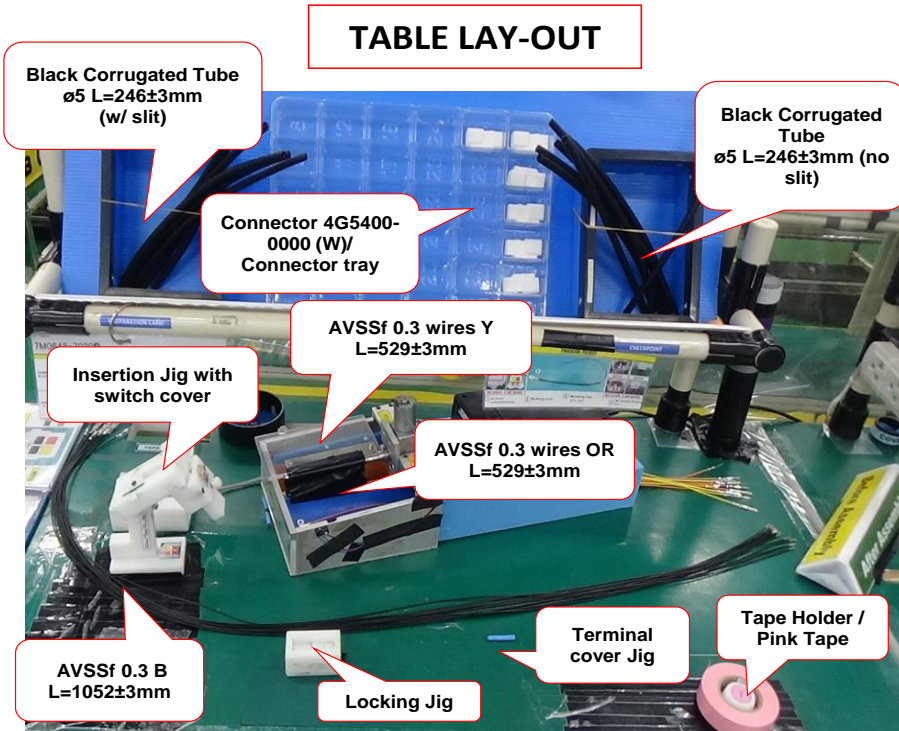




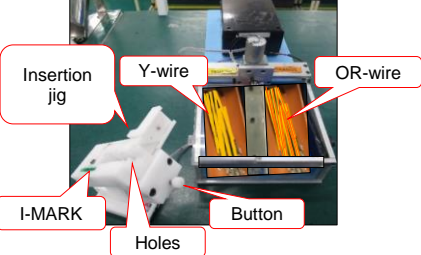
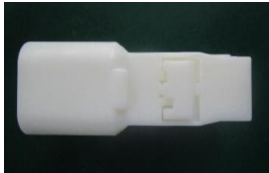
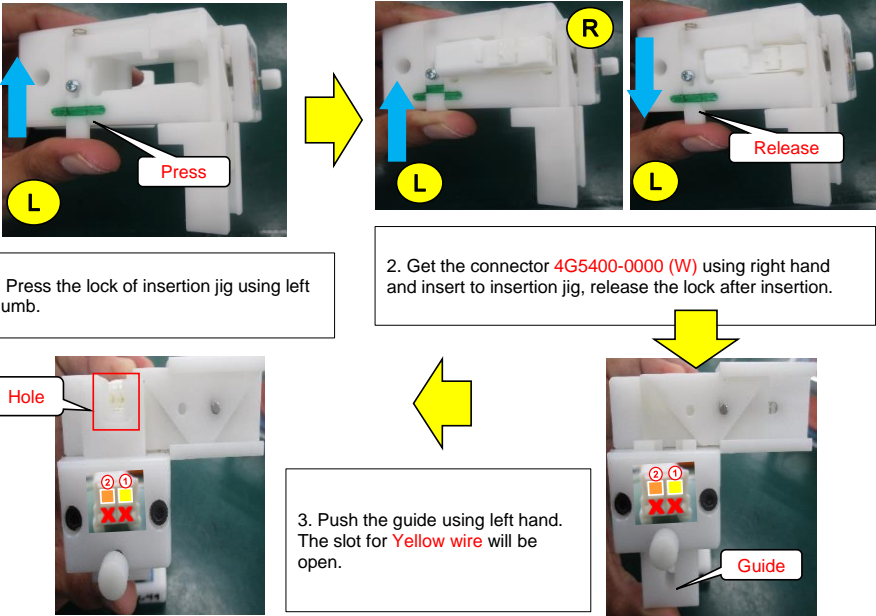
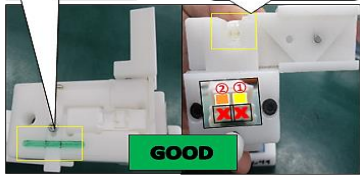

