Locking	jig	
NO.		PROCESS NAME	WORK F	PROCEDURE/ ILLUST	RATION		TOOLS/PPE	(	QUALITY POIN	TERS
10	Δ P1	Connnector lock (Continuation)	HOLD THE HANDLE  R  SLIDE		PULL-DOWN  3. H lock dow after only  R  SLIDE	king jig using yn and bring ir locking. No /. I. Remove th eft hand basi	dle of the connector right hand then gently pull back to original position tte: Pull down one time	1. Please e lock/retaine object prior half-lock co 2. Maintain connector 3. Connector 4. Make su process. 5. No wrong 6. No dama 7. No unlock limportain 1. Incompathe jig.	ensure that Conne er will not touch or r insertion into loc onnector. n 10mm proper ho or must be fully in:	ctor hit by any king jig to avoid lding of wire to serted to g before locking ctor. ck connector  lote/s: cess will alarm
			STEP 1	STEP 2	STEP 2	2	5. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.	immediate leader. <b>W</b>	untered abnoma ely <b>CALL</b> the att <b>'AIT</b> for further ir the process.	ention of the



			WORK INS	TRUCTION		Effectivity Date:		July 12, 2024	
		Process Name/Title:		G ASSEMBLY PROC	CESS	Validity Date:		n/a	
		Model code/Part number:	D01L / 7M0654-7020A	Customer: TRJ	Car Model: <b>DAIHATSU-TANTO</b>	Document No.:		WI-ENG-PDE-15	56A
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	5	Page No.:	10 of 11
	4 51 1	0// 1 0// 0 51 407 4							
PARTS:	2. Assy					JIG:	n/a		
NO.	P	ROCESS NAME	WORK P	ROCEDURE/ ILLUSTR	ATION	TOOLS/PPE	(	QUALITY POIN	TERS
11	P1	Wire Insertion to Black SV tube (Vinyl) ø5 L=487±4mm	1. Hold the 2 Black wires using left insert the wire using right hand.	t hand and get the SV tube of	(Vinyl) ø5 L=487±4mm then	n/a	1. No wron 2. No defo	g use of parts rmed terminal	



			STRUCTION		Effectivity Date:	July 12,	2024
	Process Name/Title:		IG ASSEMBLY PRO		Validity Date:	n/a	3
	Model code/Part number:	D01L / 7M0654-7020A	Customer: TRJ	Car Model: <b>DAIHATSU-TANTO</b>	Document No.:	WI-ENG-P	DE-156A
	Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	5 Page No.	: 11 of 11
PARTS: 1. Assy	y parts				JIG:	n/a	
		<u> </u>					
		<u> </u>	SUAL INSPECTION/ QU	ALITY CHECKPOINTS			
P1			7IVI06	54-7020A			
		2					
Married Townson							
							1000
GOO	D    GO	OD O			COOD		
			SIGNE.		GOOD		OD
	1	2			A CONTRACTOR		
					AND DESCRIPTIONS	1	
The second second					1		
				Marie Company			
NO CO	NO C	2000		3			
NO GO					NO GOO	D NO G	GOOD
		No Wrong Inse	wt				
K <del>-</del> /	nlock/	Z INO Wrong Inse	$^{\prime\prime}$	lissing Clip $(4)$	<b>No Terminal</b>		
Halflo	ocked Connecto	or (on 3 connector)		iissiiig Ciip			
	nnector)	•	Clam	p	<b>Backing Out</b>		
( 5 001	illectory		<u> </u>	<u> </u>			
	•						