



WORK INSTRUCTION

Process Name/Title:

OFFLINE ASSEMBLY PROCESS

Effectivity Date:

October 30, 2024

Model code/Part number:

D01L / 7M0653-7020A

Customer: TRJ

Car Model: Daihatsu/Tanto

Validity Date:

n/a

Purpose:

☐ PROTOTYPE☐ PRE-LAUNCH☒ MASSPRO

Document No.:

WI-ENG-PDE-132

Revision No.:

5

Page No.:

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PARTS:

1. Connector 4G5400-0000 (W); AVSSf 0.3 Y wire L=373±2mm; AVSSf 0.3 B wire L=831±3mm

JIG:

1. Insertion jig with switch cover
2. Locking jig

NO.

PROCESS NAME

WORK PROCEDURE/ ILLUSTRATION

TOOLS/PPE

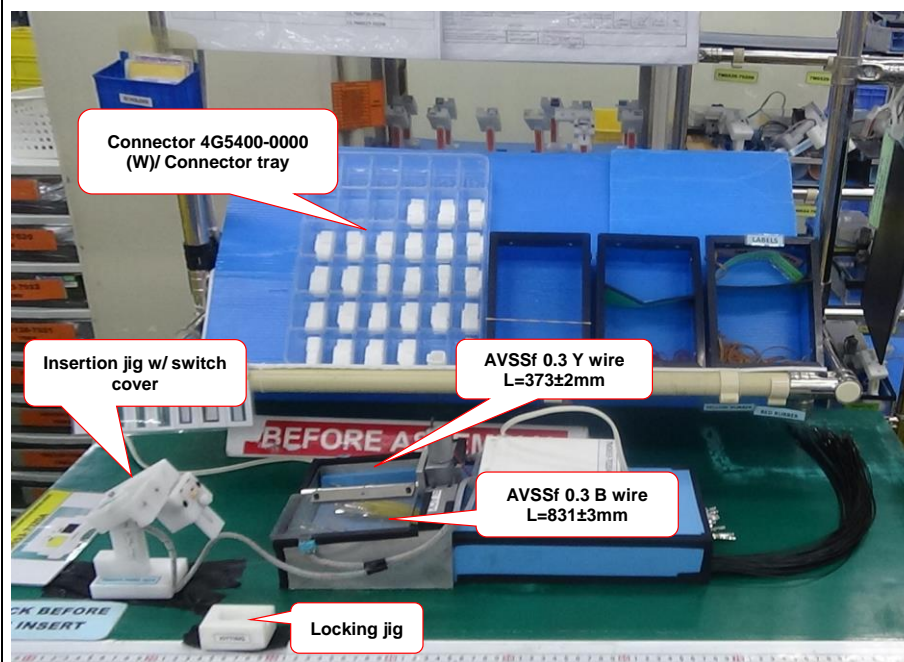
QUALITY POINTERS

1

n/a

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-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	5	Transfer to new format and inclusion of Car Model "DAIHATSU/TANTO". Improve measurement and visual inspection/quality checkpoints.	A.Hernandez	C. Villanueva	A. Arañes	n/a					
06/08/23	4	Changed table lay-out; Inclusion of Quality Checkpoints (Page 5); Improve Quality pointers: Reminders/Notes and reference/s (page 1,3 and 4); Improve Work procedure/Illustration(process no. 4); Change Process Name/Title from "KITTING ASSEMBLY PROCESS" to "OFFLINE ASSEMBLY PROCESS"	M. Ariola	J. Loterte	C. Villanueva	A. Arañes					
04/09/21	3	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	A. Hernandez	C. Villanueva	A. Arañes		n/a
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	October 29, 2019			

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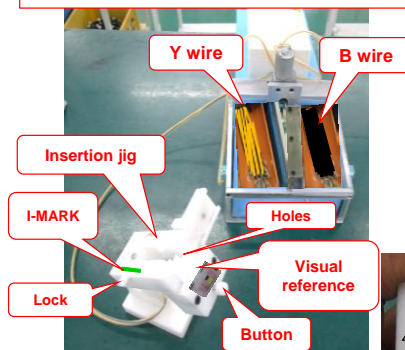