	WORK INSTRUCTION TAPING ASSEMBLY PROCESS				Effectivity Date: January 22, 2025	
	Process Name/Title:				Validity Date: n/a	
	Model code/Part number: D01L / 7M0648-7020D		Customer: TRJ	Car Model: DAIHATSU-TANTO	Document No.: WI-ENG-PDE-095A	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.: 5		Page No.:	1 of 9

PARTS: 1. Connector 4G5400-0000 (W); Black Corrugated Tube ø5 L=246±3mm (w/ slit in); Black Corrugated Tube ø5 L=246±3mm (no slit); AVSSf 0.3 wires Y L=529±3mm; AVSSf 0.3 wires OR L=529±3mm; AVSSf 0.3 B L=1052±3mm; Pink tape		JIG: 1. Insertion with switch cover 2. Locking jig 3. Terminal cover jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE
1	P1	<div> <div> TABLE LAY-OUT </div>  </div>	<div> <p>Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)</p> <p>Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker.</p> <p>Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.</p> </div>
		QUALITY POINTERS Document reference/s: 1. 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
01/22/25	5	Inclusion of Car model "DAIHATSU-TANTO". Improved Visual inspection/Quality checkpoint	D.Castillo	C. Villanueva	A. Arañes	n/a	 D.Castillo	 C. Villanueva	 A. Arañes
05/10/23	4	Inclusion of quality checkpoints	J. Loterte	C. Villanueva	A. Arañes	N/A			
10/20/22	3	Merge from P3 to P4. Remove process no.9 and transfer to P1 due to process improvement. Improve work procedure/Illustration on process 5 and 9- Wire insertion; Process no.7- Connector lock. Improve Quality Pointers; Reminders/notes and references on page no. 1,3,4,5 and 7.	M. Ariola	J. Loterte	C. Villanueva	A. Arañes			
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	February 27, 2020	

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		Model code/Part number:	D01L / 7M0648-7020D	Customer:	TRJ	Car Model:	DAIHATSU-TANTO	Document No.: WI-ENG-PDE-095A
		Purpose:	<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO	Revision No.:		5	Page No.:	2 of 9
PARTS:		1. Connector 4G5400-0000 (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 4G5400-0000 (W)	<div> <div> INSERTION JIG WITH SWITCH COVER  </div> <div>  </div> <div>  </div> <div> <p>1. Press the lock of insertion jig using left thumb.</p> <p>2. Get the connector 4G5400-0000 (W) using right hand and insert to insertion jig, release the lock after insertion.</p> <p>3. Push the guide using left hand. The slot for Yellow wire will be open.</p> </div> </div>			n/a		<div> Connector Orientation Illustration <div> I-mark was align  GOOD </div> <div> I-mark was not align  NG </div> </div> <p>1. Use provided jig per model 2. No wrong usage of parts 3. No wrong orientation of connector 4. No damaged connector</p>	

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Model code/Part number:

D01L / 7M0648-7020D

Customer:

TRJ

Car Model:

DAIHATSU-TANTO

Document No.:

WI-ENG-PDE-095A

Purpose:



PROTOTYPE



PRE-LAUNCH




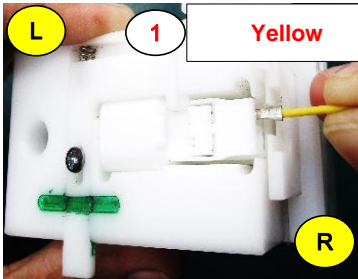
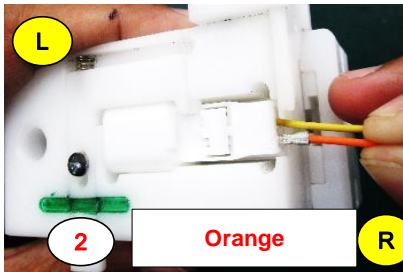
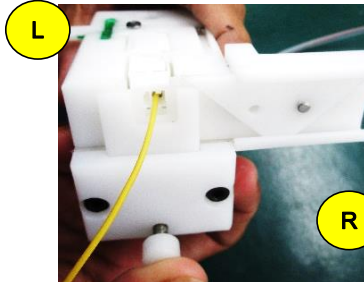
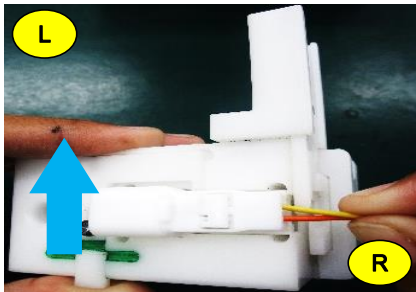
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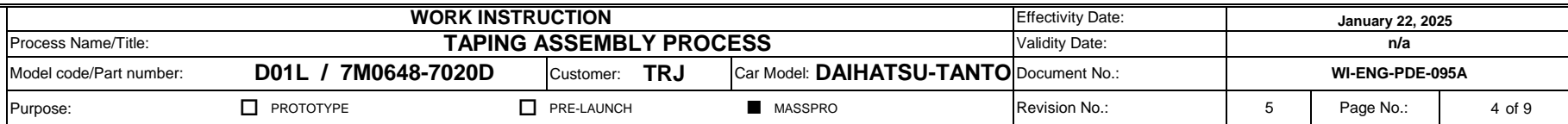
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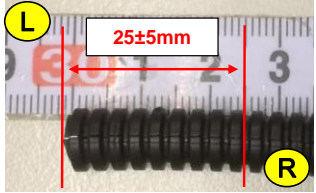



