						WORK IN	STRUCTION			Effec	tivity Date:		April 26, 2023	3
			Process Name/Title:			TAPIN	G ASSEMBLY PRO	CESS		Valid	ity Date:		n/a	
	-10	5	Model code/Part number:	500B	1	7L0084-7023	Customer:	TRQSS		Docu	ment No.:		WI-ENG-PDE-42	26C
			Purpose:	PRO	TOTYPE	E	PRE-LAUNCH	MASSPRO		Revis	sion No.:	3	Page No.:	1 of 10
												•	•	
PARTS:		. Assy p	oarts 5 82711-52090 (W)				<ol> <li>4. Clamp 82711-3A540</li> <li>5. Black tape [5pcs.]</li> </ol>	(W)			JIG:	Insertion     Locking		
			82711-48070 (GR)				6. Blue tape [1pc.]				0.0.	3. Termina		
NO		PF	ROCESS NAME			WORK P	ROCEDURE/ ILLUSTI	RATION			TOOLS/PPE		QUALITY POIN	TERS
1		Р3	Table Lay-out		Assy par		Clamp 82711-48070 (GR Clamp Tray			1 F.	Be sure to wear required personal required personal during operation (gloves, finger cots etc.)  Housekeeping Maintain and alw: practice 5's. Personal things of the workplace is prohibited. Keep it your locker.  Alert level or any trouble, infone Assembly Assista Supervisor or Line.eader for immedia corrective action.	ays  1. No miss 2. No exce 3. No wron  rm	ing parts/tools ss parts/tools g position of parts/to	ools
		•				Revision History					Prepared by	Reviewed by	Approved by	Noted by
04/26/23			of quality checkpoints			·		J. Loterte C. Villanueva	A. Arañes r	n/a				
11/12/22			quality pointers, notes referend n in process no.5 - visual/by tv		2,3,4,5 a	and 6 as document impro	vement. Work procedure and	M. Catapang J. Loterte	C. Villanueva A. A	rañes	$\bigcirc$	. / /	Alas	
03/23/22			document purpose from Pre-la	unch to masspro	)					rañes	CXIN	Jone House		,
03/21/22 Eff. Date R		nitial issu	ie	D-1	taile of C	Shanga		· · · · ·		rañes	J.Loterte	C. Villanueva	✓ A. Arañes	n/a
Lii. Date R	ev. NO			Det	tails of C	unange		Revised Reviewed	Approved No	oted	Est. Date:	March 21, 2022		

					WORK INSTRUC	TION		Effectivity Date:			April 26	5, 2023
		Process Name/Title:			TAPING ASS	EMBLY PR	OCESS	Validity Date:			n/	а
		Model code/Part number:	500B	1	7L0084-7023	Customer:	TRQSS	Document No.:			WI-ENG-F	PDE-426C
		Purpose:		PROTOTYPI		PRE-LAUNCH	MASSPRO	Revision No.:		3	Page No.:	2 of 10
<u> </u>	1							1	I			
		parts o 82711-52090 (W) [2pcs.] o 82711-48070 (GR) [2pcs.	]			4. Clamp 8271 5. Black tape [			JIG	1. Clamp	Assembly	iig
NO.	PI	ROCESS NAME			WORK PROCEI	DURE/ ILLUS	STRATION	TOOLS/	PPE	QI	UALITY F	POINTERS
2	P3	Clamp setting			82711-48070 (G	3	82711-3A540 (W)  4 5  1-52090 (W)	SMITTH ASSEMBLY NBC 1		1. No wro 2. No wro 3. No dai		ape np
					s. of clamp 82711-52090 (W) set to clamp location 1 and 5		3. Get 1pc. of clamp 82711-3A! then set to location 3 using bot			1. Pleas	e check the (	ers/Note/s: Clamp first before avoid wrong use of
					s. of clamp <mark>82711-48070 (GR)</mark> set to clamp location <b>2 and 4</b>		4. Initially attach Black tape to and 5 using both hands.	clamp location 1, 2, 3, 4		GOOD 82711-5	CLAMP ILLU	NG 82711-12A80 (W)
											, ,	eri 11 12/100 (11)