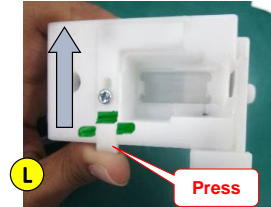
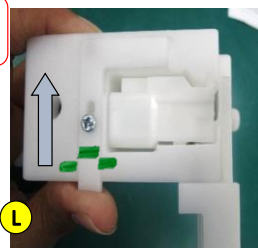
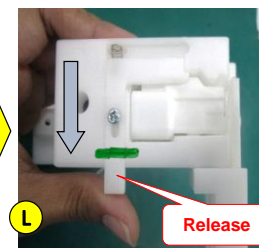
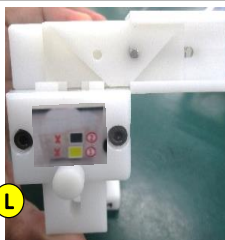
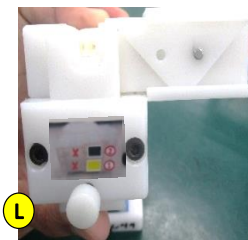
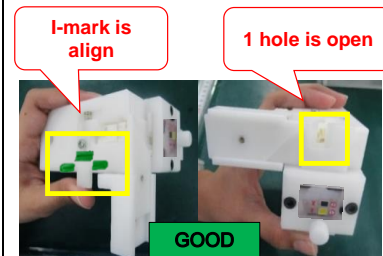
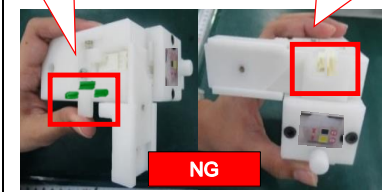
☒ MASSPRO

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PARTS:		1. Connector 4G5400-0000 (W)		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
2	n/a Connector setting to insertion jig 4G5400-0000 (W)	<div><div>INSERTION JIG WITH SWITCH COVER</div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div>1. Press the lock of insertion jig using left thumb.</div><div>2. Insert the connector 4G5400-0000 (W) into jig using right hand and release the lock. Note: Follow the connector orientation.</div><div>3. Push the guide using left thumb. The slot for Y wire will be opened.</div></div>		n/a	<div>1. Use the provided jig per model</div> <div>2. No wrong orientation of connector</div> <div>3. No wrong use of connector</div> <div>4. No damaged connector</div> <div>Connector Orientation Illustration</div> <div></div> <div></div> <div>GOOD</div> <div>NG</div>

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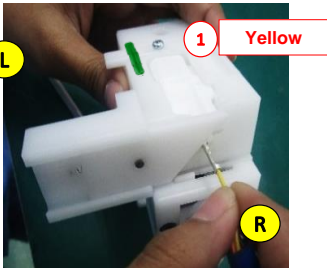
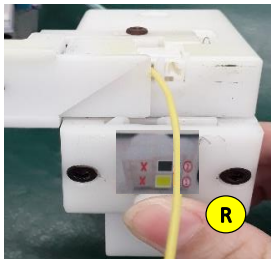
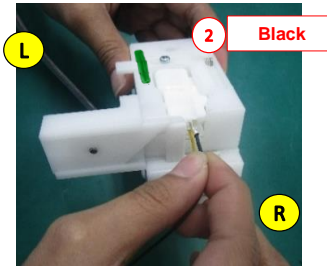
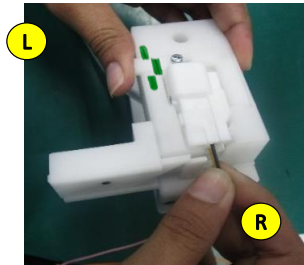
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PARTS:	1. AVSSf 0.3 Y wire L=373±2mm; AVSSf 0.3 B wire L=831±3mm		JIG:	1. Insertion jig with switch cover
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	n/a Wire insertion to connector 4G5400-0000 (W)	<div><div>Wire facing</div></div> <div><div>1. Hold the insertion jig using left hand, get the Y wire then insert to terminal slot 1 using right hand.</div></div> <div><div>2. After insertion of Y wire press the button using right thumb. The slot for B wire will be opened.</div></div> <div><div>3. Get the B wire then insert to terminal slot 2 using right hand.</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>	n/a	<div>1. No loose insertion 2. No wrong insertion 3. One by one insertion 4. No deformed terminal 5. No wrong wire facing</div> <div>Important reminders/Note/s: <i>1. Please hold the wire near terminal during insertion.</i> <i>2. Wire insertion must be from left to right.</i> <i>3. Make sure wires are properly inserted.</i> <i>Conduct Pull-Push-Pull-Push after insertion.</i> <i>Do not exert extra force.</i></div> <div>Document reference/s: <i>1. Please refer to WI-ENG-PRO-CNC-017 for Wire and strip length tolerance.</i> <i>2. Please refer to GL-PRO-ASSY-029 for Pull-Push procedure.</i></div>