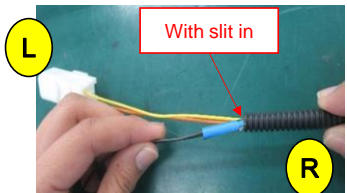

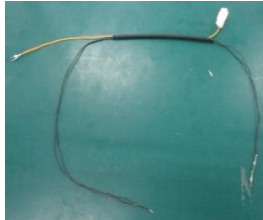

PARTS:		1. AVSSf 0.3 Y wire L=529±2mm 2. AVSSf 0.3 OR wire L=529±2mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P1 Wire insertion to connector 4G5400-0000 (W)	<div><div><div>Terminal facing</div></div><div><div><div>1. Get Yellow wire then insert to terminal slot ① using right hand.</div></div><div><div>2. Get Orange wire then insert to terminal slot ② using right hand.</div></div></div><div><div><div>2. After insertion of Yellow wire press the button using right hand. The slot for Orange wire will be open.</div></div><div><div>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.</div></div></div></div>		n/a	<p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal.</p> <p>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p>

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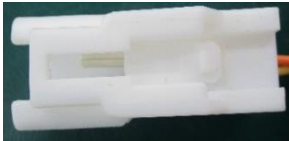

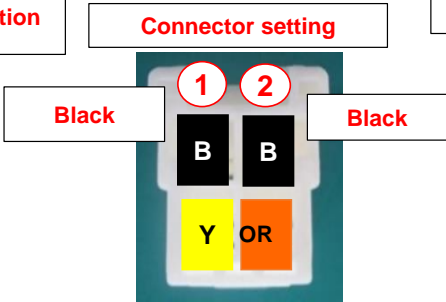
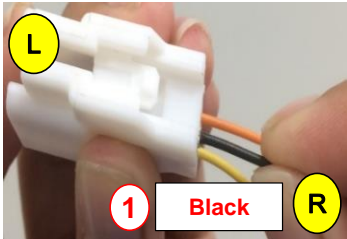
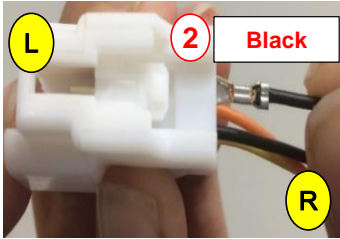
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PARTS:	1. Assy parts 2. Black Corrugated tube $\phi 5$ L=246 \pm 3mm (w/ slit in 25 \pm 5mm)	3. AVSSf 0.3 wires B L=1052 \pm 3mm [2pcs]	JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	Wire insertion to Black Corrugated tube $\phi 5$ L=246 \pm 3mm (w/ slit in 25 \pm 5mm)	  <p>1. Get the COT $\phi 5$ L=246\pm3mm (with slit in) and confirm slit in measurement 25\pm5mm.</p> <p>2. Get the Yellow and Orange wire then insert to COT using left hand.</p>	<p>MEASURING TAPE</p> 	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>1. No wrong use of parts</p>
5	Wire insertion to assy parts	  <p>1. Get the terminal cover jig using right hand and insert 2 Black wires using left hand.</p> <p>2. Hold the Corrugated tube $\phi 5$ L=246\pm3mm (with slit in) using right hand then and insert the 2 Black wires.</p> <p>3. After insertion, remove the terminal cover jig using right hand.</p>  	<p>TERMINAL COVER JIG</p> 	<p>Document reference/s:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No wrong use of parts 2. No deformed terminal</p>

