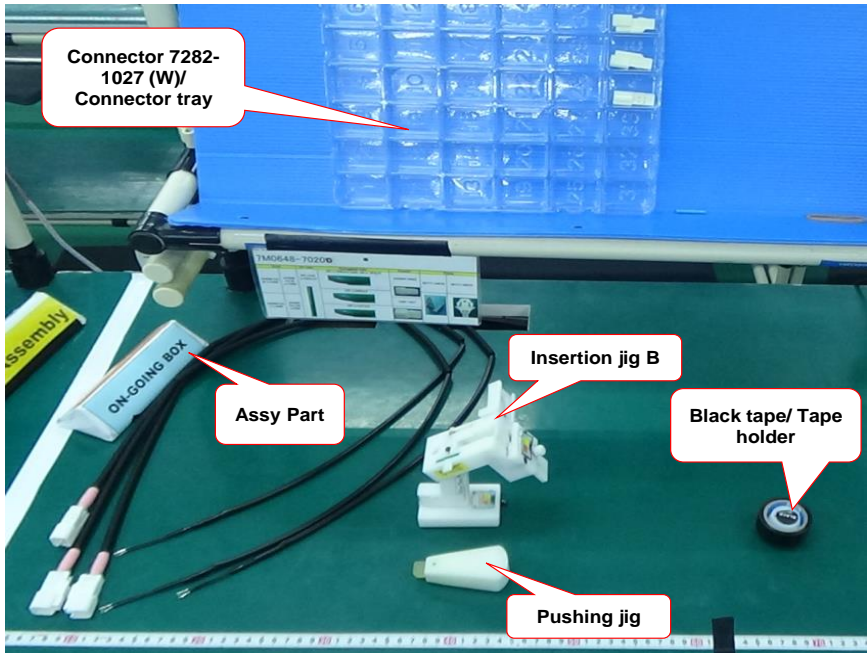

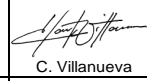
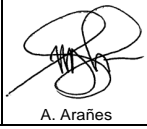

	WORK INSTRUCTION				Effectivity Date:		January 22, 2025	
	Process Name/Title: TAPING ASSEMBLY PROCESS				Validity Date:		n/a	
	Model code/Part number: D01L / 7M0648-7020D		Customer: TRJ	Car Model: DAIHATSU-TANTO	Document No.:		WI-ENG-PDE-095C	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/>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

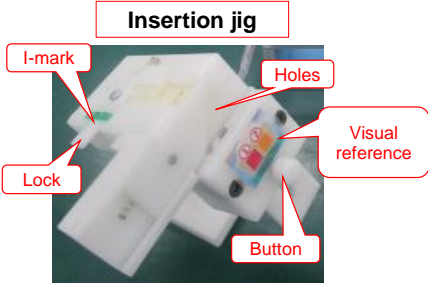
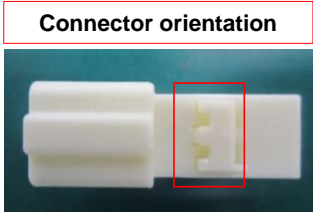
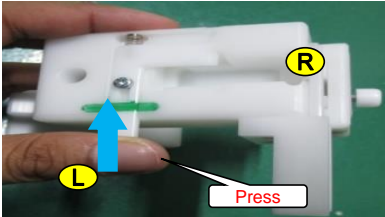
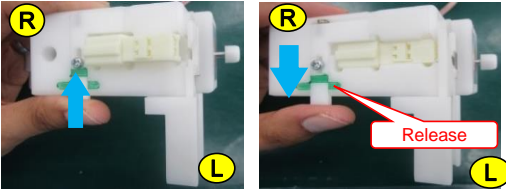
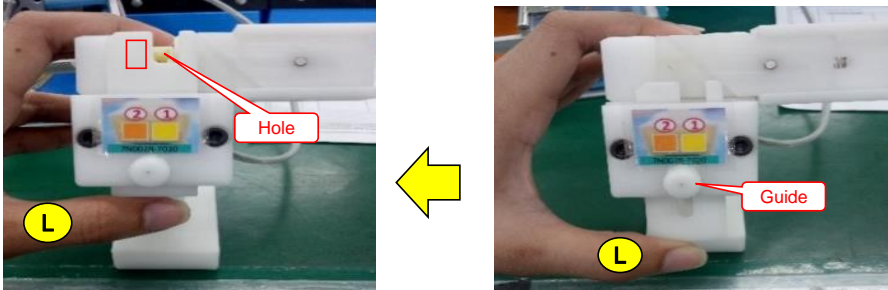
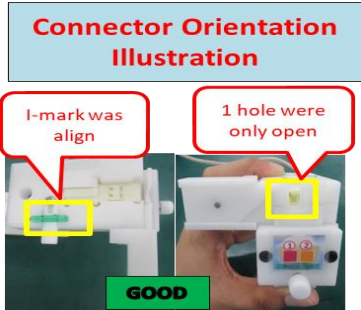