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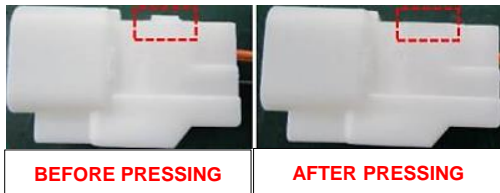



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PARTS:		1. Assy Parts		JIG:	1. Locking jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS
4	n/a	Connector Lock	<div></div> <div></div> <div></div> <div></div> <div>1. Put the connector into locking jig using both hands then press 2x using both hands.</div> <div>2. Ensure that the connector is in locked condition by slide touching the connector lock based on the sequence illustrated.</div>	<div>LOCKING JIG</div> 	Important reminders/Notes: 1. Manual locking may cause damaged connector lock. 1. Use provided jig per models 2. No Unlock/Half-locked

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PARTS: 1. Assy Parts

JIG:

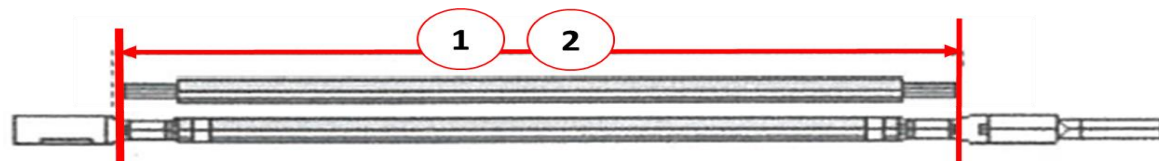
n/a

NO.**PROCESS NAME****WORK PROCEDURE/ ILLUSTRATION****TOOLS/PPE****QUALITY POINTERS**

Note:

