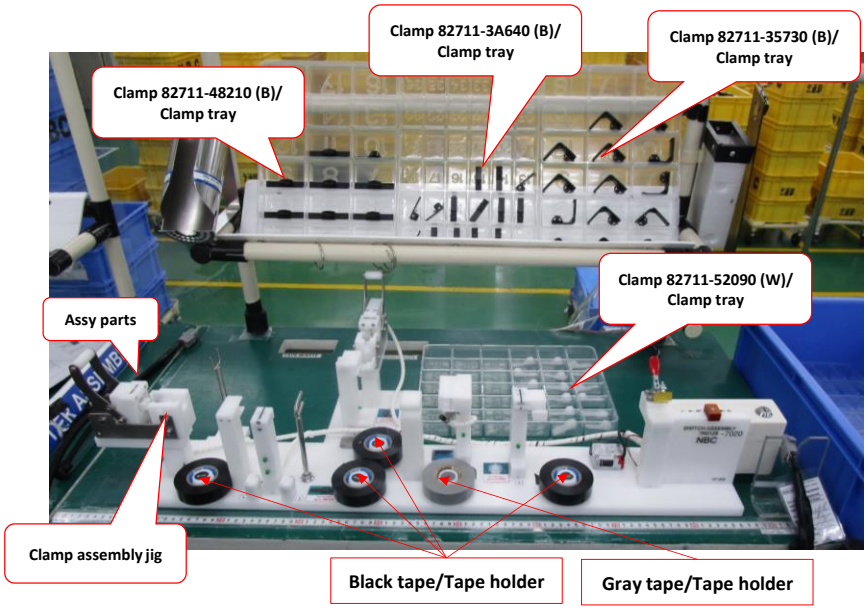
	WORK INSTRUCTION			Effectivity Date:	January 06, 2022		
	Process Name/Title:	TAPING ASSEMBLY PROCESS		Validity Date:	n/a		
	Model Code/Part Number:	178D / 7N0128-7020	Customer: TRJ	Document No.:	WI-ENG-PDE-331C		
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.:	1 of 6

PARTS:	1. All parts: Assy parts; Clamp 82711-48210 (B); Clamp 82711-3A640 (B); Clamp 82711-35730 (B); Clamp 82711-52090 (W); Black tape [4pcs.]; Gray tape [1pc.]	JIG:	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
1	P3	1 Table Lay-out	**Table Lay-out**  	**Safety Instruction** Be sure to wear required 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.	1. No missing parts/tools 2. No excess parts/tools

Revision History							Prepared by	Reviewed by	Approved by	Noted by
01/06/22	1	Change from Pre-launch to Masspro. Improve work procedure/Illustration and quality pointers; Additional Table Lay-out.	M. Catapang	J. Loterte	C. Villanueva	A. Arañes	M. Catapang	J. Loterte	C. Villanueva	A. Arañes
09/09/21	0	Initial issue	M. Catapang	J. Loterte	C. Villanueva	A. Arañes				
Eff. Date	Rev. No	Details of Change	Revised	Reviewed	Approved	Noted	Est. Date:	September 09, 2021		

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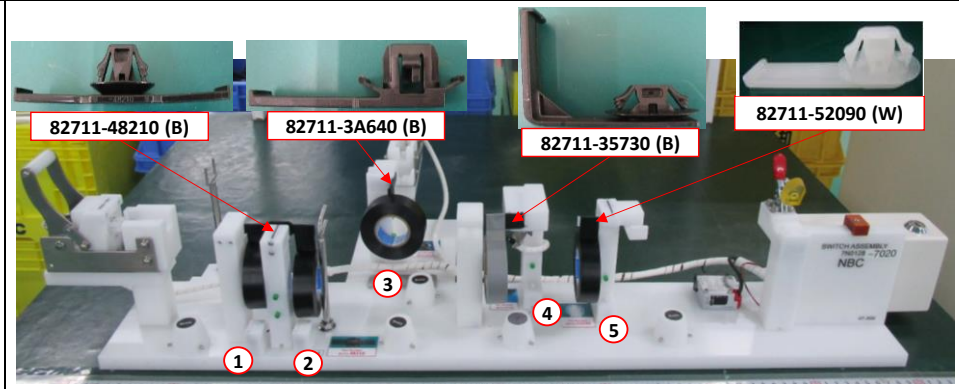
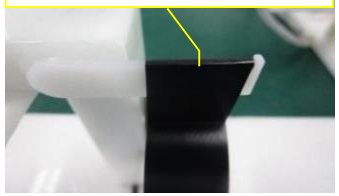
PARTS: 1	1. Clamp 82711-48210 (B) 2. Clamp 82711-3A640 (B) 3. Clamp 82711-35730 (B	4. Clamp 82711-52090 (W) 5. Black tape [4pcs.] 6. Gray tape [1pc.]	JIG	1. Clamp assembly jig