PARTS:		1. Assy parts; Connector 7282-1027 (W); Black tape				JIG:		1. Insertion jig 2. Pushing jig					
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION				TOOLS/PPE		QUALITY POINTERS					
1	P3 Table lay-out	<div style="text-align: center; border: 1px solid red; padding: 5px; margin-bottom: 10px;"> TABLE LAY-OUT </div> 				<div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Safety Instruction Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) </div> <div style="border: 1px solid red; padding: 5px; margin-bottom: 10px;"> Housekeeping 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. </div> <div style="border: 1px solid red; padding: 5px;"> Alert level For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action. </div>		1. No missing parts/tools 2. No excess parts/tools					
Revision History						Prepared by		Reviewed by		Approved by		Noted by	
01/22/25	5	Transfer process 2-4 from P2 and process 6 from P4. Yansfer Y-taping to P4. Inclusion of Car model "DAIHATSU-TANTO". Change jig from Glue stick to Pushing jig. Improved Table lay-out and Visual inspection/Quality checkpoint.				D.Castillo	C. Villanueva	A. Arañes	n/a	 D. Castillo	 C. Villanueva	 A. Arañes	n/a
05/10/23	4	Inclusion of quality checkpoints				J. Loterte	C. Villanueva	A. Arañes	N/A				
10/20/22	3	Remove process of Clamp setting; Clamp Assembly; Visual/by two's inspection and measurement and transfer to P4; Transfer process 4 from P2 to P3 due to Project Improvement. Improve Quality pointers; Reminders/notes and references on page no.2 and 3.				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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	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Process Name/Title:			Document No.:	WI-ENG-PDE-095C		
	Model code/Part number: D01L / 7M0648-7020D		Customer: TRJ	Car Model: DAIHATSU-TANTO	Revision No.: 5 Page No.: 2 of 7		
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO							

PARTS:		1. Connector 7282-1027 (W)		JIG:	1. Insertion jig	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
2	P3 Connector Setting to insertion jig 7282-1027 (W)	<div><div></div><div></div><div></div><div></div><div></div></div> <div><p>1. Press the lock of insertion jig using left thumb.</p><p>2. Get the connector 7282-1027 (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>		n/a	<div><div></div><div></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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D01L / 7M0648-7020D

Customer:

TRJ

Car Model:

DAIHATSU-TANTO

Document No.:

WI-ENG-PDE-095C

Purpose:



PROTOTYPE



PRE-LAUNCH




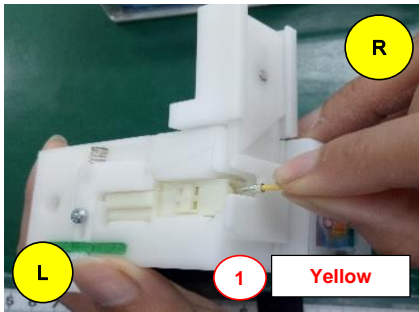
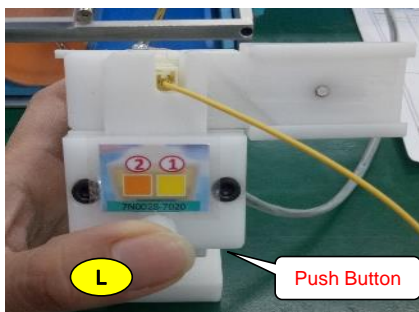
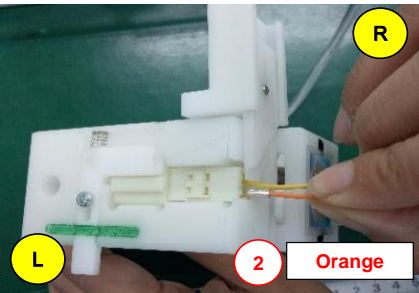
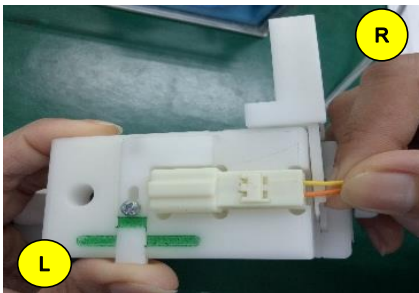
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PARTS:		1. Assy parts		JIG:	1. Insertion jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
3	P3 Wire insertion to connector 7282-1027 (W)	<div><p>Terminal facing</p></div> <div><p>1. Get Yellow wire then insert to terminal 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 open.</p></div> <div><p>3. Get Orange wire then insert to the 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	<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>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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D01L / 7M0648-7020D

