			WORK INSTRUCTION		Effectivity Date:		April 24, 2023		
		Process Name/Title:	TAPING ASSEMBLY PROC	ESS		Validity Date:	n/a		
	1	Model Code/Part Number	817B / 7N0051-7020B Customer:	TRJ		Document No.:		WI-ENG-PDE-25	9
		Purpose:	PROTOTYPE PRE-LAUNCH	MASSPRO		Revision No.:	4	Page No.:	1 of 6
		•					1 1	•	
PARTS:		Pre-Assy parts Black tape				JIG:	n/a		
NO.		PROCESS NAME	WORK PROCEDURE/ ILLUSTRA	ATION		TOOLS/PPE	QUALITY POINTERS		
1		P1 Table Lay-out	Table Lay-OUT  Assy parts  Tape holder/Black tape	DOTAL STATE OF THE PARTY OF THE		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.		arts/tools  ocument reference -ENG-PDE-258 fo	
			Revision History			Prepared by R	Reviewed by	Approved by	Noted by:
04/24/23 4		clusion of quality checkpoints	00(0(4))	J. Loterte C. Villanueva	A. Arañes n	ı/a			
09/09/22 3	tei		o 33(+3/-1mm) as countermeasure for encountered NG dimension from end of tape to e/Illustration on process no. 2, 3, 4 and 5; Quality pointers and notes on page no.1, 2, nt.	M. Ariola J. Loterte	C. Villanueva A. Ar	rañes Au	ant Tilloum		
09/23/21 2			ear connector and update the illustration.	D. Castillo J. Loterte	C. Villanueva A. Ar	- \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	10/1	ANTA	
07/08/21 1		hanged from pre-launch to masspro		D. Castillo C. Villanueva			. Villanueva	A Arabes	n/a
Eff. Date Rev. I	No		Details of Change	Revised Reviewed	Approved No	oted Est. Date: April 8	8, 2021		

			WORK INSTRUC	CTION		Effectivity Date:		April 2	4, 2023			
		Process Name/Title:	TAPING AS	SEMBLY PRO	CESS	Validity Date:		n/a				
		Model Code/Part Number	817B / 7N0051-7020B	Customer:	TRJ	Document No.:		WI-ENG-	PDE-259			
		Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:		4 Page No.:	2 of 6			
PARTS:	1. Black 2. Assy						JIG n/	ı/a				
NO.	Р	ROCESS NAME	WORK PROCE	EDURE/ ILLUSTF	RATION	TOOLS/PP	PΕ	QUALITY POINTERS				
2	P1	Taping 1 Corrugated tube to wire near terminal	A STATE OF THE STA	3. Confirm measu tape up to termin taping process us	end of COT up to terminal pointed a continue the taping process using turement of 33±3mm from end of the pointed tip then continue the	MEASURING TA 6 7 8 9 1 2 3 4 5 6  Weekle 2 2000 1000 2000 2000 2000 2000 2000 2	2. 3. 4. 5. 6.	. No peel-off tape 2. No flip-out tape 3. No loose tape 4. No wrong use of t 5. No wrong dimens 6. No missing tape  Important remains 1. Please use calibus measuring tape who measurement.	inders/Note/s: rated/verified			

				WORK INSTRUCT	ΓΙΟΝ		Effectivity Date:			April 24	l, 2023
		Process Name/Title: TAPING ASSEMBLY PROCESS							n/a		
		Model Code/Part Number	817B /	7N0051-7020B	Customer:	TRJ	Document No.:			WI-ENG-F	PDE-259
		Purpose:	PROTOTY	PE	PRE-LAUNCH	MASSPRO	Revision No.:		4	Page No.:	3 of 6
							1		<u> </u>		
PARTS:	1. Black 2. Assy							JIG	n/a		
NO.	P	ROCESS NAME		WORK PROCE	OURE/ ILLUSTRATI	ON	TOOLS/	PPE	QI	JALITY F	POINTERS
3	P1	Taping 2 Corrugated tube to wire near connector	L 25±3mm			the corrugated tube up to the 3mm. Then continue taping	MEASURING 6 7 8 9 1 2 3 4	5 TAPE	2. No flip 3. No loo 4. No wro 5. No wro 6. No mis Impo 1. Please measuri measure 2. Avoid adjust the the toler If encounthe proc	se tape ong use of ta ong dimensi ssing tape  ortant remi e use calibr ing tape whe ement.  I pulling do ne dimensic ance during ntered abne	anders/Note/s: rated/verified en getting the wan the COT to on if still within g measurement. ormality STOP the Leader and