NO.	PROCESS NAME		1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
2	P3	Clamp setting	 **Note: Please check the Clamp first before start of assembly to avoid wrong use of clamp.** 1. Get 1 pc. of clamp **82711-48210 (B)** using right hand then insert to clamp location **1 and 2** using both hands. 2. Get 1 pc. of clamp **82711-3A640 (B)** using right hand then insert to clamp location **3** using both hands. 3. Get 1 pc. of clamp **82711-35730 (B)** using right hand then insert to clamp location **4** using both hands. 4. Get 1 pc of clamp **82711-52090 (W)** using right hand then insert to clamp location **5** using both hands. 5. Get the **Black tape** then initially attach to clamp location **1, 2, 3, and 5** using both hands. 6. Get the **Gray tape** then initially attach to clamp location **4** using both hands.	n/a	**STANDARD TAPING FOR CLAMP** One side tape under clamp  1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wvrong clamp position

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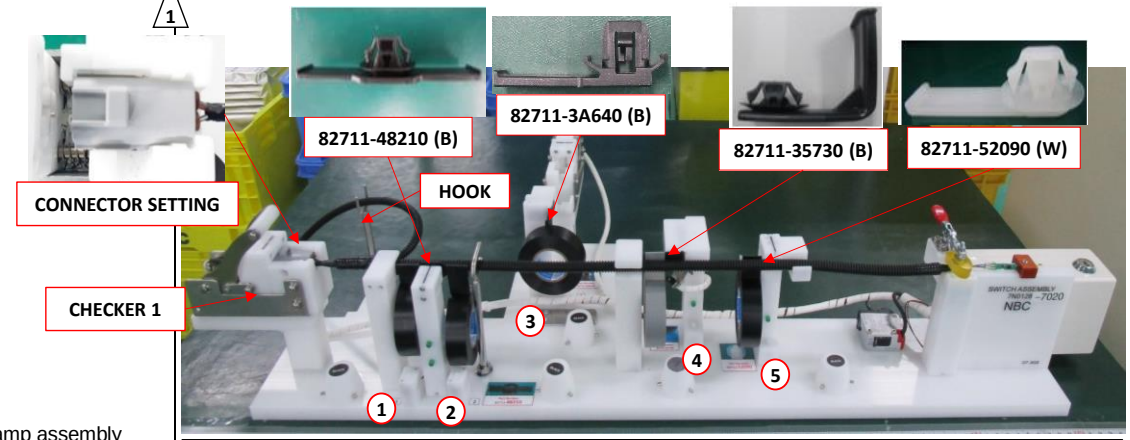
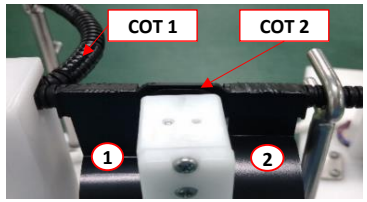
	Purpose:	☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO		Revision No.:	1	Page No.:	3 of 6

PARTS:	1. Assy parts 2. Black tape	JIG	1. Clamp assembly jig

NO.	PROCESS NAME		1 WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3	Clamp assembly	 1. Get the assy parts and set into jig. ***(See above picture for correct setting of harness).*** First, set the connector **6188-0066 (GR)** to **Checker 1** then pull the checker fixture for continuity checking. Second, put the assy parts with black connector **6189-1161 (B)** into **HOOK.** Continue to set the harness in jig. Last, set the PCB within the stopper then press by **Toggle clamp**. Continue if the sequence light of location **1** was **ON.** 2. Check if all LED light for **Power On, Clamp On, Wire1 & Wire2** was **ON.** If encountered abnormality, **STOP** and immediately **CALL** the attention of the leader. **WAIT** for further instruction then continue the process.  3. On clamp location **1,** make **2 windings** of tape using both hands. Repeat the process on clamp location **2.** ***Note: DO NOT CUT THE TAPE.***	n/a	 *Note: Make sure no gap between stopper jig and PCB* 1 1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position