					WORK INSTRUCT	TON		Effectivity Date:			April 26	, 2023
		Process Name/Title:			TAPING ASS	EMBLY PR	OCESS	Validity Date:			n/	a
		Model code/Part number:	500B	1	7L0084-7023	Customer:	TRQSS	Document No.:			WI-ENG-F	DE-426C
		Purpose:		PROTOTY	PE 🔲	PRE-LAUNCH	MASSPRO	Revision No.:		3	Page No.:	3 of 10
	I							<u> </u>	I	<u> </u>		
PARTS:	1. Assy 2. Blue t								JIG	n/a		
NO.	PI	ROCESS NAME			WORK PROCED	URE/ ILLUS	TRATION	TOOLS/	PPE	C	QUALITY F	POINTERS
3	P3	Taping 1 Black corrugated tube to Black sunprene tube		Start of f	184±3mm using b	2. Get the Blue t start taping proc	elted wire 176±3mm and up  rape using right hand then less using both hands.	MEASURING 6 7 8 9 1 1 2 3 4	W(	1. Use 2. Plet measu measu 1. No fli 2. No p 3. No lo 4. No m 5. No w	ip-out tape eel-off tape oose tape irong use of tarong dimensi	only ated/verified en getting the

3. After taping, check the measurement and taping condition.

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Process Name/Title: TAPING ASSEMBLY PROCESS  Model code/Part number: 500B / 7L0084-7023   Oustomer: TRQSS   Document No.: WH-ENG-PDE-426C   WH-ENG-PDE-426C   WH-ENG-PDE-426C   Document No.: WH-ENG-PDE-426C   WH						WORK INSTRU	CTION	Effectivity Date:		April 26	5, 2023	
PARTS:  1. Assy parts 2. Black tape  NO. PROCESS NAME  WORK PROCEDURE/ILLUSTRATION  TOOLS/PPE  QUALITY POINTERS  RECEIVER BASE 1  CONNECTOR SETTING  CONNECTOR SETTING  CONNECTOR SETTING  1. No wrong use of parts 2. No wrong use of farpe 3. No wrong use of farpe 4. No wrong use of farpe 4. No wrong use of farpe 5. No wrong use of farpe 6. No wro			Process Name/Title:			TAPING AS	SEMBLY PR	OCESS	Validity Date:		n/	'a
PARTS: 1. Assy parts 2. Black tape  NO. PROCESS NAME  WORK PROCEDURE/ ILLUSTRATION  TOOLS/PPE  QUALITY POINTERS  RECEIVER BASE 1  CONNECTOR SETTING			Model code/Part number:	500B	1	7L0084-7023	Customer:	TRQSS	Document No.:		WI-ENG-F	PDE-426C
NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS  RECEIVER BASE 1  COUNECTOR SETTING  RECEIVER BASE 1  COUNECTOR SETTING  RECEIVER BASE 1  COLOR SENSOR 2 YELLOW TAPE only  Important reminders/Note/s: 1. Make sure no ago between stopper and PCB  1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong use of tape 4. No wrong use of tape 4. No wrong use of tape 5. No wrong use of tape 6. No wrong use of tape 7. Life the assy parts and set into jig. (See above picture for correct setting of horness). First, set the connector 6188-0066 (GR) to Checker 1 then pull the checker future for continuity checking. This, set the connector 6188-0066 (GR) to Checker 1 then pull the checker future for continuity checking. Second, set the connector 6188-0066 (GR) to Checker 1 then pull the checker future for continuity checking. Second, set the connector 6188-0066 (GR) to Checker 1 then pull the checker future for continuity checking. Second, set the connector 6188-0066 (GR) to Checker 1 then pull the checker future for continuity checking. Second, set the connector 6188-0066 (GR) to Checker 1 then pull the checker future for continuity checking. Second, set the connector 6188-0066 (GR) to Checker 1 then pull the checker future for continuity checking. Second, set the connector 6188-0066 (GR) to Checker 1 then pull the checker future for continuity checking. Second, set by the connector 6188-0066 (GR) to Checker 1 then pull the checker future for continuity checking. Second, set by the connector of the pull the checker 1 then pull the checker future for continuity checking. Second, set by the connector of the pull the checker 1 then pull the checker 1			Purpose:	F	PROTOTYP	E [	PRE-LAUNCH	MASSPRO	Revision No.:	3	Page No.:	4 of 10