1. Measurement point: End of core wire to the end of core wire
2. Terminal is reference only.

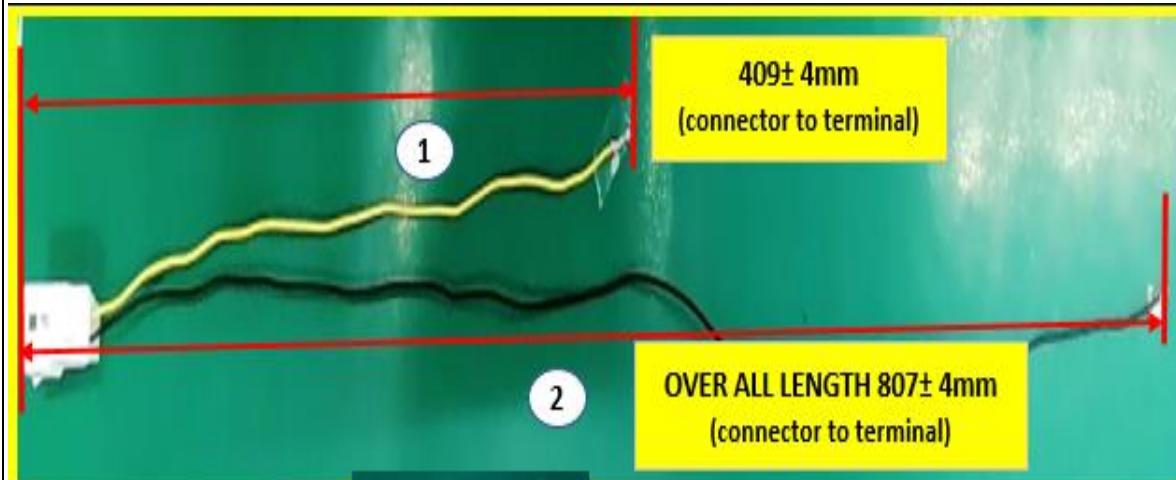
Measuring tape

**5**

5

n/a

Measurement

**Important reminders and note/s:**

1. Please use calibrated/verified measuring tape when getting the measurement.

2. For Hatsumono, Nakamono and Owarimono.

Document reference/s:

1. Refer to **WI-PRO-ASY-056** for Sub-assembly Hatsumono Nakamono Owarimono Inspection

1. No wrong dimension

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PARTS:

n/a

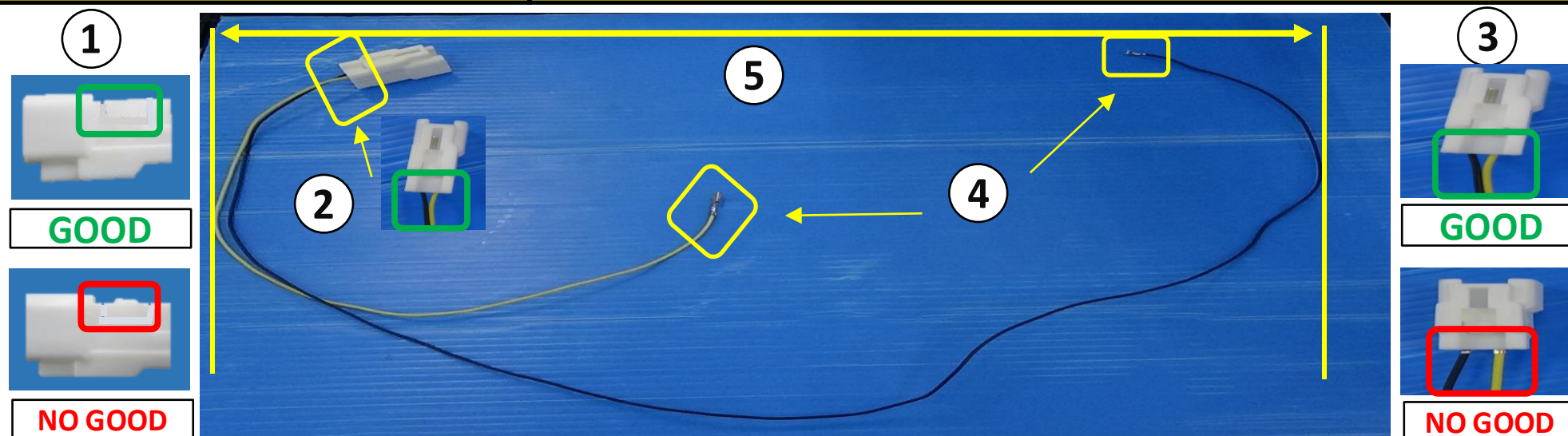
JIG:

n/a

VISUAL INSPECTION/QUALITY CHECKPOINTS

OFFLINE INSERTION

7M0653-7020A



① No **Unlock connector**

③ No **Terminal Backing Out**

② No **Wrong insert**

④ No **Deformed Terminal**

⑤ Check the **Alignment**

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