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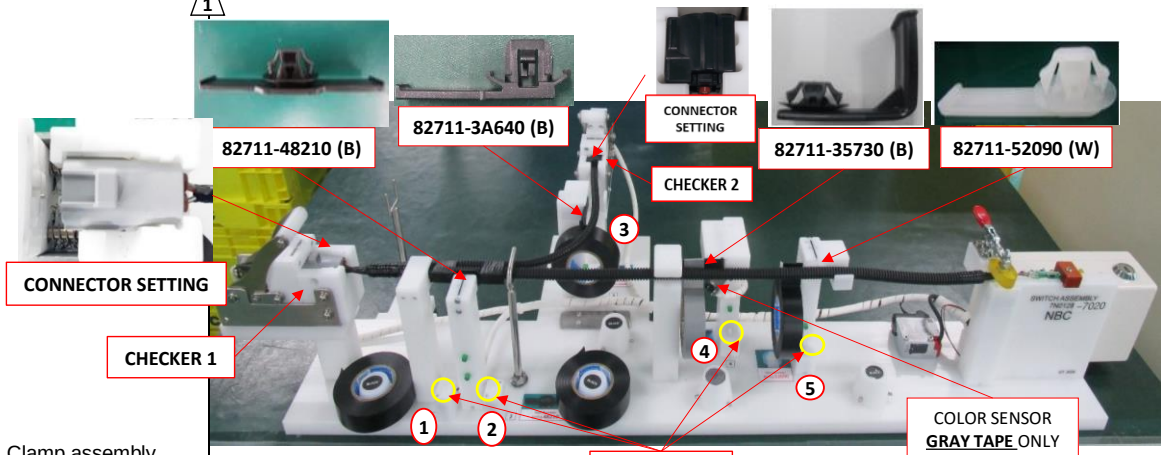
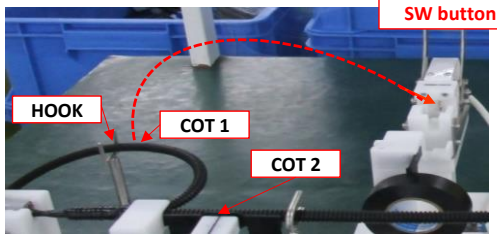
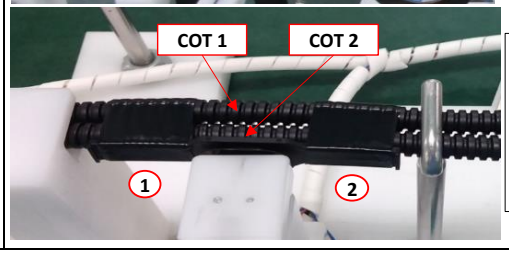
	Purpose: ☐ PROTOTYPE ☐ PRE-LAUNCH ■ MASSPRO			Revision No.:	1	Page No.: 4 of 6

PARTS:	1. Assy parts 2. Black tape	JIG	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3	Clamp assembly (Continuation)	  4. Remove the assy parts with Black connector **6189-1161 (B)** from **HOOK** then set to **CHECKER 2,** pull down the handle to lock using both hands.  5. Combine the **COT 1** and **COT 2** using both hands. On clamp location 1, hold the tape then make **3 windings** of tape then cut the tape using both hands. Press the **SW button** using both hands. Continue if the sequence light on clamp **2** was **ON.**	n/a	 *Note: Make sure no gap between stopper jig and PCB* 1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position

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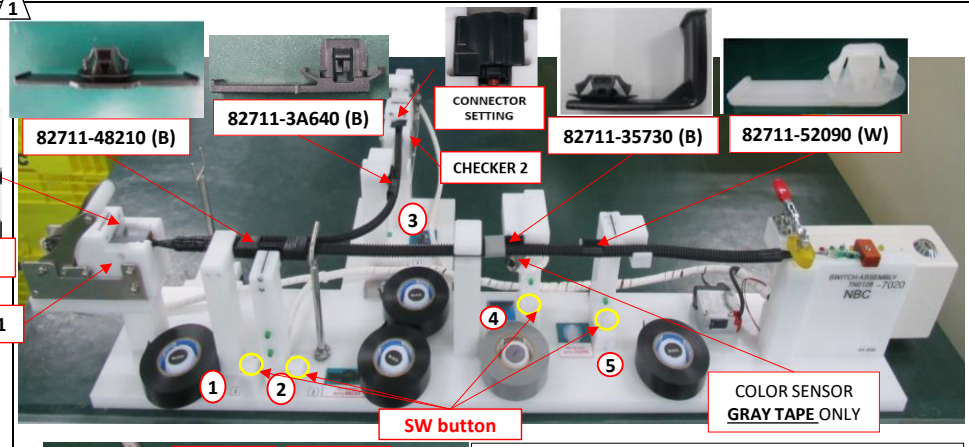
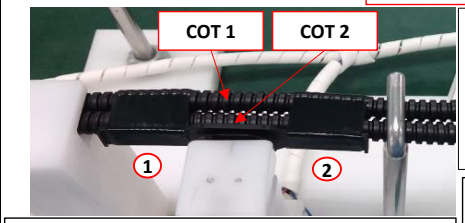
PARTS:	1. Assy parts 2. Black tape	3. Gray tape	JIG	1. Clamp assembly jig