NO. PROCESS NAME WORK PROCEDURE/ ILLUSTRATION TOOLS/PPE QUALITY POINTERS  RECEIVER BASE 1  COUNTECTOR SETTING  RECEIVER BASE 1  COUNTECTOR SETTING  RECEIVER BASE 1  COLOR SENSOR 2 YELLOW TAPE only  Important reminders/Note/s: 1. Make sure no app between stopper and PCB  1. No wrong use of parts 2. No wrong use of parts 2. No wrong use of tape at parts 3. No damaged clamp 4. No wrong clamp position  1. Get the assy parts and set into jig. (See above picture for correct setting of horness). First, set the connector 6188-0066 (GR) to Checker 1 then pull the checker fixture for continuity checking. This, set the connector 6188-0066 (GR) to Checker 1 then pull the checker fixture for continuity checking. This, set the connector 6188-0066 (GR) to Checker 1 then pull the checker fixture for continuity checking. This, set the connector 6188-0066 (GR) to Checker 1 then pull the checker fixture for continuity checking. This, set the connector 6188-0066 (GR) to Checker 1 then pull the checker fixture for continuity checking. This case the connector 6188-0066 (GR) to Checker 1 then pull the checker fixture for continuity checking. This case the connector 6188-0066 (GR) to Checker 1 then pull the checker fixture for continuity checking. This case the connector 6188-0066 (GR) to Checker 1 then pull the checker fixture for continuity checking. This case the connector 6188-0066 (GR) to Checker 1 then pull the checker fixture for continuity checking. This case the connector 6188-0066 (GR) to Checker 1 then pull the checker fixture for continuity checking. This case the connector of the connector of the pull the checker 2 then pull the checker 1 then p		1										
CONNECTOR SETTING  CONNECTOR SETTING  RECEIVER BASE 1  COLOR SENSOR 1 SETTING  RECEIVER BASE 1  COLOR SENSOR 2 YELLOW TAPE only  Important reminders/Note/s:  1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position  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 fature for continuity checking. Second, set the connector 6189-0451 (W) to Checker 2 then pull the checker fature for continuity checking. Third, set the most connector 6189-0451 (W) to Checker 2 then pull the harness in jig. Color sensor 1 will beep/buzz if sensor detects Blue tape. Color sensor 2 will beep/buzz if sensor detects Vellow tape. Last, set the hotmetic wires and terminal end together within the stopper then press by Toggle clamp. Check if the sequence light of	PARTS:								JIG	1. Clam	p Assembly	jig
CONNECTOR SETTING  1. No wrong use of parts 2. No wrong use of tape 3. No damaged clamp 4. No wrong clamp position  1. Get the assy parts and set into jig, <i>(See above picture for correct setting of homess)</i> . First, set the connector 6188-0066 (GR) to Checker 1 then pull the checker fixture for continuity checking. Second, set the connector 6189-0451 (W) to Checker 2 then pull the checker fixture for continuity checking. Third, set the connector 6088-310 (W) to Receiver base 1 then lock. Continue to set the harness in jig, Color sensor 1 will beep/buz if sensor detects blue tape. Color sensor 2 will beep/buz if sensor detects blue tape. Last, set the hometed writes and terminal end togener than press by Toggle clamp. Check if the sequence light to fixed the sequence light	NO.	PF	ROCESS NAME			WORK PROC	EDURE/ ILLUS	TRATION	TOOLS/PPE	C	<b>UALITY</b> F	POINTERS
2. Check if all LED light for Power On, Clamp On, Wire1 & Wire2, Color sensor 1 and Color sensor 2 was ON. If encountered abnormality, STOP and immediately CALL the attention of the leader. WAIT for further instruction then continue the process.	4	P3	Clamp Assembly	1. Get t Checke checke harness Last, se location	he assy pa r 1 then pu fixture fo s in jig. Col- t the hotm n 1 was ON	rts and set into jig. (See abould the checker fixture for correction or sensor 1 will beep/buzz inelted wires and terminal end.)	DINNECTOR SETTING  DOVE picture for correct ontinuity checking. See, set the connector 6 if sensor detects Blue and together within the condition of the condit	color sensor 1 BLUE TAPE only  82711-48070 (GR)  8271  t setting of harness). First, set the connect cond, set the connector 6189-0451 (W) to 098-3810 (W) to Receiver base 1 then lock. tape. Color sensor 2 will beep/buzz if sens e stopper then press by Toggle clamp. Chec	vellow tape.  If encountered	1. No w 2. No w 3. No da	Make sure no oper and PCE rong use of prong use of tangenerates	g <b>ap between</b> 3  Darts Dare