Customer:

TRJ

Car Model:

DAIHATSU-TANTO

Document No.:

WI-ENG-PDE-095C

Purpose:



PROTOTYPE



PRE-LAUNCH



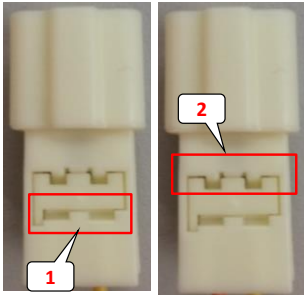
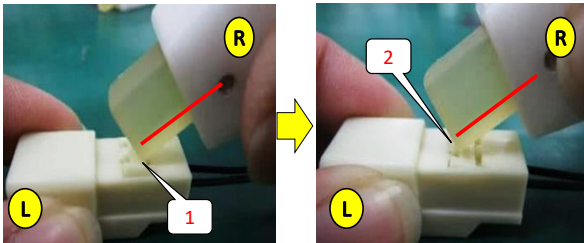
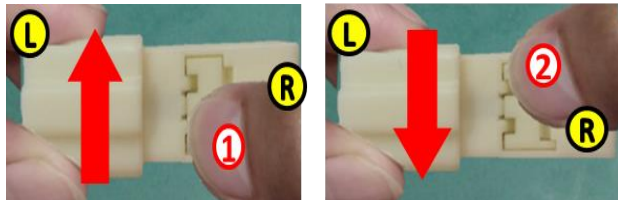
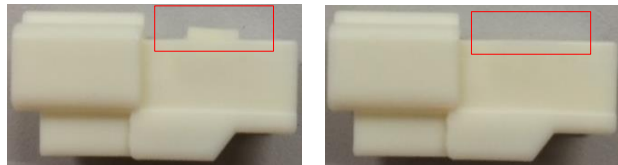

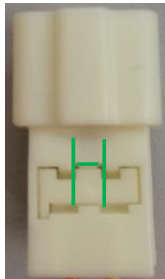
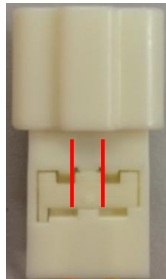
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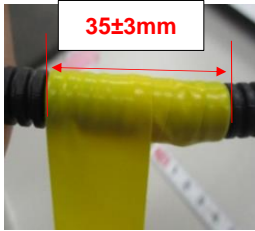
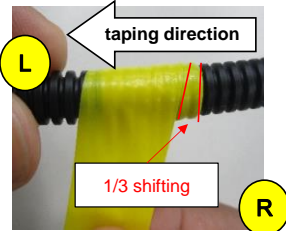
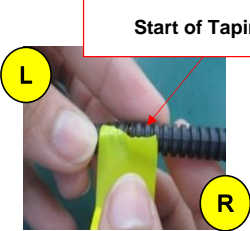

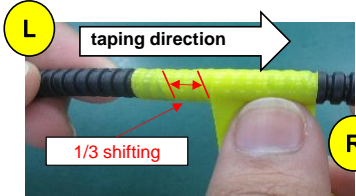
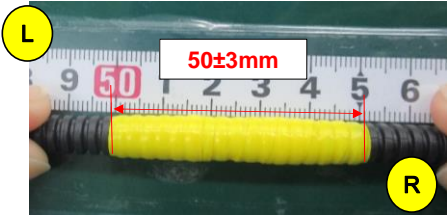