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
3	P3	Clamp assembly (Continuation)	  6. On clamp location **2**, hold the tape then make **3 windings** of tape then cut the tape using both hands. Press the **SW button** using both hands. Continue if the sequence light on clamp **3** was **ON.** 7. Hold the tape on clamp location **3**, make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. Continue the process if sequence light on clamp location **4** was **ON.** 8. Hold the tape on clamp location **4**, make **3 windings** of tape then cut the tape using both hands. **Color sensor** light will beep/buzz if sensor detects **Gray tape.** Press the **SW button** after taping. Continue the process if sequence light on clamp location **5** was **ON.** 9. Hold the tape on clamp location **5**, make **3 windings** of tape then cut the tape using both hands. Press the **SW button** after taping. **Go** sound will be heard. 10. After taping, **CONDUCT POINT CHECKING** before removing the harness from jig.	n/a	 *Note: Make sure no gap between stopper jig and PCB* 1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position

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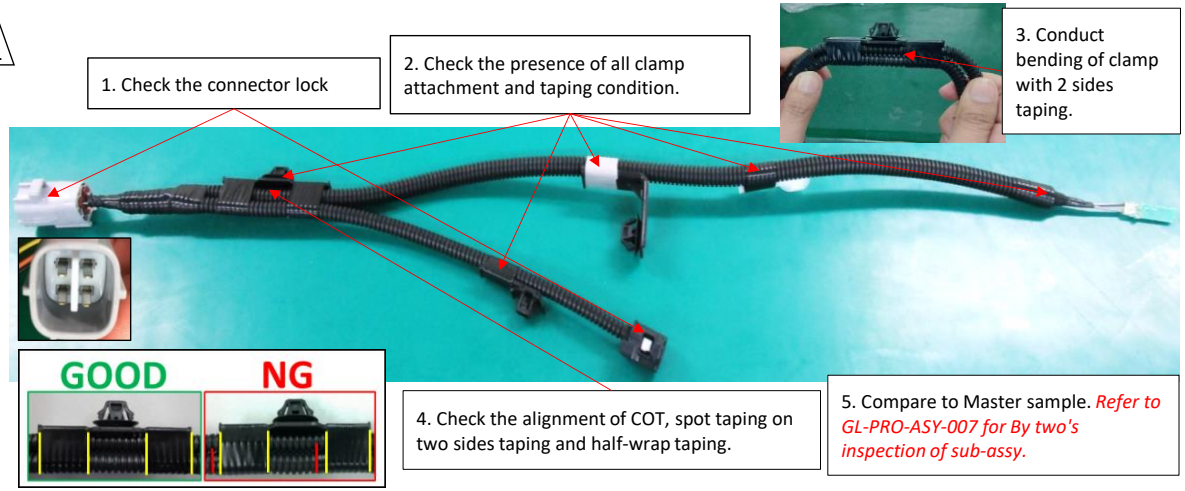
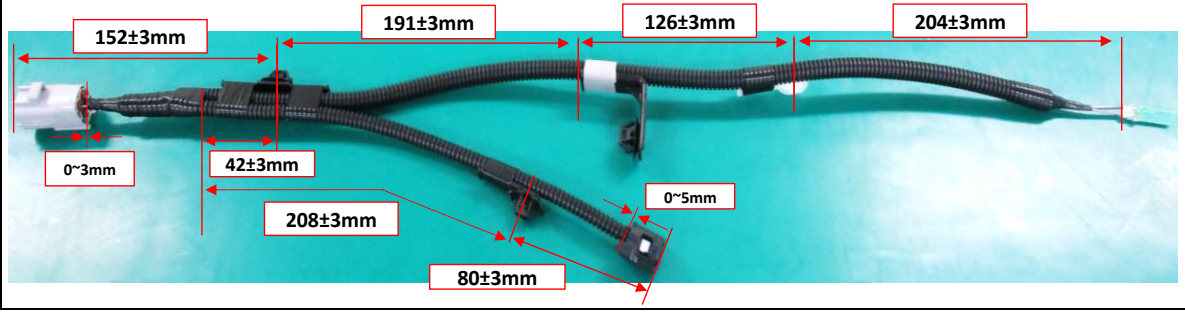
PARTS:	n/a	JIG	n/a

NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS
4	P3	Visual/By Two's Inspection	1  		MASTER SAMPLE
5		Measurement	1 MEASURING TAPE *Note:* *Please use calibrated/verified measuring tape when getting the measurement.*  		***FOR HATSUMONO AND OWARIMONO*** 1. No wrong dimension

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