		Process Name/Title:	Effectivity Date: Validity Date:		<b>April 24, 2023</b> n/a						
		Model Code/Part Number	817B /	7N0051-7020B	Customer:	TRJ	Document No.:			WI-ENG-P	DE-259
		Purpose:	☐ PROTOTYF	PE [	☐ PRE-LAUNCH ■ MASSPRO		Revision No.:		4	Page No.:	4 of 6
ARTS:	n/a							JIG	n/a		
NO.	Р	ROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/I	PPE	QUALITY POINTERS			
							UAL PRODUC	CT	-	MASTER S	AMPLE
		Visual/By two's		,				è	1. No sl	kip checking on.	during



1. Conduct alignment of harness (Master sample vs. Assembled parts) using both hands.

Master sample



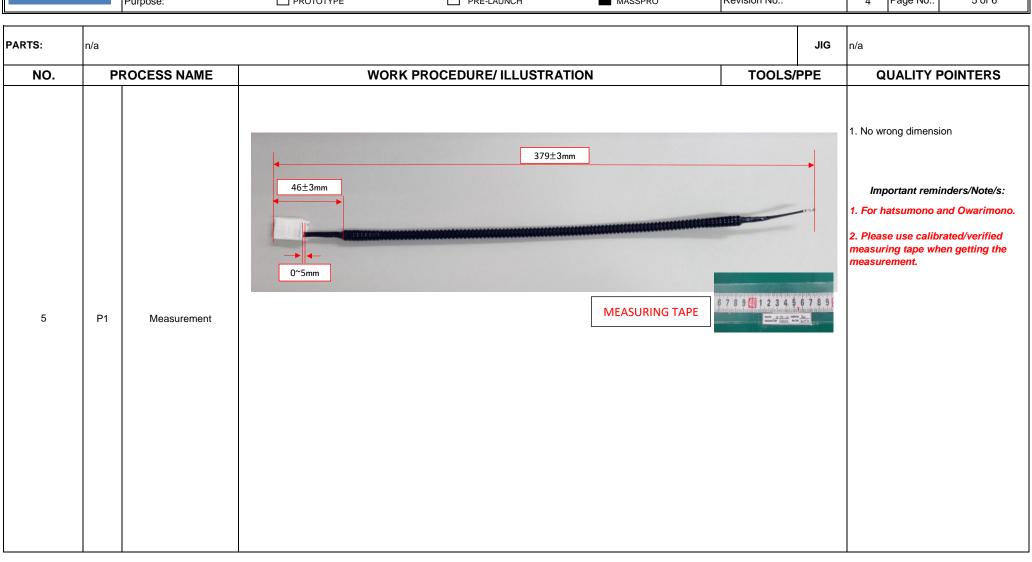
2. Check the connector lock, wire insertion and taping condition.



3. Check the taping condition and terminal appearance. Must be no deformed terminal.

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WORK INSTRUCTION					Effectivity Date:	April 24, 2023			
Process Name/Title:	le: TAPING ASSEMBLY PROCESS						n/a		a
Model Code/Part Number:	817B	1	7N0051-7020B	Customer:	TRJ	Document No.:		WI-ENG-	PDE-259
Purpose:	☐ PR	ОТОТҮР		PRE-LAUNCH	MASSPRO	Revision No.:	4	Page No.:	5 of 6



	WORK	INSTRUCTION		E# - chile : D-t-		A! 1 0 4	0000
Process Name/Title:		Effectivity Date:  Validity Date:	· · · · · · · · · · · · · · · · · · ·				
Model Code/Part Num		PING ASSEMBLY PROC -7020B Customer:	TRJ	Document No.:		WI-ENG-F	
						1	
Purpose:	☐ PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	4	Page No.:	6 of 6
PARTS: n/a				JI	<b>G</b> n/a		
-		4 QUALITY CHECKPO	DINTS	-1	•		
P1		<b>7N005</b> 1	L-7020B				
GOOD  NO GOOD	2 No Missi	ing Tape (3) No		(3)			OD OOD OOD
1 No Unlock Co	oupier 						