PARTS:	1. Assy parts		JIG:	1. Pushing jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P3 <div>5</div> Connector lock	<div><div>Pressing sequence</div><div></div><div></div><div>1. Hold the connector using left hand and place on the table. Get the pushing jig using right hand and start the sequential locking based on the above illustration. Push the lower part of the connector lock first and then push the upper part.</div><div></div><div></div><div>BEFORE PRESSING</div><div>AFTER PRESSING</div><div>2. Ensure that connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</div></div> <div><div>Pushing Jig</div><div></div></div> <div><div>Important reminders/Note/s:</div><div>1. MANUAL LOCKING MAY CAUSE DAMAGED CONNECTOR</div><div>2. Use the provided jig tool to lock the connector.</div><div>3. Position of pushing jig during locking must be slanted</div><div>1. No unlocked/half-locked connector</div><div>2. No damage connector</div><div>LOCK CONDITION</div><div> GOOD</div><div> NG</div></div>		

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	Model code/Part number: D01L / 7M0648-7020D		Customer: TRJ	Car Model: DAIHATSU-TANTO	Document No.:	WI-ENG-PDE-095C	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	5	Page No.:	5 of 7

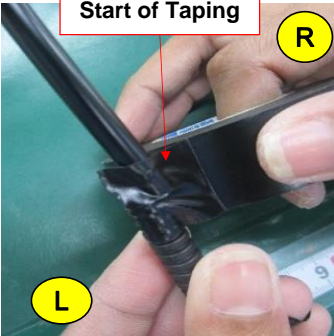
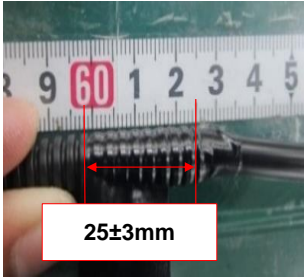
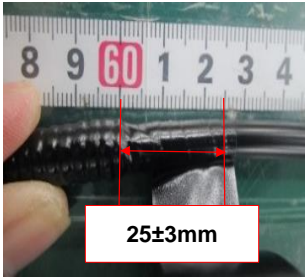
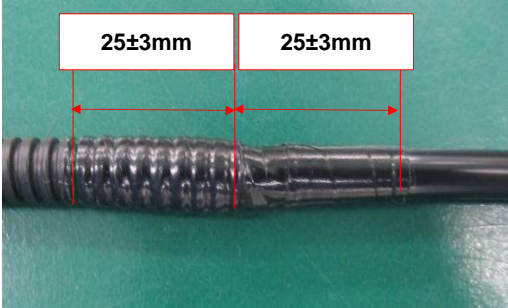

PARTS:	1. Assy parts 2. Blackk tape			JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
5	P3 Taping 3 Black corrugated tube (with slit in) to Black corrugated tube (no slit)	<div></div> <div>1. Hold the 2 corrugated tube using left hand, start taping at the middle of the corrugated tube using right hand. Make 2 windings and wind the tape to the left side 1/3 shifting up, until measurement from tape to tape becomes 35±3mm.</div> <div></div> <div>2. Winding the tape 1/3 shifting going to the other side of the corrugated tube, until measurement from tape to tape becomes 50±3mm.</div> <div></div> <div>4. After taping ,check the measurement and taping condition.</div>	<div>Measuring tape</div> 	Important reminders/Note/s: 1. Use YELLOW TAPE for easy visualization of shifting lines, but actual should be BLACK TAPE. 2. Please use calibrated/verified measuring tape when getting the measurement. 1. No flip-out tape 2. No peel-off tape 3. No loose tape 4. No missing tape 5. No wrong use of tape 6. No wrong dimension 7. No insufficient tape	

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	Model code/Part number: D01L / 7M0648-7020D		Customer: TRJ	Car Model: DAIHATSU-TANTO			
Purpose:				Revision No.:	5	Page No.:	6 of 7
				<input type="checkbox"/> PROTOTYPE		<input type="checkbox"/> PRE-LAUNCH	
				<input checked="" type="checkbox"/> MASSPRO			