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	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	5	Page No.:	5 of 9

PARTS:	1. Assy parts			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
6	P1 Connector Setting to insertion jig 4G5400-0000 (W)	<div> Connector Orientation</div> <div> Terminal facing</div> <div> Connector setting</div> <div> 1. Get the first black wire and insert to connector slot 1 using right hand.</div> <div> 2. Get the 2nd black wire and insert to connector slot 2 using right hand.</div>	n/a	<p>Important reminders/Note/s:</p> <p>1. Please hold the wire near terminal.</p> <p>2. Make sure wires are properly inserted. Conduct Pull-Push-Pull-Push after insertion. Do not exert extra force.</p> <p>Document references:</p> <p>1. Refer to GL-PRO-ASY-029 for Pull-Push procedure.</p> <p>2. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</p>	

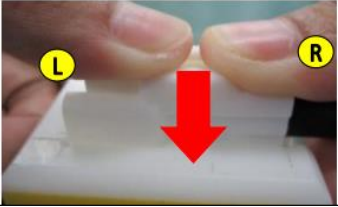
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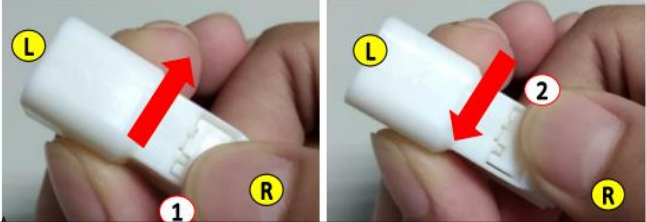
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	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Revision No.:		5	Page No.:


PARTS:		1. Assy parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
7	P1	Connector lock			



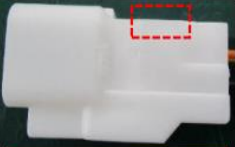
1. Put the connector into locking jig using both hands then press **2x** using both hands.



2. Ensure that the connector is in locked condition by slide touching the connector lock based on the sequence illustrated.




BEFORE PRESSING



AFTER PRESSING


LOCKING JIG

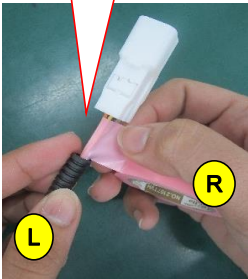
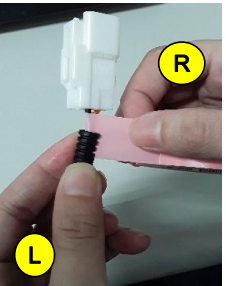
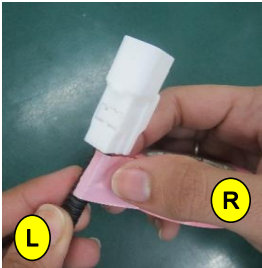

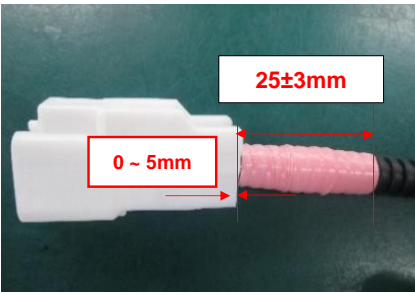



Important reminders/Note/s:

1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR

1. No unlocked/half-locked connector
2. No damage connector


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	Model code/Part number: D01L / 7M0648-7020D		Customer: TRJ	Car Model: DAIHATSU-TANTO	Revision No.: 5 Page No.: 7 of 9		
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PARTS:		1. Assy parts 2. Pink tape		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
8	P1 Taping 1 Wire to Black corrugated tube	<div><div><p>1. Hold the connector using left hand and tape the wires using right hand. <i>Note: Make 3 times winding.</i></p></div><div><p>2. Hold the connector using left hand and insert the tape into COT with 25mm slit using right hand.</p></div><div><p>3. After Insertion of tape, Winding the tape 2~3 times before shifting.</p></div><div><p>4. Make 1/3 shifting until it covers the slit. Wind 3 times, then cut the tape.</p></div><div><p>5. After tape, check the taping condition and measurement.</p></div></div> <div><div>Measuring tape</div></div> <div><p>Important reminders/Note/s:</p><p>1. Use PINK TAPE only</p><p>2. Please use calibrated/verified measuring tape when getting the measurement.</p><ul style="list-style-type: none">1. No flip-out tape2. No peel-off tape3. No loose tape4. No missing tape5. No wrong use of tape6. No wrong dimension7. No insufficient tape</div>			

