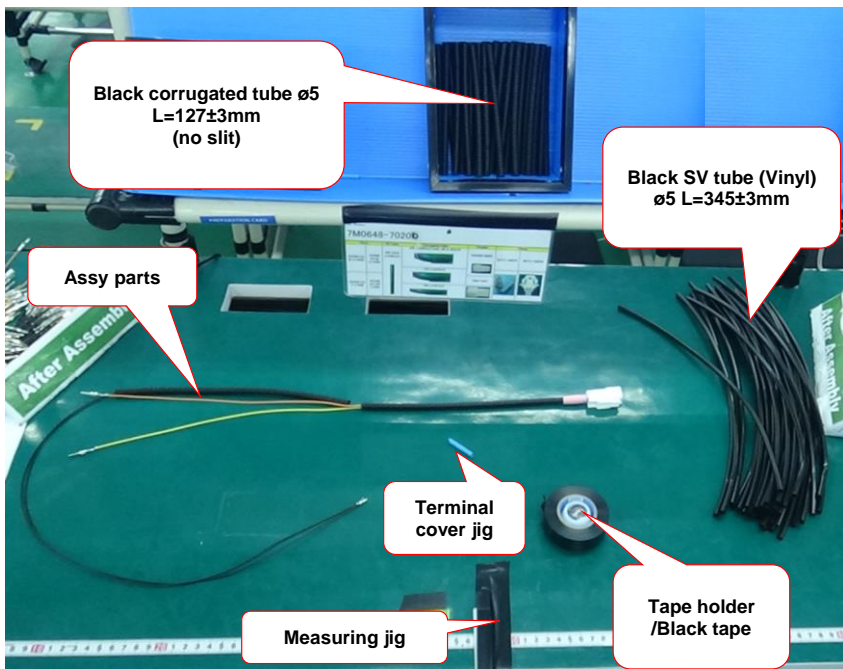

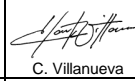
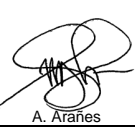

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	TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Process Name/Title:	D01L / 7M0648-7020D		Customer:	TRJ	Car Model:	DAIHATSU-TANTO
	Model code/Part number:			Document No.:	WI-ENG-PDE-095B		
Purpose:	<input type="checkbox"/> PROTOTYPE	<input type="checkbox"/> PRE-LAUNCH	<input checked="" type="checkbox"/> MASSPRO	Revision No.:	6	Page No.:	1 of 5

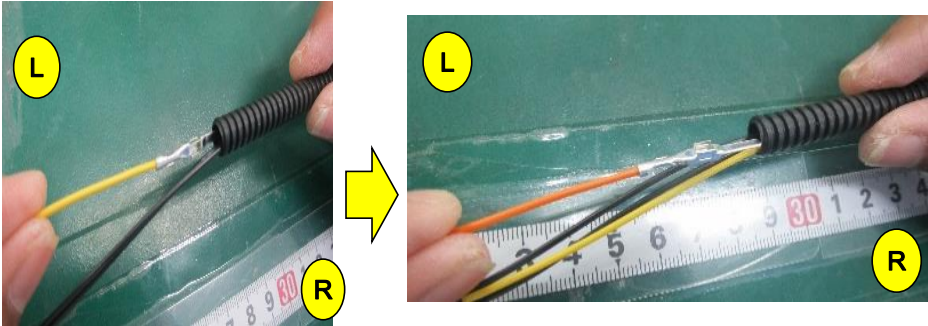
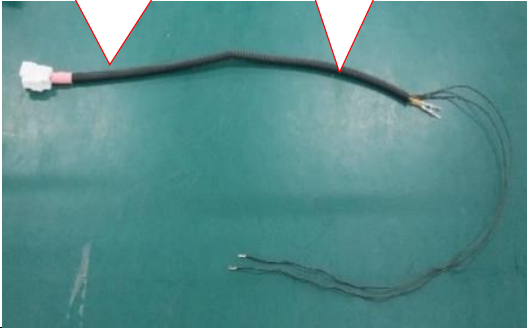
PARTS:	1. Assy parts; Black corrugated tube ø5 L=127±3mm (no slit); Black SV tube (Vinyl) ø5 L=345±3mm; Black tape			JIG:	1. Measuring jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
1	<div>6</div> P2 Table lay-out	<div>TABLE LAY-OUT</div> 	<div>Safety Instruction</div> Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.) <div>Housekeeping</div> 1. Maintain and always practice 5's. 2. Personal things on the workplace is prohibited. Keep it in your locker. <div>Alert level</div> For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.	1. No missing parts/tools 2. No excess parts/tools	