					WORK INSTRU	ICTION			Effectivity Date:			April 26	5, 2023
		Process Name/Title:			TAPING AS	SSEMBLY F	ROCESS		Validity Date:			n/	a
		Model code/Part number:	500B	1	7L0084-7023	Customer:	TRQ	SS	Document No.:			WI-ENG-P	PDE-426C
		Purpose:	F	PROTOTYP	E	PRE-LAUNCH	N	MASSPRO	Revision No.:		3	Page No.:	5 of 10
									1		<u> </u>	<u> </u>	
PARTS:	1. Black 2. Assy									JIG	1. Clamp	Assembly j	iig
NO.	PF	ROCESS NAME			WORK PROC	EDURE/ ILLI	JSTRATION		TOOLS/	PPE	QI	UALITY F	POINTERS
4	P3	Clamp Assembly (Continuation)	3. cu Cc	Hold the tat the tape intinue the	ape on clamp location 1. No using both hands. Press the process if sequence light ape on clamp location 2. No the SW button after tapin	CONNECTOR SETTING  Make 3 windings of the SW button after in clamp location 2  Make 3 windings of the SW button after in clamp location 2	taping. was ON.  No tu  tape then cut the tape of	Layer 2 6098-3810 (W) Layer 3 6189-0451 (W)  ote: Follow the correct arbes before taping.	11-52090 (W)		1. Mo wro 2. No wro 3. No dai		oarts ape ip

									1	
					WORK INSTRUC			Effectivity Date:	April 26,	2023
		Process Name/Title:			TAPING ASS	SEMBLY PR	OCESS	Validity Date:	n/a	
		Model code/Part number:	500B	1	7L0084-7023	Customer:	TRQSS	Document No.:	WI-ENG-PD	E-426C
		Purpose:	P	ROTOTYP	,E	PRE-LAUNCH	MASSPRO	Revision No.:	3 Page No.:	6 of 10
PARTS:	1. Black 2. Assy							JIG	1. Clamp Assembly jig	
NO.	PI	ROCESS NAME			WORK PROCE	DURE/ ILLUS	TRATION	TOOLS/PPE	QUALITY PO	INTERS
4	P3	Clamp Assembly (Continuation)	5. Hold the then cut the taping. Con was ON.  6. Hold the then cut the	tape on cle tape usin tinue the	CHECKER 2	NNECTOR SETTING  dings of tape button after clamp location 4  dings of tape button after	COLOR SENSOR 1 BLUE TAPE only	SW button after taping.	Important remind  1. Make sure no g stopper and PCB  1. No wrong use of pa 2. No wrong use of tag 3. No damaged clamp 4. No wrong clamp pos	ap between  rts  be