PARTS:		1. Assy parts 2. Blackk tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
6	P3 Taping 4 Black corrugated tube (with slit in) to Black SV tube (Vinyl)	<div><div><p>Start of Taping</p><p>(R)</p><p>(L)</p></div><div><p>1. Hold the corrugated tube using left hand and get the Black tape then start taping using right hand.</p></div></div> <div><div><p>25±3mm</p></div><div><p>25±3mm</p></div><div><p>2. Measure 25±3mm to corrugated tube then continue taping up to SV tube (Vinyl) then measure 25±3mm.</p></div></div> <div><div><p>25±3mm</p><p>25±3mm</p></div><div><p>3. Check the taping condition and measurement.</p></div></div>		<div><p>Measuring tape</p></div>	<p>Important reminders/Note/s:</p> <p>1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document references:</p> <p>1. Refer to WI-PRO-ASY-001B for Taping procedure</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	

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D01L / 7M0648-7020D

Customer:

TRJCar Model: **DAIHATSU-TANTO**

Document No.:

WI-ENG-PDE-095C

Purpose:



PROTOTYPE



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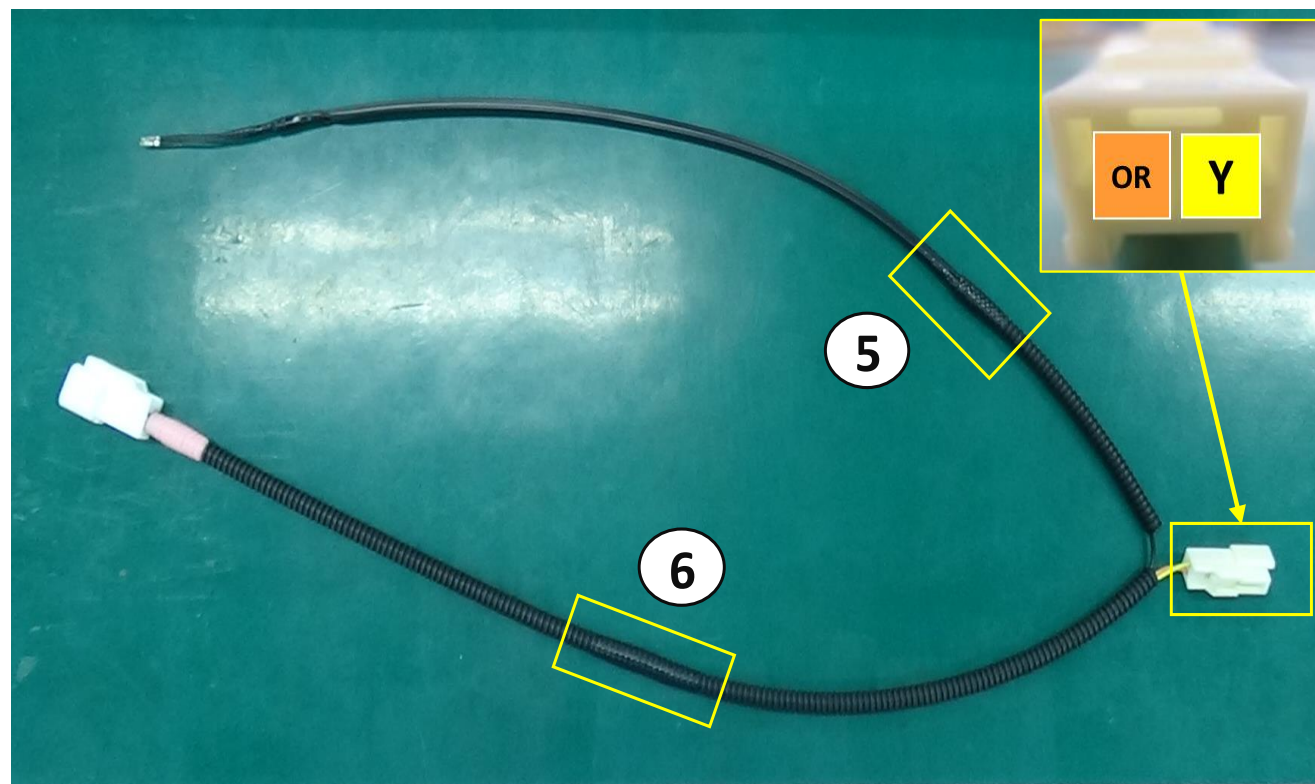
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PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P3****7M0648-7020D**

- ① No Unlocked/
Half-locked connector
- ② No Wrong Insert
- ③ No Deformed terminal
- ④ No Terminal backing
out
- ⑤ ⑥ No Missing Tape/
No Wrong color of
tape

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