Revision History								Prepared by	Reviewed by	Approved by	Noted by
01/22/25	6	Transfer wire insertion to connector and connector lock to P3. Inclusion of Car model "DAIHATSU-TANTO". Improved Tble lay-out and Visual inspection/Quality checkpoint.	D.Castillo	C. Villanueva	A. Arañes	n/a	 D.Castillo	 C. Villanueva	 A. Arañes	n/a	
05/17/23	5	Inclusion of quality checkpoints	J. Loterte	C. Villanueva	A. Arañes	n/a					
10/26/22	4	Transfer process no.9 Taping 3:Black corrugated tube to vinyl tube to P4 due to process improvement	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-095B		
	Model code/Part number: D01L / 7M0648-7020D		Customer: TRJ	Car Model: DAIHATSU-TANTO	Revision No.: 6 Page No.: 2 of 5		
Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO							


PARTS:		1. Assy parts		JIG:	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
2	P2 Wire insertion to Assy parts (Black corrugated tube ø5 L=246±3mm (No Slit))	<div><div><div>1. Hold the corrugated tube ø5, L=246±3mm (Assy parts) using right hand, then insert the Yellow wire using left hand.</div><div>2. Get the Orange wire then insert using left hand</div></div><div><div>ø5, L=246±3mm (with slit in)</div><div>ø5, L=246±3mm (no slit)</div></div></div>	n/a	1. No wrong use of parts 2. No deformed terminal	








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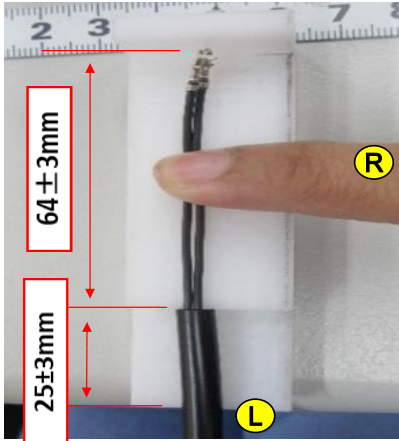
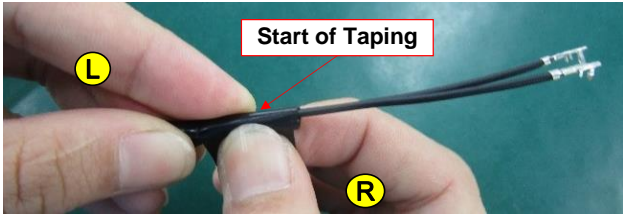
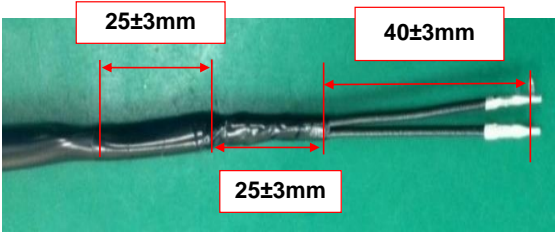

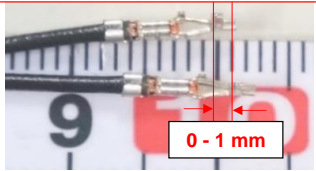
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	WORK INSTRUCTION			Effectivity Date:	January 22, 2025		
	Process Name/Title: TAPING ASSEMBLY PROCESS			Validity Date:	n/a		
	Model code/Part number: D01L / 7M0648-7020D		Customer: TRJ	Car Model: DAIHATSU-TANTO	Document No.:	WI-ENG-PDE-095B	
	Purpose: <input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO			Revision No.:	6	Page No.:	3 of 5

PARTS:		1. Black Corrugated tube $\phi 5$ L=127 \pm 3 (No slit) 2. Black SV tube (Vinyl) $\phi 5$ L=345 \pm 3mm		JIG:	1. Terminal cover jig
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	Wire insertion to Black Corrugated tube $\phi 5$ L=127 \pm 3 (No slit)	<div>  <p>1. Get the terminal cover jig using right hand and insert the wires using left hand.</p> </div> <div>  <p>2. Hold the corrugated tube $\phi 5$ L=127\pm3 no slit using right hand then and insert the Black wires.</p> </div> <div>  <p>3. After insertion, remove the terminal cover jig using right hand.</p> </div> 	<div> TERMINAL COVER JIG </div> 	1. No wrong use of parts 2. No deformed terminal	
4	Wire insertion to Black SV tube (Vinyl) $\phi 5$ L=345 \pm 3mm	<div>  <p>1. Get the 2 Black wires using left hand and get the SV tube (Vinyl) $\phi 5$ L=345\pm3mm then insert to wire using right hand.</p> </div> 	n/a	1. No wrong use of parts 2. No deformed terminal	