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Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO							

PARTS:		1. Assy parts 2. Black corrugated tube ø5 L=246±3mm (No Slit)		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
9	P1 Wire insertion to Black corrugated tube ø5 L=246±3mm (No Slit)	<div><p>1. Get the terminal cover jig using right hand and insert wires using left hand.</p></div> <div><p>2. Get the corrugated tube ø5, L=246±3mm using right hand and insert to wires.</p></div> <div><p>3. After insertion, remove the terminal cover jig using right hand.</p></div> <div></div>		<div>TERMINAL COVER JIG</div> 	<p>Document reference/s:</p> <p>1. Refer to WI-PRO-CNC-017 for Wire and Strip Length Tolerance</p> <p>1. No wrong use of parts 2. No deformed terminal</p>

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Customer:

TRJCar Model: **DAIHATSU-TANTO**

Document No.:

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PROTOTYPE



PRE-LAUNCH



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PARTS:

1. Assy parts

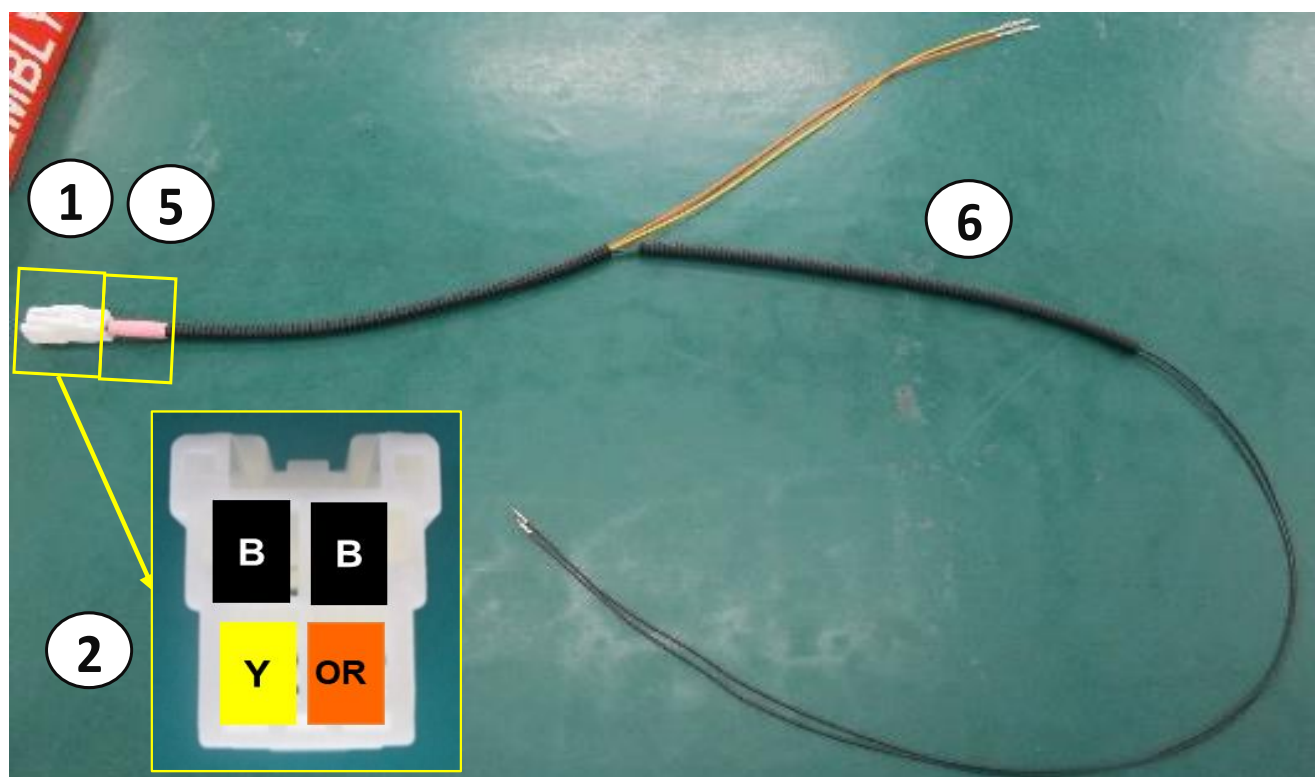
JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS**

TAPING - P1

7M0648-7020D



- ① No **Unlocked/ Half-locked connector**
- ② No **Wrong Insert**
- ③ No **Deformed terminal**
- ④ No **Terminal backing out**
- ⑤ No **Missing Tape/ No Wrong color of tpe**
- ⑥ No **Missing parts (COT)**

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