					WORK INSTRUC	TION		Effectivity Da	ite:		April 26	, 2023
		Process Name/Title:			TAPING ASS	EMBLY P	ROCESS	Validity Date			n/	a
		Model code/Part number:	500B	1	7L0084-7023	Customer:	TRQSS	Document N	0.:		WI-ENG-P	DE-426C
		Purpose:	PR	ОТОТҮР	:	PRE-LAUNCH	MASSPRO	Revision No.	:	3	Page No.:	7 of 10
<u> </u>	1	•									<u>'</u>	
PARTS:	1. Assy	parts			•				JIG	n/a		
NO.	PI	ROCESS NAME			2 WORK PROCE	DURE/ ILLU	ISTRATION	TOOL	S/PPE	C	UALITY F	POINTERS
5	P3	Visual Inspection/By Two's inspection	Assembled parts		2. Check tterminal, taping cor sample  1. Conduct alignment of harness (Master sample vs. assembled parts)			3. Check the presence of clarattachment and taping cond		1. No sl	MASTER kip checking	SAMPLE  during inspection



using both hands.

	_				WORK INSTRUC	TION		Effectivity Date:			April 26,	2023
		Process Name/Title:				SEMBLY PRO	CESS	Validity Date:			n/a	l
		Model code/Part number:	500B	1	7L0084-7023	Customer:	TRQSS	Document No.:			WI-ENG-P	DE-426C
		Purpose:		PROTOTY	/PE	] PRE-LAUNCH	MASSPRO	Revision No.:		3	Page No.:	8 of 10
PARTS:	n/a							,	JIG	n/a		
NO.	Р	ROCESS NAME			WORK PROCE	DURE/ ILLUST	RATION	TOOLS/I	PE	C	QUALITY P	OINTERS
5	P3	Visual/By two's inspection		S. Charlet	the presence of clamp		6. Conduct the presence and colore and taping condition.	ed tape used		1. No sk	MASTER S	SAMPLE
	F3	(Continuation)			ent and taping condition.							



7. Check the terminal and PCB appearance. Must be no deformed terminal.

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					WORK INSTRUCT	ION		Effectivity Date:			April 26	3, 2023
		Process Name/Title:			TAPING ASSI	EMBLY PF	ROCESS	Validity Date:			n/	'a
		Model code/Part number:	500B	1	7L0084-7023	Customer:	TRQSS	Document No.:			WI-ENG-F	PDE-426C
		Purpose:	P	ROTOTYPE	: 🗆	PRE-LAUNCH	MASSPRO	Revision No.:		3	Page No.:	9 of 10
	1											
PARTS:	n/a								JIG	n/a		
NO.	Pi	ROCESS NAME			WORK PROCED	URE/ ILLU:	STRATION	TOOLS/I	PPE	Q	UALITY F	POINTERS
9	P3	Measurement	0~5mm	0°5mm	MEASURING TAP  6 7 8 9 1 2 3 4 5 6 7  100 ± 5mm  0°5mm  116 ± 3mm	Note: Please us when get	e calibrated/verified measuring tape ting the measurement.  397±3mm  124±3mm	339±3mm		1. FOR OWAR	tant reminde R HATSUMON RIMONO	NO AND

	WORK INS	TRUCTION		Effectivity Date:	April 26, 2023
Process Name/Title:		G ASSEMBLY PROC	ESS	Validity Date:	n/a
Model code/Part number:	500B / 7L0084-702	Customer:	TRQSS	Document No.:	WI-ENG-PDE-426C
Purpose:	PROTOTYPE	PRE-LAUNCH	MASSPRO	Revision No.:	3 Page No.: 10 of 10
PARTS: 1. Assy parts				JIG	n/a
	<u></u>	QUALITY CHECKPO	DINTS		
D2		71,000	4.7022		
P3		/LUU8	4-7023		
			3		
	Annumum Company				7
		37			VEIE .
GOOD	(5)			1	
GOOD	6	(4)			
					NO GOOD
					7
NO GOOD	$\overline{O}$				الطف
	Alle vin	8	9		
NO	anamumm)				GOOD
NO		WWW MILLSING	THE RESERVE		
$\bigcirc$	A NO LINI OCKED/	LIALEL OCKED	COMMECTOR	No WPO	NG USE of tape/
(1)(3)	(4) NO UNLOCKED/	HALFLUCKED	CONNECTOR	(8)(9)	ivo ose oi tape/
GOOD 2 (5)	67No Missing	g Clamp			
		*			