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	Model code/Part number: D01L / 7M0648-7020D		Customer: TRJ	Car Model: DAIHATSU-TANTO	Document No.:	WI-ENG-PDE-095B	
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PARTS:		1. Assy parts 2. Pink tape		JIG:	n/a	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION		TOOLS/PPE	QUALITY POINTERS	
5	P2 Taping 2 Black SV tube (Vinyl) to wire near terminal	<div><p>1. Get the assy part and measure the end of the SV tube (Vinyl) up to the terminal tip 64±3mm. Then, measure 25±3mm from the end of SV tube (Vinyl) using measuring jig.</p></div> <div><p>2. Hold the SV tube (Vinyl) using left hand and get the Black tape then start taping using both hands.</p></div> <div><p>3. After taping, check the condition of tape, measurement and wire alignment.</p></div>		<div><p>Measuring tape</p></div>	<p>Important reminders/Note/s: 1. Please use calibrated/verified measuring tape when getting the measurement.</p> <p>Document references: 1. Refer to WI-PRO-ASY-001B for Taping procedure</p> <div><p>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</p></div> <div><p>Wire alignment tolerance</p></div>	

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**WORK INSTRUCTION**

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TAPING ASSEMBLY PROCESS

Effectivity Date:

January 22, 2025

Validity Date:

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Model code/Part number:

D01L / 7M0648-7020DCustomer: **TRJ**Car Model: **DAIHATSU-TANTO**

Document No.:

WI-ENG-PDE-095B

Purpose:



PROTOTYPE



PRE-LAUNCH



MASSPRO

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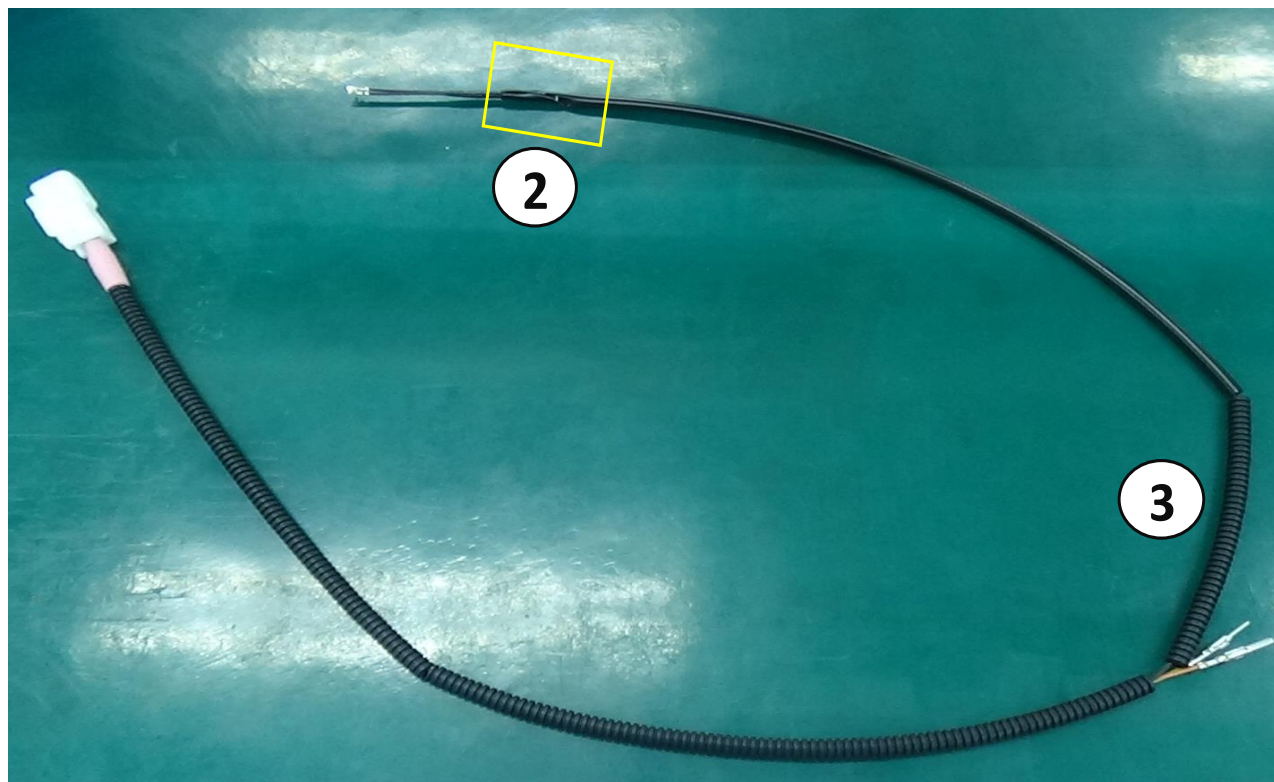
5 of 5

PARTS:

1. Assy parts

JIG:

n/a

**VISUAL INSPECTION/ QUALITY CHECKPOINTS****TAPING - P2****7M0648-7020D**

- ① No Deformed terminal
- ② No Missing Tape/
No Wrong color of
tpe
- ③ No Missing parts (COT)

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